

CHAPTER

25

**EQUIPMENT/
FURNISHINGS**



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25-EFFECTIVE PAGES			25-00-00 (cont)			25-00-00 (cont)		
1 thru 9	JUN 15/2016		707	Feb 15/2015		824	Feb 15/2016	
10	BLANK		708	Feb 15/2015		825	Feb 15/2016	
25-CONTENTS			709	Feb 15/2015		826	Feb 15/2016	
1	Feb 15/2016		710	Feb 15/2015		827	Feb 15/2016	
2	Feb 15/2015		711	Feb 15/2015		828	Feb 15/2016	
3	Feb 15/2015		712	Feb 15/2015		829	Feb 15/2016	
4	Feb 15/2015		713	Oct 15/2015		830	Feb 15/2016	
O 5	Jun 15/2016		714	Jun 15/2015		831	Feb 15/2016	
O 6	Jun 15/2016		715	Feb 15/2015	R	832	Jun 15/2016	
O 7	Jun 15/2016		716	Feb 15/2015		25-00-00		
O 8	Jun 15/2016		717	Oct 15/2015		901	Feb 15/2015	
O 9	Jun 15/2016		718	Jun 15/2015		902	Feb 15/2015	
O 10	Jun 15/2016	25-00-00				903	Feb 15/2015	
O 11	Jun 15/2016		801	Oct 15/2015		904	Feb 15/2015	
O 12	Jun 15/2016		802	Oct 15/2015		905	Feb 15/2015	
O 13	Jun 15/2016		803	Jun 15/2015		906	Feb 15/2015	
R 14	Jun 15/2016		804	Jun 15/2015		907	Feb 15/2015	
O 15	Jun 15/2016		805	Jun 15/2015		908	Feb 15/2015	
R 16	Jun 15/2016		806	Feb 15/2015		909	Feb 15/2015	
R 17	Jun 15/2016		807	Oct 15/2015		910	Feb 15/2015	
O 18	Jun 15/2016		808	Oct 15/2014		911	Feb 15/2015	
O 19	Jun 15/2016		809	Oct 15/2014		912	Feb 15/2015	
O 20	Jun 15/2016		810	Oct 15/2014		913	Feb 15/2015	
O 21	Jun 15/2016		811	Oct 15/2014		914	Feb 15/2015	
O 22	Jun 15/2016		812	Feb 15/2016	25-11-00			
O 23	Jun 15/2016		813	Feb 15/2016		201	Feb 15/2015	
O 24	Jun 15/2016		814	Feb 15/2016		202	Feb 15/2015	
O 25	Jun 15/2016		815	Feb 15/2016	25-11-01			
26	BLANK		816	Feb 15/2016		401	Feb 15/2016	
25-00-00			817	Feb 15/2016		402	Feb 15/2016	
701	Feb 15/2015		818	Feb 15/2016		403	Oct 15/2015	
R 702	Jun 15/2016		819	Feb 15/2016		404	Oct 15/2015	
O 703	Jun 15/2016		820	Feb 15/2016		405	Oct 15/2015	
O 704	Jun 15/2016		821	Feb 15/2016		406	BLANK	
O 705	Jun 15/2016		822	Feb 15/2016				
706	Feb 15/2015		823	Feb 15/2016				

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25-11-01			25-11-21 (cont)			25-21-01		
601	Feb 15/2016		215	Oct 15/2015		201	Feb 15/2016	
602	Jun 15/2015		216	Feb 15/2015		202	Feb 15/2016	
603	Oct 15/2015		217	Oct 15/2014		25-21-12		
604	Oct 15/2015		218	Oct 15/2015		R 401	Jun 15/2016	
25-11-02			219	Oct 15/2015		O 402	Jun 15/2016	
401	Oct 15/2014		220	Oct 15/2015		R 403	Jun 15/2016	
402	Oct 15/2015		221	Oct 15/2015		R 404	Jun 15/2016	
403	Oct 15/2015		222	Oct 15/2015		R 405	Jun 15/2016	
404	Oct 15/2015		223	Oct 15/2015		R 406	Jun 15/2016	
25-11-04			224	Oct 15/2015		O 407	Jun 15/2016	
401	Oct 15/2014		R 225	Jun 15/2016		O 408	BLANK	
402	Oct 15/2015		226	Oct 15/2015		D 409	Jun 15/2016	
403	Oct 15/2014		227	Oct 15/2015		D 410	Jun 15/2016	
404	BLANK		R 228	Jun 15/2016		D 411	Jun 15/2016	
25-11-11			229	Oct 15/2014		D 412	Jun 15/2016	
601	Jun 15/2015		230	Oct 15/2015		D 413	Jun 15/2016	
602	Feb 15/2015		231	Oct 15/2014		D 414	Jun 15/2016	
603	Oct 15/2015		232	BLANK		25-21-20		
604	Oct 15/2015		25-11-22			401	Oct 15/2014	
605	Feb 15/2015		401	Oct 15/2014		402	Oct 15/2014	
606	Oct 15/2014		R 402	Jun 15/2016		403	Oct 15/2014	
25-11-21			R 403	Jun 15/2016		404	Oct 15/2014	
201	Oct 15/2014		R 404	Jun 15/2016		405	Oct 15/2015	
202	Oct 15/2014		O 405	Jun 15/2016		406	Oct 15/2015	
203	Oct 15/2014		R 406	Jun 15/2016		25-21-24		
204	Oct 15/2014		R 407	Jun 15/2016		401	Oct 15/2014	
205	Oct 15/2014		R 408	Jun 15/2016		402	Oct 15/2015	
206	Oct 15/2015		R 409	Jun 15/2016		403	Oct 15/2015	
207	Oct 15/2015		R 410	Jun 15/2016		404	Oct 15/2015	
208	Oct 15/2015		R 411	Jun 15/2016		25-21-25		
209	Oct 15/2015		R 412	Jun 15/2016		401	Oct 15/2014	
210	Oct 15/2015		R 413	Jun 15/2016		402	Oct 15/2014	
211	Oct 15/2015		R 414	Jun 15/2016		403	Oct 15/2015	
212	Oct 15/2015		R 415	Jun 15/2016		404	Oct 15/2015	
213	Oct 15/2015		416	BLANK			BLANK	
214	Oct 15/2014							

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25-21-30			25-21-45 Config 1 (cont)			25-22-00		
401	Oct 15/2014		415	Oct 15/2014		401	Oct 15/2015	
402	Oct 15/2015		416	Oct 15/2015		R 402	Jun 15/2016	
403	Oct 15/2015		417	Oct 15/2015		O 403	Jun 15/2016	
R 404	Jun 15/2016		418	Oct 15/2014		R 404	Jun 15/2016	
A 405	Jun 15/2016		419	Oct 15/2014		405	Oct 15/2015	
A 406	BLANK		420	Oct 15/2015		406	Oct 15/2015	
25-21-31			421	Oct 15/2015		R 407	Jun 15/2016	
401	Oct 15/2014		422	Oct 15/2014		408	BLANK	
402	Oct 15/2014		423	Oct 15/2014		25-22-00		
403	Oct 15/2015		424	Oct 15/2015		R 601	Jun 15/2016	
404	BLANK		425	Oct 15/2015		602	Jun 15/2015	
25-21-34			426	Oct 15/2014		603	Oct 15/2015	
401	Oct 15/2014	25-21-46				R 604	Jun 15/2016	
402	Oct 15/2015	R 401	Jun 15/2016			25-23-13		
403	Oct 15/2015		402	Jun 15/2015		R 401	Jun 15/2016	
404	Oct 15/2015		403	Jun 15/2015		R 402	Jun 15/2016	
25-21-35			404	Oct 15/2015		403	Oct 15/2015	
R 401	Jun 15/2016	25-21-71				404	Oct 15/2015	
402	Oct 15/2014		401	Oct 15/2014		405	Oct 15/2015	
403	Oct 15/2015		402	Oct 15/2014		R 406	Jun 15/2016	
404	BLANK		403	Oct 15/2015		R 407	Jun 15/2016	
25-21-45 Config 1			404	Oct 15/2015		408	BLANK	
401	Oct 15/2014		405	Oct 15/2015		25-23-61		
402	Feb 15/2015		406	Oct 15/2015		R 401	Jun 15/2016	
403	Feb 15/2015		407	Oct 15/2015		402	Jun 15/2015	
404	Feb 15/2015		408	Oct 15/2015		403	Feb 15/2016	
405	Oct 15/2015		409	Oct 15/2015		R 404	Jun 15/2016	
406	Oct 15/2015		410	Oct 15/2015		405	Feb 15/2016	
407	Oct 15/2014		411	Oct 15/2015		406	Feb 15/2016	
408	Oct 15/2015		412	Oct 15/2015		407	Feb 15/2016	
409	Oct 15/2015		413	Oct 15/2014		408	Feb 15/2016	
410	Oct 15/2014		414	Oct 15/2014		R 409	Jun 15/2016	
411	Oct 15/2014		415	Oct 15/2014		R 410	Jun 15/2016	
412	Oct 15/2015		416	Oct 15/2014		A 411	Jun 15/2016	
413	Oct 15/2015		417	Oct 15/2015		A 412	Jun 15/2016	
414	Oct 15/2014		418	BLANK		A 413	Jun 15/2016	

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25-23-61 (cont)			25-24-31			25-24-40 (cont)		
A 414	BLANK		201	Feb 15/2016		206	Oct 15/2015	
25-24-05			202	Feb 15/2016		207	Oct 15/2015	
401	Oct 15/2014		203	Feb 15/2016		208	Oct 15/2014	
402	Oct 15/2014		204	Feb 15/2016		209	Oct 15/2014	
403	Oct 15/2015		25-24-31 Config 1			210	Oct 15/2014	
404	BLANK		401	Feb 15/2016		211	Oct 15/2015	
25-24-07			402	Feb 15/2016		212	Oct 15/2015	
R 401	Jun 15/2016		403	Feb 15/2016		213	Oct 15/2014	
R 402	Jun 15/2016		404	Feb 15/2016		214	BLANK	
403	Oct 15/2015		405	Feb 15/2016		25-24-40		
404	Oct 15/2015		406	Feb 15/2016		401	Oct 15/2015	
25-24-10 Config 1			407	Feb 15/2016		402	Oct 15/2015	
401	Oct 15/2015		408	Feb 15/2016		403	Oct 15/2015	
402	Oct 15/2015		409	Feb 15/2016		404	Oct 15/2015	
403	Oct 15/2015		410	Feb 15/2016		405	Oct 15/2015	
404	Oct 15/2015		411	Feb 15/2016		406	Oct 15/2015	
405	Oct 15/2015		412	Feb 15/2016		25-24-77		
406	Oct 15/2015		413	Feb 15/2016		R 401	Jun 15/2016	
407	Oct 15/2014		414	Feb 15/2016		R 402	Jun 15/2016	
408	Oct 15/2014		415	Feb 15/2016		R 403	Jun 15/2016	
R 409	Jun 15/2016		416	Feb 15/2016		O 404	Jun 15/2016	
410	Oct 15/2015		25-24-36			405	Feb 15/2016	
411	Oct 15/2015		201	Feb 15/2016		406	Feb 15/2016	
412	Oct 15/2015		202	Feb 15/2016		407	Feb 15/2016	
413	Feb 15/2016		203	Feb 15/2016		408	Feb 15/2016	
414	Oct 15/2015		204	Feb 15/2016		25-25-11		
415	Feb 15/2016		205	Feb 15/2016		401	Jun 15/2015	
416	BLANK		206	Feb 15/2016		R 402	Jun 15/2016	
25-24-15 Config 1			207	Feb 15/2016		403	Oct 15/2014	
401	Oct 15/2014		208	BLANK		404	Oct 15/2015	
402	Oct 15/2015		25-24-40			405	Oct 15/2015	
403	Oct 15/2015		201	Oct 15/2014		406	Oct 15/2015	
404	Oct 15/2015		202	Oct 15/2015		407	Jun 15/2015	
405	Oct 15/2015		203	Oct 15/2015		408	Jun 15/2015	
406	Oct 15/2014		204	Oct 15/2014		409	Oct 15/2015	
			205	Oct 15/2014		410	Oct 15/2015	

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R 411	Jun 15/2016		R 201	Jun 15/2016		R 408	Jun 15/2016	
O 412	Jun 15/2016		202	Feb 15/2016		R 409	Jun 15/2016	
25-25-12			203	Oct 15/2015		R 410	Jun 15/2016	
401	Oct 15/2014		R 204	Jun 15/2016		411	Oct 15/2015	
402	Oct 15/2014		205	Feb 15/2016		R 412	Jun 15/2016	
403	Oct 15/2015		206	BLANK		R 413	Jun 15/2016	
404	BLANK		25-29-07			414	BLANK	
25-25-12			401	Feb 15/2016		25-31-31		
601	Feb 15/2015		402	Feb 15/2016		R 201	Jun 15/2016	
602	Feb 15/2015		403	Oct 15/2015		R 202	Jun 15/2016	
603	Oct 15/2015		404	BLANK		25-31-31		
604	Feb 15/2015		25-31-11			R 401	Jun 15/2016	
25-27-15			201	Feb 15/2015		R 402	Jun 15/2016	
401	Oct 15/2014		202	Feb 15/2015		R 403	Jun 15/2016	
402	Oct 15/2014		25-31-11			R 404	Jun 15/2016	
403	Oct 15/2015		401	Oct 15/2014		R 405	Jun 15/2016	
404	Oct 15/2015		R 402	Jun 15/2016		R 406	Jun 15/2016	
R 405	Jun 15/2016		R 403	Jun 15/2016		R 407	Jun 15/2016	
O 406	Jun 15/2016		404	Oct 15/2014		R 408	Jun 15/2016	
25-27-21			R 405	Jun 15/2016		D 409	Jun 15/2016	
401	Oct 15/2014		406	Feb 15/2015		D 410	BLANK	
402	Oct 15/2015		407	Oct 15/2015		25-31-41		
403	Oct 15/2015		408	Oct 15/2015		201	Feb 15/2015	
404	Oct 15/2014		409	Oct 15/2015		202	Feb 15/2015	
R 405	Jun 15/2016		410	Oct 15/2015		25-31-41 Config 5		
406	Oct 15/2015		25-31-21			401	Oct 15/2014	
407	Oct 15/2015		201	Feb 15/2015		402	Oct 15/2014	
408	Oct 15/2015		202	Feb 15/2015		403	Oct 15/2015	
25-27-31			25-31-21			R 404	Jun 15/2016	
401	Oct 15/2014		R 401	Jun 15/2016		405	Oct 15/2014	
402	Oct 15/2014		R 402	Jun 15/2016		406	Oct 15/2014	
403	Oct 15/2015		R 403	Jun 15/2016		407	Feb 15/2015	
404	Oct 15/2015		R 404	Jun 15/2016		408	Oct 15/2015	
R 405	Jun 15/2016		R 405	Jun 15/2016		409	Oct 15/2015	
406	Jun 15/2015		R 406	Jun 15/2016		410	Oct 15/2015	
			R 407	Jun 15/2016		411	Oct 15/2015	

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25-31-41 Config 5 (cont)			25-40-01 (cont)			25-40-14 (cont)		
412	BLANK		406	BLANK		A 413	Jun 15/2016	
25-31-61			25-40-08			A 414	Jun 15/2016	
R 401	Jun 15/2016		R 601	Jun 15/2016		A 415	Jun 15/2016	
R 402	Jun 15/2016		R 602	Jun 15/2016		A 416	BLANK	
R 403	Jun 15/2016		A 603	Jun 15/2016		25-40-15		
R 404	Jun 15/2016		A 604	Jun 15/2016		R 401	Jun 15/2016	
25-31-71			25-40-11			O 402	Jun 15/2016	
R 201	Jun 15/2016		R 401	Jun 15/2016		R 403	Jun 15/2016	
R 202	Jun 15/2016		R 402	Jun 15/2016		R 404	Jun 15/2016	
25-31-71			R 403	Jun 15/2016		R 405	Jun 15/2016	
R 401	Jun 15/2016		R 404	Jun 15/2016		R 406	Jun 15/2016	
R 402	Jun 15/2016		R 405	Jun 15/2016		R 407	Jun 15/2016	
R 403	Jun 15/2016		R 406	Jun 15/2016		R 408	Jun 15/2016	
R 404	Jun 15/2016		R 407	Jun 15/2016		R 409	Jun 15/2016	
R 405	Jun 15/2016		R 408	Jun 15/2016		R 410	Jun 15/2016	
R 406	Jun 15/2016		R 409	Jun 15/2016		A 411	Jun 15/2016	
R 407	Jun 15/2016		O 410	Jun 15/2016		A 412	Jun 15/2016	
R 408	Jun 15/2016		R 411	Jun 15/2016		A 413	Jun 15/2016	
25-31-83			O 412	Jun 15/2016		A 414	BLANK	
R 401	Jun 15/2016		A 413	Jun 15/2016		25-52-00		
R 402	Jun 15/2016		A 414	Jun 15/2016		601	Feb 15/2015	
R 403	Jun 15/2016		A 415	Jun 15/2016		602	Feb 15/2016	
404	BLANK		A 416	Jun 15/2016		603	Feb 15/2016	
25-40-00			25-40-14			604	Feb 15/2015	
201	Feb 15/2015		R 401	Jun 15/2016		605	Feb 15/2015	
202	Feb 15/2015		R 402	Jun 15/2016		606	Oct 15/2015	
R 203	Jun 15/2016		O 403	Jun 15/2016		607	Oct 15/2015	
O 204	Jun 15/2016		R 404	Jun 15/2016		608	Oct 15/2015	
R 205	Jun 15/2016		R 405	Jun 15/2016		609	Oct 15/2015	
206	BLANK		R 406	Jun 15/2016		610	BLANK	
25-40-01			O 407	Jun 15/2016		25-52-00		
401	Oct 15/2015		R 408	Jun 15/2016		701	Jun 15/2015	
402	Oct 15/2014		R 409	Jun 15/2016		702	Feb 15/2015	
403	Oct 15/2015		R 410	Jun 15/2016		703	Jun 15/2015	
404	Oct 15/2015		O 411	Jun 15/2016		704	Jun 15/2015	
405	Oct 15/2015		R 412	Jun 15/2016				

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R 801	Jun 15/2016		403	Oct 15/2015		432	Oct 15/2015	
R 802	Jun 15/2016		404	Oct 15/2015		433	Oct 15/2015	
O 803	Jun 15/2016		R 405	Jun 15/2016		434	Oct 15/2015	
804	Feb 15/2016		R 406	Jun 15/2016		435	Oct 15/2015	
805	Feb 15/2016		25-52-10			436	Oct 15/2015	
806	Feb 15/2016		401	Oct 15/2015		437	Oct 15/2015	
807	Oct 15/2015		R 402	Jun 15/2016		438	Oct 15/2015	
808	Oct 15/2015		O 403	Jun 15/2016		439	Oct 15/2015	
R 809	Jun 15/2016		404	Oct 15/2015		440	Oct 15/2015	
810	Feb 15/2016		405	Oct 15/2015		441	Oct 15/2015	
811	Feb 15/2016		406	Oct 15/2015		442	BLANK	
812	Feb 15/2016		407	Oct 15/2015		25-52-12		
813	Feb 15/2016		408	Oct 15/2015		401	Oct 15/2014	
814	Oct 15/2015		409	Oct 15/2015		402	Oct 15/2015	
815	Oct 15/2015		410	Oct 15/2015		403	Oct 15/2015	
816	Oct 15/2015		411	Oct 15/2015		404	Oct 15/2015	
817	Oct 15/2015		412	Oct 15/2015		405	Oct 15/2015	
818	Feb 15/2015		413	Oct 15/2015		406	Oct 15/2015	
819	Feb 15/2016		414	Oct 15/2015		407	Oct 15/2015	
820	Oct 15/2014		415	Oct 15/2015		408	BLANK	
821	Oct 15/2014		416	Oct 15/2015		25-52-16		
822	Oct 15/2014		417	Oct 15/2015		401	Feb 15/2015	
823	Oct 15/2014		418	Oct 15/2015		402	Oct 15/2015	
824	BLANK		419	Oct 15/2015		403	Oct 15/2015	
25-52-06			420	Oct 15/2015		404	Oct 15/2015	
401	Oct 15/2015		421	Oct 15/2015		25-52-17		
R 402	Jun 15/2016		422	Oct 15/2015		401	Oct 15/2014	
O 403	Jun 15/2016		423	Oct 15/2015		402	Oct 15/2015	
O 404	Jun 15/2016		424	Oct 15/2015		403	Oct 15/2015	
405	Oct 15/2015		425	Oct 15/2015		404	Oct 15/2015	
406	Oct 15/2015		426	Oct 15/2015		25-52-18		
407	Oct 15/2015		427	Oct 15/2015		401	Oct 15/2014	
408	BLANK		428	Oct 15/2015		402	Oct 15/2015	
25-52-09			429	Oct 15/2015		403	Oct 15/2015	
R 401	Jun 15/2016		430	Oct 15/2015		404	Oct 15/2015	
R 402	Jun 15/2016		431	Oct 15/2015				

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25-52-19			25-64-00 (cont)			25-66-01 (cont)		
401	Oct 15/2014	R	207	Jun 15/2016		417	Jun 15/2015	
402	Oct 15/2015	O	208	Jun 15/2016		418	Jun 15/2015	
403	Oct 15/2015	25-64-00				419	Jun 15/2015	
404	Oct 15/2015	401	Feb 15/2015			420	BLANK	
25-52-20			402	Oct 15/2014		25-66-01		
401	Oct 15/2014	25-66-00				601	Jun 15/2015	
402	Oct 15/2015	201	Feb 15/2015			R 602	Jun 15/2016	
403	Oct 15/2015	202	Oct 15/2014			603	Oct 15/2015	
404	Oct 15/2015	203	Oct 15/2015			604	Oct 15/2015	
25-61-10			204	Feb 15/2015		605	Oct 15/2015	
201	Oct 15/2014	205	Oct 15/2015			606	Oct 15/2015	
202	Feb 15/2015	206	Oct 15/2015			25-66-02		
203	Oct 15/2014	207	Feb 15/2015			201	Feb 15/2016	
204	Oct 15/2015	208	BLANK			202	Feb 15/2016	
205	Oct 15/2015	25-66-00				203	Feb 15/2016	
206	Oct 15/2014	501	Feb 15/2015			204	Oct 15/2015	
207	Oct 15/2014	502	Feb 15/2015			25-71-00		
208	Oct 15/2015	503	Oct 15/2015			401	Oct 15/2014	
209	Oct 15/2014	504	Oct 15/2015			402	Oct 15/2015	
210	Oct 15/2015	25-66-01				403	Oct 15/2015	
211	Oct 15/2015	401	Feb 15/2015			404	Oct 15/2015	
212	Oct 15/2015	402	Feb 15/2015			405	Oct 15/2015	
213	Oct 15/2015	403	Feb 15/2015			406	Oct 15/2014	
214	BLANK	404	Oct 15/2015			407	Oct 15/2014	
25-61-13			405	Oct 15/2015		408	Oct 15/2015	
401	Oct 15/2014	406	Oct 15/2015			409	Oct 15/2015	
402	Oct 15/2014	407	Oct 15/2015			410	Oct 15/2014	
403	Oct 15/2014	408	Oct 15/2015			411	Oct 15/2015	
404	Oct 15/2015	409	Oct 15/2015			412	Oct 15/2015	
25-64-00			410	Oct 15/2015		413	Oct 15/2014	
201	Jun 15/2015	411	Feb 15/2015			414	BLANK	
202	Feb 15/2015	412	Jun 15/2015			25-71-00		
203	Feb 15/2015	413	Feb 15/2015			601	Jun 15/2015	
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INSULATION - REPAIRS	25-80-00				801	AKS ALL
Repair the Insulation Blanket with BMS8-377 Cover Material TASK 25-80-00-340-803					801	AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
Repair the Insulation Blanket with BMS8-370 Cover Material TASK 25-80-00-340-805					805	AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
Repair the Insulation Blanket that has BMS 8-396 Fire Resistant Material TASK 25-80-00-340-809					807	AKS ALL
Repair the Insulation Blanket that has BMS8-380 Cover Material TASK 25-80-00-340-808					811	AKS ALL
Insulation Blanket Manufacturing TASK 25-80-00-300-801					815	AKS ALL
Repair of Cargo Door Insulation Blankets TASK 25-80-00-340-806					832	AKS ALL

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EQUIPMENT/FURNISHINGS - CLEANING/PAINTING

1. General

A. This procedure contains these tasks:

- (1) The cleaning of the airplane equipment and furnishings.
- (2) The painting of the airplane equipment and furnishings.

NOTE: When cleaning areas of the aircraft where electrical system wiring and components are present, refer to CLEANING TO REMOVE COMBUSTIBLE MATERIAL (EZAP) - MAINTENANCE PRACTICES, PAGEBLOCK 20-60-02/201 and WIRE BUNDLE PROTECTION (EZAP) - PROTECTION OF EWIS (EZAP) - MAINTENANCE PRACTICES, PAGEBLOCK 20-60-07/201 procedures.

TASK 25-00-00-100-801

2. Equipment/Furnishings - Cleaning

(Figure 701)

A. General

- (1) Many of the decorative surfaces contain different materials. Some of these materials are:
 - (a) Tedlar
 - (b) Polycarbonate (Lexan)
 - (c) Fabrics
 - (d) Silicone
 - (e) Rubber
 - (f) Metal
 - (g) Ultem
 - (h) Declar
- (2) Be careful not to get the clean surfaces dirty when cleaning adjacent surfaces.

B. References

Reference	Title
25-00-00-300-802	Decorative Surface Repair (P/B 801)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2477	Tools - Vacuum Cleaner Set Part #: R80 Supplier: \$0373 Opt Part #: 02146A Supplier: 0A5X2 Opt Part #: 44SPEC Supplier: 0Y8U0 Opt Part #: 655406-7M Supplier: 0Y8U0 Opt Part #: C-39485-41 Supplier: 16893 Opt Part #: WD80 Supplier: \$0373
STD-123	Brush - Soft Bristle
STD-183	Cleaner - Vacuum
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

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Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin
STD-3911	Brush - Bristle, Medium Nylon
STD-4048	Bottle - Hand Spray

D. Consumable Materials

Reference	Description	Specification
B00032	Cleaner - Glass - GLYST A-1859	
B00033	Cleaner - Glass - Glasswax	
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00081	Solvent - Trichloroethylene	BMS11-6
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
B00090	Solvent - Inhibited Trichloroethane 1,1,1	MIL-T-81533
B00093	Solvent - Tetrachloroethylene (Perchloroethylene)	ASTM D4081
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00153	Solvent - Toluene, Nitration	JAN-T-171 Grade A
B00157	Cleaner - Detergent - Spraywhite E	
B00158	Cleaner - Clean Quick Broad Range Quaternary Sanitizer	
B00294	Cleaner - Detergent - Glo Do-All Formula 1D	
B00334	Cleaner - Sodium Bicarbonate	ASTM D928, or commercially available product
B00460	Cleaner - Multi-Purpose - Winsol APC-120-WX	
B00541	Cleaner - General Purpose Household Detergent	
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
B00641	Cleaner - Aircraft (Interior And Exterior) - Turco 5948	
B00700	Polish - Aluminum, Met-All	
B00702	Cleaner - Acrylic Window - Dustless (An alternative is Static Stop)	BAC5038
B00703	Compound - Plastic Polish	P-P-560
B00705	Cleaner - Detergent - SE-700	
B00710	Cleaner - Clear Plastic, Meguiar's Mirror Glaze 17 - (Formerly Meguiar's MGH-17)	
B50078	Solvent - Aliphatic Naphtha (For Organic Coatings)	TT-N-95 Type I (Supersedes BMS3-2 Type I)
B50079	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II (Supersedes BMS3-2 Type II)
B50119	Solvent - Chlorinated	BAC5750
B50120	Solvent - Fluorocarbon	BAC5750

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Reference	Description	Specification
B50123	Cleaner - Glass	
B50189	Polish - Clear Plastic, Meguiar's Mirror Glaze 10 - (Formerly Meguiar's MGH-10)	
B50225	Solvent - Citra-Safe (Deodorized)	
B50226	Solvent - Citra-Safe	
B50251	Cleaner - Miller-Stephenson MS-260 Safezone Cleaner For Plastic, Glass And Metal	
B50264	Detergent - General, Sanikleen, 10 percent	N/A
B50265	Detergent - Ultra Spic and Span	Commercially Available
B50266	Detergent - General	Commercially Available
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00110	Sponge - Silicone Rubber, Closed-Cell, General Purpose, Non-Solvent Use	BMS1-23
G00116	Sponge - Synthetic	
G00215	Brush - Soft Bristle Fiber	
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02360	Tape - Textile Hook And Loop Fasteners Tape (Polypropylene Hook & Nylon Loop)	BMS8-285 Type V
G02414	Brush - Stainless Steel	
G50138	Cloth - Soft Cotton	
G50222	Brush - Tampico Fiber, Non-Metallic	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Procedure

SUBTASK 25-00-00-160-001

- (1) Use these special tools and equipment:
 - (a) vacuum cleaner tool set, COM-2477

SUBTASK 25-00-00-160-002

- (2) Use these standard tools and equipment:
 - (a) hand spray bottle, STD-4048
 - (b) tampico fiber brush, G50222 - Stiff fiber, 0.5 in. (12.7 mm) long bristles, 1.125 ± 0.875 in. (28.6 ± 22.3 mm) wide (glue brushes or paint brushes with bristles cut to length).
 - (c) medium nylon bristle brush, STD-3911 - Medium fiber bristles, 4 in. (10 cm) wide
 - (d) brush, G02414- Hand, solvent - resistant
 - (e) hard resin phenolic scraper, STD-1064
 - (f) cotton wiper, G00034
 - (g) hardwood or plastic fillet smoothing spatula, STD-810
 - (h) sponge, G00116

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SUBTASK 25-00-00-110-001

- (3) Use any of these detergents:
- (a) Spraywhite E cleaner, B00157
 - (b) Clean Quick sanitizer, B00158
 - (c) Glo Do-All Formula 1D cleaner, B00294
 - (d) Winsol APC-120-WX cleaner, B00460
 - (e) Turco 5948 cleaner, B00641
 - (f) SE-700 cleaner, B00705
 - (g) general detergent, B50264
 - (h) Spic and Span, B50265
 - (i) JB/B2, B50266

SUBTASK 25-00-00-110-002

- (4) Use any of these cleaners:
- (a) GLYST A-1859 cleaner, B00032
 - (b) Glasswax cleaner, B00033
 - (c) Spic and Span, B50265
 - (d) sodium bicarbonate cleaner, B00334
 - (e) Dustless cleaner, B00702
 - (f) compound, B00703
 - (g) clear plastic cleaner, B00710
 - (h) general purpose household detergent cleaner, B00541
 - (i) glass cleaner, B50123
 - (j) clear plastic polish, B50189
 - (k) MS-260 cleaner, B50251
 - (l) general detergent, B50264

SUBTASK 25-00-00-110-003

- (5) Use any of these solvents:
- (a) alcohol, B00068
 - (b) solvent, B00090
 - (c) solvent, B00081
 - (d) solvent, B00083
 - (e) solvent, B00093
 - (f) solvent, B00153
 - (g) solvent, B00148
 - (h) aliphatic naphtha, B50078
 - (i) aliphatic naphtha, B50079
 - (j) chlorinated solvent, B50119
 - (k) fluorocarbon solvent, B50120
 - (l) citra-safe solvent, B50225

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- (m) citra-safe solvent, B50226

SUBTASK 25-00-00-110-004

- (6) Use this metal polish:
(a) Met-All polish, B00700

G. Prepare for the Cleaning

SUBTASK 25-00-00-160-003

- (1) These are your recommended detergent mixtures:
- (a) Mix one part Spraywhite E cleaner, B00157 to 10 parts water (by volume).
 - (b) Mix one part Clean Quick sanitizer, B00158 to 64 parts water (by volume).
 - (c) Mix one part SE-700 cleaner, B00705 to 20 parts water (by volume).
 - (d) Mix one part Glo Do-All Formula 1D cleaner, B00294 to 30 parts water (by volume).
 - (e) Mix one part Winsol APC-120-WX cleaner, B00460 to 32 parts water (by volume).
 - (f) Mix one part Turco 5948 cleaner, B00641 to 20 part of water (by volume).

H. Clean the Opaque Plastic and Painted Surfaces

SUBTASK 25-00-00-110-015

- (1) Use foam and a vacuum cleaner, STD-183 to remove unwanted materials from perforated or acoustic surfaces.
- (a) If you cannot use foam and a vacuum cleaner, use moist soft cotton cloth, G50138 or a sponge, G00110.

NOTE: If the cloth is soaked, too much fluid will go through the perforations and openings.

SUBTASK 25-00-00-160-004

- (2) To clean a small area on the surface, do the steps that follow:

NOTE: Do not rub solid colored Tedlar surfaces when they are dry. The surface is hard to clean if particles get pushed into the surface of the material.

- (a) Lift the loose unwanted material with a cotton wiper, G00034 wiper.
 - 1) Do not rub, spread, or push the unwanted material into the textured or perforated surfaces, joints, or seams.
- (b) Apply general purpose household detergent cleaner, B00541 to the dirty area with a spray hand spray bottle, STD-4048 or moist sponge, G00116.
- (c) Lightly rub the area with a cotton wiper, G00034 wiper.
 - 1) For textured surfaces, remove the unwanted materials from recesses with a small fiber brush, G00215.
- (d) Remove the general purpose household detergent cleaner, B00541 with a sponge, G00116 that is moist with water.
- (e) Dry the area with a clean cotton wiper, G00034 wiper. Rub the area in a straight line movement. If the area stays dirty do the steps that follow:



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WARNING: DO NOT GET THE SOLVENT IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM IT. PUT ON GOGGLES, AND GLOVES WHEN YOU USE IT. KEEP IT AWAY FROM SPARKS, FLAMES, AND HEAT. IT IS POISONOUS AND FLAMMABLE. THE SOLVENT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT USE MORE SOLVENT THAN IS NECESSARY. DAMAGE TO THE SURFACE CAN OCCUR IF THE CONCENTRATION OF THE SOLUTION TO THE AREA IS HIGH.

CAUTION: USE ONLY FREON OR ALIPHATIC NAPHTHA TYPE II TO CLEAN PLASTICS. BUT DO NOT USE FREON IF THE PART IS PAINTED WITH A WATER-BASED PAINT. THE FREON WILL CAUSE DAMAGE TO THE PAINT. YOU CAN USE ALIPHATIC NAPHTHA FOR PAINTED SURFACES, BUT FIRST YOU MUST REMOVE THE PART FROM THE AIRPLANE.

- 1) Carefully rub the dirty area with a cotton wiper, G00034 wiper that is moist with solvent, B00083 or Limonene solvent, B00634.
- 2) Do the steps again to remove the solvent with a detergent.

SUBTASK 25-00-00-160-005

- (3) To clean all of the surface do the steps that follow:
 - (a) Apply Turco 5948 cleaner, B00641 to the surface with a sponge, G00116 or a spray hand spray bottle, STD-4048.
 - (b) Let the Turco 5948 cleaner, B00641 stay on the surface for one-half to two minutes.
 - (c) Rub the surface with a cotton wiper, G00034 that is moist with clean water.
 - (d) Remove the Turco 5948 cleaner, B00641 with a clean cotton wiper, G00034 that is soaked with clean water.
 - (e) Dry the surface with a clean dry cotton wiper, G00034.

I. Clean Tedlar Covered Surfaces

SUBTASK 25-00-00-160-006

- (1) To clean the Tedlar covered surface of a part while it is installed in the airplane, do these steps:
 - (a) Apply the Turco 5948 cleaner, B00641 with a soft bristle brush, STD-123. Rub the surface in all directions with the soft bristle brush, STD-123.
 - (b) Remove the Turco 5948 cleaner, B00641 with a sponge, G00116 that is moist with clean water.
 - (c) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-160-007

- (2) To clean the Tedlar coated surface of a part that is out of the airplane, do the steps that follow:
 - (a) Repair all the damaged parts. Do this task: TASK 25-00-00-300-802
 - (b) You can use the same method to clean the parts you would use if the parts were installed, or you can use the method that follows:
 - 1) Remove or cover with Scotch Flatback Masking Tape 250, G00270 all the plastic and painted surfaces which are not resistant to solvent damage.

NOTE: These solvents will remove the paint from the edge of the part.

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WARNING: DO NOT GET THE SOLVENT IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM IT. PUT ON GOGGLES, AND GLOVES WHEN YOU USE IT. KEEP IT AWAY FROM SPARKS, FLAMES, AND HEAT. IT IS POISONOUS AND FLAMMABLE. THE SOLVENT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- 2) Clean the part with a clean cotton wiper, G00034 and one of these solvents:
 - a) solvent, B00148
 - b) solvent, B00153
 - c) A 50%-50% mixture of solvent, B00148 and solvent, B00153.
 - d) alcohol, B00068
 - e) solvent, B00093 or solvent, B00090.
 - f) aliphatic naphtha, B50078
 - g) aliphatic naphtha, B50079
 - h) chlorinated solvent, B50119
 - i) fluorocarbon solvent, B50120
- 3) If you accidentally removed paint from a part when you used the solvent, do this task: Equipment/Furnishings - Painting, TASK 25-00-00-370-801

J. Clean the translucent and transparent plastic surfaces (Does not include windows)

SUBTASK 25-00-00-160-008

CAUTION: DO NOT RUB THE SURFACES WITH A DRY CLOTH. YOU WILL CAUSE SCRATCHES AND STATIC ELECTRICITY. DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Rub the surface lightly with a clean cotton wiper, G00034 that is soaked with mixed detergent.

SUBTASK 25-00-00-160-009

- (2) Remove the mixed detergent with a clean cotton wiper, G00034 that is moist with water.

SUBTASK 25-00-00-160-040

- (3) Dry the surface with a clean cotton wiper, G00034.
 - (a) Do not rub the plastic after it is dry.

SUBTASK 25-00-00-160-010

- (4) Remove a thin dust layer or electrostatic charge with a clean cotton wiper, G00034 that is moist with water.

K. Clean the Mirrors

SUBTASK 25-00-00-160-011

- (1) To clean the glass mirrors, do these steps:

- (a) Use a razor blade to remove dry paint and other unwanted materials that are not easy to rub off.
- (b) Use GLYST A-1859 cleaner, B00032 or Glasswax cleaner, B00033 or glass cleaner, B50123 or MS-260 cleaner, B50251 to clean the glass.

NOTE: Obey the manufacturer's CAUTIONS and instructions.



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SUBTASK 25-00-00-160-012

CAUTION: DO NOT RUB THE SURFACES WITH A DRY CLOTH. YOU WILL CAUSE SCRATCHES AND STATIC ELECTRICITY. DAMAGE TO EQUIPMENT CAN OCCUR.

(2) To clean the plastic mirrors, do these steps:

- (a) Remove the loose unwanted materials with a clean cotton wiper, G00034.
- (b) Rub the stains with a cotton wiper, G00034 that is moist with general purpose household detergent cleaner, B00541.
- (c) Remove the general purpose household detergent cleaner, B00541 with a cotton wiper, G00034 that is moist with water.
- (d) Rub all of the surface very lightly with a cotton wiper, G00034 that is moist with water to remove the sharp particles.
- (e) Polish the plastic with a clean cotton wiper, G00034 and clear plastic cleaner, B00710 or clear plastic polish, B50189.

L. Clean the Fabrics

SUBTASK 25-00-00-160-013

(1) Clean the carpets, the seat upholstery, and equivalent equipment as follows:

(a) To clean a small area on the surface, do these steps:

NOTE: Remove stains as soon as possible. It is not possible to remove some materials from the fabric if you do not remove them immediately.

1) To remove tea, coffee, fruit juices, wines, fruit, catsup, soft and mixed drinks, chocolate, syrups, perfumes, vomit, and urine, do these steps:

CAUTION: DO NOT USE TOO MUCH HAND PRESSURE WHEN YOU RUB THE FABRIC WITH THE BONE SCRAPER. IF YOU USE TOO MUCH HAND PRESSURE, THE BONE SCRAPER CAN CAUSE DAMAGE TO THE FABRICS.

a) Carefully rub the area with a hard resin phenolic scraper, STD-1064 to loosen the unwanted material from the fabric.

b) Apply a mixed detergent to the dirty area.

c) Rub the area with a hard resin phenolic scraper, STD-1064.

d) Use a vacuum cleaner to remove the detergent and the unwanted materials.

NOTE: Use a soft cloth to remove the remaining moisture if it is necessary.

2) If there is an odor, do these steps:

a) Mix one teaspoon of bicarbonate of soda in six ounces of water.

b) Apply the mixture to the area.

c) Rub the area with a hard resin phenolic scraper, STD-1064.

d) Remove the moisture with a cotton wiper, G00034.

3) To remove fresh paints, greases, lipsticks, permanent inks, oils, jet fuel, hydraulic fluid, powdered graphite, and powdered aluminum, do these steps:

a) Remove the loose unwanted material as soon as possible with a cotton wiper, G00034.

b) Apply a mixed detergent to the area.

c) Let it soak for 30 seconds.

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- d) Apply an additional quantity of the mixed detergent to the area.
- e) Carefully rub the area with the blunt end of hard resin phenolic scraper, STD-1064 to lift the unwanted material into the detergent.
- f) Use a vacuum cleaner tool set, COM-2477 to remove the detergent and the unwanted material.
- g) Use a cotton wiper, G00034 to remove all the remaining moisture if it is necessary.
- h) If the area is not fully clean, do the above steps again until the area is fully clean.
- i) Use a soft bristle brush, STD-123 to straighten and lift the fabric pile.

- 4) To remove adhesives, sealants, paints, asphalt, and gum, do these steps:
 - a) Use a vacuum cleaner tool set, COM-2477 to remove all the loose unwanted material from the fabric.
 - b) Put a cover on the plastic and painted surfaces adjacent to the dirty area.
 - <1> Use a hand spray bottle, STD-4048 with a nozzle to apply chlorinated solvent, B50119 to the dirty area.

NOTE: Use only the minimum quantity of chlorinated solvent necessary to remove the unwanted material. Chlorinated solvent on an uncovered surface can make a new stain.

- c) Let the solution soak for up to 30 seconds.
- d) Carefully rub the fabric with a hard resin phenolic scraper, STD-1064 to remove unwanted materials.
- e) Remove the unwanted materials with a cotton wiper, G00034.
- f) Do the above steps again until the area is fully clean.
- g) Immediately after the area looks fully clean, clean the area with a mixed detergent to remove the solvent.

NOTE: Refer to the instructions given before for the use of detergents on small areas.

- (b) To do regular cleaning, do these steps:

- 1) Use a vacuum cleaner tool set, COM-2477 to remove loose materials from the fabric.
- 2) Use one of the recommended detergent mixtures.

CAUTION: APPLY ONLY THE FOAM FROM THE MIXTURE. THE LIQUID WILL SOAK INTO THE FABRIC AND WILL CAUSE DAMAGE.

- 3) Carefully rub the foam from the mixture into the fabric with a sponge, G00116 or a medium-fiber bristle soft bristle brush, STD-123. Use a circular motion and make it to overlap with each motion.

NOTE: Clean only a small area at a time until you are done.

- 4) Use a brush, G02414 to lift the fabric pile.

NOTE: Carefully rub the fabric in one direction only or the fabric will not look satisfactory.

- 5) When the fabric is fully dry use a vacuum cleaner tool set, COM-2477 to remove the remaining unwanted materials.

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- (c) To clean seat covers and drapes, do these steps:

NOTE: Fabrics are treated with fire retardant. If you do the instructions that follow, the fire retardant will stay satisfactory. If there are instructions for the fabric from the manufacturer or supplier, obey their instructions.

- 1) Attach the hook and loop fastener tape, G02360 together to prevent contamination or damage to the hook and pile.
- 2) To remove tea, coffee, liqueurs, fruit juice, chocolate, syrup, perfume, vomit, urine, do these steps:
 - a) Make the unwanted material soft with a mixed detergent and steam.
 - b) Remove the moisture and the unwanted material with a cotton wiper, G00034.
- 3) Turn the seat covers inside out (turn the inner surface to the outer side).

CAUTION: USE COLD WATER. DO NOT USE MORE THAN 8% WATER IN THE MIXTURE. THE FABRIC CAN BECOME SMALLER IF YOU ADD TOO MUCH WATER OR THE WATER IS NOT COLD.

- 4) Mix the solvent, B00093, chlorinated solvent, B50119 or, fluorocarbon solvent, B50120 and mix detergent and cold water as follows:
 - a) Obey the proportion information given by the manufacturer or the supplier of the detergent and the solvent. Add cold water, up to 8% to the mixture.
 - b) Use a cleaning drum temperature that is not hotter than 72°F (22°C).
- 5) Dry the fabric at a maximum temperature (air into the drum) of 130°F (54°C).
- 6) Remove the remaining stains with a detergent and steam.
- 7) Remove the hook and loop fastener tape, G02360 if it is necessary.

M. Clean the Leather or Naugahyde

SUBTASK 25-00-00-160-014

- (1) To clean a small area on the surface, do these steps:

- (a) Remove water based stains with a mixed detergent.

NOTE: Refer to the paragraph below for regular cleaning instructions.

WARNING: DO NOT GET THE SOLVENT IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM IT. PUT ON GOGGLES, AND GLOVES WHEN YOU USE IT. KEEP IT AWAY FROM SPARKS, FLAMES, AND HEAT. IT IS POISONOUS AND FLAMMABLE. THE SOLVENT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT USE MORE THAN IS NECESSARY. MAKE SURE YOU PREVENT THE CONTAMINATION OF THE ADJACENT CLEAN AREAS BY THE FREON. IF YOU USE TOO MUCH FREON, DAMAGE TO PARTS WILL OCCUR.

- (b) Rub oil-based stains with a cotton wiper, G00034 wiper that is moist with solvent, B00081.

- (c) Then use a mixed detergent to clean the area.

SUBTASK 25-00-00-160-015

- (2) To clean by the usual procedure do these steps:

- (a) Mix one part of Winsol APC-120-WX cleaner, B00460 to 32 parts of water.

- (b) Apply only the foam to the leather or naugahyde with a clean cotton wiper, G00034. Rub carefully in a circular movement.

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- (c) Remove the detergent with a clean cotton wiper, G00034 that is moist with water.
- (d) Rub the surface with a dry soft cotton wiper, G00034.

N. Clean the Painted, Plastic or Rubber Floor Coverings

SUBTASK 25-00-00-160-016

- (1) Use a vacuum cleaner tool set, COM-2477 to remove loose and unwanted materials.

SUBTASK 25-00-00-160-017

- (2) Apply mixed detergent to the floor covering.

SUBTASK 25-00-00-160-018

- (3) Rub the surface with a medium nylon bristle brush, STD-3911, if it is necessary.

SUBTASK 25-00-00-160-019

- (4) Flush the surface with clean water.

SUBTASK 25-00-00-160-020

- (5) Remove the loose or unwanted materials with a clean cotton wiper, G00034.

SUBTASK 25-00-00-160-021

- (6) Do the steps again until the surface is fully clean.

O. Clean the Silicone Seals

SUBTASK 25-00-00-110-005

- (1) Apply mixed detergent with a spray hand spray bottle, STD-4048 and sponge, G00116.

SUBTASK 25-00-00-160-022

- (2) Let it soak on the seal for one-half to two minutes.

SUBTASK 25-00-00-160-023

- (3) Rub the surface of the seal with a cotton wiper, G00034 that is moist with water.

SUBTASK 25-00-00-160-024

- (4) Remove the detergent from the seal with a clean cotton wiper, G00034 that is soaked with water.

SUBTASK 25-00-00-160-025

- (5) Dry the seal with a clean dry cotton wiper, G00034.

P. Clean the Bare Metal Surfaces

SUBTASK 25-00-00-160-026

CAUTION: USE ONLY CLEAN OR CHLORINATED WATER WHEN YOU CLEAN THE FRONT COVERS OF THE OVENS. DETERGENTS WILL CAUSE DETERIORATION OF THE SURFACE FINISH.

- (1) To clean a small area of an aluminum surface, do these steps:

- (a) Apply mixed detergent to the surface with a sponge, G00116 or a spray hand spray bottle, STD-4048
- (b) Let it soak on the surface for one-half to two minutes.
- (c) Rub the surface with a clean cotton wiper, G00034 that is soaked with water.
- (d) Remove the detergent with a sponge, G00116 that is moist with water.



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WARNING: DO NOT GET THE SOLVENT IN YOUR MOUTH, EYES, OR ON YOUR SKIN.
DO NOT BREATHE THE FUMES FROM IT. PUT ON GOGGLES, AND GLOVES WHEN YOU USE IT. KEEP IT AWAY FROM SPARKS, FLAMES, AND HEAT. IT IS POISONOUS AND FLAMMABLE. THE SOLVENT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT USE MORE THAN IS NECESSARY. MAKE SURE YOU PREVENT THE CONTAMINATION OF THE ADJACENT CLEAN AREAS BY THE FREON. IF YOU USE TOO MUCH FREON, DAMAGE TO PARTS WILL OCCUR.

- (e) Dry the surface with a clean cotton wiper, G00034.

NOTE: Rub the surface in a straight line movement. If the area is still dirty, do the steps that follow:

- 1) Rub the area with a cotton wiper, G00034 that is moist with solvent, B00081.
- 2) After the surface looks fully clean, remove the solvent, B00081 with a mixed detergent.

SUBTASK 25-00-00-160-027

- (2) To clean aluminum with a usual procedure do these steps:

- (a) Apply mixed detergent to the surface with a sponge, G00116 or a spray hand spray bottle, STD-4048.
- (b) Let it soak on the surface for one-half to two minutes.
- (c) Rub the surface with a cotton wiper, G00034 that is moist with water.
- (d) Remove the detergent with a clean cotton wiper, G00034 that is soaked with water.
- (e) Dry the surface with a clean dry cotton wiper, G00034.

SUBTASK 25-00-00-160-028

- (3) To clean stainless steel, do these steps:

- (a) Do the procedure given for opaque plastic or painted surfaces to clean the stainless steel; then polish the stainless steel with the following steps:
 - 1) Use a cotton wiper, G00034 to apply polish to a small area.
NOTE: Use Met-All polish, B00700 for highly-polished surfaces and satin finishes.
 - 2) Rub the area until the polish becomes black.
 - 3) Rub the surface with a clean, dry cotton wiper, G00034 until the rubbed area looks bright and continuous.
 - 4) Remove the remaining polish with a mixed detergent.

Q. Clean the Air Grill Panels

SUBTASK 25-00-00-160-029

- (1) Use a vacuum cleaner tool set, COM-2477 to clean the air grill panels.

———— END OF TASK ————

TASK 25-00-00-370-801

3. Equipment/Furnishings - Painting

(Figure 701)

A. General

- (1) It is necessary to paint the equipment when the surface finish is damaged.
- (2) Apply the paint with a paint sprayer, a hand brush, or an air brush.

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- (3) Apply a surface finish that is equivalent to the initial surface finish.
- (4) There should be no visual difference between the initial surface finish and the new surface finish.
- (5) The procedures that follow are divided into groups of decorative surfaces which you will be painting. These groups are Tedlar, polycarbonate (Lexan), ULTEM, and Declar.
NOTE: Only paint the components that were previously painted by design intent and production drawing.
NOTE: Unless the interior component was previously painted by design, painting is limited to 100 sq. in. for repair and touch up purposes only.
- (6) Fully mix the paint before you use it. It is better to use a mechanical mixer. Do not shake the water emulsion paint too much, because air bubbles will occur.
- (7) Mix the paint to the correct consistency before you spray it. Do not mix thinners from different vendors.
- (8) Keep the air clean. Dirt or lint can contaminate the paint before it is dry.
- (9) The color of the paint must be the same as the old paint or you will see an outline. Use paint with high-grade commercial standards.

B. References

Reference	Title
20-30-98-910-801	Cleaning of Specific Polymerics (Series 98) (P/B 201)

C. Consumable Materials

Reference	Description	Specification
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00157	Cleaner - Detergent - Spraywhite E	
B00158	Cleaner - Clean Quick Broad Range Quaternary Sanitizer	
B00159	Cleaner - Detergent - Glo Do-All Formula 3B	
B00161	Cleaner - Detergent - Orvus W. A. paste	
B00294	Cleaner - Detergent - Glo Do-All Formula 1D	
B01018	Solvent - Cleaning Of Specific Polymerics (AMM 20-30-98/201) - Series 98	
B50117	Detergent - General	
C00039	Primer - Interior Decorative Urethane, White	BMS10-83 Type I
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83 Type II
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83 Type III
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02408	Abrasive - Paper, #50 to #400 grit	

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D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Procedure

SUBTASK 25-00-00-110-006

WARNING: OBEY THE AIRLINE POLICY, LOCAL HEALTH DEPARTMENT, AND LAW ENFORCEMENT REGULATIONS WHEN YOU DISCARD THIS MATERIAL. OBEY THESE INSTRUCTIONS TO PREVENT INJURIES TO PERSONNEL.

WARNING: OBEY ALL OF THE WARNINGS AND CAUTIONS IN THE REFERENCED PROCEDURE. IF YOU DO NOT OBEY THE WARNINGS AND CAUTIONS, INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

WARNING: DO NOT GET THESE MATERIALS IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THESE MATERIALS. PUT ON A RESPIRATOR, GOGGLES, AND GLOVES WHEN YOU USE THESE MATERIALS. KEEP THESE MATERIALS AWAY FROM SPARKS, FLAME, AND HEAT. THESE MATERIALS ARE POISONOUS AND FLAMMABLE. THEY CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Use these consumable materials:

- (a) alcohol, B00130
- (b) solvent, B00148
- (c) primer, C00039
- (d) coating, C00040
- (e) coating, C00923
- (f) compound, D00147
- (g) Scotch Flatback Masking Tape 250, G00270
- (h) #50 to #400 grit abrasive paper, G02408

NOTE: The minimum grit number to be used is 180 grit.

SUBTASK 25-00-00-110-007

- (2) Use these detergents:

- (a) Spraywhite E cleaner, B00157
- (b) Clean Quick sanitizer, B00158
- (c) Glo Do-All Formula 1D cleaner, B00294
- (d) Glo Do-All Formula 3B cleaner, B00159
- (e) Orvus WA paste cleaner, B00161

SUBTASK 25-00-00-170-001

- (3) Use the following steps to paint the Tedlar surfaces:



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CAUTION: DO NOT KEEP THE SOLVENTS ON THE PLASTICS FOR TOO MUCH TIME. IF THE SOLVENTS STAY ON THE PLASTICS FOR TOO MUCH TIME, DAMAGE TO THE PLASTICS WILL OCCUR.

- (a) Rub the surface with a cotton wiper, G00034 that is moist with Series 98 solvent, B01018 (TASK 20-30-98-910-801).
- (b) Dry the surface with a clean dry cotton wiper, G00034 before the solvent becomes dry.
- (c) Apply Scotch Flatback Masking Tape 250, G00270 to the adjacent surfaces.
- (d) Apply primer, C00039 to the area you will paint.

SUBTASK 25-00-00-170-002

- (4) Prepare to paint the polycarbonate (Lexan) surfaces using the following steps:
 - (a) Clean the surface with a cotton wiper, G00034 that is moist with a mixed detergent.
 - (b) Rub the surface lightly with a 180 grit abrasive cloth, B00102 to remove gloss.
 - (c) Clean the surface with a clean cotton wiper, G00034 that is moist with the mixed detergent.

SUBTASK 25-00-00-210-001

- (5) Examine the surface for porosity and voids. If you find surface porosity and voids, do these steps:
 - (a) Put putty on a clean cotton wiper, G00034 at package consistency.
 - (b) Rub the surface with a cotton wiper, G00034 to push the putty into surface defects.
 - (c) Let the putty dry for 3/4 to one hour.
 - (d) Remove the unwanted putty with abrasive cloth, B00102.
 - (e) Clean the surface with a cotton wiper, G00034 that is moist with mixed detergent.

SUBTASK 25-00-00-370-001

CAUTION: YOU MUST USE THE CORRECT PRIMER BEFORE YOU PAINT THE POLYCARBONATE SURFACES. IF YOU DO NOT USE THE CORRECT PRIMER, THE SOLVENTS IN THE PAINT CAN CAUSE DAMAGE TO THE POLYCARBONATE.

- (6) Apply primer, C00039 to the surface of the part you want to paint.

SUBTASK 25-00-00-110-008

- (7) Use the following steps to prepare to paint the ULTEM and Declar surfaces:
 - (a) Clean the surface of the part with cotton wiper, G00034 that is moist with a mixed general detergent, B50117 or alcohol, B00130
 - 1) If you use alcohol, wipe the surface dry quickly. Do not let the alcohol dry first.
 - (b) Dry the surface with a clean dry cotton wiper, G00034.
 - (c) Examine the surface for porosity or voids. If you find surface porosity or voids, refer to the steps given before to repair the surfaces of polycarbonate materials.
 - (d) Clean the surface of the part again with cotton wiper, G00034 that is moist with mixed general detergent, B50117 or alcohol, B00130.
 - 1) If you use alcohol, wipe the surface dry quickly. Do not let the alcohol dry first.

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- (e) Dry the surface with a clean dry cotton wiper, G00034.

F. Prepare to Paint the Tedlar, Polycarbonate, ULTEM, and Declar Surfaces

SUBTASK 25-00-00-370-002

- (1) Mix the coating, C00923

- (a) Use the manufacturer's instructions to mix paint.

SUBTASK 25-00-00-370-003

- (2) Apply several cross-layers of paint until the color agrees with the adjacent areas.

SUBTASK 25-00-00-370-004

- (3) Remove the Scotch Flatback Masking Tape 250, G00270 if it is applicable.

SUBTASK 25-00-00-370-005

- (4) Let the first layer of paint cure for two hours at 70°F (21°C) to 80°F (27°C) before you touch it.

SUBTASK 25-00-00-370-006

- (5) Let the first layer cure for one hour before you apply a texture coat.

SUBTASK 25-00-00-370-007

- (6) If it is necessary, apply a texture layer of the same paint (do not make it thin).

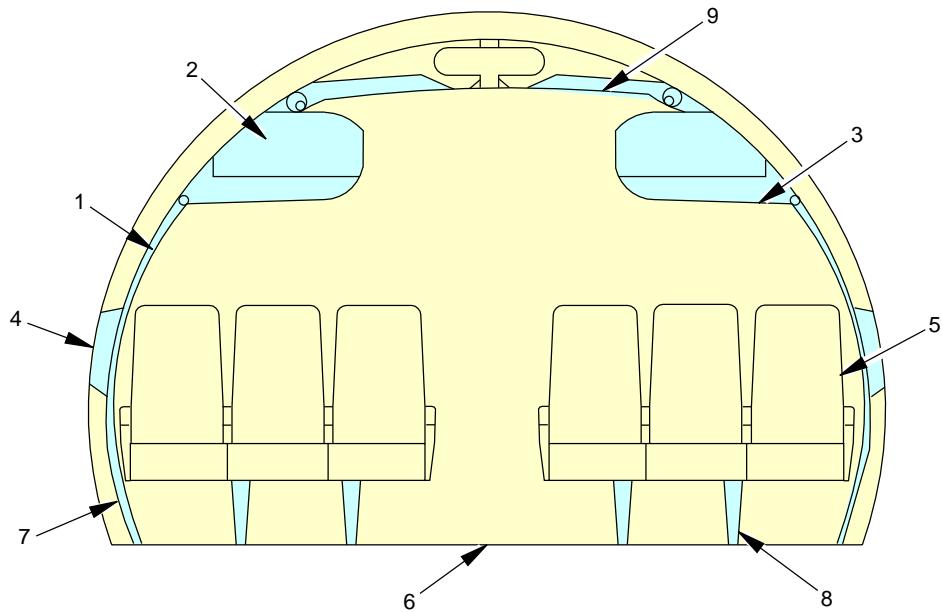
SUBTASK 25-00-00-370-008

- (7) Let it dry for three hours before you touch it.

———— END OF TASK ————

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1. SIDEWALL PANELS - DECORATIVE TEDLAR COVERED CRUSHED CORE
2. STOWAGE BINS - DECORATIVE TEDLAR COVERED HONEYCOMB
3. PASSENGER SERVICE UNITS (PSUs) - TEDLAR CLAD ALUMINUM
4. WINDOW REVEALS - POLYCARBONATE
DUST COVER - HARD COATED POLYCARBONATE
SHADE - TEDLAR COVERED POLYCARBONATE
5. SEAT UPHOLSTERY - 100% WOOL OR 90% WOOL AND 10% NYLON
6. CARPETS - 100% WOOL FACE PILE
UNDERLAY - NOMEX PAD BMS 8-242
7. RISER PANEL FACING - 100% WOOL FABRIC
8. SEAT TRACK COVERS - POLYURETHANE
SEAT TRACKS - ALUMINUM ALLOY
9. CEILING PANELS - DECORATIVE TEDLAR COVERED CRUSHED CORE

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737-700 Advanced Technology Interior Material Identification
Figure 701/25-00-00-990-801

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TASK 25-00-00-100-802

4. Clean the Leather or Haugahyde - Cleaning/Painting

A. General

- (1) This task is for COC task card purposes.

B. Consumable Materials

Reference	Description	Specification
B00081	Solvent - Trichloroethylene	BMS11-6
B00460	Cleaner - Multi-Purpose - Winsol APC-120-WX	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Clean the Leather or Naugahyde.

SUBTASK 25-00-00-160-041

- (1) To clean a small area on the surface, do these steps:

- (a) Remove water based stains with a mixed detergent.

NOTE: Refer to the paragraph below for regular cleaning instructions.

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WHEN YOU USE IT. KEEP IT AWAY FROM SPARKS, FLAMES, AND HEAT. IT
IS POISONOUS AND FLAMMABLE. THE SOLVENT CAN CAUSE INJURIES TO
PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (b) Rub oil-based stains with a cotton wiper, G00034 wiper that is moist with solvent, B00081.
- (c) Then use a mixed detergent to clean the area.

SUBTASK 25-00-00-160-042

- (2) To clean by the usual procedure do these steps:

- (a) Mix one part of Winsol APC-120-WX cleaner, B00460 to 32 parts of water.
- (b) Apply only the foam to the leather or naugahyde with a clean cotton wiper, G00034. Rub carefully in a circular movement.
- (c) Remove the detergent with a clean cotton wiper, G00034 that is moist with water.
- (d) Rub the surface with a dry soft cotton wiper, G00034.

———— END OF TASK ————



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EQUIPMENT/FURNISHINGS - REPAIRS

1. General

- A. This procedure contains these tasks:
- (1) Crushed-Core and Sandwich Panel Repair,
 - (2) Decorative Surface Repair,
 - (3) Decorative tedlar removal/installation
 - (4) Repair for Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover,
 - (5) Repair for Tedlar Covers of Aluminum Laminates,
 - (6) Perforated Panel Repair,
 - (7) Repair for Polycarbonate (Lexan), Ultem, and Declar Plastics,
 - (8) Urethane Foam Repair,
 - (9) Aluminum trim

TASK 25-00-00-300-801

2. Crushed-Core and Sandwich Panel Repair

A. General

- (1) This procedure gives instructions to repair crushed-core and sandwich panels that have these types of damage:
- (a) Small scratches and dents
 - (b) Large dents in thin crushed-core panels
 - (c) Small holes and gouges
 - (d) Damage that is more than 0.5 in² (3.2 cm²) but has no core damage
 - (e) Damage that is more than 0.5 in² (3.2 cm²) with core damage

B. References

Reference	Title
20-10-27-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-10679	Hole Saw Part #: A32091-1920 Supplier: 81205
STD-442	Gun - Heat, 180° F (82° C) Maximum Output Temperature
STD-552	Knife - Utility

D. Consumable Materials

Reference	Description	Specification
A01021	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (12-25 Min Gel)	BMS5-28 Type 18
B00102	Abrasive - Aluminum Oxide Coated Cloth	

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Reference	Description	Specification
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00316	Fabric - Woven Glass Reinforcements For Laminating Plastics	BMS9-3
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	
G50077	Abrasive - Aluminum Oxide Paper, 240 grit or finer	
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Small Scratch and Dent Repair

SUBTASK 25-00-00-350-001

- (1) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must apply a foil-backed decorative laminate over the repair. Refer to the Decorative Surface Repair, TASK 25-00-00-300-802.
- (2) Use this process to repair panels that have damage that does not go into the fiberglass or carbon skins.
- (3) For panels that are 0.25 in. (6.35 mm) thick or more, use this procedure to repair scratches and small surface dents that are not more than 0.1 in. (2.5 mm) deep.
- (4) For panels that are less than 0.25 in. (6.35 mm) thick, use this repair procedure to repair scratches and small surface dents that are not more than 0.005 in. (0.127 mm) deep.
- (5) Fill the damaged area with compound, D00147 to make a crown above the adjacent areas.

SUBTASK 25-00-00-350-002

- (6) After the filler is hard, rub it with abrasive cloth, B00102 (400 to 600 grit) to the same level as the surface of the panel.

SUBTASK 25-00-00-350-003

- (7) If this is a decorative panel, do this task: Decorative Surface Repair, TASK 25-00-00-300-802.

G. Large Dent Repair for Crushed-Core Panels

SUBTASK 25-00-00-350-004

- (1) This procedure is for panels less than 0.25 in. (6.35 mm) thick with dents that are more than 0.005 in. (0.127 mm) deep.



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CAUTION: BE CAREFUL WHEN YOU APPLY HEAT NEAR MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR MUST NEVER BE MORE THAN 200° F OR THE TEMPERATURE AT WHICH THE TEDLAR DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR.

- (2) On the side that does not have dents, increase the temperature of the panel.
 - (a) Use a standard heat 180° F (82° C) maximum output temperature heat gun, STD-442 until the panel is approximately 200°F (93°C).

NOTE: The area of the panel will get more flexible, and very hot. Refer to TASK 20-10-27-910-801 for cautions to obey when you use heat guns.

SUBTASK 25-00-00-350-005

- (3) Push the backside of the panel forward with the round surface of a tool to remove as much of the dent as you can.

SUBTASK 25-00-00-350-006

- (4) After the panel is cool do the process to remove small scratches and dents, if it is necessary.

H. Small Hole and Gouge Repair

SUBTASK 25-00-00-350-007

- (1) This repair is for:
 - (a) Damage that is less than 0.5 in² (3.2 cm²) and goes through the face sheets.
 - (b) Core damage that is less than 0.5 in² (3.2 cm²).
- (2) Remove loose and broken pieces, contamination, and other unwanted material from the damaged area.
 - (a) Use 240 grit or finer abrasive paper, G50077 and a utility knife, STD-552.

SUBTASK 25-00-00-160-030

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Clean the area with a cotton wiper, G00034 that is soaked with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-031

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-001

- (5) Fill the hole with the compound, A01021.

SUBTASK 25-00-00-280-001

- (6) Let the compound cure for 7 days at 77 ±2°F (25 ±1°C), or 5 hours at 125 ±10°F (52 ±6°C).

SUBTASK 25-00-00-300-001

- (7) If it is a decorative panel, do this task: Decorative Surface Repair, TASK 25-00-00-300-802.

I. Repair for Panels with No Core Damage

SUBTASK 25-00-00-020-001

- (1) Use this procedure to repair panels that have more than 0.5 in. (12.7 mm) damage but no core damage.
- (2) Remove the damaged part of the panel skin.

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SUBTASK 25-00-00-120-002

- (3) Rub the area and two inches more on all the sides of the area with abrasive cloth, B00102 (400 to 600 grit) until the area is not glossy.

SUBTASK 25-00-00-160-032

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) Clean the area with a cotton wiper, G00034 that is soaked with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-033

- (5) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-002

- (6) Follow the manufacturer's instructions to mix the resin, G50400.

SUBTASK 25-00-00-340-003

- (7) Apply fabric, G00316 that is soaked with the mixed adhesive and make an overlap of approximately 0.5 in. (12.7 mm).

NOTE: Use 50% more glass fabric than the initial skin.

SUBTASK 25-00-00-340-004

- (8) Let the fabric, G00316 and adhesive cure for 24 to 36 hours at 75°F (24°C) to 90°F (32°C), or for 3 to 4 hours at 140°F (60°C) to 160°F (71°C).

SUBTASK 25-00-00-350-008

- (9) If this is a decorative panel, do this task: Decorative Surface Repair, TASK 25-00-00-300-802.

J. Repair for Panels with Core Damage

SUBTASK 25-00-00-020-002

- (1) Use this procedure to repair panels that have more than 0.5 in. (12.7 mm) of damage and damaged core
- (2) Remove the damaged skin until you can see at least 0.5 in. (12.7 mm) of core that does not have damage.

SUBTASK 25-00-00-020-003

- (3) Remove the damaged part of the core.
 - (a) Make sure 0.5 in. (12.7 mm) of core without damage is shown on all sides of the damaged area.

SUBTASK 25-00-00-160-034

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) Clean the area with a cotton wiper, G00034 soaked with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-035

- (5) Dry the area with a clean cotton wiper, G00034.

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SUBTASK 25-00-00-350-009

- (6) Use the manufacturer's instructions to mix the compound, A01021.

SUBTASK 25-00-00-350-010

- (7) Fill the damaged area with the adhesive mixture.

SUBTASK 25-00-00-350-011

- (8) Let the repair cure for 3 hours at 75°F (24°C).

SUBTASK 25-00-00-350-012

- (9) Repair the skin with the steps given for panels that do not have core damage.

K. Potted Insert Repair

SUBTASK 25-00-00-020-004

- (1) Remove the damaged skin and approximately 0.5 in. (12.7 mm) more on all sides of the damage.

SUBTASK 25-00-00-160-036

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- (2) Clean the area with a cotton wiper, G00034 that is soaked with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-037

- (3) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-280-002

- (4) Cut around the insert from the backside of the panel with a hole saw, SPL-10679 or an equivalent tool.

NOTE: Be careful not to cut the front side of the panel.

SUBTASK 25-00-00-280-003

CAUTION: BE CAREFUL WHEN YOU APPLY HEAT NEAR MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR MUST NOT BE MORE THAN 200° F (93.3° C) OR THE TEMPERATURE AT WHICH THE TEDLAR DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR.

- (5) Carefully increase the temperature of the insert until you can remove the insert from the panel.

SUBTASK 25-00-00-340-005

- (6) Use the manufacturer's instructions to mix the compound, A01021.

SUBTASK 25-00-00-340-006

- (7) Fill the hole with the adhesive mixture.

SUBTASK 25-00-00-340-007

- (8) Push the new insert slowly into the mixture.

(a) Let the mixture flow around the insert and completely fill the hole.

SUBTASK 25-00-00-340-008

- (9) Let the adhesive mixture cure at 75°F (24°C) for 3 hours.

SUBTASK 25-00-00-300-002

- (10) Repair the skin with the procedure given for panels that do not have core damage.

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L. Bassinet Fitting Repair

SUBTASK 25-00-00-340-009

- (1) Fully remove the old epoxy material.

SUBTASK 25-00-00-340-010

- (2) Remove some material from under the top skin.

SUBTASK 25-00-00-340-011

- (3) Use the manufacturer's instructions to mix the compound, A01021.

SUBTASK 25-00-00-340-012

- (4) Fill the hole with the adhesive mixture.

SUBTASK 25-00-00-340-013

- (5) Apply Permacel P-255 tape, G02480 to make a cover on the end of the hole in the bassinet fitting.

SUBTASK 25-00-00-340-014

- (6) Slowly push the fitting in the hole.

SUBTASK 25-00-00-340-015

- (7) Remove the unwanted adhesive that comes out when you push the insert in the hole.

SUBTASK 25-00-00-340-016

- (8) Let the adhesive cure for 3 hours minimum.

———— END OF TASK ————

TASK 25-00-00-300-802

3. Decorative Surface Repair

A. General

- (1) This task contains instructions to repair painted or Tedlar laminate surfaces that have small scratches, small holes, and gouges.

- (2) This task has these repairs:

- A repair of small scratches and unwanted marks.
- A repair of the pattern on the tedlar laminate.
- A repair of small holes and gouges.
- Application of decorative tedlar laminate - non-acoustical (non-adhesive-back).
- Application of decorative tedlar laminate with a pressure sensitive adhesive (adhesive-back).

NOTE: This is the preferred repair when tedlar material will be applied inside the airplane.

- (3) The area for repair of decorative surfaces must be smaller than 100 square inches. If the area is larger than 100 in² (645 cm²), you must replace the part.

B. References

Reference	Title
20-10-27-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

Reference	Description
STD-442	Gun - Heat, 180° F (82° C) Maximum Output Temperature

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Reference	Description
STD-1080	Brush - Paint
STD-1089	Source - Vacuum, 0 to -3.00 PSIG
STD-1133	Gun - Spray, Paint, with Interchangable Nozzles
STD-1205	Wheel - Buffer, Cotton Cloth, 80/92 Thread Count, Spiral Sewn, 6 Inch Diameter, 7/8 Inch Thick, 1/4 Inch Arbor Hole
STD-6639	Vacuum Source, 10-30 Inches of Mercury (absolute)

D. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II
B00026	Compound - Buffing - Learok 119	
B00027	Compound - Buffing - Learok 884E (Formerly Learock 888)	
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00063	Ink - Screen Printing, Pigmented	BMS10-73 Type I
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G02022	Rubber - Silicone Casting - RTV B	
G02310	Ink - Water-Based, Screen Printing	BMS10-107
G02446	Laminate - Tedlar	BAC5596 Type 13

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Small Scratch and Unwanted Mark Repair

SUBTASK 25-00-00-120-003

- (1) The repair depth cannot be larger than 0.10 in. (2.5 mm) in a Tedlar laminate covered panel that is 0.25 in. (6.35 mm) thick or more, or 0.005 in. (0.127 mm) deep in a panel that is less than 0.25 in. (6.35 mm) thick.
- (2) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must replace the full decorative tedlar part Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801.

CAUTION: DO NOT RUB THROUGH THE TEDLAR WHEN YOU REPAIR THE SMALL SCRATCHES OR UNWANTED MARKS. YOU WILL CAUSE MORE EXPENSIVE REPAIRS TO BE NECESSARY IF YOU RUB THROUGH THE TEDLAR.

- (3) Rub the surface lightly with abrasive cloth, B00102 paper (400 to 600 grit) until the area is not rough.

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SUBTASK 25-00-00-340-017

- (4) Polish the damaged area with the buffing cotton cloth buffer wheel, STD-1205 until the area is as glossy as the adjacent areas.
 - (a) Use buffing Learok 119 compound, B00026 or buffing Learok 884E compound, B00027.

G. Tedlar Pattern Repair

SUBTASK 25-00-00-370-009

- (1) Apply ink, C00063 or ink, C00368 of the correct color.
 - (a) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-370-010

- (2) To reduce the gloss of the silk screen ink, lightly apply a clear acrylic with a spray paint spray gun with interchangeable nozzles, STD-1133.

H. Small Hole and Gouge Repair

SUBTASK 25-00-00-340-018

- (1) Apply compound, D00147 to the area with damage.

NOTE: Apply more filler than is necessary to make sure the gouge is fully filled. You will remove the unwanted filler in the subsequent steps.

SUBTASK 25-00-00-340-019

CAUTION: DO NOT RUB THROUGH THE TEDLAR THAT IS NOT DAMAGED. IF YOU REMOVE TEDLAR THAT DOES NOT HAVE DAMAGE, MORE REPAIR WORK IS NECESSARY.

- (2) When the filler is hard, rub the area with abrasive cloth, B00102 paper (240 to 320 grit) until the filler is level with the adjacent surfaces.

SUBTASK 25-00-00-340-020

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Use these steps to make a silicone embossing pad of the surface that is adjacent to the area you will repair.
 - (a) Clean the surface with a clean cotton wiper, G00034 soaked with Butyl Carbitol solvent, B01027.
 - (b) Dry the surface with a clean cotton wiper, G00034.
 - (c) Make a frame approximately $\frac{3}{8}$ in. (10 mm) wide by $\frac{1}{2}$ in. (13 mm) high, around the clean surface.
 - 1) Use wood, clay, or high temperature vacuum sealant tape for the frame.
 - (d) Apply a thin level of prepared silicone rubber on the textured surface in the frame with a brush.
 - 1) Apply a thin layer of the prepared silicone RTV B rubber, G02022on the textured surface in the frame with a paint brush, STD-1080.

NOTE: Almost all brands, types, or colors of castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Prepare the silicone rubber with the manufacturer's instructions.

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Continue to use the brush until you cannot see air bubbles.

- (e) Pour the remaining silicone RTV B rubber, G02022 on the brushed surface until it is $\frac{1}{4}$ in. (6 mm) thick.

NOTE: One pound of prepared silicone rubber will make a 10 in. (25 cm) by 10 in. (25 cm) by $\frac{1}{4}$ in. (6 mm) replica.

- 1) Let the silicone cure at room temperature for 48 hours.

- (f) When the silicone is dry, remove the embossed pad from the surface.

SUBTASK 25-00-00-370-011

- (4) Apply ink, G02310 or ink, C00368 of the correct color to the repair surface.
(a) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-340-021

- (5) Apply the silicone embossing pad to the repaired surface.

SUBTASK 25-00-00-340-022

- (6) Use a vacuum source, STD-6639 to apply a vacuum of approximately 10 in. (25 cm) of mercury at 160°F (71°C).

SUBTASK 25-00-00-340-023

- (7) If the above procedure is not satisfactory, replace the decorative laminate. Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801.

I. Apply Decorative Tedlar Laminate - Non-Acoustical (Non-adhesive-back)

NOTE: If it is necessary, repair the panel before you apply the tedlar.

SUBTASK 25-00-00-020-005

- (1) Remove the trim strips from the panel.

SUBTASK 25-00-00-120-004

- (2) Rub the area with abrasive cloth, B00102 paper where you will apply the adhesive.

SUBTASK 25-00-00-160-038

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- (3) Clean the area with a cotton wiper, G00034 that is moist with Butyl Carbitol solvent, B01027 or solvent, B00148.

SUBTASK 25-00-00-160-039

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-024

- (5) Mix sixteen parts adhesive (by volume) with one part curing agent of adhesive, A00555.

- (a) Let the mixture set for two minutes.



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SUBTASK 25-00-00-340-025

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- (6) If you want to spray the adhesive mixture, mix (by volume) one part adhesive mixture with one part solvent, B00148.

SUBTASK 25-00-00-340-026

- (7) Carefully spray the mixture with a paint spray gun with interchangeable nozzles, STD-1133 or apply the mixture with a brush.
 - (a) Let the surface dry at room temperature for a minimum of two hours.

NOTE: The surface must be fully dry before you install the tedlar laminate. If you install the tedlar to a wet surface, you will not get a satisfactory bond.

SUBTASK 25-00-00-210-002

CAUTION: MAKE SURE THE DECORATIVE TEDLAR LAMINATE HAS THE CORRECT COLOR AND PATTERN. THE REPAIR WILL NOT BE SATISFACTORY IF THE NEW TEDLAR DOES NOT MATCH THE ORIGINAL SURFACE.

- (8) Put the decorative Tedlar laminate, G02446 in position.

NOTE: Use the masking tape to hold the decorative Tedlar laminate in the correct position.

SUBTASK 25-00-00-880-001

CAUTION: BE CAREFUL WHEN YOU APPLY HEAT NEAR MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR MUST NOT BE MORE THAN 200° F (93.3°C) OR NOT MORE THAN THE TEMPERATURE AT WHICH THE TEDLAR DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR.

- (9) Use a heat 180° F (82° C) maximum output temperature heat gun, STD-442 to reactivate the adhesive.

NOTE: Make sure the temperature is constant across the surface of the laminate. Refer to TASK 20-10-27-910-801 for cautions to obey when you use the heat guns.

NOTE: These steps are recommended to achieve a better adhesion.

SUBTASK 25-00-00-340-027

- (10) Use a vacuum source (0 to -3 PSIG), STD-1089 to make sure the laminate touches all of the panel:

NOTE: These steps are recommended to achieve a better repair. They are not required.

- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Cure the laminate for 24 hours at room temperature, or for two hours at 120°F (49°C), or for 30 minutes at 180°F (82°C).
- (c) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

J. Apply Decorative Tedlar Laminate with a Pressure Sensitive Adhesive (adhesive-back)

NOTE: Use this procedure to apply laminate to non-acoustical (not perforated) panels with flat or simple contours. If it is necessary, repair the panel before you apply the tedlar.

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SUBTASK 25-00-00-020-006

- (1) Remove the trim strips from the panel.

SUBTASK 25-00-00-340-028

- (2) Rub the area where you will apply the Tedlar laminate with abrasive cloth, B00102 to remove the surface contamination.

SUBTASK 25-00-00-110-010

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Clean the area with a cotton wiper, G00034 that is soaked with Butyl Carbitol solvent, B01027 or solvent, B00148.

SUBTASK 25-00-00-110-011

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-020-007

- (5) Remove the release paper from the laminate you want to apply.

SUBTASK 25-00-00-420-001

- (6) Apply the laminate.

NOTE: Make sure the pattern is in the correct position. If the patterns are not aligned, the repair will not look satisfactory.

NOTE: Bubbles will result if you allow air to get below the laminate.

SUBTASK 25-00-00-880-002

CAUTION: BE CAREFUL WHEN YOU APPLY HEAT NEAR MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR MUST NOT BE MORE THAN 200° F (93.3°C) OR MORE THAN THE TEMPERATURE AT WHICH THE TEDLAR DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT WILL CAUSE DAMAGE TO THE TEDLAR.

- (7) Use a heat 180° F (82° C) maximum output temperature heat gun, STD-442 to increase the temperature of the tedlar laminate.

NOTE: Make sure the temperature remains constant across the surface of the laminate. Refer to (TASK 20-10-27-910-801) for cautions to obey when you use heat guns.

SUBTASK 25-00-00-340-029

- (8) Rub the tedlar laminate until the bond is satisfactory and you cannot see bubbles.

SUBTASK 25-00-00-340-030

- (9) Use a vacuum source (0 to -3 PSIG), STD-1089 to make sure the laminate touches all of the panel:

NOTE: These steps are recommended to achieve a better repair. They are not required.

- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Cure the laminate for 24 hours at room temperature, or for two hours at 120°F (49°C), or for 30 minutes at 180°F (82°C).
- (c) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

— END OF TASK —

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TASK 25-00-00-900-801

4. Decorative Tedlar Removal/Installation

A. General

- (1) This task gives the instructions to replace damaged decorative Tedlar laminate on the honeycomb sandwich panels.

NOTE: If possible, replace the damaged area with the same type of Tedlar material that the damaged area was initially made from.

- (a) To do this repair, it is necessary to replace the damaged laminate.

- (2) This task has these repairs:

- (a) Removal of the decorative Tedlar laminate (non-adhesive-backed)..
(b) Installation of the decorative Tedlar laminate (non-adhesive-backed).
(c) Removal of the decorative Tedlar laminate (pressure sensitive adhesive backed).
(d) Installation of decorative Tedlar laminate (pressure sensitive adhesive backed).

B. References

Reference	Title
20-10-27-910-801	Precautions for Heat Devices (P/B 201)
20-30-98-910-801	Cleaning of Specific Polymerics (Series 98) (P/B 201)

C. Tools/Equipment

Reference	Description
STD-94	Bag - Vacuum
STD-442	Gun - Heat, 180° F (82° C) Maximum Output Temperature
STD-549	Knife - Putty, Broad Blade
STD-745	Roller - Hard Rubber
STD-821	Squeegee - Plastic
STD-1134	Vacuum - Source, 24 Inch Hg Minimum
STD-1181	Gloves - Heat Protective

D. Consumable Materials

Reference	Description	Specification
A50010	Adhesive - Bonding Decorative Laminates	BMS5-127 Type IV
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00130	Alcohol - Isopropyl	TT-I-735
B01018	Solvent - Cleaning Of Specific Polymerics (AMM 20-30-98/201) - Series 98	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
B50005	Solvent - Cleaning - Vertrel MCA	BAC5402
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G02316	Material - Foil-Backed Laminate, Flexible	BAC5596 Type 14
G02446	Laminate - Tedlar	BAC5596 Type 13

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Reference	Description	Specification
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G51199	Material - Double Flexible Decorative Laminate	BAC5596 Type VIA
G51343	Sleeve - Felt, Low-Friction (FS-4)	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Removal of the Decorative Tedlar Laminate (non-adhesive-backed)

SUBTASK 25-00-00-000-001

- (1) Do these steps to remove the decorative laminate, G02446 or decorative laminate, G51199 from the base panel.

NOTE: This repair procedure is best completed after the panel is removed from the airplane.

- (a) Attach the panel safely with the decorative side in the up position.
- (b) Put on the heat protective gloves, STD-1181.
- (c) Use a 180° F (82° C) maximum output temperature heat gun, STD-442 to apply heat to the corner of the panel (TASK 20-10-27-910-801).
NOTE: Do not let the heat collect in one spot for more than 20 seconds.
- (d) Pull at the corner away from the panel to remove the laminate.
- (e) Point the heat gun in front of the area where the laminate continues to be attached to the panel.
 - 1) Keep a constant pressure on the laminate while you pull it from the panel.
 - 2) When the temperature is at the correct level, the laminate will release from the panel.
- (f) Continue this procedure until the laminate is fully removed.

G. Installation of the Decorative Tedlar Laminate (non-adhesive-backed)

SUBTASK 25-00-00-400-001

- (1) Do the following steps to install the decorative laminate, G02446 or the decorative laminate, G51199 to the base panel.
- (a) Prepare the panel surface as follows:
 - 1) Use a broad blade putty knife, STD-549 to remove unwanted adhesive.
 - 2) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.
 - 3) If necessary, use compound, D00147 to fill surface defects.
 - a) Make sure that the filler dries sufficiently.
 - b) Use 180 grit abrasive paper, G50381 to smooth the filler.
 - c) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.



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- (b) Clean the panel surface with a clean cotton wiper, G00034 that is soaked with Series 98 solvent, B01018, (TASK 20-30-98-910-801).
- (c) Apply adhesive, A50010 to panel surface.
- (d) Put the laminate on the panel surface.
 - 1) Align the laminate by the pattern location.

CAUTION: WHEN YOU DO WORK AROUND THE TEDLAR LAMINATE, MAKE SURE THAT YOU DO NOT APPLY MORE THAN 220°F (104°C) OF HEAT TO THE TEDLAR LAMINATE. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR LAMINATE.

- (e) Preheat the laminate to 170°F (77°C) to allow the laminate to form to the panel contours when vacuum is applied.

NOTE: This cycle will have to be determined for each part.

- (f) Use a vacuum bag, STD-94 or vacuum (24 Inch Hg Minimum), STD-1134 to apply 20 in/Hg (68 kPa) vacuum to the panel.

- (g) Use a vacuum with a minimum of 20 in/Hg (68 kPa) to pull the flexible laminate onto the panel surface.

- (h) Let the part cure.

NOTE: For 24 hours at 75 ±15°F (24 ±8°C), for 2 hours at 120°F (49°C), or for 30 minutes at 180°F (82°C).

- (i) Remove the vacuum only when the part cools to 90°F (32°C) or below, or to a temperature that will make sure that the laminate does not delaminate from the panel.

- (j) Remove the unwanted laminate from the edge of the panel.

H. Removal of Decorative Tedlar Laminate (pressure sensitive adhesive backed)

SUBTASK 25-00-00-100-003

- (1) Do these steps to remove the decorative laminate material, G02316, from the interior panel.

- (a) Make sure that the surrounding equipment and components are protected from damage during the removal.

- (b) Remove the components on the interior panel that will keep you from removing the laminate.

- (c) Use a utility knife, to make vertical cuts in the decorative laminate at intervals of 3 in. (8 cm) to 4 in. (10 cm).

NOTE: Make sure that you do not cut into the panel below the laminate.

- (d) Carefully remove the decorative laminate and manually peel the laminate from the panel.

- (e) If necessary, use a broad blade putty knife, STD-549 to remove unwanted adhesive.

NOTE: Make sure that the panel below the laminate is not damaged.

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I. **Decorative Tedlar Installation (pressure sensitive adhesive-backed)**

NOTE: Use this task to apply laminate to non-acoustical (not perforated) panels with flat or simple contours.

SUBTASK 25-00-00-100-002

- (1) Do these steps to install the decorative laminate material, G02316 to the base panel.

- (a) Prepare the panel surface as follows:
 - 1) Use a broad blade putty knife, STD-549 to remove unwanted adhesive.
 - 2) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.
 - 3) If necessary, use compound, D00147 to fill surface defects.
 - a) Make sure that the filler dries sufficiently.
 - b) Use 180 grit abrasive paper, G50381 to smooth the filler.
 - c) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (b) Clean the area with a clean cotton wiper, G00034 that is wet with approved solvent.
 - 1) It is recommended that you use Isopropyl alcohol, B00130 to clean the area.
 - 2) It is acceptable to use these solvents to clean the area:
 - a) Series 98 solvent, B01018.
 - b) Butyl Carbitol solvent, B01027.
 - c) Denatured alcohol, B00068.
 - d) Vertrel MCA solvent, B50005.
- (c) Dry the area with a clean cotton wiper, G00034.
- (d) Do these steps to pre-cut the decorative laminate.
 - 1) Make a template that is larger than the area to be covered with decorative laminate.
NOTE: Make sure that 3 in. (8 cm) to 4 in. (10 cm) of excess remains on the four sides of the template.
 - 2) Use the template to cut the decorative laminate to approximately 3 in. (8 cm) to 4 in. (10 cm) over net trim.
- (e) Do these steps to install the decorative laminate on the panel.
NOTE: For best results, install the decorative laminate in a stable environment at room temperature.
 - 1) Make sure that your hands and tools are free from unwanted debris or contamination.
NOTE: It is recommended that you wear gloves to keep the panel and laminate free of unwanted debris or contamination.
 - 2) Remove the release paper from the first 6 in. (15 cm) of decorative laminate.

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- 3) If necessary, align any watermarks.
 - 4) Make sure that the decorative laminate completely covers the surface of the panel.
 - 5) Install the exposed adhesive to the panel.
 - a) Use a plastic squeegee, STD-821 and a felt sleeve, G51343 to apply firm and even pressure to the surface of the decorative laminate in the area of the adhesive backing.
 - 6) Use two hands to manually remove the release paper from next 4 in. (10 cm) of decorative laminate.
 - 7) Do the previous steps again to install the laminate on the panel.
 - a) Work down the length of the panel to completely install the laminate.
 - b) Make sure that no air bubbles are trapped between the applied laminate and the underlying panel.
 - 8) Use a hard rubber roller, STD-745 to do these steps:
 - a) Manually apply 5 lbf (22 N) to 10 lbf (44 N) while moving the tool over the entire face of the laminate.
 - <1> Apply the correct force in the recommended direction.
 - <2> If air bubbles are seen when you use the roller, then remove and replace the decorative laminate.
 - <3> If a crackling sound is heard when you use the roller, then remove and replace the decorative laminate.
- NOTE: A crackling sound indicates that air bubbles are trapped under the laminate.
- (f) If necessary, do these steps with vacuum pressure to make sure that the laminate touches all of the panel:
 - 1) Use the maximum vacuum possible that will not cause damage to the panel.
- (g) Use a utility knife to remove the unwanted laminate from the edge of the panel.

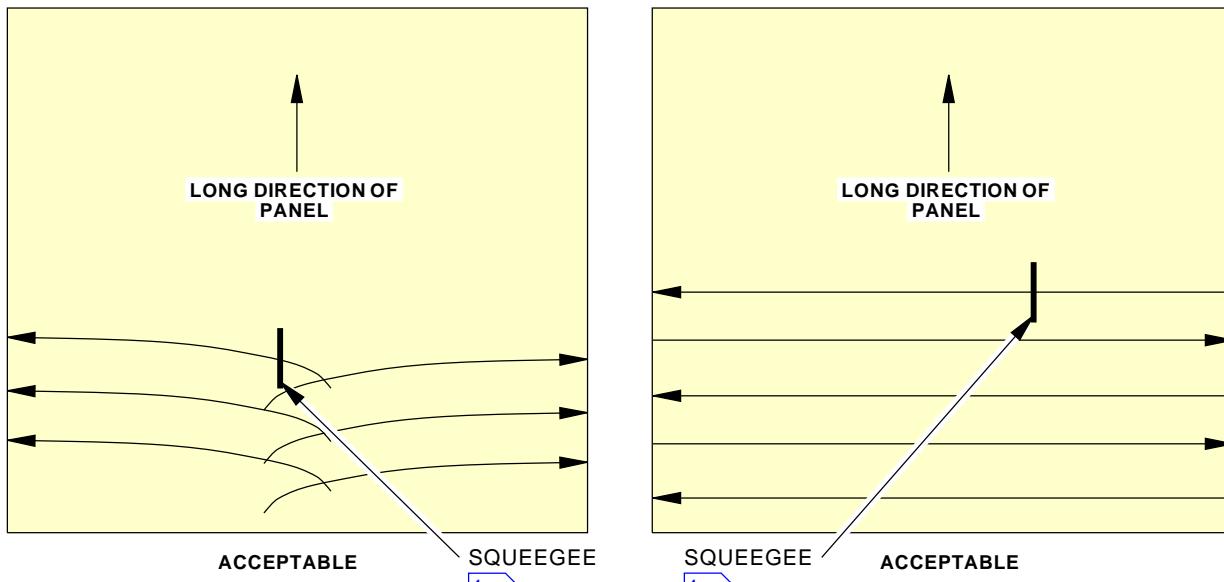
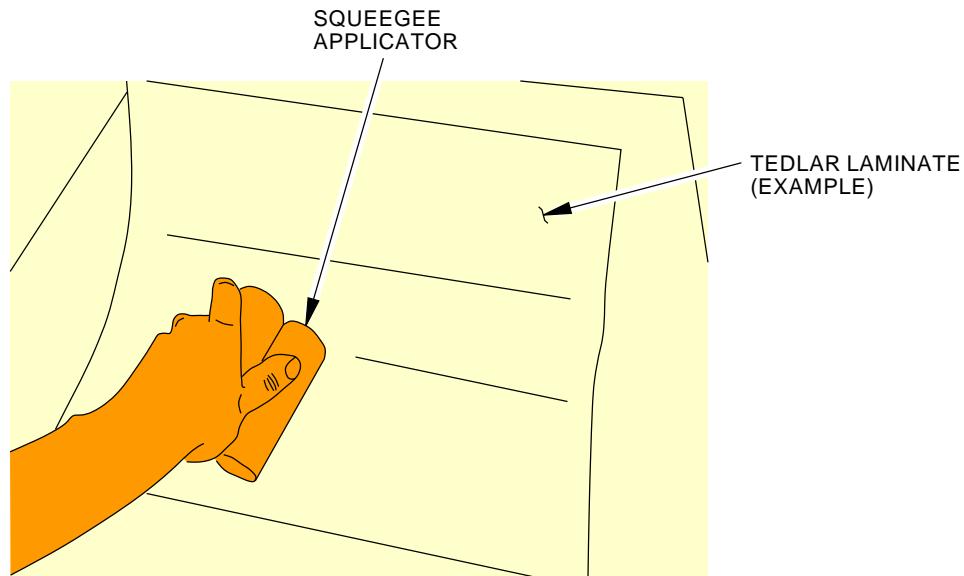
———— END OF TASK ————

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METHODS FOR LAMINATE INSTALLATION

- 1 SQUEEGEE IS HELD PERPENDICULAR
AND IS USED TO SWEEP THE
DECORATIVE LAMINATE INTO PLACE
ALONG LINES INDICATED ABOVE

2475246 S0000580543_V1

Decorative Tedlar Laminate Repair
Figure 801/25-00-00-990-803 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

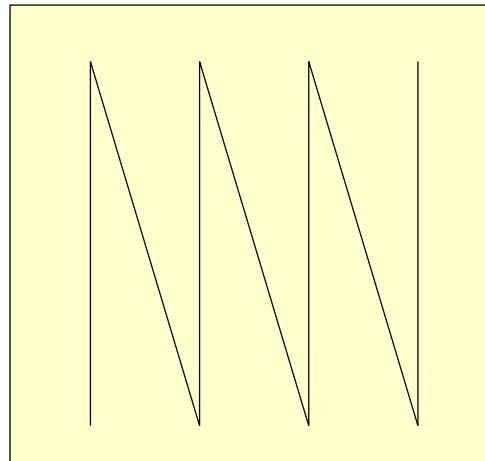
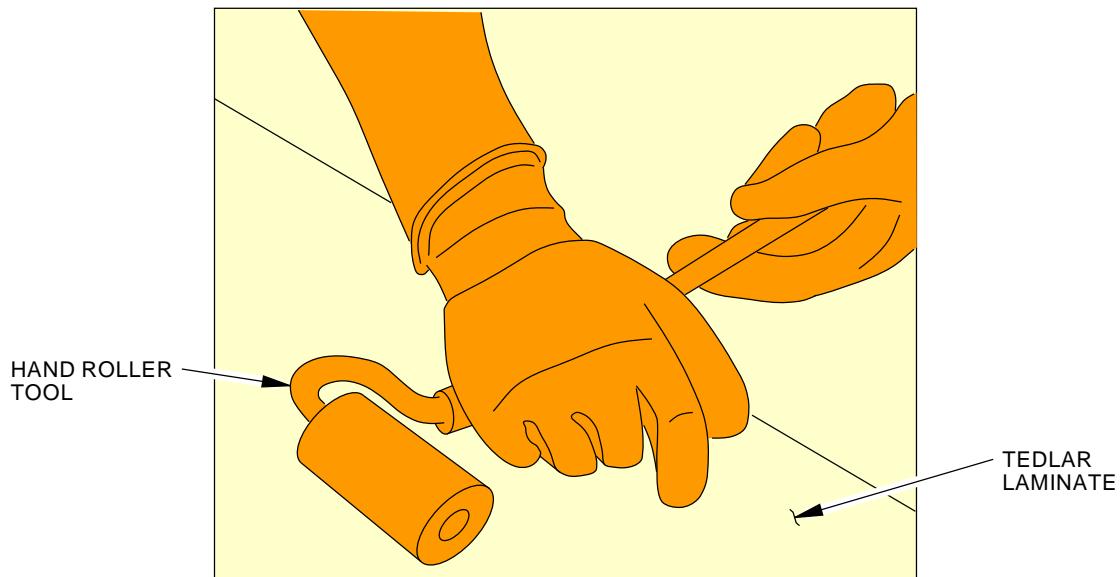
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RECOMMENDED PATTERN
OF FORCE APPLICATION

METHOD FOR LAMINATE INSTALLATION

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Decorative Tedlar Laminate Repair
Figure 801/25-00-00-990-803 (Sheet 2 of 2)

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TASK 25-00-00-300-803

5. Repair for Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover

A. General

- (1) This task gives instructions to repair damage that went through the decorative Tedlar laminate into the honeycomb sandwich panels.
- (2) The area to be repaired must be smaller than 100 square inches (645.16 square cm). If the area to be repaired is larger than 100 square inches (645.16 square cm) you must replace the part.
- (3) The repairs in this procedure are not effective for the panels in the cargo compartment. Refer to CARGO COMPARTMENT LINING - REPAIRS, PAGEBLOCK 25-52-01/801 for the applicable repair.

B. References

Reference	Title
25-52-01 P/B 801	CARGO COMPARTMENT LINING - REPAIRS

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-10679	Hole Saw Part #: A32091-1920 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00273	Adhesive - Epoxy Polyamide, 2 Part, Natural Colored	BMS5-126 Type II Class 1
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00063	Ink - Screen Printing, Pigmented	BMS10-73 Type I
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G01288	Tape - Carpet	BMS5-133
G02022	Rubber - Silicone Casting - RTV B	
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)

E. Location Zones

Zone	Area
200	Upper Half of Fuselage



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F. Repair for Flat Panels or Simple Contoured Panels with Large Radii

SUBTASK 25-00-00-340-031

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Use these steps to make a silicone embossing pad of the surface that is adjacent to the area you will repair:

- (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.
 - (b) Dry the area with a clean cotton wiper, G00034.
 - (c) Make a frame, approximately 3/8-inch (9.5 mm) wide by 1/2-inch (12.7 mm) high, around the clean surface.

NOTE: Use wood, clay, or high temperature vacuum sealant tape for the frame.

- (d) Apply a thin layer of prepared silicone RTV B rubber, G02022 on the textured surface in the frame with a brush.

NOTE: Almost all brands, types, or colors of castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV E, 587, or 93-072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.

- (e) Pour the remaining RTV B rubber, G02022 on the brushed surface until it is 1/4-inch thick.

NOTE: One pound of prepared silicone rubber will make a 10-inch (25.4 cm) by 10-inch (25.4 cm) by 1/4-inch (6.4 mm) replica.

- 1) Let the silicone cure at room temperature for 48 hours.

- (f) When the silicone is dry, remove the embossed pad from the surface.

SUBTASK 25-00-00-340-032

- (2) Attach a template with the correct hole diameter on the damaged area with the carpet tape, G01288.

- (a) Use the hole saw, SPL-10679 to remove the damaged area.

NOTE: Use a guard to make sure you do not cut the aft surface of the panel.

SUBTASK 25-00-00-340-033

- (3) Mix the adhesive, A00273.

NOTE: If the adhesive is a four-component system, do the steps that follow:

- (a) Mix 80 parts (by weight) of Epon 828 or DER 331 with 20 parts (by weight) Heloxy 68 to make component A.
 - (b) Mix 50 parts (by weight) of Versamid 115 with 50 parts (by weight) of Versamid 125 to make component B.
 - (c) Mix equal parts (by weight) of components A and B to make the adhesive mixture.



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SUBTASK 25-00-00-340-034

- (4) Bond a piece of decorative laminate of the correct color, design and texture to a piece of foam with the adhesive mixture.

NOTE: The foam thickness must be the same thickness as the honeycomb core from the damaged area.

- (a) Let the adhesive cure.

SUBTASK 25-00-00-340-035

- (5) Attach a template to a piece of foam with the carpet tape, G01288.

NOTE: The hole diameter of the foam must equal the inner diameter of the cutter.

SUBTASK 25-00-00-340-036

- (6) Cut a repair plug from the piece of foam.

SUBTASK 25-00-00-340-037

- (7) Rub the repair plug with abrasive cloth, B00102 paper (120 to 200 grit) if it is necessary to get a satisfactory fit.

SUBTASK 25-00-00-340-038

- (8) Bond the repair plug in the hole with the adhesive, A00273 mixture.

NOTE: Use the minimum quantity possible to get a satisfactory bond.

SUBTASK 25-00-00-340-039

- (9) Fill the clearance around the repair plug with the adhesive, A00273 mixture.

NOTE: Apply more than is necessary to make sure the clearance is fully filled. The unwanted material is removed in the following step.

SUBTASK 25-00-00-340-040

- (10) Let the adhesive, A00273 mixture cure.

SUBTASK 25-00-00-950-001

- (11) Apply the Scotch Flatback Masking Tape 250, G00270 to the area around the repair.

SUBTASK 25-00-00-340-041

- (12) Rub the area with 240 to 320 grit abrasive cloth, B00102 paper until it is smooth and level with the adjacent surfaces.

SUBTASK 25-00-00-370-012

- (13) Apply ink, C00063 or ink, C00368 of the correct color to match the adjacent area.

- (a) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-340-042

- (14) Apply the silicone embossing pad to the surface you repaired and then apply vacuum pressure (approximately 10 inches (25.4 cm) of Hg).

- (a) Keep this configuration until the surface is cured (15 minutes at 160° F) (71.1°C).

G. Compound Curative Panel Repair

SUBTASK 25-00-00-280-004

- (1) Attach a template with the correct hole diameter on the damaged area with the carpet tape, G01288.

SUBTASK 25-00-00-340-043

- (2) Cut out the damaged area; go through the full thickness of the panel (non-decorative skin too).

- (3) In areas where you cannot use a template, do the steps that follow:



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- (a) Drill a 1/4-inch (6.4 mm) hole through the damaged area.
- (b) Use a hole saw, SPL-10679 with a 1/4-inch (6.4 mm) pilot to remove the damaged area.

SUBTASK 25-00-00-340-044

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- (4) Use these steps to make a silicone embossing pad of the surface that is adjacent to the area you will repair:
 - (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.
 - (b) Dry the area with a clean cotton wiper, G00034.
 - (c) Make a frame, approximately 3/8-inch (9.5 mm) wide by 1/2-inch (12.7 mm) high, around the clean surface.

NOTE: Use wood, clay, or high temperature vacuum sealant tape for the frame.

- (d) Apply a thin layer of prepared silicone RTV B rubber, G02022 on the textured surface in the frame with a brush.

NOTE: Almost all brands, types, or colors of castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV E, 587, or 93-072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.

- (e) Pour the remaining silicone RTV B rubber, G02022 on the brushed surface until it is 1/4-inch (6.4 mm) thick.

NOTE: One pound of prepared silicone rubber will make a 10-inch (25.4 cm) by 10-inch (25.4 cm) by 1/4-inch (6.4 mm) replica.

- 1) Let the silicone cure at room temperature for 48 hours.

- (f) When the silicone is dry, remove the embossed pad from the surface.

SUBTASK 25-00-00-340-045

- (5) Put the silicone embossing pad over the hole in the decorative face of the panel.

SUBTASK 25-00-00-340-046

- (6) Hold the texture blanket in the correct position with weights or a vacuum bag.
- (7) In areas where you cannot use a texture blanket, seal the hole with Scotch Flatback Masking Tape 250, G00270.

SUBTASK 25-00-00-340-047

WARNING: DO NOT GET RESIN, BMS8-201, TYPE IV ADHESIVE IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES. PUT ON PROTECTIVE SPLASH GOGGLES AND GLOVES. RESIN BMS8-201, TYPE IV ADHESIVE CONTAINS EPOXY RESINS WHICH CAN CAUSE INJURY TO PERSONS.

- (8) Fill the hole from the non-decorative side of the panel with resin, G50400.

SUBTASK 25-00-00-340-048

- (9) Let the adhesive cure at room temperature for 24 hours, or at 140° F (60°C) for 2 hours.

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SUBTASK 25-00-00-020-008

- (10) Remove the silicone embossing pad or the tape.

SUBTASK 25-00-00-370-013

- (11) Apply ink, C00063 or ink, C00368 of the correct color.

SUBTASK 25-00-00-370-014

- (12) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-340-049

- (13) Apply the silicone embossing pad to the repaired surface, if it is possible.

- (a) Apply vacuum pressure (approximately 10 inches (25.4 cm) to Hg).

SUBTASK 25-00-00-340-050

- (14) Let the surface cure for about 15 minutes at 160° F (71.1°C) before you remove the embossing pad.

———— END OF TASK ————

TASK 25-00-00-300-804

6. Repair for Tedlar Covers of Aluminum Laminates

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-00-00-300-003

- (1) To repair scratches or small dents (not more than 0.050-inch (12.7 mm) depth), do the repair procedures given for Crushed-Core and Sandwich Panel Repair, TASK 25-00-00-300-801.

———— END OF TASK ————

TASK 25-00-00-300-805

7. Perforated Panel Repair

A. General

- (1) This task gives the instructions to repair damage of not more than 1.5-inches (38.1 mm) in diameter to the following panels:
- (a) A repair of acoustical panels that have damage through the decorative surface and the fiberglass screen.
 - (b) To apply Tedlar laminate to the surface of the acoustical panels.

B. References

Reference	Title
20-10-27-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1474	Generator - Vacuum Part #: ST9999-VBA-201 Supplier: 81205



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(Continued)

Reference	Description
STD-442	Gun - Heat, 180° F (82° C) Maximum Output Temperature
STD-1080	Brush - Paint

D. Consumable Materials

Reference	Description	Specification
A00039	Adhesive - Epibond 126-A/B Epoxy Adhesive (126-A/B System)	
A00040	Resin - Self-Extinguishing Laminating - Epochast 50-A1 with Epochast 9816	BMS8-201 Type III (Long work life)
A00153	Adhesive - Low Odor, Synthetic Rubber Cement	BMS5-30
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00153	Solvent - Toluene, Nitration	JAN-T-171 Grade A
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00063	Ink - Screen Printing, Pigmented	BMS10-73 Type I
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G00423	Film, Polyvinyl Fluoride	BMS8-98
G00450	Fabric, Flow Resistant Acoustic	BMS8-64
G01288	Tape - Carpet	BMS5-133
G02446	Laminate - Tedlar	BAC5596 Type 13
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Repair Perforated Panels

SUBTASK 25-00-00-420-002

- (1) Put a routing template, with a hole diameter larger than the damaged area, over the area with damage.
- (2) Hold the template in place with carpet tape, G01288.

SUBTASK 25-00-00-010-001

- (3) Remove the damaged area with a router.
 - (a) Make sure the depth of the router does not cause damage to the screen under the decorative layer.
 - (b) For panels with tedlar covers, put one or two layers of Permacel P-255 tape, G02480 over the damaged area and over the perforated decorative sheet.

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SUBTASK 25-00-00-340-051

- (4) Remove the flow resistant fabric.

SUBTASK 25-00-00-340-052

- (5) Mix the adhesive as follows:

- (a) Mix (by weight) 60 to 65 parts of resin, A00040 with 100 parts of Epibond 126-A/B epoxy adhesive, A00039.

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- 1) Mix (by volume) one part of the adhesive mixture with one part of solvent, B00148 and one part of solvent, B00153.

SUBTASK 25-00-00-340-053

- (6) Cut a piece of flow-resistant fabric, G00450 that is larger than the damaged area.

SUBTASK 25-00-00-340-054

- (7) Bond the flow-resistant fabric, G00450 to a piece of perforated film, G00423 with the adhesive mixture.

SUBTASK 25-00-00-340-055

- (8) Use a routing template to cut a patch from the perforated sheet you made in the previous step.

SUBTASK 25-00-00-340-056

- (9) Rub the patch with abrasive cloth, B00102 paper (240 to 400 grit) to make sure the patch fits correctly in the cutout.

- (10) Make two marks on the patch and on the adjacent surface.

NOTE: This will help you install the patch in the position that it has the best fit.

SUBTASK 25-00-00-950-002

- (11) Apply masking Scotch Flatback Masking Tape 250, G00270 to the decorative side of the patch and around the cutout area.

SUBTASK 25-00-00-110-012

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- (12) Clean the surface with a cotton wiper, G00034 that is moist with Butyl Carbitol solvent, B01027.

- (13) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-057

- (14) Apply a heavy layer of the mixed adhesive with a paint brush, STD-1080 on the mating surfaces of the patch and the cutout.

- (a) Let the adhesive dry for 10 minutes.

SUBTASK 25-00-00-340-058

- (15) Remove the masking tape from the patch and panel.

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SUBTASK 25-00-00-340-059

- (16) Apply the carpet tape, G01288 to the decorative side of the patch and to the area around the cutout.

NOTE: The patch marks you made must show.

SUBTASK 25-00-00-340-060

- (17) Put the patch on a piece of transparent plexiglass which is slightly larger than the patch.
(18) Put the flow-resistant fabric between the patch and the fiberglass screen.

SUBTASK 25-00-00-340-061

- (19) Put the patch into the cutout.
(20) Look through the plexiglass to align the marks that you made.

SUBTASK 25-00-00-340-062

- (21) Apply pressure to the plexiglass, as necessary, to make sure the patch is level with the adjacent surfaces.

SUBTASK 25-00-00-340-063

- (22) Let the patch cure for 24 hours at room temperature, or for 3 hours at 115°(46.1C) to 125° F (51.7°C).

SUBTASK 25-00-00-340-064

- (23) Put the compound, D00147 in all of the cracks that you can see.
(a) Let the compound, D00147 cure.

SUBTASK 25-00-00-340-065

- (24) Apply masking Scotch Flatback Masking Tape 250, G00270 to the area around the repair.

SUBTASK 25-00-00-340-066

- (25) Rub the compound, D00147 with 240 to 320 grit abrasive cloth, B00102 paper until it is smooth and level with the adjacent surfaces.

SUBTASK 25-00-00-370-015

- (26) Apply ink, C00063 or ink, C00368 of the correct color to match the adjacent area.
(a) Let the ink dry.

SUBTASK 25-00-00-340-067

- (27) Drill holes to make perforations if it is necessary.

NOTE: Use a piece of perforated material for a template.

G. Apply Decorative Tedlar to Acoustical (Perforated) Panels

SUBTASK 25-00-00-020-009

- (1) Remove the trim strips from the panel.

SUBTASK 25-00-00-120-005

- (2) Rub the area which you will apply the adhesive with abrasive cloth, B00102 paper until the area is not glossy.



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SUBTASK 25-00-00-110-013

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- (3) Clean the area with a cotton wiper, G00034 that is moist with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-100-001

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-110-014

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH, OR YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. SOLVENTS MAY BE FLAMMABLE OR HARMFUL TO THE ENVIRONMENT. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

- (5) Mix (by volume) one part adhesive, A00153 adhesive with one part solvent, B00148.

SUBTASK 25-00-00-340-068

- (6) Carefully apply the mixture to the surface with a paint brush, STD-1080.

SUBTASK 25-00-00-370-016

CAUTION: MAKE SURE THE SURFACE IS FULLY DRY BEFORE YOU INSTALL THE TEDLAR LAMINATE. IF YOU INSTALL THE TEDLAR LAMINATE TO A WET SURFACE, YOU WILL NOT GET A SATISFACTORY BOND.

- (7) Let the surface dry at room temperature for a minimum of 2 hours.

SUBTASK 25-00-00-210-003

CAUTION: MAKE SURE THE DECORATIVE TEDLAR LAMINATE HAS THE CORRECT COLOR AND PATTERN. THE REPAIR WILL NOT LOOK SATISFACTORY IF THE NEW TEDLAR LAMINATE IS NOT CORRECT.

- (8) Put the decorative tedlar laminate, G02446 in position.

NOTE: Use masking Scotch Flatback Masking Tape 250, G00270 to hold the decorative tedlar laminate in position. If you use perforated tedlar for the repair, align the holes in the tedlar with the holes in the panel you will cover.

SUBTASK 25-00-00-880-003

CAUTION: BE CAREFUL WHEN YOU APPLY HEAT NEAR MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR MUST NOT BE MORE THAN 200° F (93.3°C) OR MORE THAN THE TEMPERATURE AT WHICH THE TEDLAR DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT WILL CAUSE DAMAGE TO THE TEDLAR.

- (9) Use a heat 180° F (82° C) maximum output temperature heat gun, STD-442 to increase the temperature of the tedlar laminate

NOTE: Make sure the temperature remains constant across the surface of the laminate. Refer to (TASK 20-10-27-910-801) for cautions to obey when you use heat guns.

SUBTASK 25-00-00-340-069

- (10) Use a vacuum generator, SPL-1474 to make sure the laminate touches all of the panel:

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- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Cure the laminate for 24 hours at room temperature, for 2 hours at 120° F (48.9°C), or for 30 minutes at 180° F (82.2°C).
- (c) Let the part cool to 90° F (32.2°C) before you remove the vacuum pressure.

————— END OF TASK ————

TASK 25-00-00-340-801

8. Repair for Polycarbonate (Lexan), Ultem, and Declar Plastics

A. General

- (1) The following data gives instructions to repair cracks and gouges in decorative and non-decorative plastics.
- (2) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must replace the part.

B. References

Reference	Title
25-00-00-370-801	Equipment/Furnishings - Painting (P/B 701)

C. Consumable Materials

Reference	Description	Specification
A00112	Hardener - Adhesive - Hysol 3561	
A50005	Resin - Adhesive, Flame-Out Casting - Hysol EE1067	
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83 Type II
C00302	Coating - Interior Decorative Water Emulsion Paint	BMS10-55 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G50172	Fabric - Woven Glass Reinforcements for Laminating Plastics, Style 181	BMS9-3 Type H
G50173	Fabric - Glass Fabric Reinforcements For Laminated Plastics Products	BMS9-3 Type H-3 Style 7781
G50593	Fabric - Woven Glass Reinforcements For Laminating Plastics	BMS9-3 Type H-2 Class 7

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Repair for Cracked Areas

SUBTASK 25-00-00-340-070

- (1) Drill a 1/16 in. (2 mm) diameter hole at each end of the crack.

SUBTASK 25-00-00-340-071

- (2) Remove the material from the crack until the width of the crack is approximately equal to the thickness of the part.

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SUBTASK 25-00-00-340-072

- (3) Rub the surface with abrasive cloth, B00102 until the surface is not glossy.

SUBTASK 25-00-00-340-073

WARNING: DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

- (5) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-074

- (6) Mix the repair resin as follows:

- (a) Mix one hundred parts of Hysol EE1067 resin, A50005 with 15 or 16 parts of Hysol 3561 hardener, A00112.

SUBTASK 25-00-00-340-075

- (7) Fill the crack with the repair resin.

SUBTASK 25-00-00-340-076

- (8) Let the repair resin cure until it is hard.

SUBTASK 25-00-00-340-077

- (9) Apply one of these materials fabric, G50172, fabric, G50173 or, fabric, G50593 that is soaked with the repair resin to make the repair stronger.

NOTE: If you want to repair a decorative part, put the fabric on the side that is not decorative. The glass fabric layers must be at least as thick as the part where the crack was. Make the glass fabric 0.5 in. (12.7 mm) smaller around the edge for each layer you apply. If the crack is at or near an edge, it is not necessary to make each layer smaller.

SUBTASK 25-00-00-340-078

- (10) Remove all the unwanted resin.

SUBTASK 25-00-00-340-079

- (11) Let the repair cure until it is hard at a temperature between 70°F (21°C) and 130°F (54°C).

SUBTASK 25-00-00-340-080

- (12) Rub the area with abrasive cloth, B00102 until the repair is smooth.

SUBTASK 25-00-00-340-081

- (13) Apply the emulsion coating, C00302 to the area.

NOTE: If you want to paint the part out of the airplane, use coating, C00040 and refer to TASK 25-00-00-370-801.

F. Repair for Gouged Areas

SUBTASK 25-00-00-340-082

- (1) If there is not a dent around the gouge, make the gouge smooth with abrasive cloth, B00102.

SUBTASK 25-00-00-340-083

- (2) If the appearance is not satisfactory after it is smooth, fill the gouge with repair resin.

- (a) Do the steps in the repair for cracked areas.

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SUBTASK 25-00-00-340-084

- (3) If the surface has dents, remove the area with dents and do the repair for cracked areas.

———— END OF TASK ——

TASK 25-00-00-350-801

9. Repair Urethane Foam

A. General

- (1) The task gives instructions on how to repair the urethane foam material with these alternatives:
- (a) Repair the foam with a Plug
 - (b) Repair the foam with an adhesive resin.

B. Tools/Equipment

Reference	Description
STD-821	Squeegee - Plastic

C. Consumable Materials

Reference	Description	Specification
A00188	Adhesive - Urethane, Two Component	BMS5-105 Type V
A00216	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (40 Min Gel) (OBSOLETE AS OF 16JAN08)	BMS5-28 Type 16 (OBSOLETE AS OF 16JAN08)
D00091	Oil - General Purpose, Low Temperature, Lubricating	MIL-PRF-7870 (NATO O-142)
G00111	Sheet - Mylar	
G01288	Tape - Carpet	BMS5-133

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Repair the Foam with a Plug

SUBTASK 25-00-00-350-013

- (1) Remove the damage with a cork bore or an equivalent tool.

NOTE: The tool size must be equal to the size of the damaged area, or up to 1/2 inch (12.7 mm) larger in diameter.

SUBTASK 25-00-00-350-014

- (2) Use the same tool to cut a repair plug from foam to fit in damaged area.

SUBTASK 25-00-00-350-015

- (3) Apply a layer of the adhesive, A00188 to each surface of the repair plug and damaged area.

SUBTASK 25-00-00-350-016

- (4) Let the adhesive dry until tacky.

NOTE: Do not stress the adhesive bond for 24 hours.

SUBTASK 25-00-00-420-003

- (5) Push the repair plug into the damaged area with hand pressure.



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F. Repair the Foam with Adhesive Resin

SUBTASK 25-00-00-350-017

- (1) Remove the damage with a cork bore or equivalent tool.

NOTE: The tool size must be equal to the size of the damaged area, or up to 1/2-inch (12.7 mm) larger in diameter.

SUBTASK 25-00-00-350-018

- (2) Use the manufacturers instructions to mix the potting compound, A00216.

SUBTASK 25-00-00-350-019

- (3) Fill the area fully with the potting compound.

SUBTASK 25-00-00-350-020

- (4) Put a sheet of mylar sheet, G00111 over the potting compound.

NOTE: The potting compound must go 2-inches (50.8 mm) beyond the edge of the filled area all around.

SUBTASK 25-00-00-350-021

- (5) Put a small portion of the oil, D00091 on the top surface of the Mylar film.

SUBTASK 25-00-00-350-022

- (6) Start at the center of the repair and rub the potting compound with a plastic squeegee, STD-821 until you get the shape necessary.

SUBTASK 25-00-00-350-023

- (7) Apply carpet tape, G01288 to hold the Mylar film in position.

SUBTASK 25-00-00-350-024

- (8) Let the compound cure for 1 hour at room temperature and then 5 hours at 115° F (46.1°C).

SUBTASK 25-00-00-350-025

- (9) Carefully remove the Mylar film after the compound is cured.

———— END OF TASK ————

TASK 25-00-00-350-802

10. Repair Aluminum Trim

A. General

- (1) This procedure gives instructions to repair aluminum trim.

B. References

Reference	Title
20-10-27-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

Reference	Description
STD-6554	Gun - Heat

D. Consumable Materials

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010 Type 70 (BMS5-92 Type 1)
A00279	Adhesive - Fast-Setting Epoxy	BMS5-123 or BAC5010 Type 71

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Reference	Description	Specification
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G01601	Abrasive - Aluminum Oxide Coated Cloth, 400 to 600 grit	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Repair aluminum trim

SUBTASK 25-00-00-350-027

- (1) Remove any fasteners from the aluminum trim if they are installed.

SUBTASK 25-00-00-020-010

- (2) Remove the aluminum trim from the panel.
 - (a) If the trim is bonded, use a heat gun, STD-6554 to help remove the trim, (TASK 20-10-27-910-801).
 - 1) Apply heat while pulling trim away from the panel.
 - 2) Remove the trim progressively from one end to the other.

SUBTASK 25-00-00-840-001

- (3) Restore the trim to its original straightness and contour.

NOTE: Use metal working techniques to remove dents and straighten the trim as much as possible.

SUBTASK 25-00-00-410-001

- (4) Put the trim onto the panel and reattach any fasteners.
 - (a) If the trim is applied with fasteners and adhesive, apply epoxy adhesive to the edge of the panel and quickly reattach the trim with the fasteners.
 - (b) If the trim is applied with adhesive only, apply an epoxy adhesive to the edge of the panel and quickly position the trim.
NOTE: adhesive, A00279 has a very short working life. If more time is required for the repair, use an adhesive such as adhesive, A00028.

(c) Use Scotch Flatback Masking Tape 250, G00270 to hold the trim in the correct position until the adhesive is fully cured.

SUBTASK 25-00-00-300-004

- (5) Fill any dents, gouges, or imperfections with compound, D00147 to make a crown above the adjacent area.
 - (a) After the compound, D00147 is hard, rub it with 400 to 600 grit abrasive cloth, G01601 to the same level as the surface of the panel.

SUBTASK 25-00-00-370-017

- (6) Apply aluminum spray paint to the repaired area. Any commercially available spray paint is acceptable.

— END OF TASK —

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EQUIPMENT/FURNISHINGS - DDG MAINTENANCE PROCEDURES

1. General

- A. This procedure has maintenance tasks for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Procedures Guide (DDPG). These tasks are used to prepare the airplane for flight with certain systems/components inoperative.
- B. This procedure also has the tasks that put the airplane back to its usual condition.
- C. These are the tasks for the equipment/furnishings components:
 - (1) DDG 25-1 Preparation - Megaphone Inoperative - EASA
 - (2) DDG 25-1 Restoration - Megaphone Inoperative - EASA
 - (3) DDG 25-3 Preparation - Flight Attendant Seat Assembly Positions Inoperative
 - (4) DDG 25-3 Restoration - Flight Attendant Seat Assembly Positions Inoperative
 - (5) DDG 25-5 Preparation - Cargo Compartment Restraint Components Inoperative
 - (6) DDG 25-5 Restoration - Cargo Compartment Restraint Components Inoperative
 - (7) DDG 25-5-1 Preparation - Cargo Compartment Restraint Components Passenger Pallets Inoperative - FAA
 - (8) DDG 25-5-1 Restoration - Cargo Compartment Restraint Components Passenger Pallets Inoperative - FAA
 - (9) DDG 25-6 Preparation - Passenger Seats (Including Seat Backs) Inoperative
 - (10) DDG 25-6 Restoration - Passenger Seats (Including Seat Backs) Inoperative
 - (11) DDG 25-16 Preparation - Cargo Compartment Linings and Floor Panel Inoperative
 - (12) DDG 25-16 Restoration - Cargo Compartment Linings and Floor Panel Inoperative
 - (13) DDG 25-18 Preparation - Flotation Equipment Inoperative - EASA
 - (14) DDG 25-18 Restoration - Flotation Equipment Inoperative - EASA
 - (15) DDG 25-21 Preparation - Flight Crew Seat Armrest or Lumbar/Thigh Supports Inoperative
 - (16) DDG 25-21 Restoration - Flight Crew Seat Armrest or Lumbar/Thigh Supports Inoperative
 - (17) DDG 25-22 Preparation - Galley/Lavatory Waste Receptacles Access Doors/Covers Inoperative
 - (18) DDG 25-22 Restoration - Galley/Lavatory Waste Receptacles Access Doors/Covers Inoperative
 - (19) DDG 25-24 Preparation - Overhead Stowage Bins/Cabin and Galley Stowage Compartments/Closets
 - (20) DDG 25-24 Restoration - Overhead Stowage Bins/Cabin and Galley Stowage Compartments/Closets

TASK 25-00-00-800-801

2. DDG 25-1 Preparation - Megaphone Inoperative - EASA

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when one or more megaphones are inoperative.

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- (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Megaphone Deactivation

SUBTASK 25-00-00-840-002

- (1) Properly configure inoperative megaphone to prevent use and maintain required distribution of operative megaphones.
- (a) Remove the inoperative megaphone from the airplane, or placard it and secure out of sight in an approved location where it will not be used by mistake.
- (b) Placard the removed location.

———— END OF TASK ————

TASK 25-00-00-800-802

3. DDG 25-1 Restoration - Megaphone Inoperative - EASA

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Megaphone Activation

SUBTASK 25-00-00-840-003

- (1) Install the operative megaphone in the airplane.
- (a) Remove the placard.
- (b) Confirm the required distribution of operative megaphones is maintained throughout the airplane.

———— END OF TASK ————

TASK 25-00-00-860-801

4. DDG 25-3 Preparation - Flight Attendant Seat Assembly Positions Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when one or two flight attendant seat assembly positions do not operate correctly.



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B. References

Reference	Title
25-25-12-000-801	Attendants' Seat Removal (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Flight Attendant Seat Assembly Deactivation

SUBTASK 25-00-00-040-001

- (1) Do the steps that follow to stow the flight attendant seat in the closed position:
 - (a) The flight attendant seats are designed to close when a person does not occupy the seat.
 - (b) If the flight attendant seat will not stay closed, it must be removed. To remove the seat, do this task: Attendants' Seat Removal, TASK 25-25-12-000-801.

SUBTASK 25-00-00-040-017

- (2) Do this step if it is necessary:
 - (a) Deactivate the heating system by opening and collaring the applicable circuit breaker on the P18 panel.

SUBTASK 25-00-00-040-002

- (3) Notify the cabin crew of the inoperative attendant seat.

———— END OF TASK ————

TASK 25-00-00-440-801

5. DDG 25-3 Restoration - Flight Attendant Seat Assembly Positions Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task puts the airplane back to its usual condition after operating with the one or two flight attendant seat assembly positions that do not operate correctly.

B. References

Reference	Title
25-25-12-000-801	Attendants' Seat Removal (P/B 401)
25-25-12-400-801	Attendants' Seat Installation (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Flight Attendant Seat Assembly Reactivation

SUBTASK 25-00-00-900-001

- (1) Replace the attendant seat(s) that does not operate correctly.

These are the tasks:

Attendants' Seat Removal, TASK 25-25-12-000-801,

Attendants' Seat Installation, TASK 25-25-12-400-801.

———— END OF TASK ————

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TASK 25-00-00-800-803

6. DDG 25-5 Preparation - Cargo Compartment Restraint Components Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when cargo compartment restraint components are inoperative.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Cargo Compartment Restraint Component Deactivation

SUBTASK 25-00-00-840-004

- (1) Deactivation procedures for most cargo restraint or cargo guiding equipment are either obvious (e.g. inoperative container stop needs to be released to retracted position or removed to prevent interference with cargo loading) or unnecessary (e.g., a damaged end stop can be left as is). With the exception of the restrictions below, no other procedures are provided in this document.

SUBTASK 25-00-00-840-005

- (2) Refer to the Weight and Balance Manual for cargo loading limits when operating with restraint components missing or inoperative. If the number of inoperative or missing restraint components exceeds the allowance in the Weight and Balance Manual, inform Dispatch that the affected cargo compartment cannot be used.

— END OF TASK —

TASK 25-00-00-800-804

7. DDG 25-5 Restoration - Cargo Compartment Restraint Components Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

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C. Cargo Compartment Restraint Component Activation

SUBTASK 25-00-00-840-007

- (1) Activation procedures for most cargo restraint or cargo guiding equipment are either obvious (e.g. operative container stop needs to be released to retracted position or removed to prevent interference with cargo loading).

———— END OF TASK ————

TASK 25-00-00-800-809

**8. DDG 25-5-1 Preparation - Cargo Compartment Restraint Components Passenger Pallets
Inoperative - FAA**

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when cargo compartment restraint components are inoperative.
- (a) This procedure is only for aircraft using the FAA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Cargo Compartment Restraint Component Passenger Pallet Deactivation

SUBTASK 25-00-00-840-012

- (1) Seat back breaks away and stow on seat bottom with 25-35 lbs. applied at top of seat back. Method of securing belts, straps, etc. is left to the discretion of each operator.

SUBTASK 25-00-00-840-013

- (2) If more than one lock per passenger pallet is inoperative, the pallet must be removed.

———— END OF TASK ————

TASK 25-00-00-800-810

**9. DDG 25-5-1 Restoration - Cargo Compartment Restraint Components Passenger Pallets
Inoperative - FAA**

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (a) This procedure is only for aircraft using the FAA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.



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B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Cargo Compartment Restraint Component Passenger Pallet Activation

SUBTASK 25-00-00-840-014

- (1) If necessary, install operational seat and loosen the belts, straps, etc.

SUBTASK 25-00-00-840-015

- (2) Install the applicable passenger pallet.

————— END OF TASK ————

TASK 25-00-00-860-802

10. DDG 25-6 Preparation - Passenger Seats (Including Seat Backs) Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight with applicable system/components inoperative.
- (2) This task gives the maintenance steps which prepare the airplane for flight when a passenger seat does not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Passenger Seat Deactivation

SUBTASK 25-00-00-040-003

- (1) Do these steps for an inoperative passenger seat in the upright position:
 - (a) Refer to the seat manufacturer's specifications to safety the seat in the upright position.
NOTE: The seat may be used during flight if the seat belts operate correctly.

SUBTASK 25-00-00-040-004

- (2) Do these steps for an inoperative passenger seat in the reclined position:
 - (a) Make sure that the inoperative passenger seat does not cause a blockage to the aisle or the emergency exit.
 - (b) Make sure that the arm rest does not cause a blockage to the aisle or the emergency exit.
 - (c) If the inoperative seat does cause a blockage to an emergency exit:
 - 1) Do this task: Passenger Seat Removal.
 - (d) If the inoperative seat does cause a blockage to the aisle:
 - 1) Safety the row of seats aft of the inoperative passenger seat.

SUBTASK 25-00-00-040-013

- (3) Do these steps for an inoperative underseat baggage restraining bar:

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- (a) Install a placard on the affected passenger seat.
- (b) Notify the cabin crew of the inoperative baggage restraining bar and its location.

———— END OF TASK ——

TASK 25-00-00-040-801

11. DDG 25-6 Restoration - Passenger Seats (Including Seat Backs) Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task puts the airplane back to its usual condition after operating with a passenger seat that does not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Passenger Seat Reactivation

SUBTASK 25-00-00-420-004

- (1) If the inoperative seat or armrest caused a blockage to an emergency exit:
 - (a) Do this task: Passenger Seat Removal.

SUBTASK 25-00-00-900-002

- (2) If the inoperative seat or armrest caused a blockage to the aisle:
 - (a) Replace the passenger seat(s) that does not operate correctly.
 - 1) Do this task: Passenger Seat Removal and Passenger Seat Installation.

SUBTASK 25-00-00-900-005

- (3) If the underseat baggage restraint bar caused the seat to be inoperative:
 - (a) Replace the passenger seat(s) that does not operate correctly.
 - 1) Do this task: Passenger Seat Removal and Passenger Seat Installation.

———— END OF TASK ——

TASK 25-00-00-800-806

12. DDG 25-16 Preparation - Lower Cargo Compartment Linings and Floor Panels - Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the lower cargo compartment linings and floor panel are inoperative.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

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C. Lower Cargo Compartment Linings and Floor Panel Deactivation

SUBTASK 25-00-00-840-009

- (1) Cargo compartment linings and floor panels may be damaged or missing provided there are procedures established and used to make sure that the compartment remains empty or is verified to contain only empty cargo handling equipment, ballast, and/or Fly Away Kits.

NOTE: Ballast may be loaded in the ULDs.

NOTE: The operator MEL must define which items are approved for inclusion in Fly Away Kits and which materials can be used as ballast.

SUBTASK 25-00-00-840-010

- (2) Each operator must develop and use procedures to make sure that any items in the associated cargo compartment are properly secured to prevent damage to airplane system components exposed by the damaged or missing lining panel.

————— END OF TASK ————

TASK 25-00-00-800-805

13. DDG 25-16 Restoration - Lower Cargo Compartment Linings and Floor Panels - Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Lower Cargo Compartment Linings and Floor Panel Activation

SUBTASK 25-00-00-420-007

- (1) Install serviceable cargo compartment linings and floor panels in the cargo area.

————— END OF TASK ————

TASK 25-00-00-800-807

14. DDG 25-18 Preparation - Flotation Equipment - Inoperative - EASA

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the flotation devices does not operate correctly.
- (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage



25-00-00



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C. Flotation Device Deactivation

SUBTASK 25-00-00-020-013

- (1) Properly configure inoperative equipment to prevent use and maintain required distribution of operative equipment.
 - (a) Remove the inoperative equipment from the airplane, or placard it INOPERATIVE and secure out of sight in an approved location where it will not be used by mistake.
 - (b) Placard the installed location, INOPERATIVE.
 - (c) Confirm required distribution of operative equipment is maintained throughout the airplane.

———— END OF TASK ——

TASK 25-00-00-800-808

15. DDG 25-18 Restoration - Flotation Equipment - Inoperative - EASA

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Flotation Equipment Activation

SUBTASK 25-00-00-840-011

- (1) Correctly configure operative equipment to provide use and distribution.
 - (a) Remove the placard.
 - (b) Install the operative equipment into the airplane
 - (c) Confirm required distribution of operative equipment is maintained throughout the airplane.

———— END OF TASK ——

TASK 25-00-00-860-804

16. DDG 25-21 Preparation - Flight Crew Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight with applicable system/components inoperative.
- (2) This task gives the maintenance steps which prepare the airplane for flight when the flight crew seat does not operate correctly.

B. References

Reference	Title
25-11-01-000-801	Captain's and First Officer's Seat Removal (P/B 401)
25-11-01-400-801	Captain's and First Officer's Seat Installation (P/B 401)

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C. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Flight Crew Seat Recline Mechanism

SUBTASK 25-00-00-720-001

- (1) Do a functional test to make sure that the seat back cannot be moved.
 - (a) Make sure that full travel of the seat on its track is not impaired.

SUBTASK 25-00-00-040-014

- (2) Notify the flight crew of the inoperative recline mechanism.

NOTE: The seat must be acceptable to the affected crew member.

- (a) If the seat is not acceptable to the affected crew member the seat must be replaced.
These are the tasks:

Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801,

Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.

E. Flight Crew Seat Vertical Adjustment

SUBTASK 25-00-00-720-002

- (1) Do a functional test to make sure that the seat cannot be moved in a vertical direction.

SUBTASK 25-00-00-040-015

- (2) Do one or both of these steps if it is necessary:

- (a) Disconnect the vertical adjustment cable to put the seat in a fixed vertical position.
- (b) Disconnect the vertical adjustment pushrod mechanism to put the seat in a fixed vertical position.

SUBTASK 25-00-00-040-016

- (3) Notify the flight crew of the inoperative vertical adjustment.

NOTE: The seat must be acceptable to the affected crew member.

- (a) If the seat is not acceptable to the affected crew member the seat must be replaced.
These are the tasks:

Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801,

Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.

F. Flight Crew Seat Armrest Deactivation

SUBTASK 25-00-00-040-007

- (1) Remove the armrest or safety the armrest in an upright position.

SUBTASK 25-00-00-040-008

- (2) Notify the flight crew of the inoperative armrest.

NOTE: The seat must be acceptable to the affected crew member.

- (a) If the seat is not acceptable to the affected crew member the seat must be replaced.
These are the tasks:

Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801,

Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.



25-00-00



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G. Flight Crew Seat Lumbar/Thigh Supports Deactivation

SUBTASK 25-00-00-040-009

- (1) Notify the flight crew of the inoperative lumbar/thigh supports.

NOTE: The seat must be acceptable to the affected crew member.

- (a) If the seat is not acceptable to the affected crew member the seat must be replaced.

These are the tasks:

Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801,

Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.

———— END OF TASK ——

TASK 25-00-00-040-803

17. DDG 25-21 Restoration - Flight Crew Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task puts the airplane back to its usual condition after operating with a flight crew seat that does not operate correctly.

B. References

Reference	Title
25-11-01-000-801	Captain's and First Officer's Seat Removal (P/B 401)
25-11-01-400-801	Captain's and First Officer's Seat Installation (P/B 401)

C. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Flight Crew Seat Reactivation

SUBTASK 25-00-00-900-004

- (1) Replace the flight crew seat(s) that does not operate correctly.

These are the tasks:

Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801,

Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.

———— END OF TASK ——

TASK 25-00-00-860-805

18. DDG 25-22 Preparation - Galley/Lavatory Waste Receptacles Access Doors/Covers Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight with applicable system/components inoperative. This task gives the maintenance steps which prepare the airplane for flight when a galley/lavatory waste receptacle access door/cover is inoperative.

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B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Galley/Lavatory Waste Receptacle Access Door/Cover Deactivation

SUBTASK 25-00-00-040-010

- (1) Safety the galley/lavatory waste receptacle access door/cover in a manner that will prevent waste from being deposited in the compartment.

———— END OF TASK ——

TASK 25-00-00-440-802

19. DDG 25-22 Restoration - Galley/Lavatory Waste Receptacles Access Door/Covers Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task puts the airplane back to its usual condition after operating with a galley/lavatory waste receptacle access door/cover that is inoperative.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Galley/Lavatory Waste Receptacles Access Door/Cover Reactivation

SUBTASK 25-00-00-910-001

- (1) Remove the tape or strap from the inoperative door/cover.

SUBTASK 25-00-00-350-026

- (2) Repair the inoperative latch on the access door/cover.

———— END OF TASK ——

TASK 25-00-00-040-804

20. DDG 25-24 Preparation - Overhead Stowage Bins/Cabin and Galley Stowage Compartments/Closets

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight with applicable system/components inoperative.
- (2) This task gives the maintenance steps which prepare the airplane for flight when an overhead Storage Bin, or Cabin, or Galley Storage Compartment or Closet does not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage



25-00-00



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C. Overhead Storage Compartment Inoperative.

SUBTASK 25-00-00-040-011

- (1) Do these steps as they apply to your situation for an inoperative Overhead Storage Bin or Cabin or Galley Storage Compartment or Closet Compartment:

NOTE: One latch/lug per compartment may be inoperative if the remaining latch(es)/lug(s) on affected compartments operates normally.

NOTE: Storage compartment key locks may be inoperative in the unlocked position provided doors can be secured by other means.

- (a) Secure the Compartment Closed

- 1) Associated bin or compartment (do not used for storage of any items, except those permanently affixed) is prominently placarded DO NOT USE.

NOTE: If no partitions are installed, the entire overhead storage compartment is considered one bin or compartment.

- (b) Remove the affected Compartment Door

NOTE: Associated bin or compartment is not used for storage of any items, except those permanently affixed.

- 1) Associated bin or compartment (do not use for storage of any items, except those permanently affixed) is prominently placarded DO NOT USE.

NOTE: If no partitions are installed, the entire overhead storage compartment is considered one bin or compartment.

NOTE: Any emergency equipment located in the associated compartment (permanently affixed) is available for use.

———— END OF TASK ————

TASK 25-00-00-440-803

**21. DDG 25-24 Restoration - Overhead Stowage Bins/Cabin and Galley Stowage Compartments/
Closets**

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task puts the airplane back to its usual condition after operating with an Overhead Storage Bin/Cabin and Galley Storage Compartment or Closet that does not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-00-00-440-001

- (1) If the bin or compartment was closed repair the bin or compartment.

SUBTASK 25-00-00-440-002

- (2) If the door was removed from compartment repair or replace the door.

- (a) Install door

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SUBTASK 25-00-00-440-003

- (3) If latch/lug on compartment was inoperative replace latch/lug.

———— END OF TASK ——

— EFFECTIVITY —
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FLIGHT COMPARTMENT SEATS - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Captain, First Officer, and Observer Seat Harness Visual Check.
 - (2) Captain, First Officer, and Observer Seat Harness and Inertia Reel Operational Check.

TASK 25-11-00-200-802

2. Captain's, First Officer's, and Observer's Seat Visual Harness Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-00-210-001

- (1) Do a visual check of the restraint harness straps:
 - (a) Make sure that the straps are not damaged.
 - 1) Look for loose stitching, cuts, tears, fraying, and discoloration.

SUBTASK 25-11-00-210-002

- (2) Do a visual check of the restraint harness fittings:
 - (a) Make sure that the fittings are not bent, loose, or corroded.

SUBTASK 25-11-00-210-003

- (3) Do a visual check of the restraint harness securing hardware:
 - (a) Make sure that the securing hardware is not bent, loose, or corroded.

———— END OF TASK ————

TASK 25-11-00-200-801

3. Captain, First Officer, and Observer Seat Harness and Inertia Reel Operational Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-00-200-001

- (1) Do the steps that follow to test the restraint harness and inertia reel:
 - (a) Make sure the shoulder harness control is in the unlocked position.
 - (b) Quickly pull one shoulder strap in the forward direction.
 - 1) Make sure the inertia reel locks.
 - 2) Make sure the strap does not extend.

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- (c) Release the pressure on the strap.
 - 1) Make sure the inertia reel releases the strap.
- (d) Quickly pull the other shoulder strap in the forward direction.
 - 1) Make sure the inertia reel locks.
 - 2) Make sure the strap does not extend.
- (e) Release the pressure on the strap.
 - 1) Make sure the inertia reel releases the strap.
- (f) Pull one of the shoulder straps slowly out of the seat back as far as possible.
- (g) Move the shoulder harness control to the locked position.
- (h) Release the shoulder strap until it retracts approximately two inches at a time, until it is fully retracted.
 - 1) At each stage, pull on the shoulder to make sure the strap locks.
- (i) Move the shoulder harness control to the unlocked position.
- (j) Pull the other shoulder strap slowly out of the seat back as far as possible.
- (k) Move the shoulder harness control to the locked position.
- (l) Release the shoulder strap until it retracts approximately two inches at a time until it is fully retracted.
 - 1) At each stage, pull on the shoulder strap to make sure the strap locks.
- (m) Put the shoulder harness control in the unlocked position.

———— END OF TASK ————

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CAPTAIN'S AND FIRST OFFICER'S SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the Captain's and First Officer's Seats,
 - (2) An installation of the Captain's and First Officer's Seats.
- B. Use this procedure to remove and install the Captain's seat or the First Officer's seat.

TASK 25-11-01-000-801

2. Captain's and First Officer's Seat Removal

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-01-020-008

- (1) Remove the life vest from the pouch found on the back of the seat.

SUBTASK 25-11-01-010-001

- (2) Move the seat to its fully aft and outboard position.

NOTE: Pull up on the horizontal control handle [2] to move the seat.

SUBTASK 25-11-01-030-001

- (3) Remove the stops [9] from the front of the seat tracks.

SUBTASK 25-11-01-020-001

- (4) Move the seat forward until the rollers are free from the tracks.

SUBTASK 25-11-01-020-002

- (5) Lift the seat and remove it from the airplane.

———— END OF TASK ————

TASK 25-11-01-400-801

3. Captain's and First Officer's Seat Installation

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-01-020-003

- (1) If the stops [9] are installed on the front ends of the seat tracks, remove them.

SUBTASK 25-11-01-410-001

- (2) Put the seat immediately forward of the seat tracks.



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SUBTASK 25-11-01-420-001

- (3) Align the roller assemblies [3] with the seat tracks. The single tapered roller [5] must be on the INBOARD SIDE of the track.

SUBTASK 25-11-01-430-001

- (4) Engage the front and rear roller assemblies [3] with the seat tracks.

SUBTASK 25-11-01-430-002

- (5) Move the seat aft and release control handle.

SUBTASK 25-11-01-430-003

- (6) Pull horizontal control handle [2] up and aft to lift lock pins.

NOTE: Handle is located on the inboard aft side of seat.

SUBTASK 25-11-01-430-004

- (7) Install the stops [9] on the seat tracks.

- (a) Tighten the bolts [8] on the seat tracks to 30 ± 5 in-lb (3.4 ± 0.6 N·m).

SUBTASK 25-11-01-700-001

- (8) AIRPLANES WITH ADJUSTABLE BOGIE;

Tighten the adjustment nut [4] of the tapered rollers [5] so that the roller lightly touches the inboard rail.

SUBTASK 25-11-01-710-001

- (9) Do this operational check for the movement of the seat.

- (a) While you are on the seat, operate the horizontal control handle [2] and move the seat forward and aft through its full range of the travel.
- (b) Make sure the seat moves freely forward and aft along the seat tracks through its full range of movement.
- (c) Operate the seat and release the control lever.
- (d) Make sure the seat locks in position.

SUBTASK 25-11-01-400-001

WARNING: MAKE SURE THAT THE LOCK PIN FULLY ENGAGES AT EACH SEAT TRACK LOCK POSITION. UNLOCKED SEATS CAN MOVE AND CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (10) Make sure the seat track lock pin is fully engaged in all seat track positions.

- (a) Make sure seat track lock pin fully engages in all seat track lock positions, positions are engaged from the farthest forward position to the farthest aft position on the straight section of the seat tracks
- (b) Make sure seat track lock positions are engaged in the parked position.

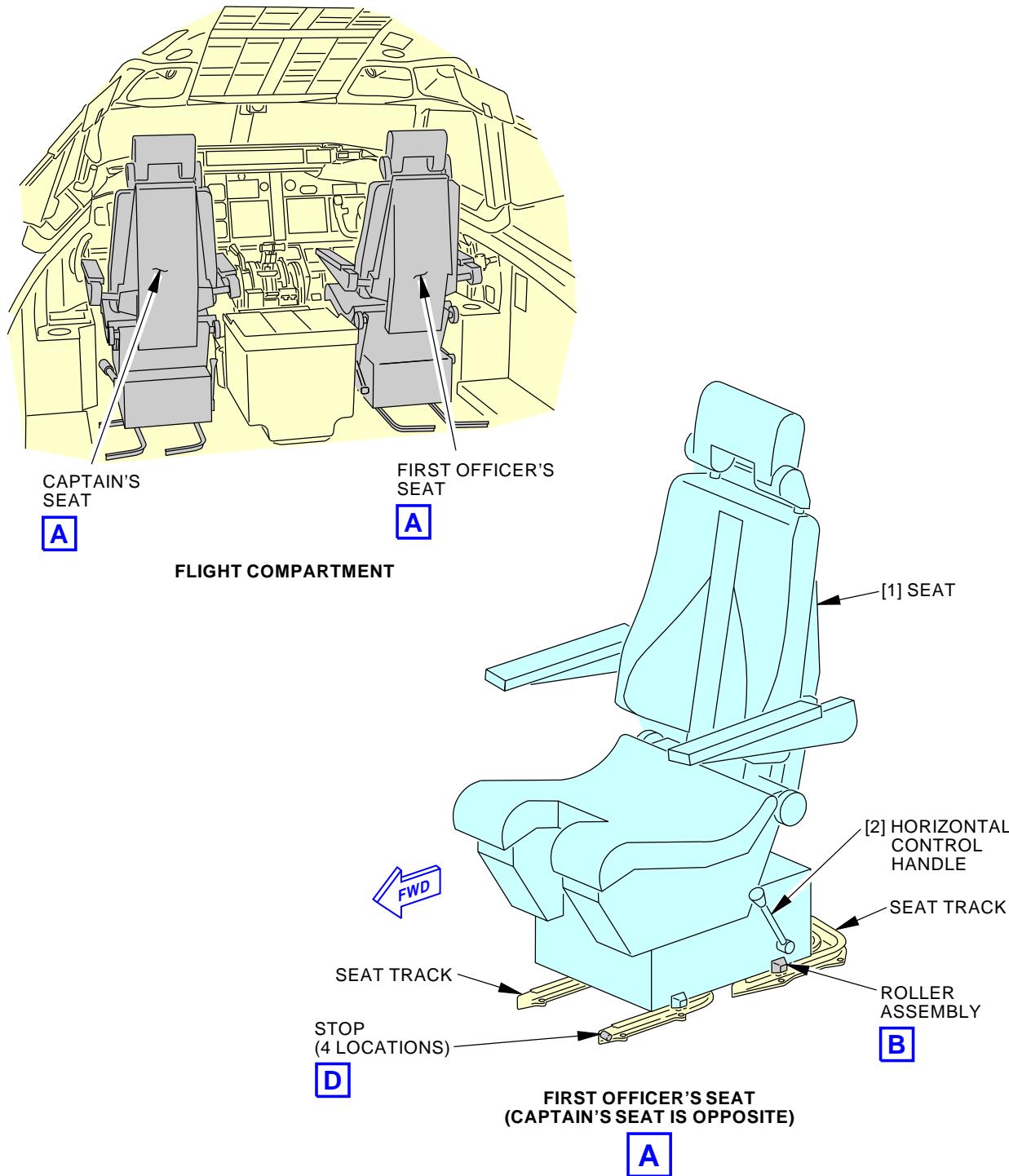
SUBTASK 25-11-01-420-009

- (11) Put the flight crew's life vest into the pouch at the rear of the seat.

———— END OF TASK ———

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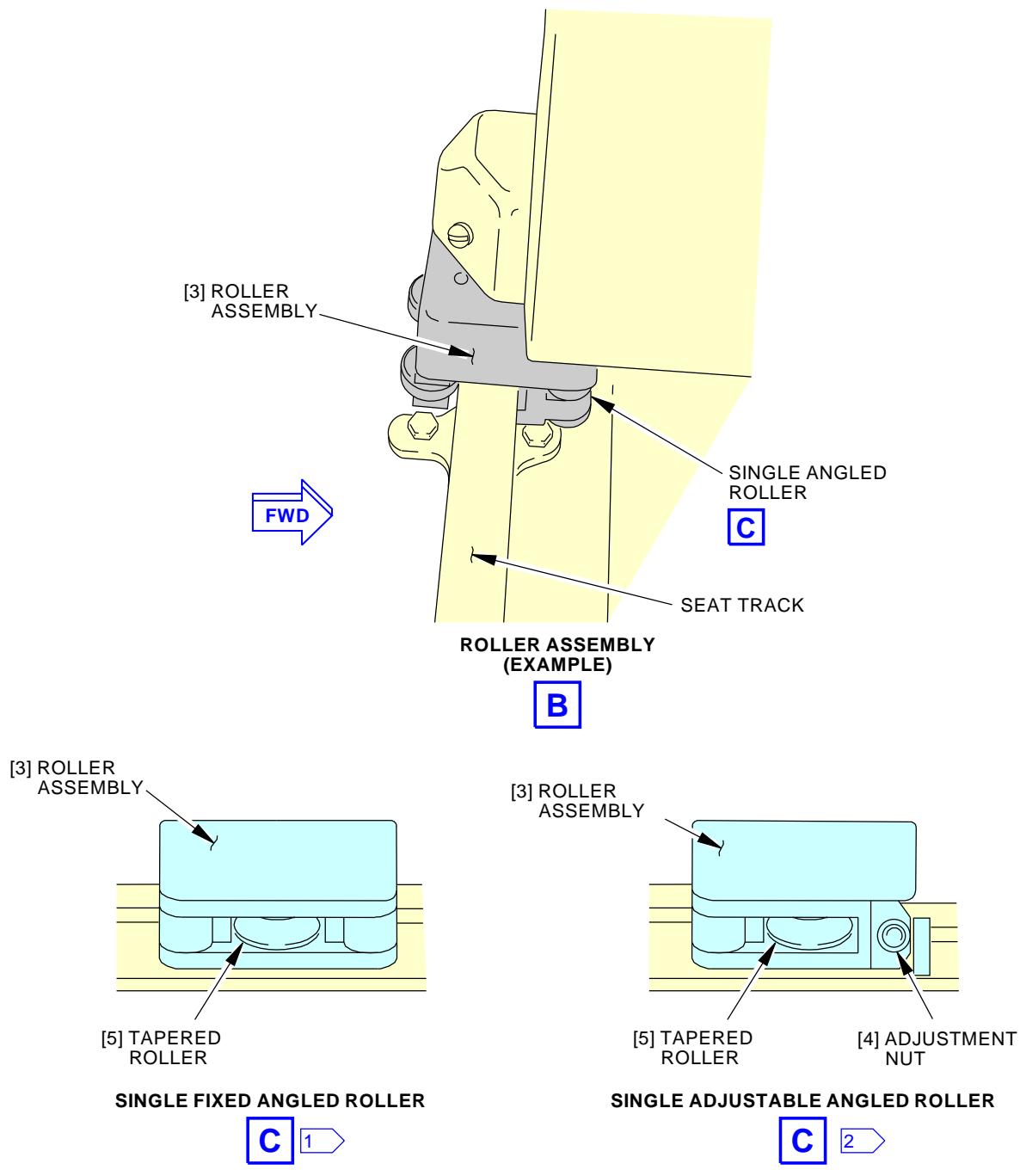
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**Captain's and First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 1 of 3)**

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- 1 AIRPLANES WITH FIXED ROLLER
 2 AIRPLANES WITH ADJUSTABLE ROLLER

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Captain's and First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 2 of 3)

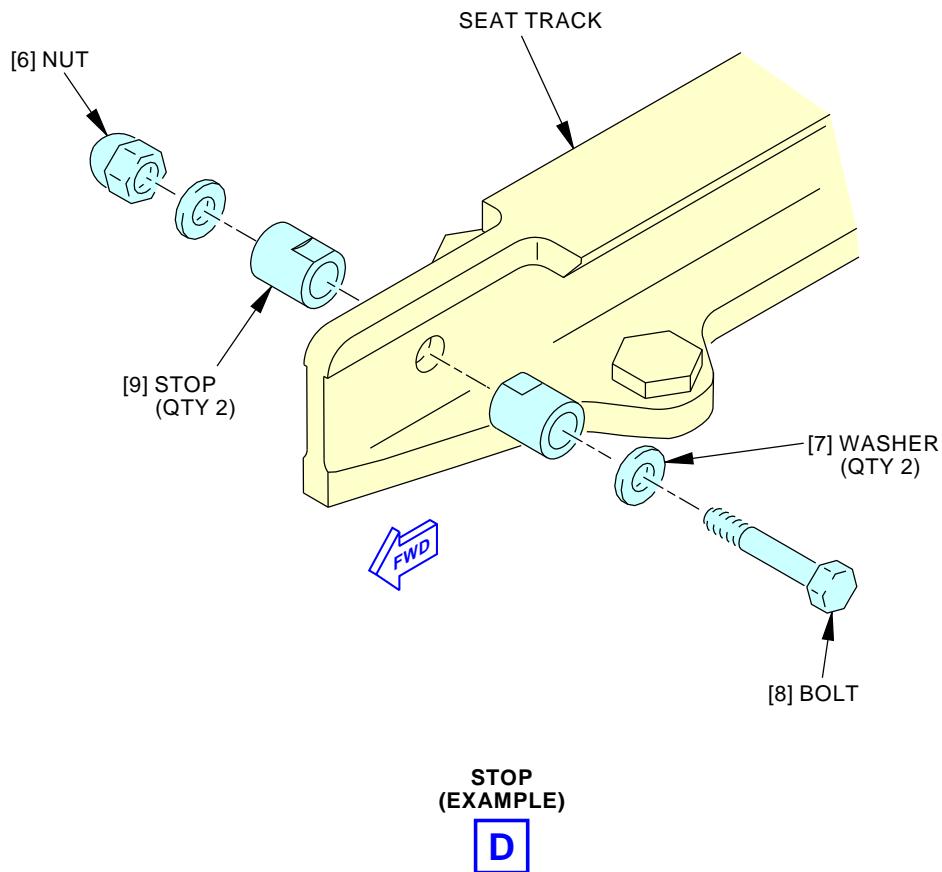
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Captain's and First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 3 of 3)

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CAPTAIN'S AND FIRST OFFICER'S SEATS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains this task:
 - (1) Captain and First Officer Seat Track and Locking Mechanism Inspection.

TASK 25-11-01-200-802

2. Captain and First Officer Seat Track and Locking Mechanism Inspection

(Figure 601 and Figure 602)

NOTE: This procedure is a scheduled maintenance task.

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1638	Gauge - Inspection, Seat Track, Flight Crew Seats (A25020-5 part of A25020-8) Part #: A25020-8 Supplier: 81205 Opt Part #: A25020-4 Supplier: 81205

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-01-210-003

- (1) Do these steps to make sure the captain's or first officer's seat tracks are fully attached to the floor:

NOTE: Use the horizontal control lever to move the seat forward and aft to examine all of the track.

 - (a) Try to move the seat tracks to make sure they are securely attached.
 - 1) If you find loose bolts on the seat tracks, tighten them.
 - (b) Do a visual inspection for cracks and corrosion on the seat tracks.

SUBTASK 25-11-01-210-007

- (2) Do these steps to inspect the seat tracks for wear:
 - (a) There are two conditions during which the seat track can become worn:
 - 1) Condition 1:
 - a) The lock pin rubs on the surface of the seat track while the seat is adjusted.
 - 2) Condition 2:
 - a) The lock hole becomes larger when the locking pin hits the edge of the lock hole too many times when the seat is adjusted.
 - (b) The seat track is in good condition when:

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- 1) The maximum depth of a groove on the surface of the seat track is not more than 0.065 in. (1.651 mm) for Condition 1.
- 2) The lock hole is 0.30 in. (7.62 mm) or less in diameter at a depth of 0.1 in. (2.54 mm) for the Condition 2.

SUBTASK 25-11-01-210-004

- (3) Do these steps to do a check of the surface of the seat track:
 - (a) Put the point of the inspection gauge, SPL-1638, in a groove that is on the surface of the seat track.
 - (b) If the protrusion touches the surface of the seat track, replace the seat track.

SUBTASK 25-11-01-210-005

- (4) Do these steps to do a check of the lock hole:
 - (a) Put the protrusion of the inspection gauge, SPL-1638, in the lock hole.
 - (b) If the bottom of the inspection gage touches the surface of the seat track, replace the seat track.

SUBTASK 25-11-01-210-006

- (5) Do a visual inspection to make sure the seat track lock pins are fully engaged at all seat track lock positions.

NOTE: Use the horizontal control lever to move the seat forward and aft to examine lock pin engagement in all track lock holes.

- (a) Make sure seat track lock pins are fully engaged in all seat track lock positions.

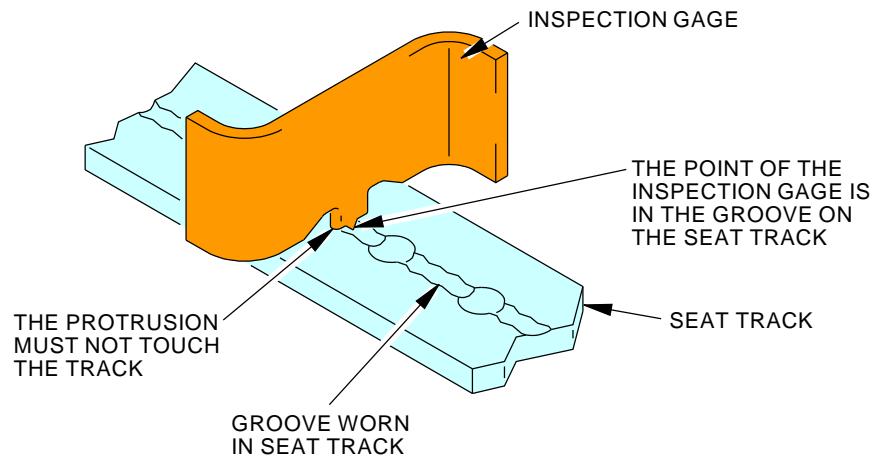
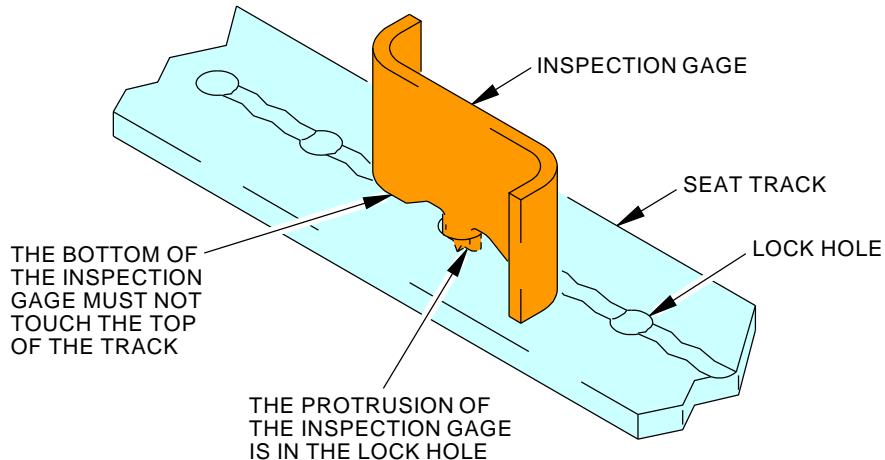
———— END OF TASK ———

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INSPECTION ON THE SURFACE OF THE SEAT TRACK

INSPECTION OF THE LOCK HOLE

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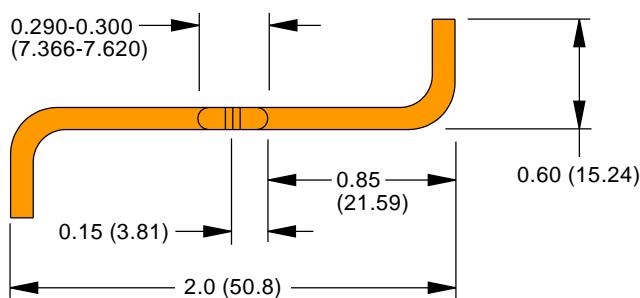
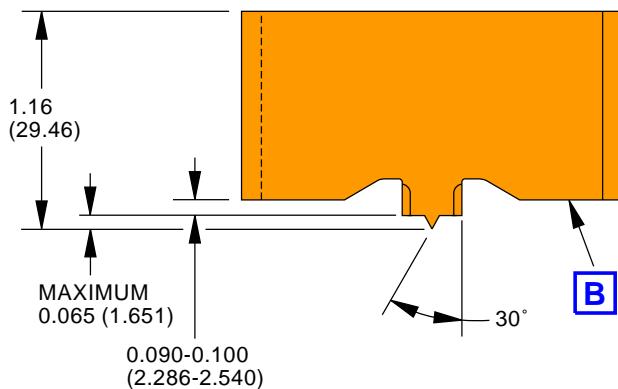
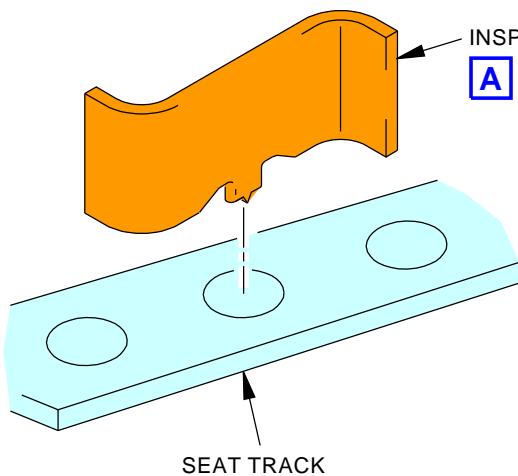
**Seat Track Inspection
Figure 601/25-11-01-990-804**

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INSPECTION GAGE
(BOTTOM VIEW)
(IPECO FLIGHT DECK SEATS)



NOTE:

ALL DIMENSIONS ARE IN INCHES (mm).

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Seat Track Inspection Gage
Figure 602/25-11-01-990-805

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OBSERVER'S SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the First Observer's Seat,
 - (2) An installation of the First Observer's Seat,
 - (3) A removal of the Second Observer's Seat,
 - (4) An installation of the Second Observer's Seat.

TASK 25-11-02-000-801

2. First Observer's Seat Removal

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-02-030-001

- (1) Remove the screws [21] that attach the seat to the seat structure.

SUBTASK 25-11-02-020-001

- (2) Remove the seat.

———— END OF TASK ————

TASK 25-11-02-400-801

3. First Observer's Seat Installation

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-02-400-001

- (1) Put the seat on the seat structure and align the screw holes.

SUBTASK 25-11-02-430-001

- (2) Install the screws [21] into the seat bottom and frame.

SUBTASK 25-11-02-700-001

- (3) Open the seat and make sure it engages the shoulder fittings [24] correctly.

- (a) If the distance between the two shoulder fittings [24] is not 21.44 ± 0.06 in.
 $(54.46 \pm 0.15$ cm), then remove or install shims [25] adjacent to the shoulder fittings.

NOTE: The shims [25] are not installed on all airplanes.

———— END OF TASK ————



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TASK 25-11-02-000-802

4. Second Observer's Seat Removal

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-02-030-002

- (1) Remove the screws [22] that attach the seat bottom to the seat structure.

SUBTASK 25-11-02-020-002

- (2) Remove the seat bottom.

SUBTASK 25-11-02-030-003

- (3) Pull on the seat back and headrest to remove them. They are attached with hook and loop fasteners (Velcro).

———— END OF TASK ————

TASK 25-11-02-400-802

5. Second Observer's Seat Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02360	Tape - Textile Hook And Loop Fasteners Tape (Polypropylene Hook & Nylon Loop)	BMS8-285 Type V

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-02-400-002

- (1) Align the bottom seat with the attachment holes and install the screws [22].

SUBTASK 25-11-02-400-003

- (2) Align the head rest and back cushions and push them against the bulkhead to engage the hook and loop fastener tape, G02360.

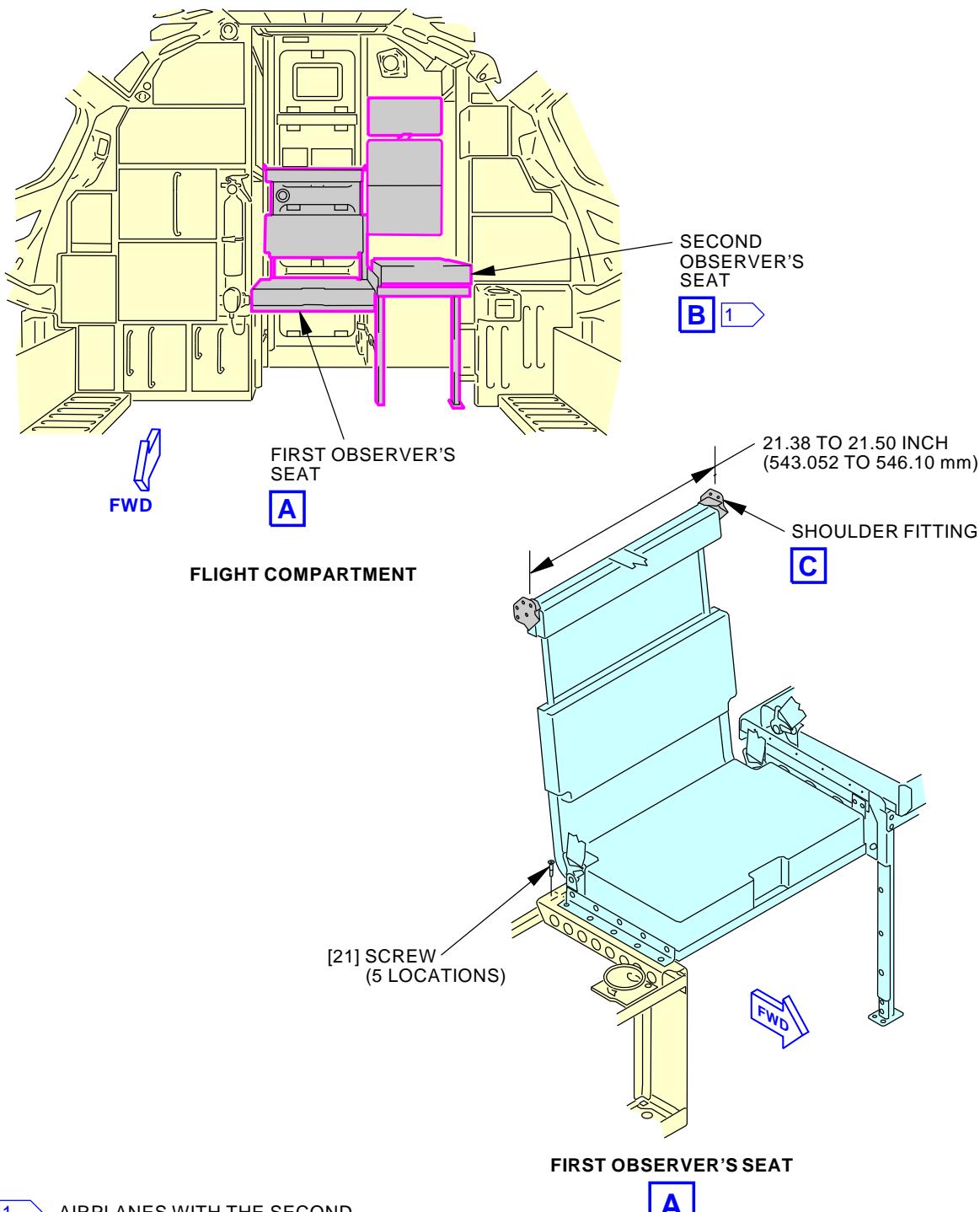
———— END OF TASK ————



25-11-02



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1 AIRPLANES WITH THE SECOND OBSERVER'S SEAT.

G86253 S0006566577_V4

Observer's Seat Installation
Figure 401/25-11-02-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

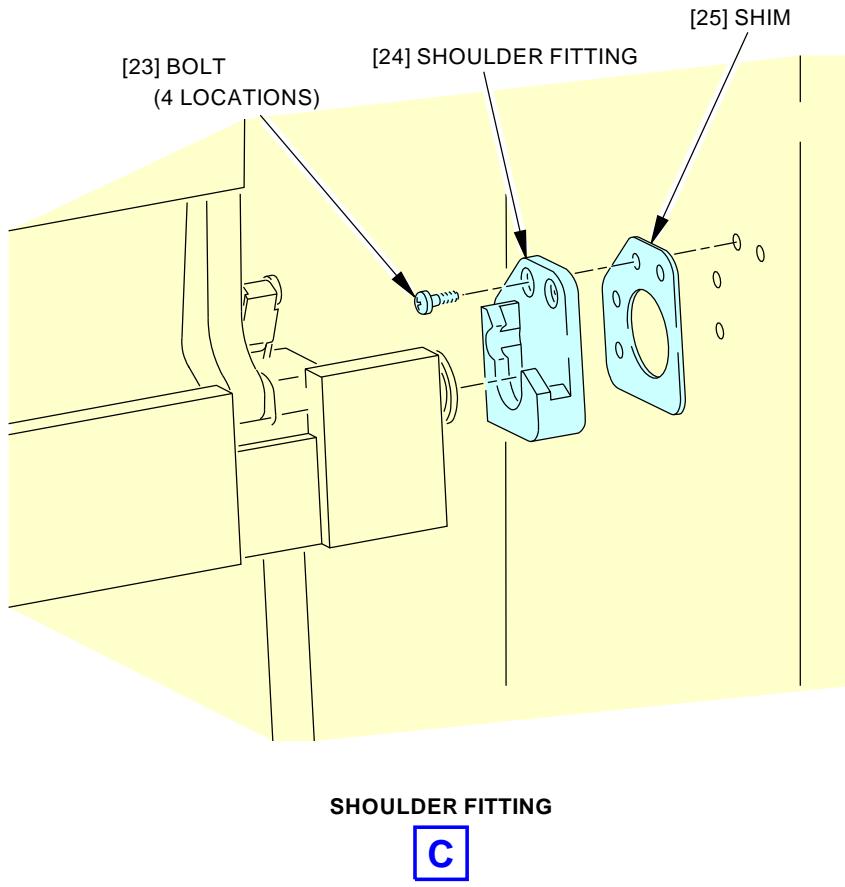
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AIRCRAFT MAINTENANCE MANUAL



1 NOT INSTALLED ON ALL AIRPLANES

G53521 S0006566579_V2

Observer's Seat Installation
Figure 401/25-11-02-990-801 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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AIRCRAFT MAINTENANCE MANUAL

FLIGHT COMPARTMENT FLOOR COVERING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The flight compartment floor covering removal.
 - (2) The flight compartment floor covering installation.

TASK 25-11-04-000-801

2. Flight Compartment Floor Covering Removal

(Figure 401)

A. General

- (1) This task includes the steps to remove the flight compartment floor covering.

B. References

Reference	Title
25-11-01-000-801	Captain's and First Officer's Seat Removal (P/B 401)
25-11-02-000-801	First Observer's Seat Removal (P/B 401)
25-11-02-000-802	Second Observer's Seat Removal (P/B 401)

C. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Procedure

SUBTASK 25-11-04-020-001

- (1) Remove the first observer's seats, if it is necessary (TASK 25-11-02-000-801).

SUBTASK 25-11-04-020-002

- (2) Remove the second observer's seats, if it is necessary (TASK 25-11-02-000-802).

SUBTASK 25-11-04-020-003

- (3) Remove the captain's and first officer's seat, if it is necessary (TASK 25-11-01-000-801).

SUBTASK 25-11-04-020-004

- (4) Remove the screws which attach the threshold at the flight compartment door, if it is applicable

SUBTASK 25-11-04-020-005

- (5) Remove the threshold.

SUBTASK 25-11-04-020-006

- (6) Pull up along all the edges of the floor covering section to remove it from the floor.

NOTE: The floor covering section is attached to the floor with double-back tape.

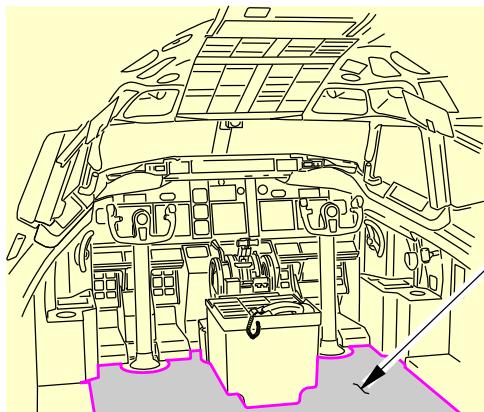
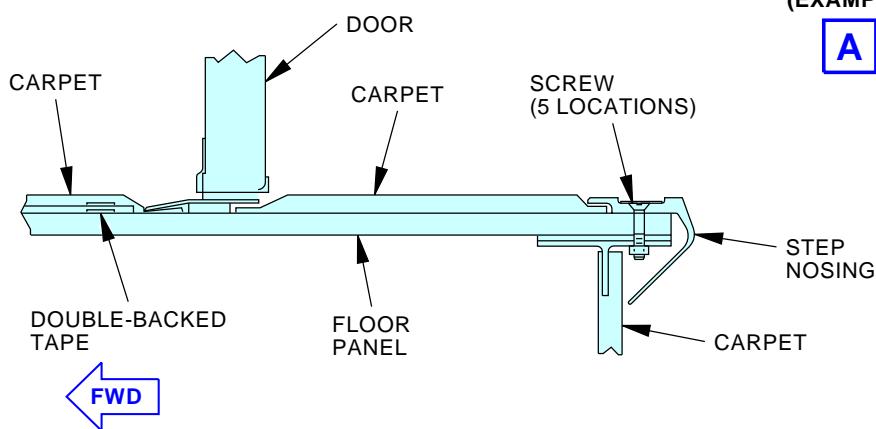
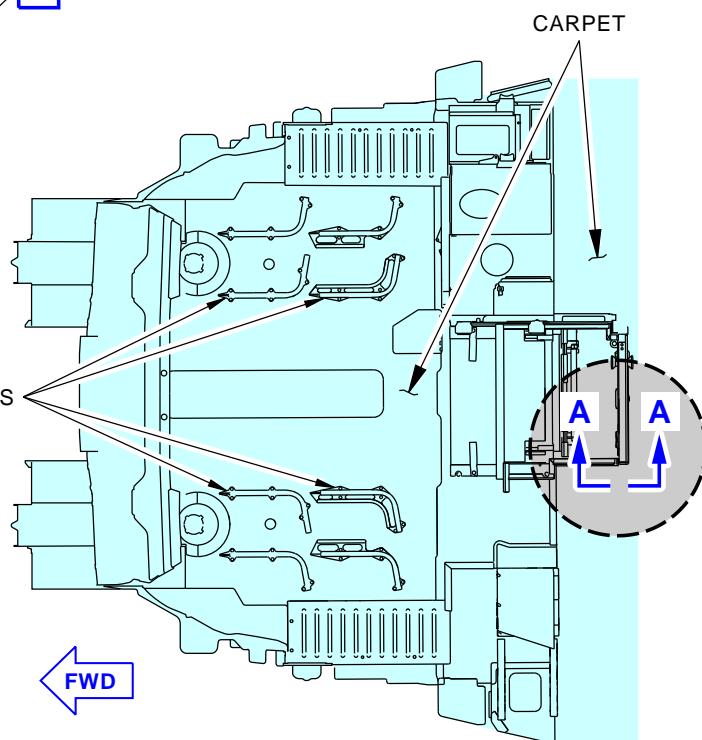
SUBTASK 25-11-04-020-007

- (7) Remove and discard the old tape.

———— END OF TASK ————



25-11-04


**FLIGHT COMPARTMENT
(EXAMPLE)**


2209078 S0000492266_V2

Flight Compartment Floor Covering Installation
Figure 401/25-11-04-990-801

 EFFECTIVITY
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TASK 25-11-04-400-801

3. Flight Compartment Floor Covering Installation

(Figure 401)

A. General

- (1) This task includes the steps to install the flight compartment floor covering.

B. References

Reference	Title
25-11-01-400-801	Captain's and First Officer's Seat Installation (P/B 401)
25-11-02-400-801	First Observer's Seat Installation (P/B 401)
25-11-02-400-802	Second Observer's Seat Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
G01288	Tape - Carpet	BMS5-133

D. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

E. Procedure

SUBTASK 25-11-04-420-001

- (1) Install the new double-back tape (carpet tape, G01288) to the floor as necessary.

SUBTASK 25-11-04-420-002

- (2) Install the floor covering sections on the floor.

NOTE: Make sure the double-back tape holds the floor covering sections to the floor.

SUBTASK 25-11-04-420-003

- (3) Install the threshold at the flight compartment door if applicable.

NOTE: Make sure you tighten the threshold screws sufficiently to keep the edges of the floor covering section in position.

SUBTASK 25-11-04-420-004

- (4) Install the captain's and first officer's seat, if removed (TASK 25-11-01-400-801).

SUBTASK 25-11-04-420-005

- (5) Install the second observer's seats, if removed (TASK 25-11-02-400-802).

SUBTASK 25-11-04-420-006

- (6) Install the first observer's seats, if removed (TASK 25-11-02-400-801).

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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FLIGHT COMPARTMENT SEAT TRACKS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains these tasks:
 - (1) Seat Track Wear Inspection,
 - (2) Seat Track Alignment Check.

TASK 25-11-11-200-801

2. Seat Track Wear Inspection

(Figure 601, Figure 602)

A. General

- (1) There are two conditions during which the seat track can become worn:
 - (a) Condition 1:
 - 1) The lock pin rubs on the surface of the seat track while the seat is adjusted.
 - (b) Condition 2:
 - 1) The lock hole becomes larger when the locking pin hits the edge of the lock hole too many times when the seat is adjusted.
- (2) The seat track is in good condition when:
 - (a) The maximum depth of a groove on the surface of the seat track is not more than 0.065 in. (1.651 mm) for Condition 1.
 - (b) The lock hole is not larger than 0.30 in. (7.62 mm) in diameter at a depth of 0.1 in. (2.54 mm) for the Condition 2.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1638	Gauge - Inspection, Seat Track, Flight Crew Seats (A25020-5 part of A25020-8) Part #: A25020-8 Supplier: 81205 Opt Part #: A25020-4 Supplier: 81205

C. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Procedure

SUBTASK 25-11-11-200-001

- (1) To do a check on the surface of the seat track, do the steps that follow:
 - (a) Put the point of the inspection gauge, SPL-1638 in a groove that is on the surface of the seat track.
 - (b) If the protrusion touches the surface of the seat track, replace the seat track.



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SUBTASK 25-11-11-200-002

- (2) To do a check of the lock hole, do the steps that follow:
- (a) Put the protrusion of the inspection gauge, SPL-1638 in the lock hole.
 - (b) If the bottom of the inspection gage touches the surface of the seat track, replace the seat track.

———— END OF TASK ————

EFFECTIVITY
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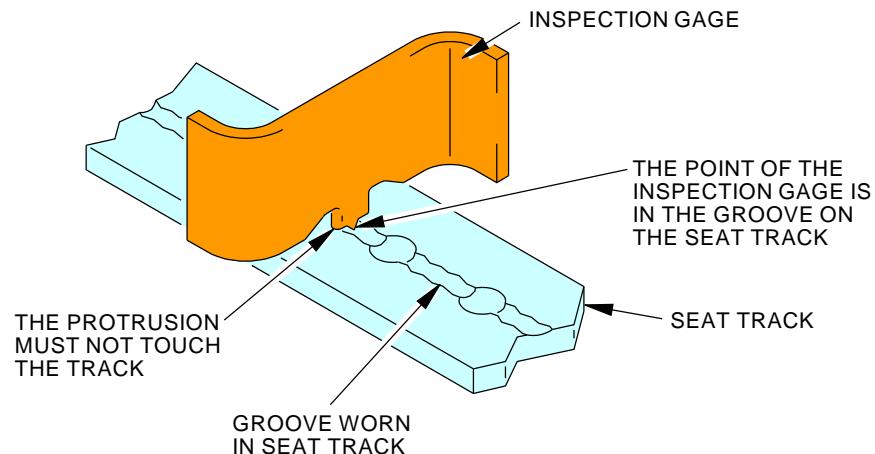
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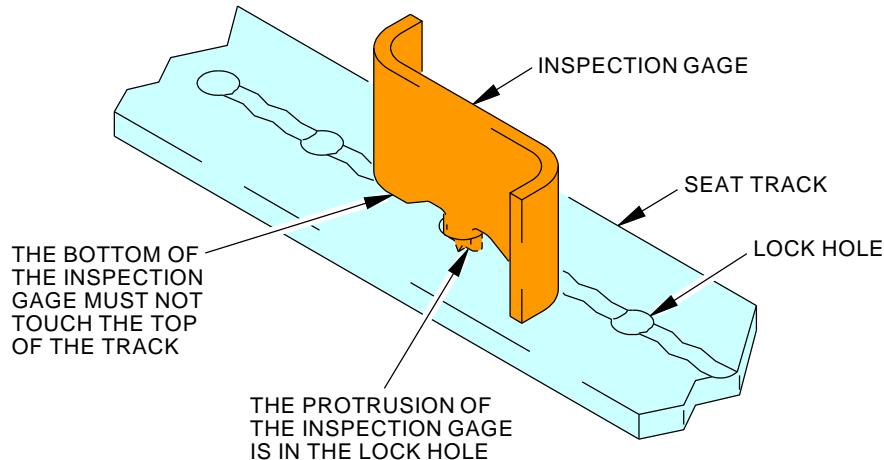
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INSPECTION ON THE SURFACE OF THE SEAT TRACK



INSPECTION OF THE LOCK HOLE

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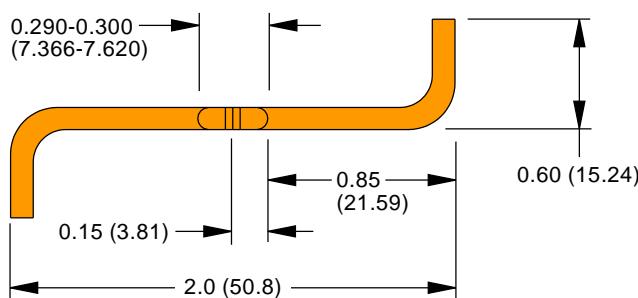
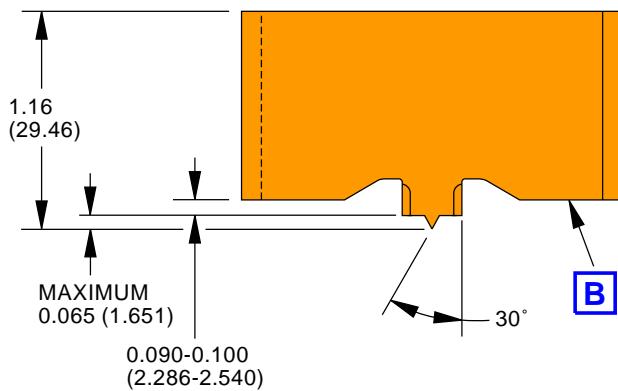
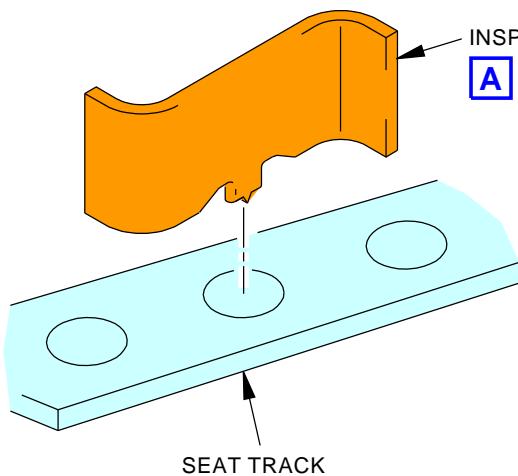
Seat Track Inspection
Figure 601/25-11-11-990-801

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL



INSPECTION GAGE
(BOTTOM VIEW)
(IPECO FLIGHT DECK SEATS)

B

NOTE:

ALL DIMENSIONS ARE IN INCHES (mm).

F96641 S0006566584_V4

Seat Track Inspection Gage
Figure 602/25-11-11-990-802

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-11-400-801

3. Flight Compartment Seat Tracks - Installation and Alignment

A. References

Reference	Title
25-11-01-000-801	Captain's and First Officer's Seat Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1644	Fixture - Track Setting Part #: 0T900-0247 Supplier: K9075

C. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Procedure

SUBTASK 25-11-11-010-001

- (1) Do this task: Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801.

SUBTASK 25-11-11-400-001

- (2) Mount the tracks in the proper positions.

NOTE: Do not tighten the bolts.

SUBTASK 25-11-11-280-001

- (3) Do these steps to align the seat tracks:

- Remove any "stops" that extend above the top surface of the seat tracks.
- Put the fixture, COM-1644, over the seat tracks.
- Make sure the fixture, COM-1644, goes easily into the tracks.

NOTE: The seat tracks are correctly aligned if all eight pins of the fixture, COM-1644, engage in the holes on the top surface of each seat track when you apply only light downward pressure.

- If the fixture, COM-1644, does not go easily into the seat tracks, loosen all of the bolts in the seat tracks.

SUBTASK 25-11-11-480-001

- (4) Put the fixture, COM-1644, over the seat tracks.

SUBTASK 25-11-11-420-001

- (5) Apply a slight downward pressure.

NOTE: The locating pins of the fixture, COM-1644, should fully engage in the holes in the top surface of each track.

SUBTASK 25-11-11-420-002

- (6) Tighten the seat track bolts that you can get access to.

EFFECTIVITY
AKS ALL

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SUBTASK 25-11-11-000-001

- (7) Remove the fixture, COM-1644.

SUBTASK 25-11-11-420-003

- (8) Tighten all the seat track bolts.

———— END OF TASK ————

———— EFFECTIVITY ————
AKS ALL

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AIRCRAFT MAINTENANCE MANUAL

FLIGHT COMPARTMENT PANELS - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:

AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD)

- (1) Flight Compartment Forward Ceiling Panel Removal,
- (2) Flight Compartment Forward Ceiling Panel Installation,

AKS ALL

- (3) Flight Compartment Dripshield Removal,
- (4) Flight Compartment Dripshield Installation.
- (5) Flight Compartment Sunvisor Adjustment and Test
- (6) Roller Sunshade Removal
- (7) Roller Sunshade Installation
- (8) Flight Compartment Aft Ceiling Panel Removal.
- (9) Flight Compartment Aft Ceiling Panel Installation.

AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD)

TASK 25-11-21-000-801

2. Flight Compartment Forward Ceiling Panel Removal

(Figure 201)

A. General

- (1) The forward ceiling panels in the flight compartment (the panels to the left and right of the circuit breaker panel) have two screws under the upper lining for the No. 3 window. Thus, you must remove the lining from the No. 3 window before you can remove the overhead panel.

B. References

Reference	Title
25-61-10-000-801	Flight Compartment Escape Rope Removal (P/B 201)

C. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Procedure

SUBTASK 25-11-21-020-009

- (1) Do these steps to remove the closure panels [2] and [4]:

- (a) Remove the two screws [3].
- (b) Remove the upper closure panel [2].

NOTE: The closure panels are attached with the hook-and-loop fasteners (Velcro).

- (c) Remove the lower closure panel [4].

SUBTASK 25-11-21-020-010

- (2) Do these steps to remove the lower lining [5] for window No. 3:

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AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD) (Continued)

- (a) Disconnect the electrical wire [6].
- (b) Remove the screws.
- (c) Move the lower lining [5] away from the wall until you can disconnect the electrical wiring from the back of the panel.
- (d) Remove the lower lining [5].

SUBTASK 25-11-21-020-011

- (3) Do these steps to remove the upper lining [7] for window No. 3:
 - (a) Remove the screws.
 - (b) Remove the upper lining [7].

SUBTASK 25-11-21-020-035

- (4) Do these steps to remove the sunvisor track [9]:
 - (a) Remove screws [8] and [10] from the sunvisor track.
 - (b) Remove the sunvisor track [9].

SUBTASK 25-11-21-020-036

- (5) Do these steps to remove the forward lining cover [11] for the window No. 1:
 - (a) Remove six screws [12] from the cover.
 - (b) Hang the forward lining cover [11] from the drain hoses.

SUBTASK 25-11-21-020-037

- (6) Do these steps to remove the eyebrow pad [14]:
 - (a) Remove the four screws [13] from the eyebrow pad.
 - (b) Remove the eyebrow pad [14].

SUBTASK 25-11-21-020-038

- (7) Do this task: Flight Compartment Escape Rope Removal, TASK 25-61-10-000-801.

SUBTASK 25-11-21-020-039

- (8) Do this step to remove the rubber trim strips [15] from the aft edge of the ceiling panel:
NOTE: The strips are attached to the ceiling panel edges with the hook-and-loop fasteners (Velcro).
 - (a) On the left ceiling panel, also remove the trim pad [1] that is in the aft corner above the small stowage compartment. It is attached with the hook-and-loop fasteners.

SUBTASK 25-11-21-020-040

- (9) Do these steps to remove the ceiling panel [17]:
 - (a) Hold the ceiling panel [17] and remove the screws [16] from it.
NOTE: On the right ceiling panel, one of the screws is in the spare bulb compartment.
 - (b) Lower the ceiling panel [17] until you can disconnect the hoses and wiring.
 - 1) Disconnect the speaker wires.
 - 2) Disconnect the air hose(s).
 - (c) Remove the ceiling panel [17].

— END OF TASK —

EFFECTIVITY
AKS ALL

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AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD) (Continued)

TASK 25-11-21-400-801

3. Flight Compartment Forward Ceiling Panel Installation

(Figure 201)

A. References

Reference	Title
25-61-10-400-801	Flight Compartment Escape Rope Installation (P/B 201)

B. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-21-420-009

- (1) Do these steps to install the ceiling panel [17]:

- Attach the speaker wires.
- Attach the air hose(s).
- Put the ceiling panel [17] in its position.
- Install the screws [16] that attach the ceiling panel to the airplane structure.

NOTE: On the right ceiling panel, one of the screw is in the spare bulb compartment.

SUBTASK 25-11-21-420-010

- (2) Do this step to install the rubber trim strips [15] on the ceiling panel edges:

- On the left ceiling panel, install the trim pad [1] that is in the aft corner above the small stowage compartment.

SUBTASK 25-11-21-420-011

- (3) Do this task: Flight Compartment Escape Rope Installation, TASK 25-61-10-400-801.

SUBTASK 25-11-21-420-012

- (4) If installed, do these steps to install the eyebrow pad [14]:

- Put the eyebrow pad [14] in its position.
- Install the screws [13] that attach the eyebrow pad [14] to the ceiling.

SUBTASK 25-11-21-420-013

- (5) Do these steps to install the forward lining cover [11] for the window No. 1:

- Put the forward lining cover [11] in its position over the window No. 1.
- Install the screws [12] that attach the forward lining cover to the airplane.

SUBTASK 25-11-21-420-014

- (6) Do these steps to install the sunvisor track [9]:

- Put the sunvisor track in its position.
- Install the screws [8] and [10] that attach the sunvisor track to the airplane.

SUBTASK 25-11-21-420-033

- (7) Do these steps to install the upper lining [7] for window No. 3.

EFFECTIVITY
AKS ALL

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AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD) (Continued)

- (a) Put the upper lining [7] in its position.
- (b) Install the screws.

SUBTASK 25-11-21-420-034

- (8) Do these steps to install the lower lining [5] for window No. 3.
 - (a) Put the lower lining [5] in its position.
 - (b) Connect the electrical wiring to the back of the panel.

AKS ALL

- (c) Make sure the receptacle connector keyway for the electrical wire [6] is set at the up position, or 12 o'clock.

AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD)

- (d) Install the screws.
- (e) Connect the electrical wire [6].

SUBTASK 25-11-21-420-035

- (9) Do these steps to install the closure panels [2] and [4]:
 - (a) Put the lower closure panel [4] in its position.
 - (b) Put the upper closure panel [2] in its position.
 - (c) Install the two screws [3].

SUBTASK 25-11-21-710-001

- (10) Do these operational checks:

AKS ALL

- (a) Make sure the oxygen system for the flight crew is pressurized.

AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD)

- (b) Make sure the SERVICE INTERPHONE switch on the pilot's overhead panel is in the OFF position.

AKS ALL

- (c) Set all audio control panels (ACPs) to these conditions:
 - 1) Push all audio monitor switches to OFF.
 - 2) Push the FLT microphone selector switch to ON.
 - a) Make sure its light comes on.
 - 3) Push the volume control for the FLT microphone selector switch.
 - a) Make sure its light comes on.
 - 4) Turn the volume control for the FLT microphone selector switch clockwise to the middle position.

AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD)

- (d) Set the captain's and first officer's ACPs to these conditions:
 - 1) Push the SPKR volume control switch to ON.
 - a) Make sure its light comes on.

EFFECTIVITY
AKS ALL

25-11-21



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AIRCRAFT MAINTENANCE MANUAL

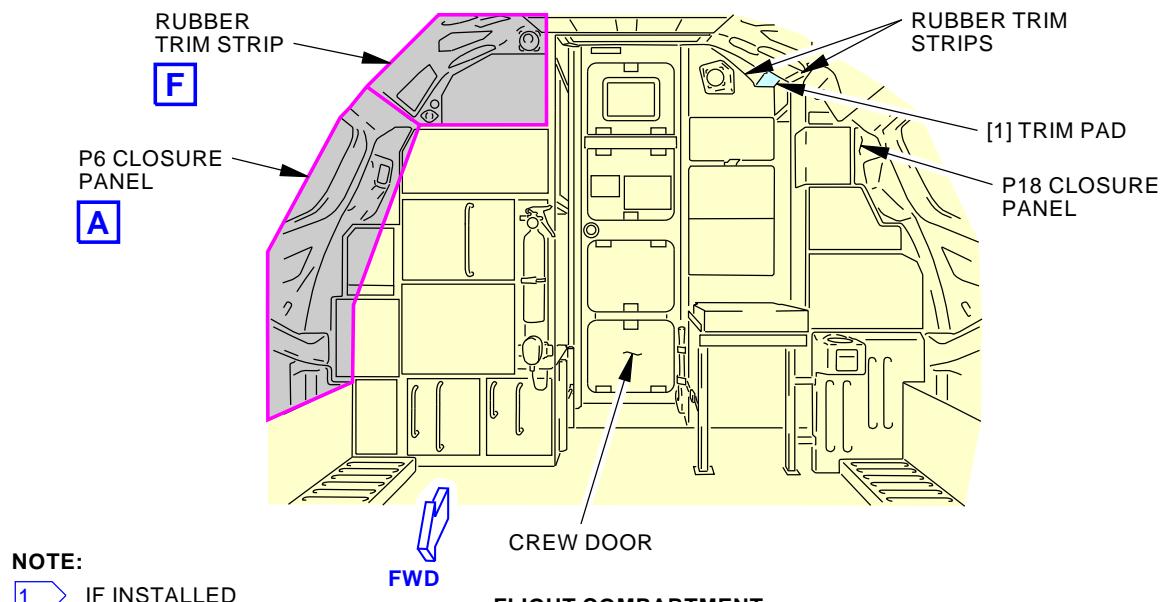
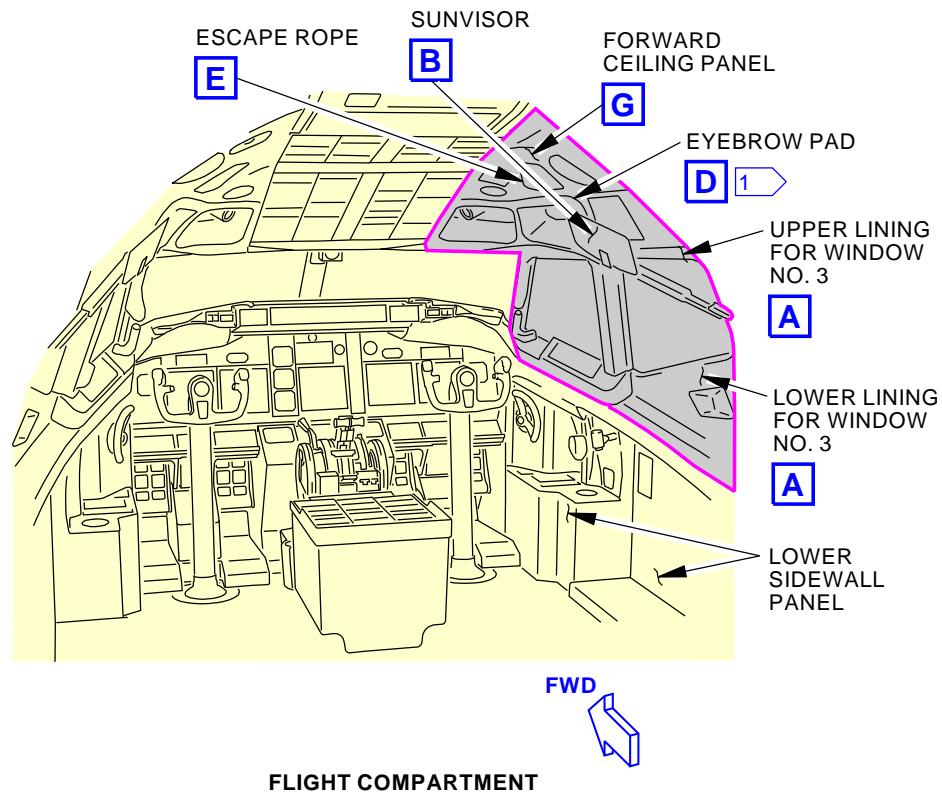
AKS ALL; AIRPLANES WITHOUT HEAD UP GUIDANCE SYSTEM (HUD) (Continued)

- 2) Turn the SPKR volume control switch clockwise to the middle position or to the volume level you are comfortable with.
- (e) Do a check of the flight crew speaker with the PTT switch on the hand microphone:
 - 1) Push and hold the PTT switch on the hand microphone at the opposite flight crew station.
 - 2) Speak into the hand microphone.
 - a) Make sure the voice is heard from the flight deck speaker.
 - 3) Release the PTT switch on the hand microphone.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-11-21

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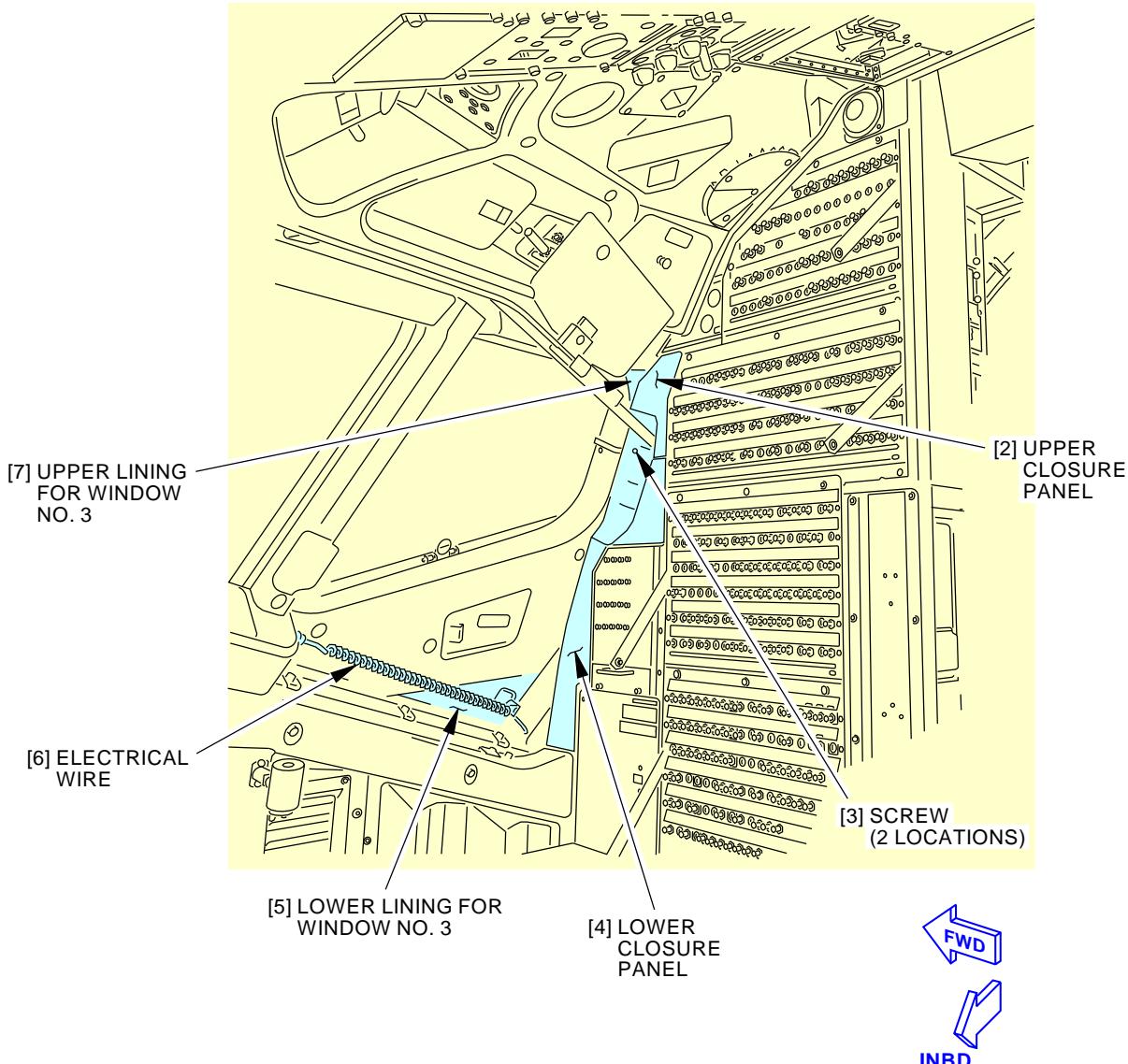
**Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 1 of 7)**

EFFECTIVITY
AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)

D633A101-AKS

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**CLOSURE AND WINDOW PANELS
(RIGHT SIDE IS SHOWN, LEFT SIDE IS OPPOSITE)**

A

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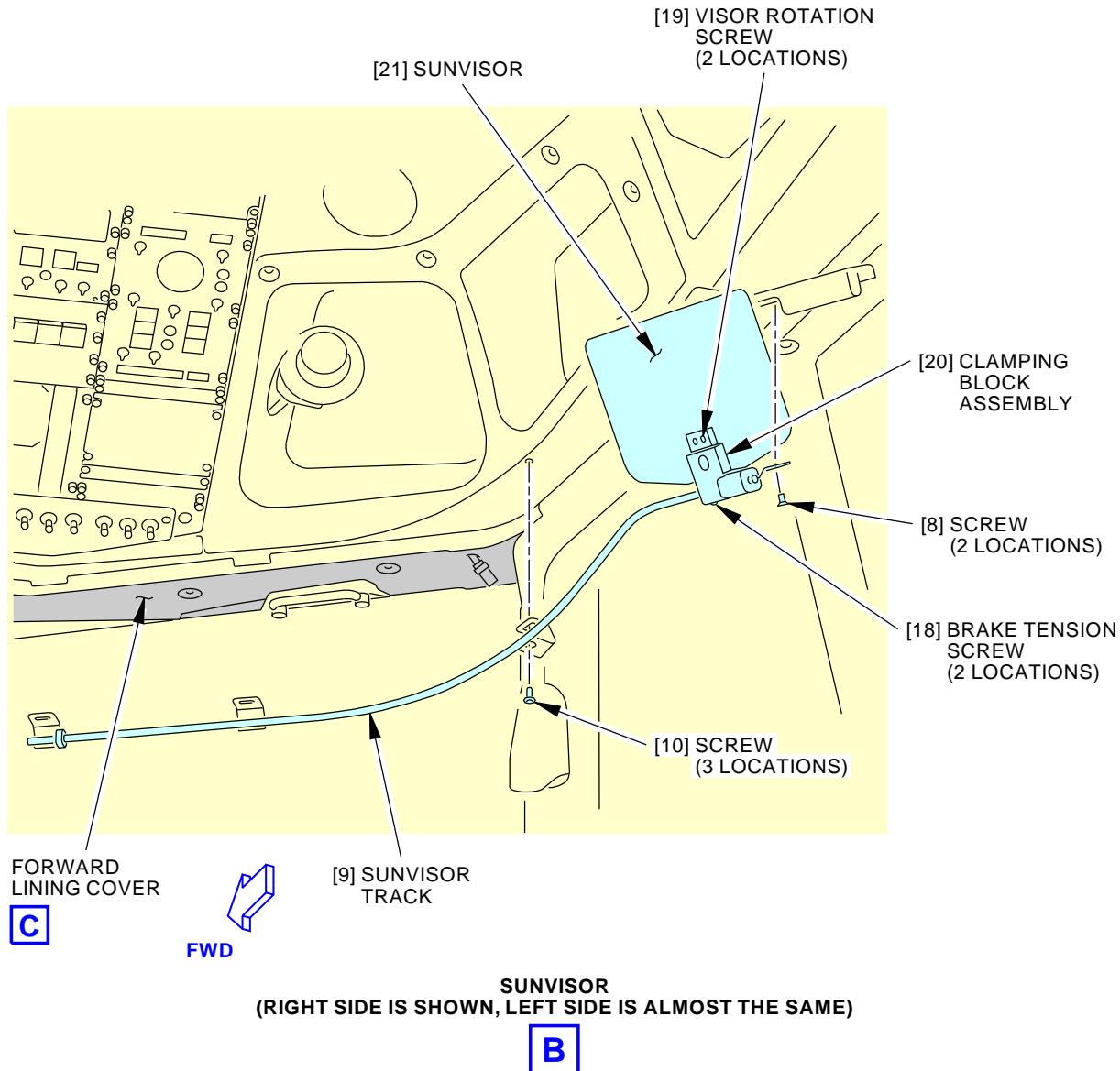
**Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 2 of 7)**

EFFECTIVITY
**AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)**

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G66380 S0006566597_V3

Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 3 of 7)

EFFECTIVITY
**AKS ALL; AIRPLANES WITHOUT HEAD UP
 GUIDANCE SYSTEM (HUD)**

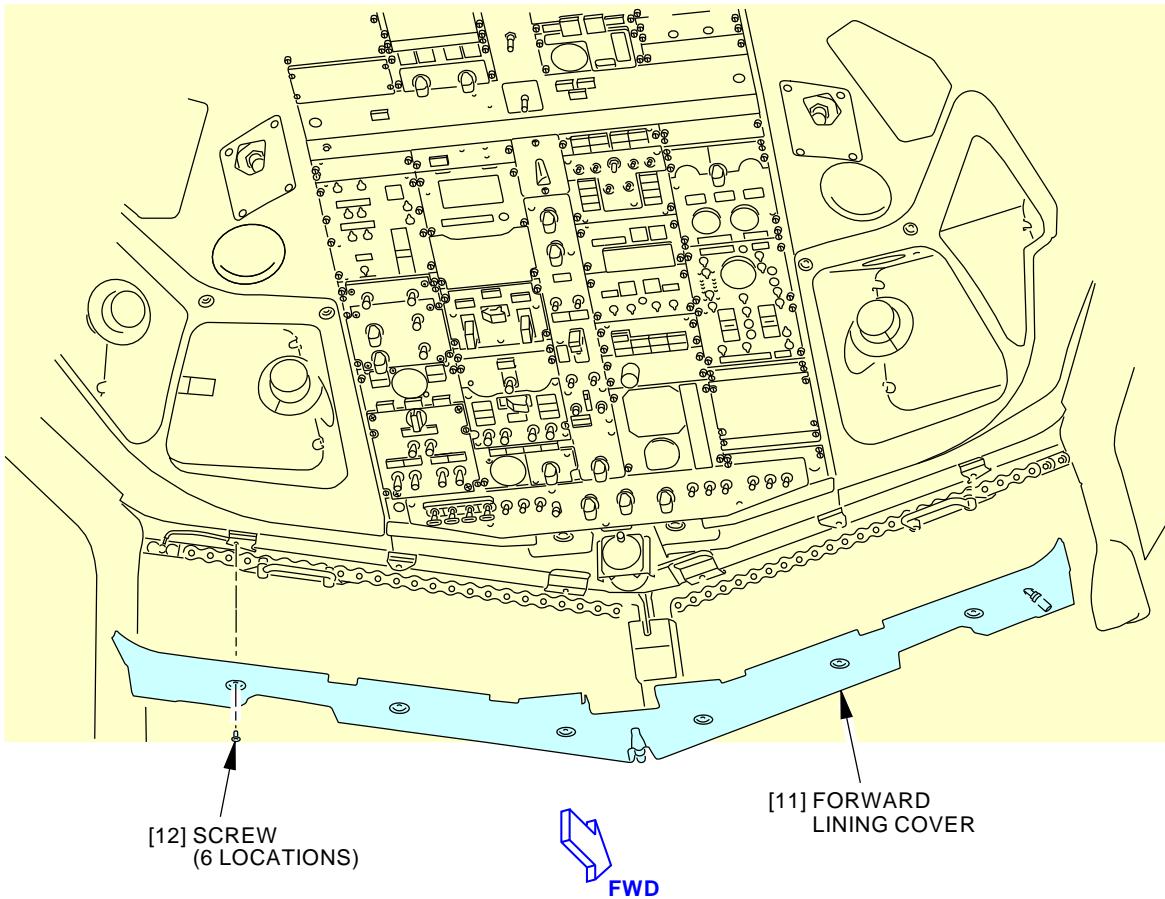
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AIRCRAFT MAINTENANCE MANUAL



FORWARD LINING COVER



G66382 S0006566598_V2

Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 4 of 7)

EFFECTIVITY
AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)

25-11-21

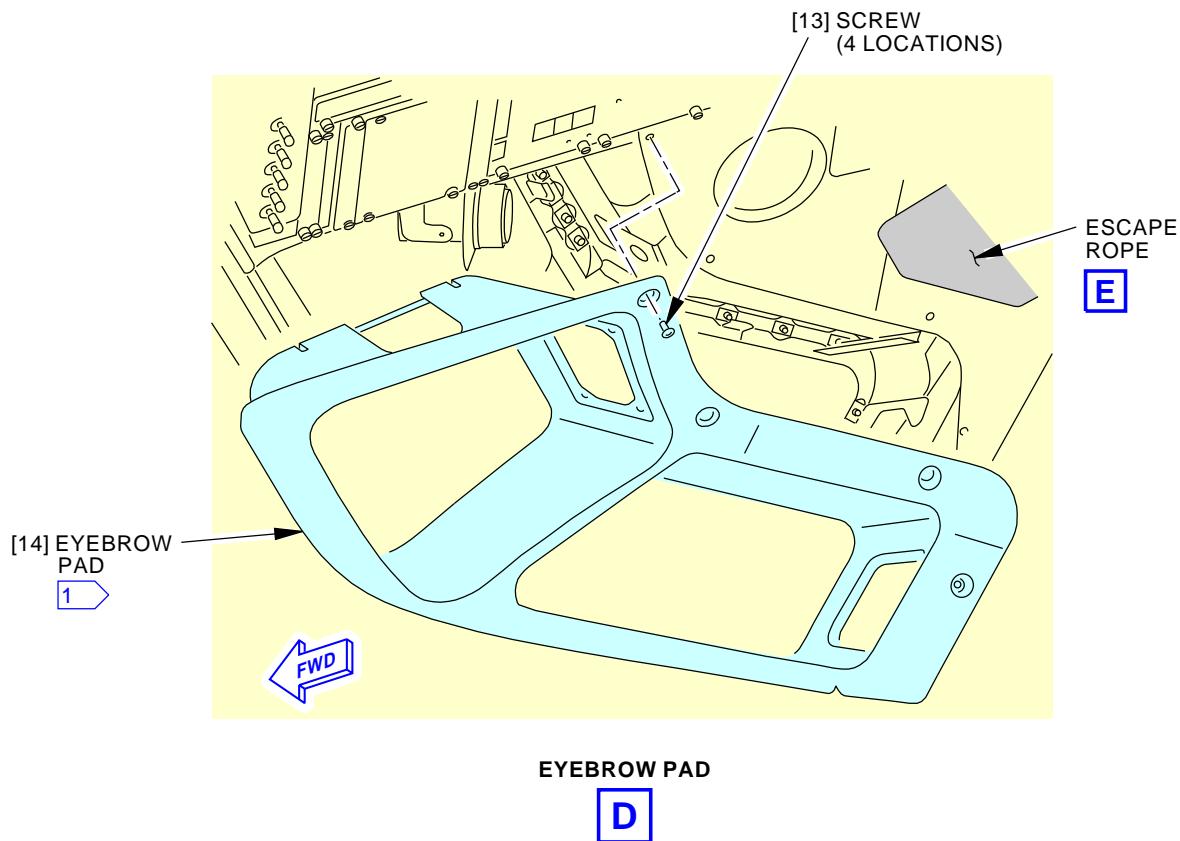
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NOTE:

IF INSTALLED

D64267 S0000162605_V3

Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 5 of 7)

EFFECTIVITY
AKS ALL

25-11-21

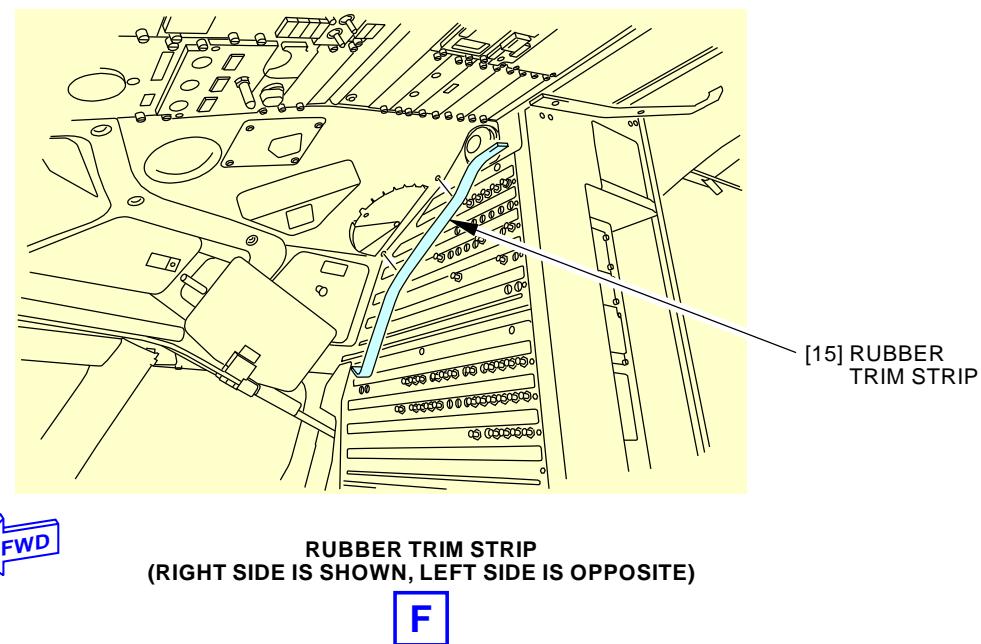
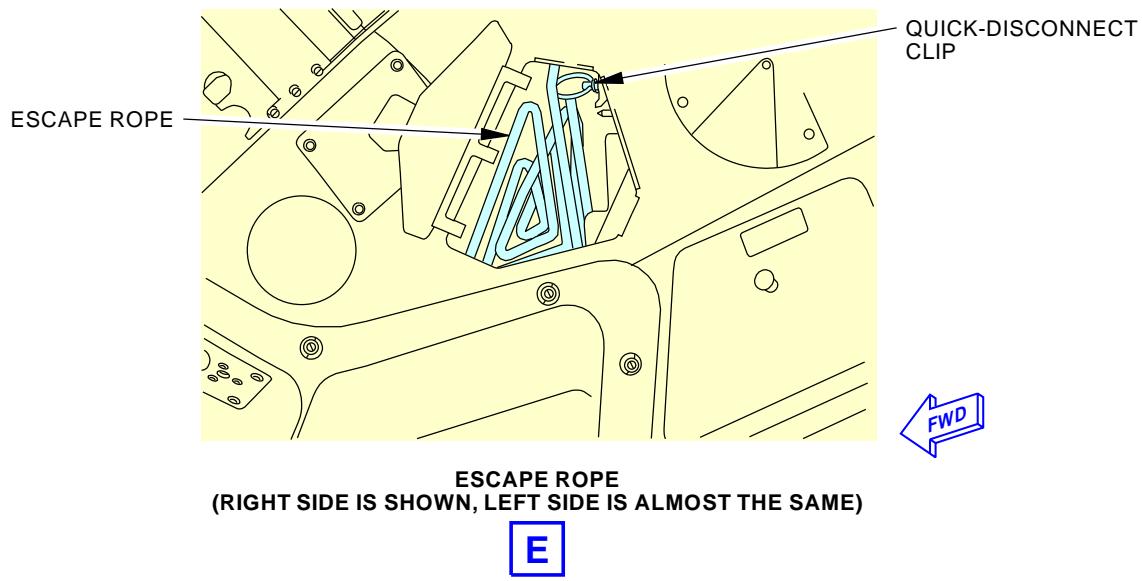
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



G66385 S0006566600_V3

Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 6 of 7)

EFFECTIVITY
AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)

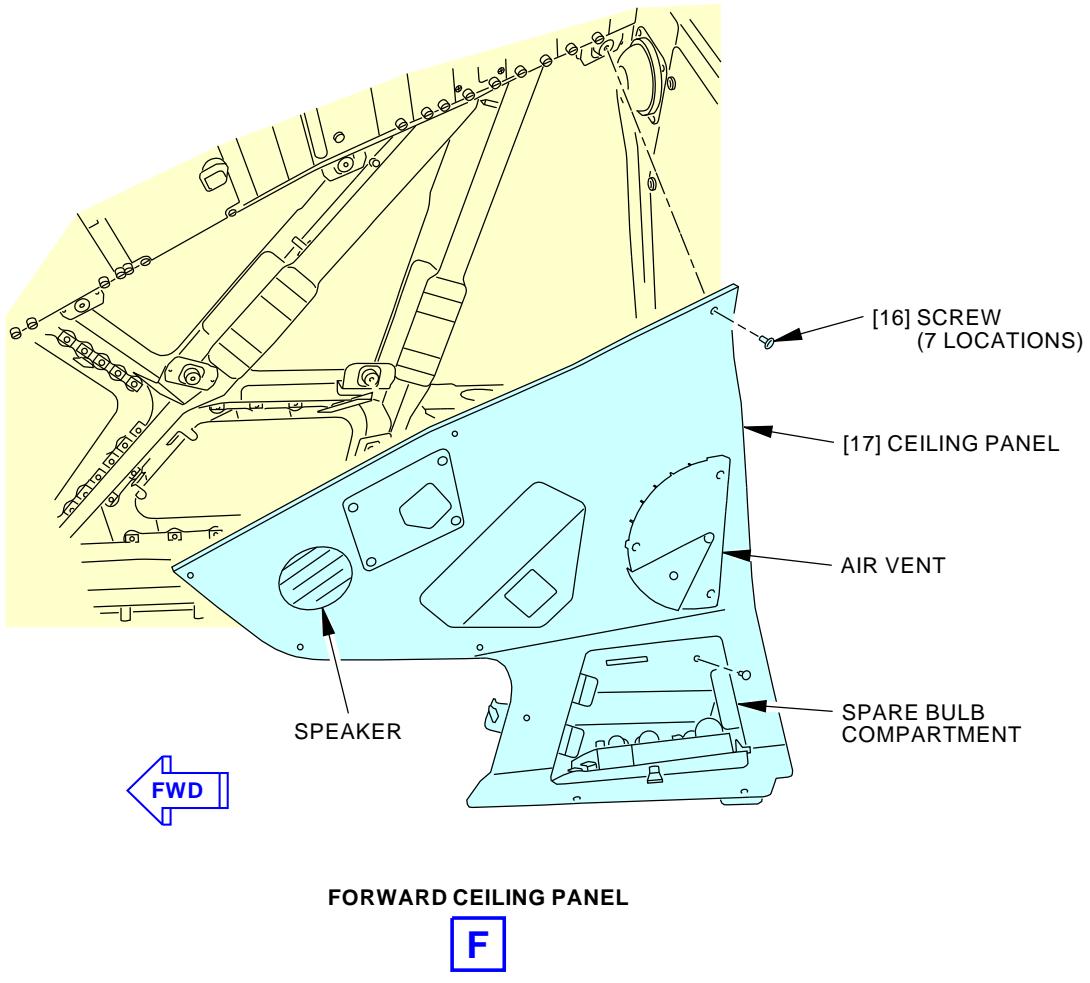
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



G89778 S0006566601_V3

Flight Compartment Forward Ceiling Installation
Figure 201/25-11-21-990-804 (Sheet 7 of 7)

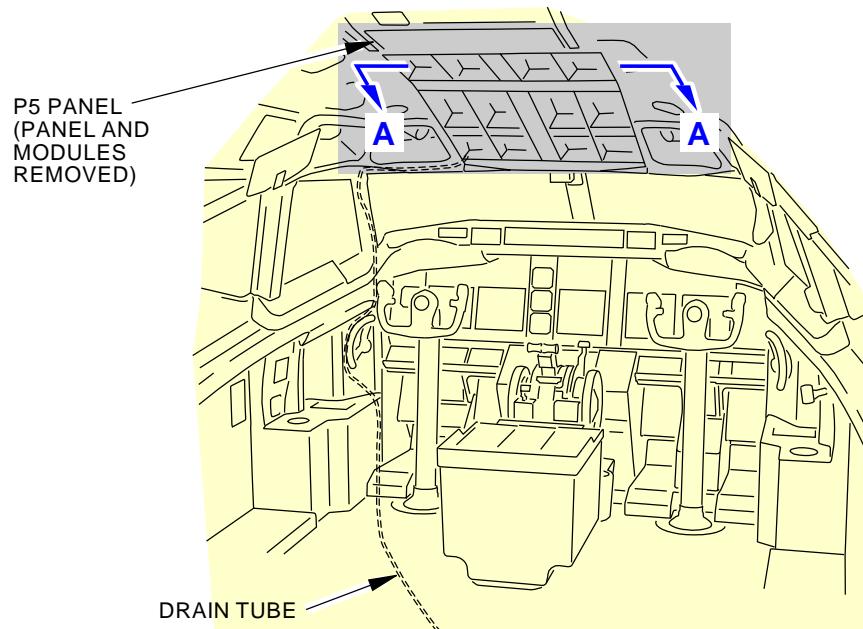
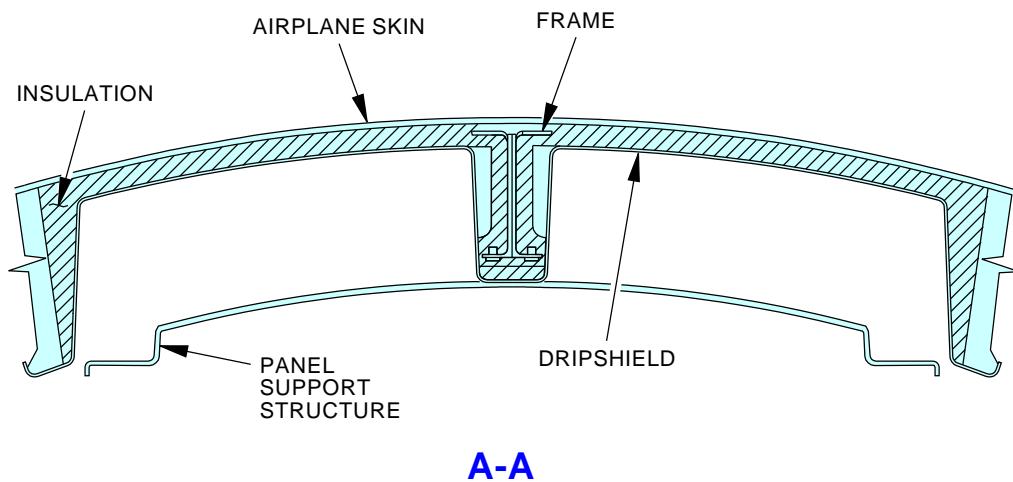
EFFECTIVITY
AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)

25-11-21

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FLIGHT COMPARTMENT

A-A

F93550 S0006566602_V2

**Flight Compartment Dripshield Installation
Figure 202/25-11-21-990-805**

EFFECTIVITY
**AKS ALL; AIRPLANES WITHOUT HEAD UP
GUIDANCE SYSTEM (HUD)**

25-11-21

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AIRCRAFT MAINTENANCE MANUAL

AKS ALL

TASK 25-11-21-000-803

4. Flight Compartment Dripshield Removal

(Figure 203)

A. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)

B. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-21-010-004

- (1) Remove the overhead, P5, instrument modules.

SUBTASK 25-11-21-010-005

- (2) Do this task: Flight Compartment Forward Ceiling Panel Removal, TASK 25-11-21-000-801.

SUBTASK 25-11-21-010-006

- (3) Remove the P5 panel support structure.

SUBTASK 25-11-21-010-007

- (4) Remove the wire supports and clips.

SUBTASK 25-11-21-020-005

- (5) Disconnect the wires where it is necessary.

SUBTASK 25-11-21-020-006

- (6) Loosen the wire bundles where it is necessary.

SUBTASK 25-11-21-020-007

- (7) Remove the fasteners that remain.

SUBTASK 25-11-21-020-008

- (8) Push the wire bundles out of the holes to remove the drip pan.

SUBTASK 25-11-21-210-003

- (9) Do this task: Insulation Blanket Removal, TASK 25-80-00-000-801.

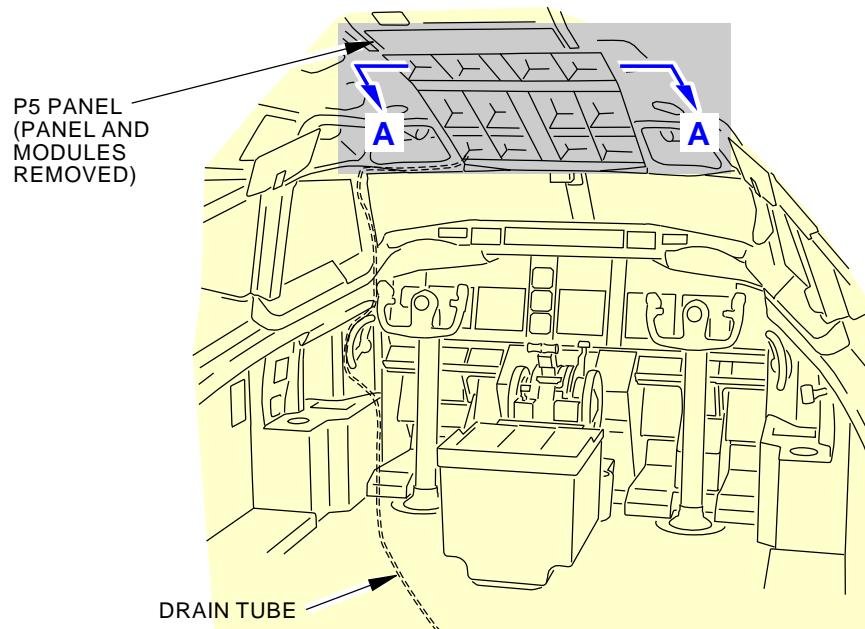
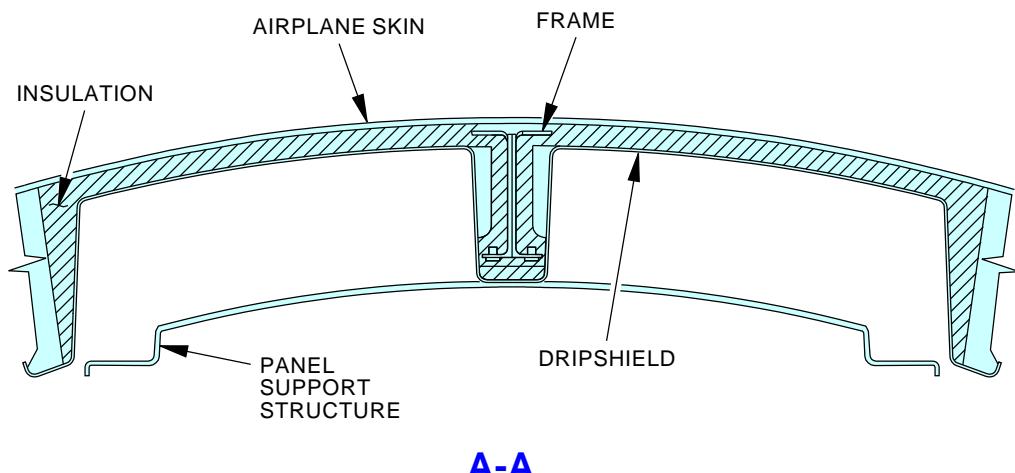
SUBTASK 25-11-21-210-004

- (10) Do a general visual inspection of the flight compartment structure above the forward and aft P5 panel dripshield.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-11-21


FLIGHT COMPARTMENT


F93550 S0006566602_V2

Flight Compartment Dripshield Installation
Figure 203/25-11-21-990-810

EFFECTIVITY
AKS ALL

25-11-21

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AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-21-400-803

5. Flight Compartment Dripshield Installation

(Figure 203)

A. References

Reference	Title
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

B. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-21-420-007

- (1) Do this task: Insulation Blanket Installation, TASK 25-80-00-400-801.
- (2) Put the drip pan into its position and install it with the bolts.

SUBTASK 25-11-21-420-008

- (3) Put the wires in the correct positions.

SUBTASK 25-11-21-410-005

- (4) Install the wire supports and the clips.

SUBTASK 25-11-21-410-006

- (5) Install the support structure of the P5 overhead panel.

SUBTASK 25-11-21-410-007

- (6) Install the overhead instrument modules.

SUBTASK 25-11-21-410-008

- (7) Do this task: Flight Compartment Forward Ceiling Panel Installation, TASK 25-11-21-400-801.

————— END OF TASK ————

TASK 25-11-21-700-801

6. Flight Compartment Sunvisor Adjustment and Test

(Figure 204)

A. General

- (1) Do this task to make sure that the necessary forces to move and turn the flight compartment sunvisors are correct.

B. Tools/Equipment

Reference	Description
STD-4787	Wrench - Allen, Hex, 9/64 inch

C. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

EFFECTIVITY
AKS ALL

25-11-21



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AIRCRAFT MAINTENANCE MANUAL

D. Procedure

SUBTASK 25-11-21-720-001

- (1) Do these steps to adjust the necessary force to rotate the sunvisor around the perimeter of the sunvisor track [9].
 - (a) Put the sunvisor in the fully down position.
 - (b) Set the sunvisor lock release lever to the lock position.
 - (c) Use the 9/64 inch allen wrench, STD-4787 to adjust the brake tension screws [18].
 - 1) Turn the two screws [18] in 1/4 turn increments.
NOTE: Turn the screws clockwise to loosen, and counterclockwise to tighten.
 - (d) Use a force gage to measure the necessary force applied perpendicular to the vertical edge of the sunvisor plate to rotate the sunvisor around the sunvisor track [9]
 - (e) The screw adjustment is correct when a force of 0.8-1.2 pounds (3.5-5.3 newtons) is necessary to rotate the sunvisor around the sunvisor track [9].

SUBTASK 25-11-21-720-002

- (2) Do these steps to adjust the necessary force to turn the sunvisor.
 - (a) Put the sunvisor in the fully down position.
 - (b) Set the sunvisor lock release lever to the lock position.
 - (c) Adjust the sunvisor rotation screws [19].
 - 1) Turn the two screws [19] in 1/4 turn increments.
 - (d) Use a force gage to measure the necessary force to turn the sunvisor.
 - (e) The screw adjustment is correct when a force of 1.0 to 1.5 pounds (4.45 to 6.67 newtons) is necessary to turn the sunvisor.

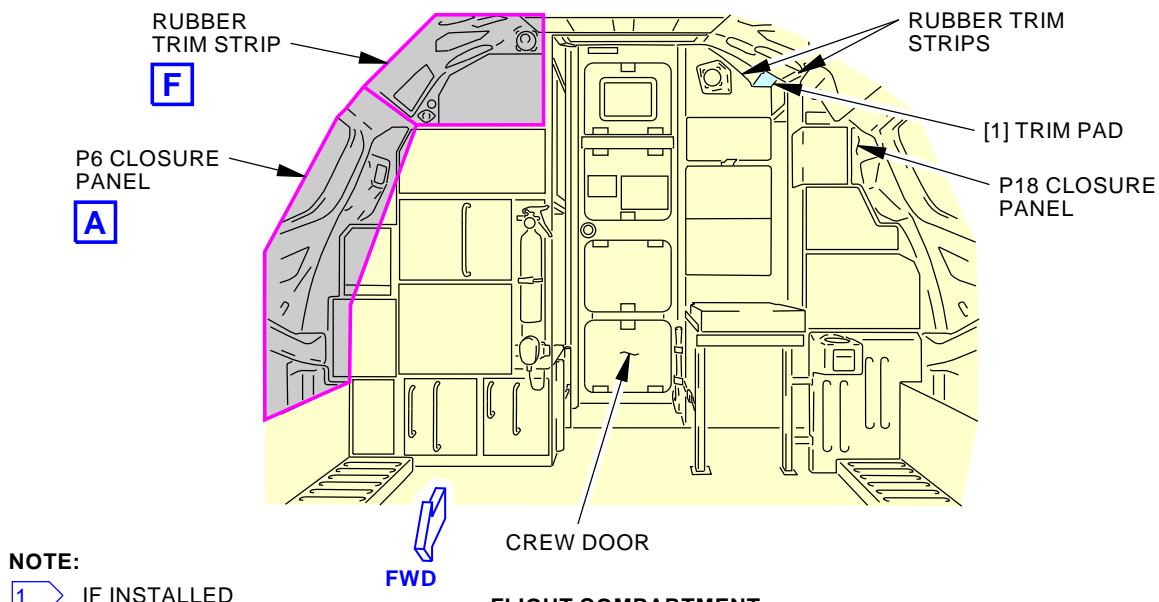
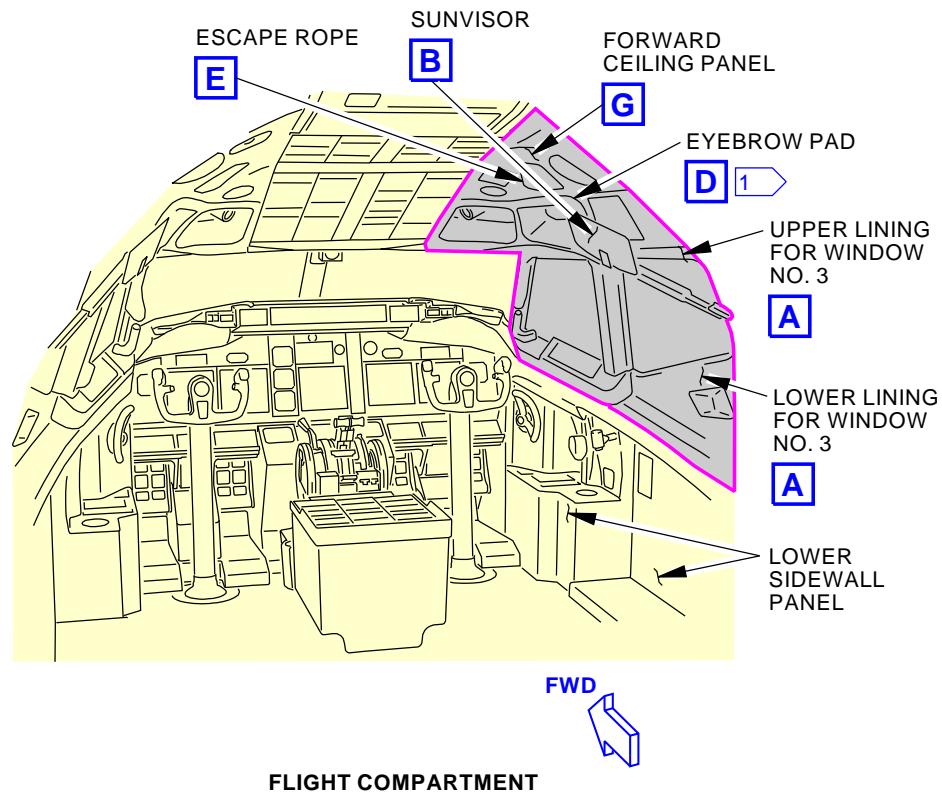
SUBTASK 25-11-21-800-001

- (3) Do these steps to check the sunvisor for travel along the length of the sunvisor track [9].
 - (a) Slide clamp block assembly [20] over the sunvisor track [9].
NOTE: The sunvisor lock release lever should be placed in the horizontal position to unlock the clamp block assembly [20]. The sunvisor will slide freely along the sunvisor track [9].
 - (b) Set the sunvisor lock release lever to the lock position.
NOTE: The sunvisor should be unable to travel along the sunvisor track [9]. If the sunvisor can be moved along the sunvisor track [9], the clamp assembly is worn and the sunvisor should be replaced.

———— END OF TASK ———



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F93264 S0006566595_V3

**Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 1 of 7)**

EFFECTIVITY
AKS ALL

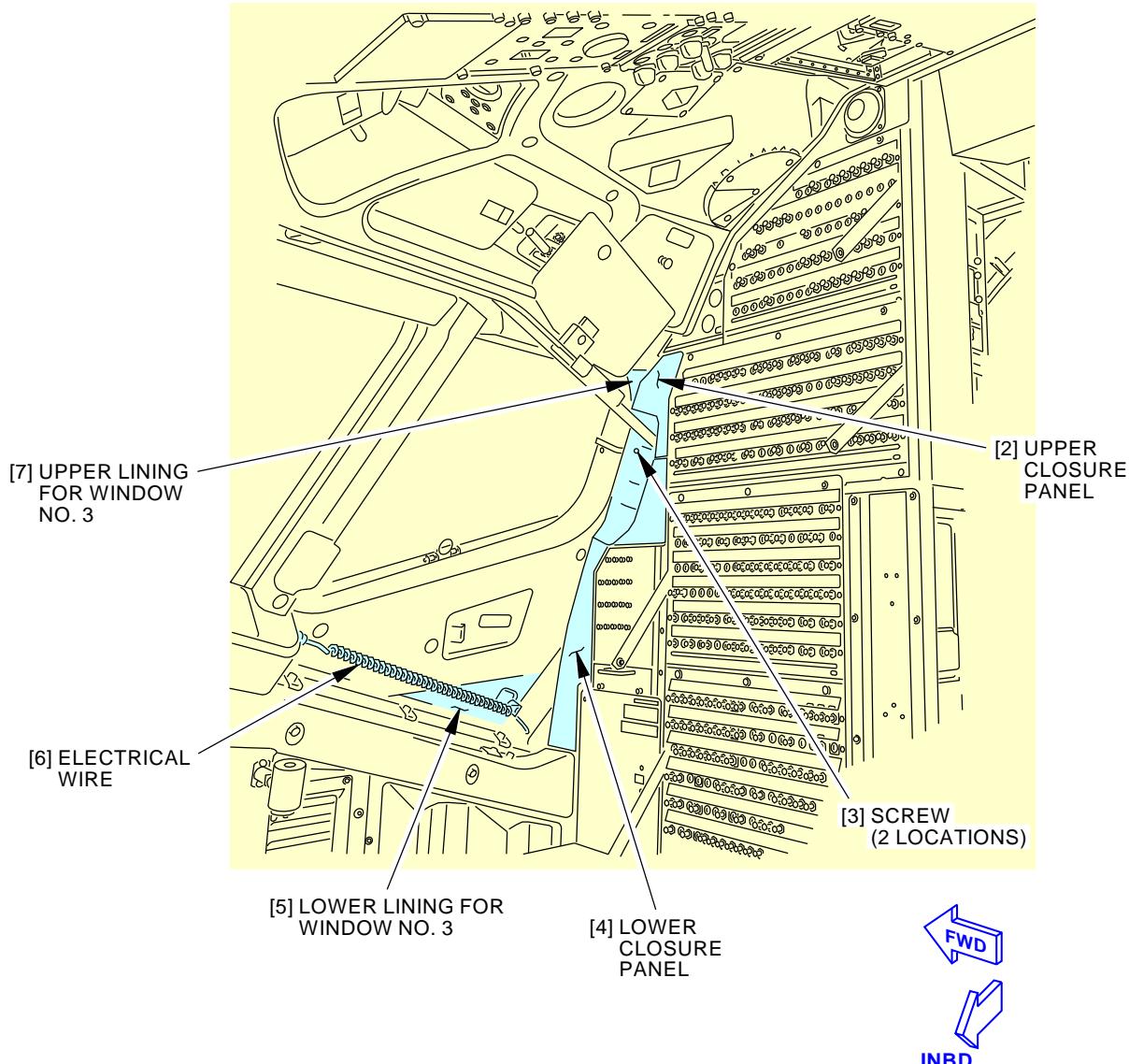
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CLOSURE AND WINDOW PANELS
(RIGHT SIDE IS SHOWN, LEFT SIDE IS OPPOSITE)

A

G66377 S0006566596_V3

Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 2 of 7)

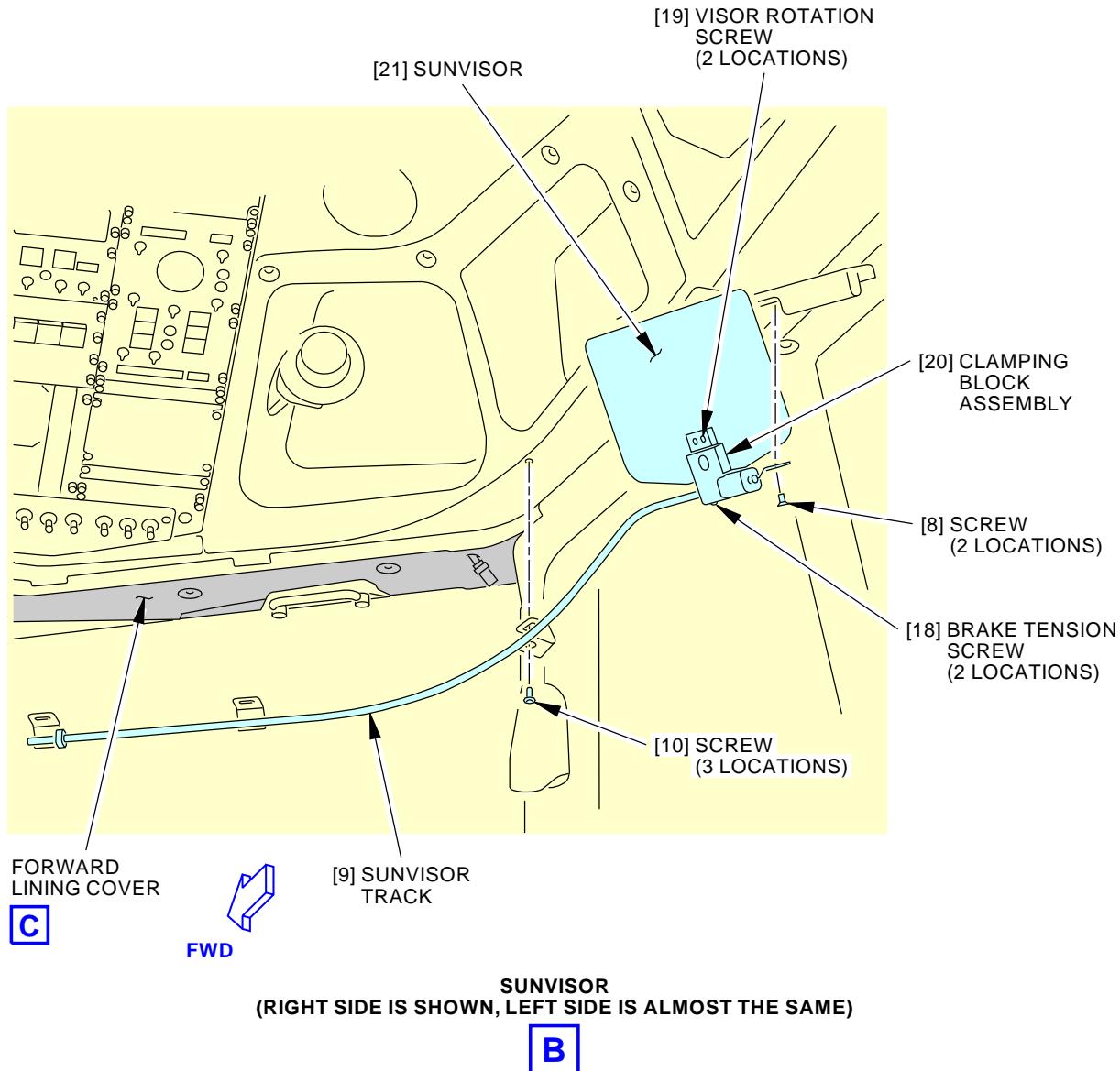
EFFECTIVITY
AKS ALL

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G66380 S0006566597_V3

Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 3 of 7)

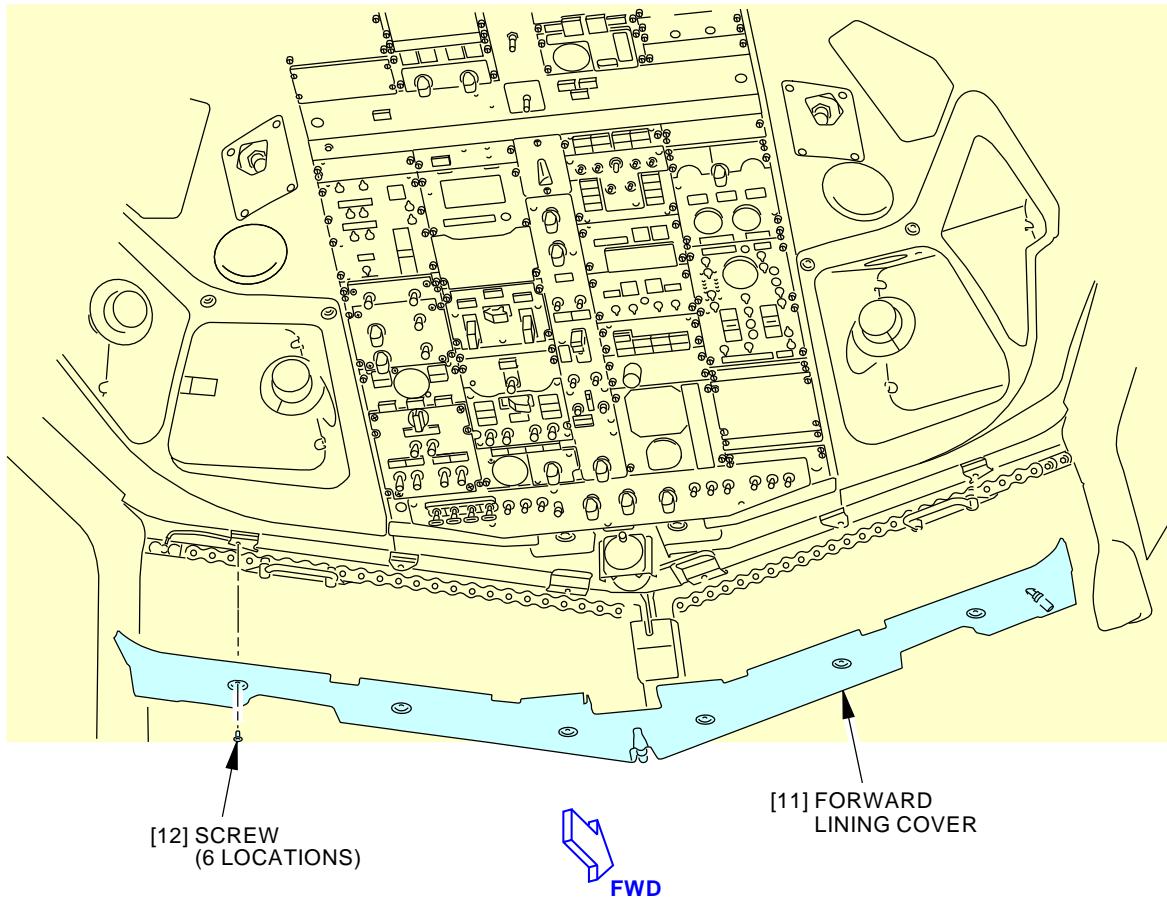
 EFFECTIVITY
 AKS ALL

25-11-21

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FORWARD LINING COVER



G66382 S0006566598_V2

Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 4 of 7)

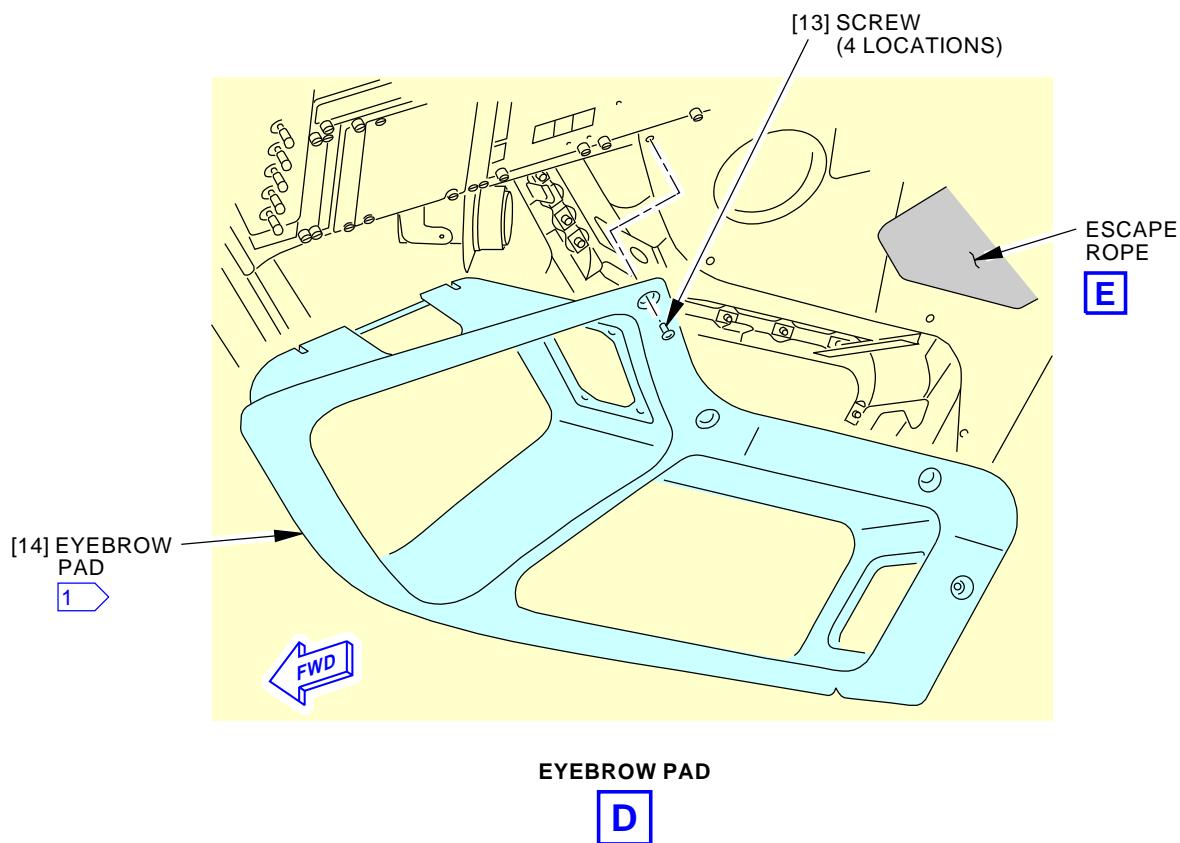
EFFECTIVITY
AKS ALL

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NOTE:

1 IF INSTALLED

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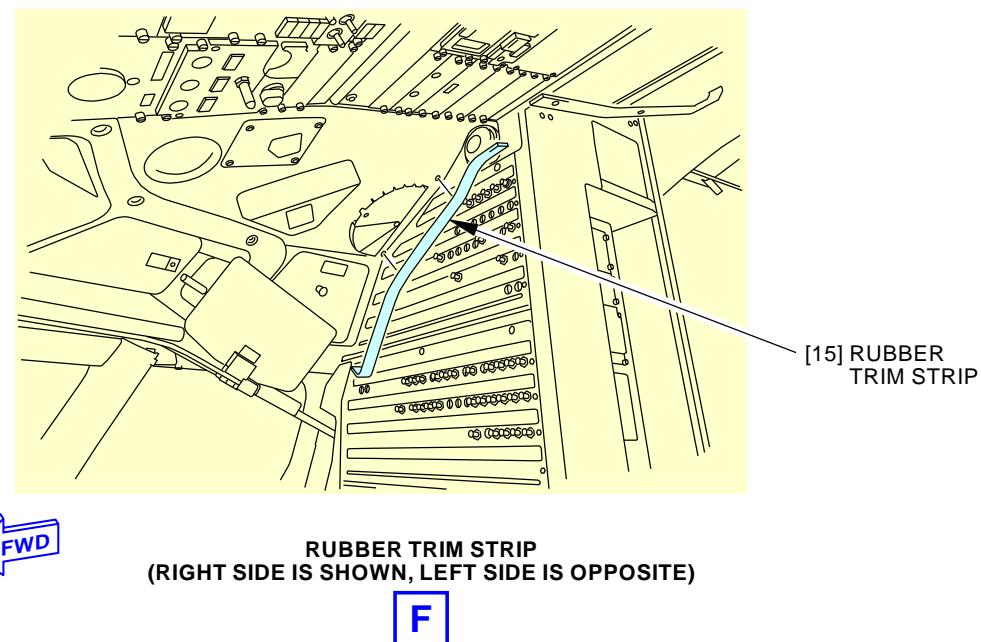
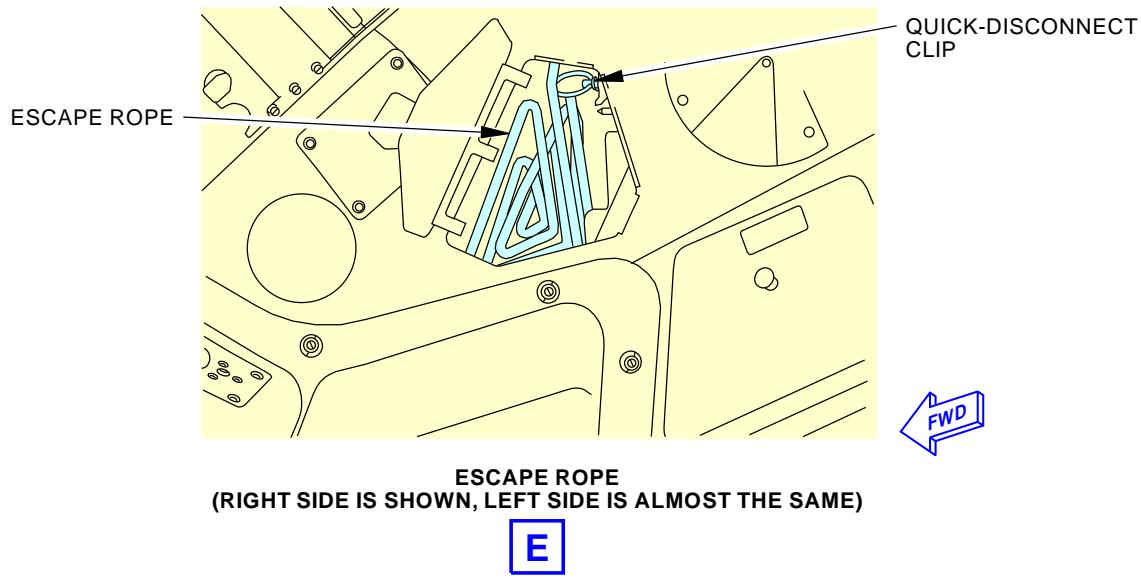
Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 5 of 7)EFFECTIVITY
AKS ALL

25-11-21

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL



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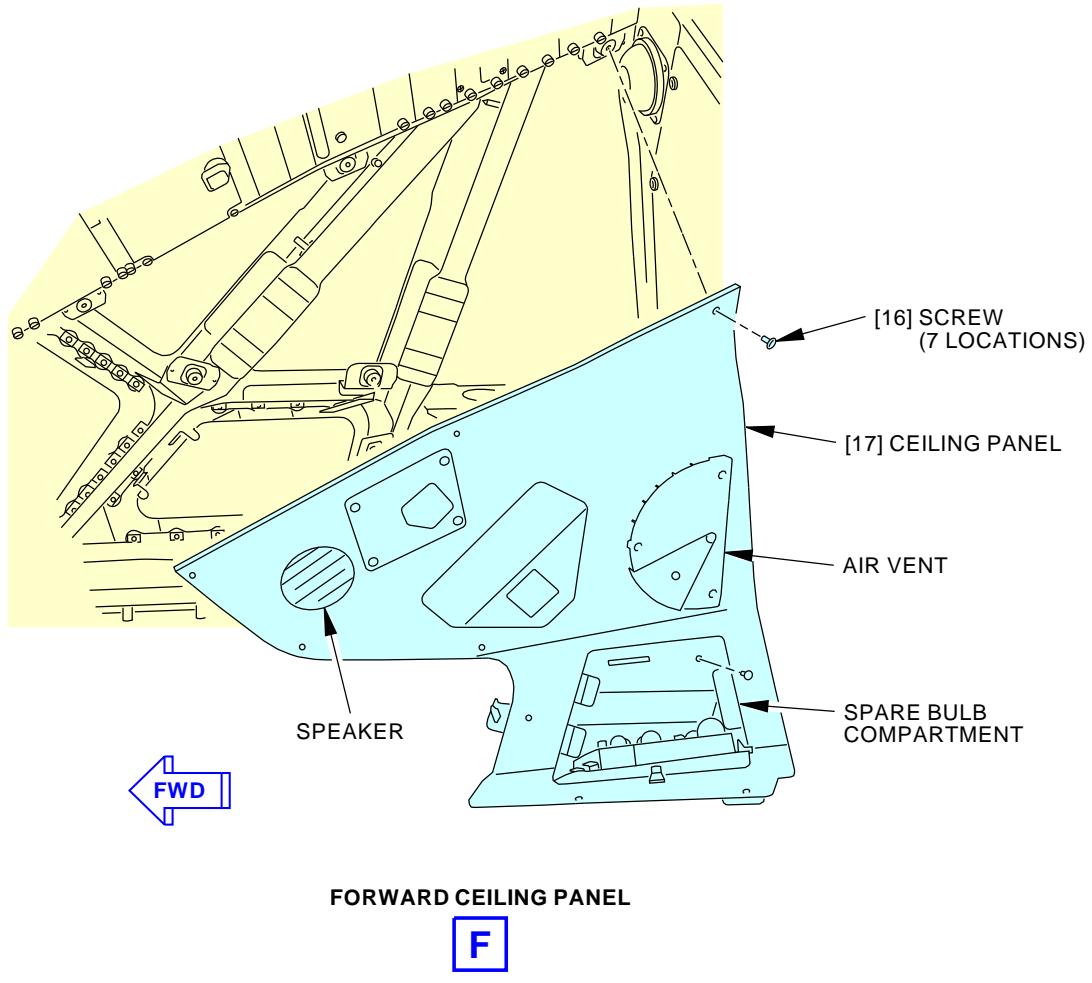
Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 6 of 7)

EFFECTIVITY
AKS ALL

25-11-21



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G89778 S0006566601_V3

Flight Compartment Forward Ceiling Installation
Figure 204/25-11-21-990-809 (Sheet 7 of 7)

EFFECTIVITY
AKS ALL

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TASK 25-11-21-700-802

7. Roller Sunshade Removal

(Figure 205)

A. General

- | (1) This procedure is for airplanes equipped with the roller sunshade installed on the number 2 and 3 windows.
- | (2) Do this task to remove the roller sunshade.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

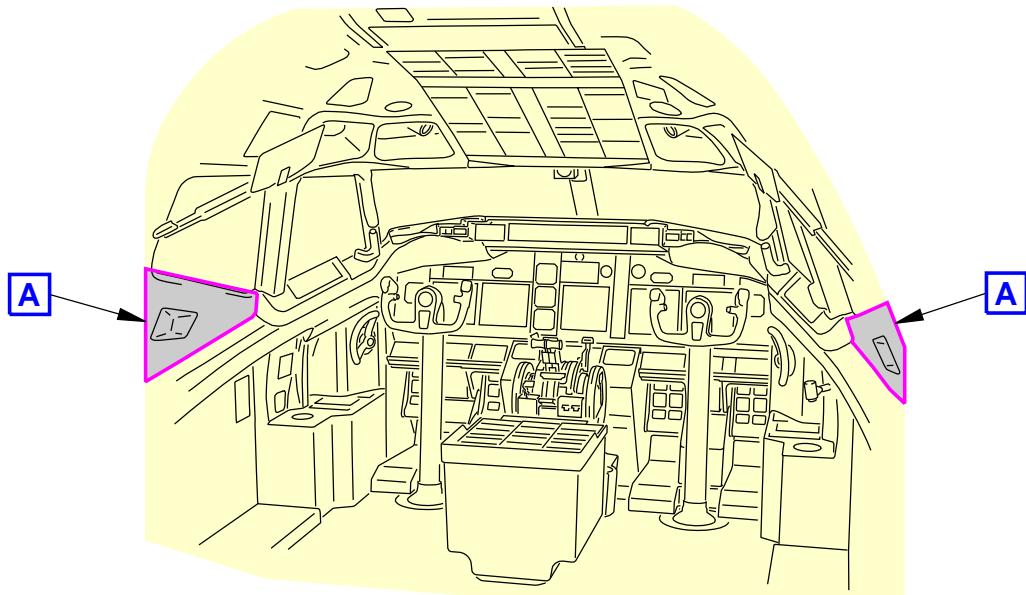
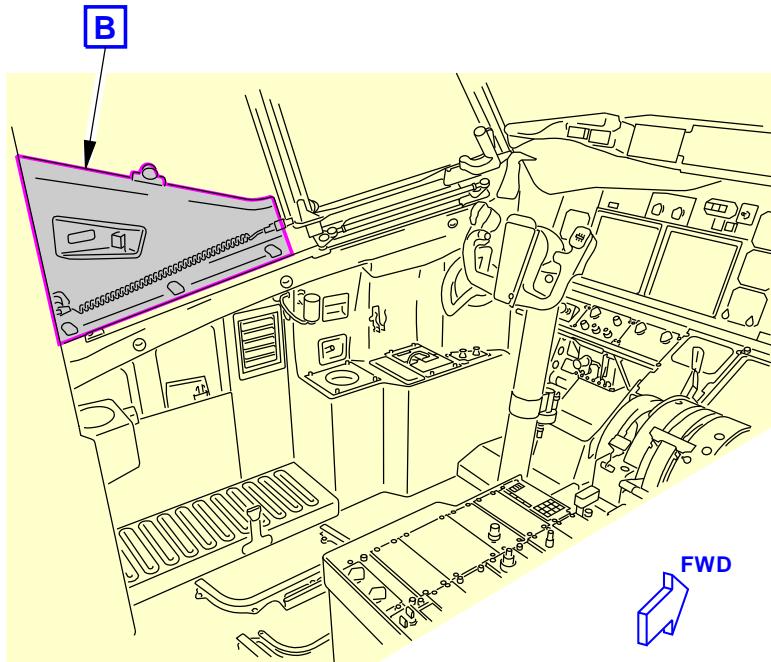
SUBTASK 25-11-21-720-003

- | (1) Do these steps to remove the roller sunshade.
 - | (a) Remove the electrical connector.
 - | (b) Remove the light.
 - | (c) Remove the applicable window lining fasteners [1].
 - | (d) Remove the applicable window lining [2].
 - | (e) Remove the roller sunshade fasteners [3].
 - | (f) Remove the roller sunshade [4].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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FLIGHT COMPARTMENT

A

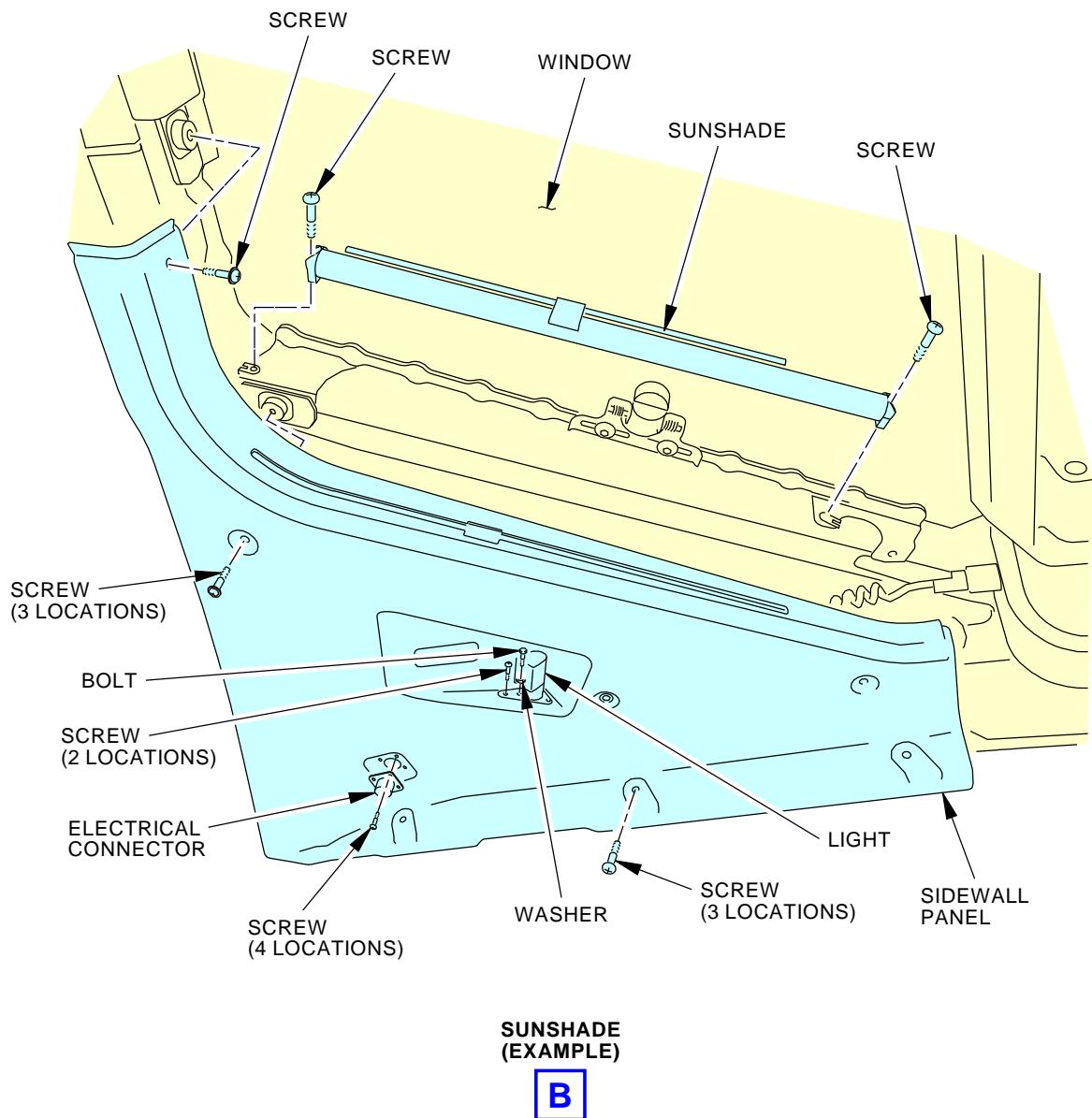
L40315 S0006566603_V2

**Sunshade Installation
Figure 205/25-11-21-990-807 (Sheet 1 of 2)**

EFFECTIVITY
AKS ALL

25-11-21

D633A101-AKS



L40365 S0006566604_V2

Sunshade Installation
Figure 205/25-11-21-990-807 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-11-21

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-21-700-803

8. Roller Sunshade Installation

(Figure 205)

A. General

- (1) This procedure is for airplanes equipped with the roller sunshade installed on the number 2 and 3 windows.
- (2) Do this task to install the roller sunshade.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-11-21-720-004

- (1) Do these steps to install the roller sunshade.
 - (a) Position the roller sunshade [4] for installation.
 - (b) Install the roller sunshade fasteners [3].
 - (c) Position the window lining [2] for installation.
 - (d) Install the light.
 - (e) Install the electrical connector.
 - 1) Make sure the receptacle connector keyway is set at the up position, or 12 o'clock.
 - (f) Install the window lining fasteners [1].

———— END OF TASK ————

TASK 25-11-21-000-806

9. Flight Compartment Aft Ceiling Panel Removal

Figure 206

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-21-860-001

- (1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-4

Row	Col	Number	Name
B	3	C01163	A/C ZONE TEMP VALVE/FAN CONT FLT DECK

SUBTASK 25-11-21-020-041

- (2) Do these steps to remove the panel assembly [1]:
 - (a) Remove the screws [2] from the panel assembly [1].
 - (b) Disconnect the two connectors from the cabin temperature sensor fan.



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- (c) Carefully pull the panel assembly [1] loose from the Velcro and the seals.

———— END OF TASK ————

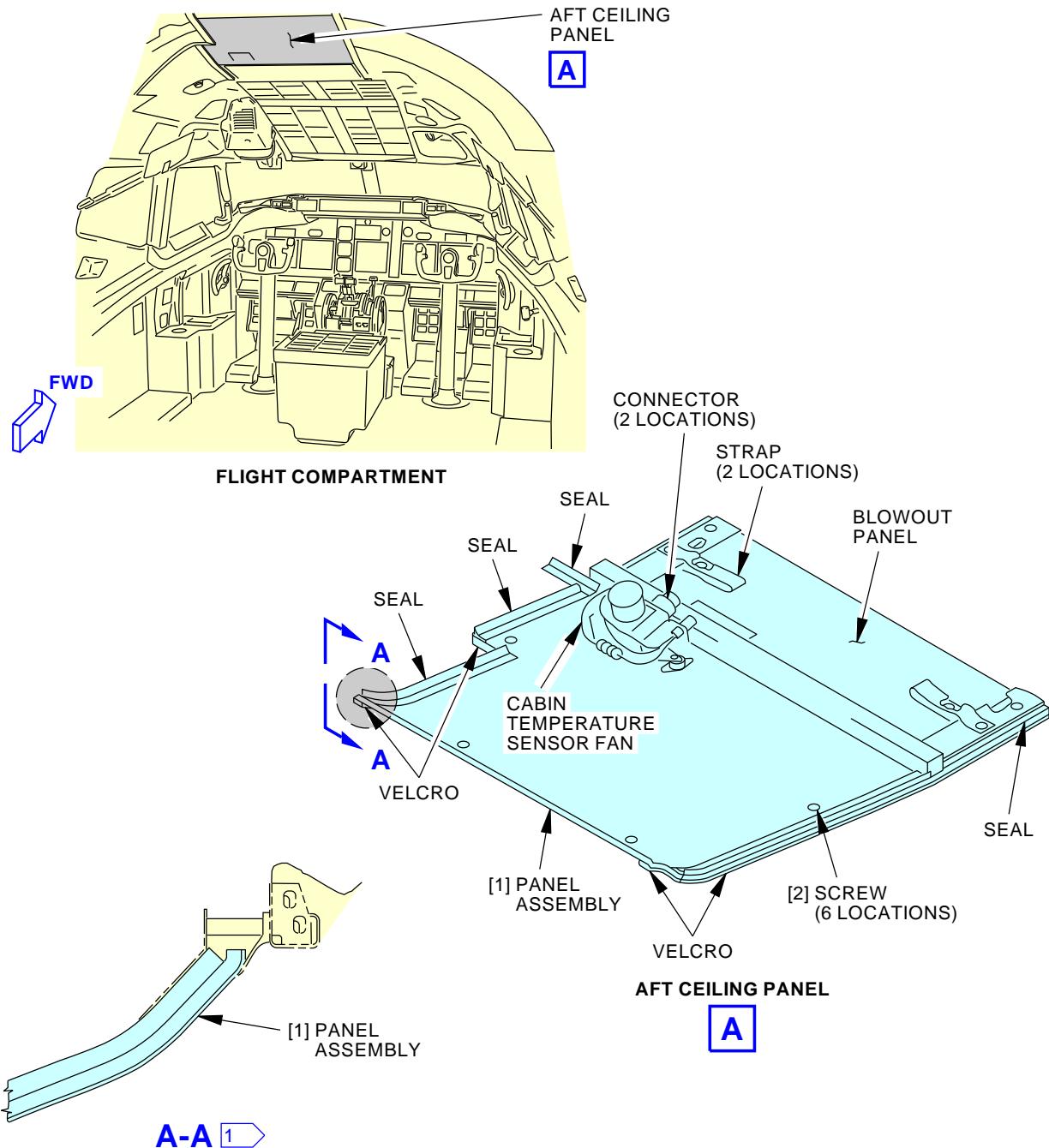
———— EFFECTIVITY ————
AKS ALL

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NOTE:

- [1]** MAKE SURE THAT THE DOOR HEADER SEAL IS ON THE BOTTOM SURFACE OF THE PANEL ASSEMBLY.

1916981 S0000357785_V4

**Flight Compartment Aft Ceiling Panel Installation
Figure 206/25-11-21-990-813**

EFFECTIVITY
AKS ALL

D633A101-AKS

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TASK 25-11-21-400-806

10. Flight Compartment Aft Ceiling Panel Installation

Figure 206

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Procedure

SUBTASK 25-11-21-420-036

- (1) Do these steps to install the panel assembly [1]:

- Connect the two connectors to the cabin temperature sensor fan.
- Carefully push the panel assembly [1] between the seals and the Velcro.

NOTE: Make sure that the door header seal is on the bottom surface of the panel assembly (View A-A, Fig. 401).

- Install the screws [2] that attach the panel assembly [1] to the airplane structure.

SUBTASK 25-11-21-860-002

- (2) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-4

Row	Col	Number	Name
B	3	C01163	A/C ZONE TEMP VALVE/FAN CONT FLT DECK

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-11-21



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FLIGHT COMPARTMENT FORWARD SIDE PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Flight Compartment Forward Side Panel Removal
 - (2) Flight Compartment Forward Side Panel Installation

TASK 25-11-22-000-801

2. Flight Compartment Forward Side Panel Removal

(Figure 401)

A. General

- (1) This procedure applies to the Captain's and First Officer's Forward Side Panel.

B. References

Reference	Title
25-11-01-000-801	Captain's and First Officer's Seat Removal (P/B 401)
32-51-41-000-801	Nose Landing Gear Steering Control Wheel Removal (P/B 401)
35-12-85-000-802	Oxygen Mask/Regulator Removal (P/B 401)

C. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Side Panel Removal

SUBTASK 25-11-22-860-001

- (1) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
A	9	C00308	CONTROL CABIN LIGHTING MAP & KIT
B	9	C00331	PANEL & INSTR 28V PRI CAPT & CTR
B	10	C00335	PANEL & INSTR 28V PRI F/O
D	8	C00701	EMER PANEL LTG

SUBTASK 25-11-22-020-001

- (2) Remove the applicable seat. Do this task: Captain's and First Officer's Seat Removal, TASK 25-11-01-000-801.

SUBTASK 25-11-22-020-002

- (3) Remove the oxygen box from the panel.

- (a) For airplanes with the nasal mask oxygen box, do these steps:

NOTE: Do these steps so you do not need to open the oxygen system.

- 1) Remove the oxygen box from the spacer and move aside.

EFFECTIVITY
AKS ALL

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- 2) Remove the spacer and drop it down through the opening.
- 3) Drop the oxygen box down through the opening.

NOTE: There is a fastener [15] that must be removed with access through this opening.

- (b) For airplanes with the full face mask oxygen box, do this task: Oxygen Mask/Regulator Removal, TASK 35-12-85-000-802.
 - 1) There is a fastener [15] that must be removed with access through this opening.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-010-001

- (4) Remove Map/Chart Holder.

NOTE: This must be removed to provide access to the fastener [16].

AKS ALL

SUBTASK 25-11-22-010-002

- (5) Remove the fasteners to disconnect the glareshield lower cover assembly [1].

SUBTASK 25-11-22-020-003

- (6) Remove the quarter sill lining [3]

SUBTASK 25-11-22-020-004

- (7) Remove the raceway cover [5].
 - (a) Remove screws [7].
 - (b) Remove Flight Kit Tiedown [4].

SUBTASK 25-11-22-000-001

- (8) Remove the bracket [11] from the forward panel to the mid panel [8].
 - (a) Remove screws [9] and [10].

SUBTASK 25-11-22-020-007

- (9) Remove utility light [22].
 - (a) Slide cord through slot in panel.

SUBTASK 25-11-22-000-002

- (10) Do this task: Nose Landing Gear Steering Control Wheel Removal, TASK 32-51-41-000-801.

NOTE: If removing the panel on an airplane without a steering control wheel on the first officer's side, disregard this step.

SUBTASK 25-11-22-000-003

- (11) Remove the tiller assembly access screw [13] and access cover [12].

SUBTASK 25-11-22-000-004

- (12) Remove panel fasteners [14].

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-000-005

- (13) Remove the Map/Chart light control module.

AKS ALL

SUBTASK 25-11-22-020-005

- (14) Disconnect the Captain or First Officer handmike from the sidewall connector.

EFFECTIVITY
AKS ALL

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SUBTASK 25-11-22-020-006

- (15) Disconnect the oxygen light [18].
(a) Remove the connector [17].

| AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

SUBTASK 25-11-22-020-009

- (16) Disconnect the electrical connection to the EFB console.

| AKS ALL

SUBTASK 25-11-22-030-004

- (17) Disconnect the oxygen hose to the oxygen box.

| AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-020-008

- (18) Remove the interphone jack [20].
(a) Disconnect the connector [21].

| AKS ALL

SUBTASK 25-11-22-080-001

- (19) Remove the panel [6].

CAUTION: THE PANEL IS VERY FRAGILE. IF THE PANEL IS HUNG UP WHEN TRYING TO REMOVE IT, MAKE SURE ALL FASTENERS ARE REMOVED AND THAT THE INTERPHONE JACK HOUSING IS CLEARING THE AIRPLANE STRUCTURE.

- (a) Hold panel at the top forward corner and bend down and inboard slightly, only enough to clear obstacles.
(b) Hold panel at the rear bottom corner and pull inboard and back.

———— END OF TASK ————

TASK 25-11-22-400-801

3. Flight Compartment Forward Side Panel Installation

(Figure 401)

A. General

- (1) This procedure is the same for the Captain's and First Officers side depending on applicable panel equipment.

B. References

Reference	Title
23-51-00-710-801	Flight Interphone System - Operational Test (P/B 501)
25-11-01-400-801	Captain's and First Officer's Seat Installation (P/B 401)
32-51-41-400-802	Nose Landing Gear Steering Control Wheel Installation (P/B 401)
35-12-00-700-802	Crew Oxygen Mask-Regulator Test (P/B 501)
35-12-85-400-802	Oxygen Mask/Regulator Installation (P/B 401)
46-15-00 P/B 501	ELECTRONIC FLIGHT BAG - ADJUSTMENT/TEST

C. Location Zones

Zone	Area
210	Subzone - Control Compartment - Body Station 178.00 to Body Station 259.50

EFFECTIVITY
AKS ALL

25-11-22



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(Continued)

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

D. Side Panel Installation

SUBTASK 25-11-22-420-001

- (1) Position the panel for installation.
 - (a) Make sure all connections are accessible.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-400-001

- (2) Connect the electrical connector for the Map/Chart lightplate control assembly.

SUBTASK 25-11-22-430-001

- (3) Install the screws for the Map/Chart lightplate control assembly.

SUBTASK 25-11-22-420-002

- (4) Connect the electrical connector for the interphone jack [20].

AKS ALL

SUBTASK 25-11-22-420-003

- (5) Connect the electrical connector for the utility light [22].
 - (a) Slide cord through slot in panel and slot in grommet.

AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

SUBTASK 25-11-22-420-012

- (6) Connect the electrical connector for the EFB console.

AKS ALL

SUBTASK 25-11-22-420-008

- (7) Connect the electrical connector for the oxygen box.

SUBTASK 25-11-22-420-009

- (8) Install the oxygen hose for the oxygen box. Torque nut to 60 - 80 inch-pounds.

SUBTASK 25-11-22-420-010

- (9) Install the screw [9] for the bracket [11].

SUBTASK 25-11-22-430-002

- (10) Install the screws [10] for the utility light [22].

SUBTASK 25-11-22-420-004

- (11) Install the electrical connector [17] for the oxygen light [18].

SUBTASK 25-11-22-420-011

- (12) Install the oxygen light [18].

SUBTASK 25-11-22-400-002

- (13) If applicable, connect the Digital Audio Control.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-400-003

- (14) Install map/chart holder
 - (a) Install fastener [16].

EFFECTIVITY
AKS ALL

25-11-22



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AKS 007, 008, 011, 012, 014, 019, 026, 028-999 (Continued)

- (b) Install holder.

AKS ALL

SUBTASK 25-11-22-410-002

- (15) Install the panel [6].

- (a) Grab panel at the forward top corner and bend down slightly.

CAUTION: DO NOT LET THE PANEL CATCH ON THE STEERING CABLES. IF THE PANEL CATCHES ON THE STEERING CABLES, THE AIRPLANE WILL NOT TURN CORRECTLY. DAMAGE TO EQUIPMENT CAN OCCUR.

- (b) Grab panel at the rear bottom corner and push forward and outboard.

- (c) Install fasteners [14].

- (d) Install the bracket [11] from the forward panel to the mid panel.

SUBTASK 25-11-22-430-003

- (16) Install the screw [13] for the access cover [12].

SUBTASK 25-11-22-410-003

- (17) If applicable, do this task: Nose Landing Gear Steering Control Wheel Installation, TASK 32-51-41-400-802.

- (a) Make sure that the access cover [12] is aligned properly before nose landing gear steering control wheel [2] is installed to make sure no damage occurs.

SUBTASK 25-11-22-410-004

- (18) Install the raceway cover [5].

SUBTASK 25-11-22-410-005

- (19) Install the quarter sill lining [3]

SUBTASK 25-11-22-410-006

- (20) Install the glareshield lower cover assembly [1].

SUBTASK 25-11-22-410-007

- (21) Install the applicable seat, do this task: Captain's and First Officer's Seat Installation, TASK 25-11-01-400-801.

SUBTASK 25-11-22-860-002

- (22) Remove the safety tags and close these circuit breakers:

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT

F/O Electrical System Panel, P6-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C00308	CONTROL CABIN LIGHTING MAP & KIT
B	9	C00331	PANEL & INSTR 28V PRI CAPT & CTR
B	10	C00335	PANEL & INSTR 28V PRI F/O
D	8	C00701	EMER PANEL LTG



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SUBTASK 25-11-22-410-001

(23) Install the oxygen box.

- (a) For airplanes with the nasal mask oxygen box, do these steps;
 - 1) Install fastener [15].
 - 2) Pull oxygen box up through opening.
 - 3) Pull spacer up through opening.
 - 4) Install spacer on panel.
 - 5) Install oxygen box on the spacer.
- (b) For airplanes with the full face mask oxygen box;
 - 1) Install fastener [15].
 - 2) Do this task: Oxygen Mask/Regulator Installation, TASK 35-12-85-400-802.

SUBTASK 25-11-22-710-001

(24) Do a test of the flight kit/reading light:

- (a) At the back of the light, use the knob to set the switch to the on mode.
 - 1) Make sure the light comes on.
- (b) Set the switch to the off mode.
 - 1) Make sure the light goes off.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-11-22-710-002

(25) Do a test of the Map switch on the Map/Chart lightplate control module:

- (a) At the P21 or P22 panel, set the applicable switch for the map light to the dim mode and then to bright.
 - 1) Make sure the intensity of the light changes from dim to bright.
- (b) Set the switch to the off mode.
 - 1) Make sure the light goes off.

SUBTASK 25-11-22-710-003

(26) Do a test of the Chart switch on the Map/Chart lightplate control module:

- (a) At the P21 or P22 panel, set the applicable switch for the chart light to the dim mode and then to bright.
 - 1) Make sure the intensity of the light changes from dim to bright.
- (b) Set the switch to the off mode.
 - 1) Make sure the light goes off.

AKS ALL

SUBTASK 25-11-22-710-004

(27) Do an operational test of the crew oxygen mask to make sure it operates correctly, do this task: Crew Oxygen Mask-Regulator Test, TASK 35-12-00-700-802.

SUBTASK 25-11-22-710-005

(28) Do a test of the boom microphone for a voice transmission between two flight crew stations, do this task: Flight Interphone System - Operational Test, TASK 23-51-00-710-801.

EFFECTIVITY
AKS ALL

25-11-22

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AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

SUBTASK 25-11-22-710-007

- (29) Do an operational test of the EFB console - ELECTRONIC FLIGHT BAG - ADJUSTMENT/TEST, PAGEBLOCK 46-15-00/501 to make sure it operates correctly.

AKS ALL

———— END OF TASK ————

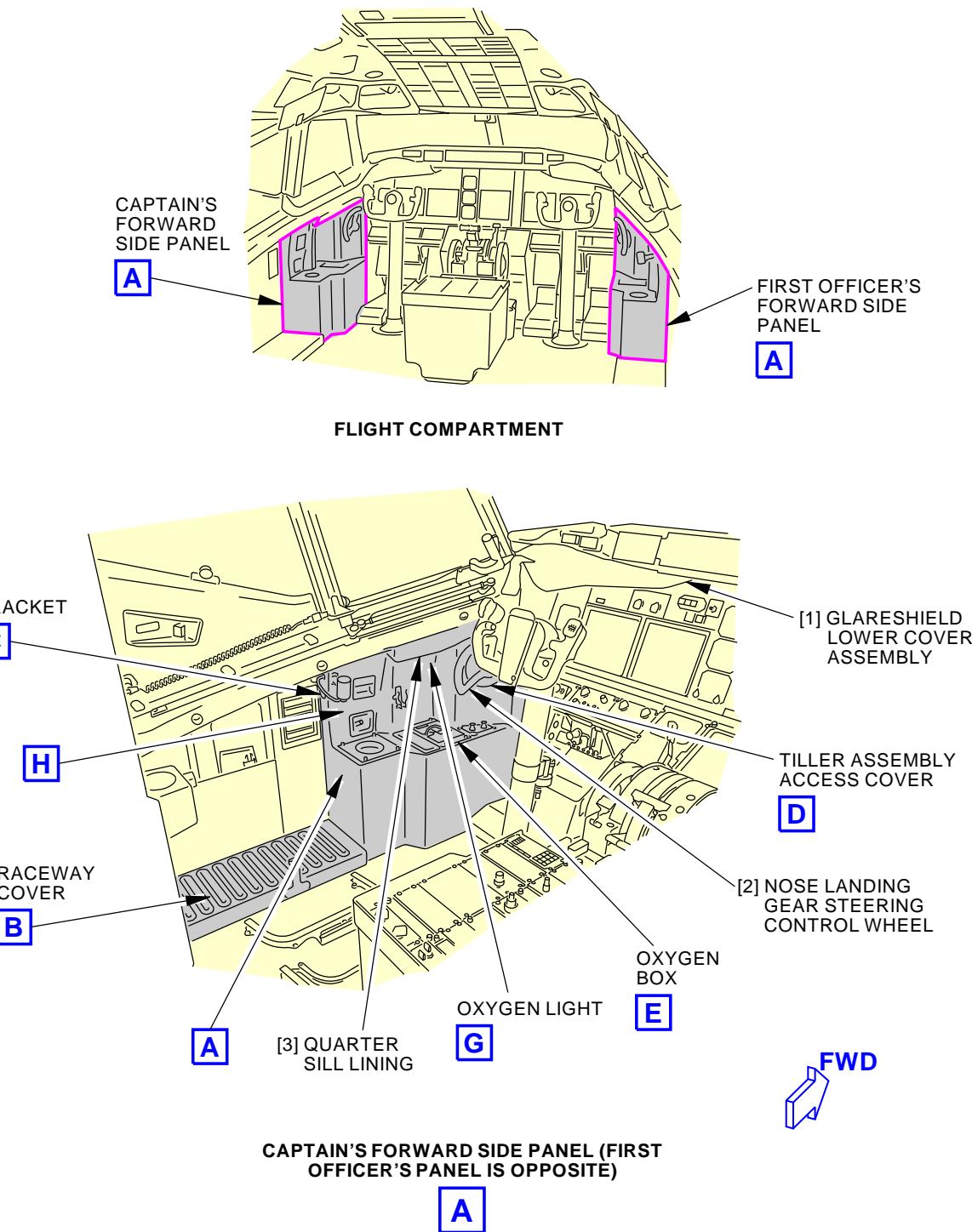
EFFECTIVITY
AKS ALL

25-11-22

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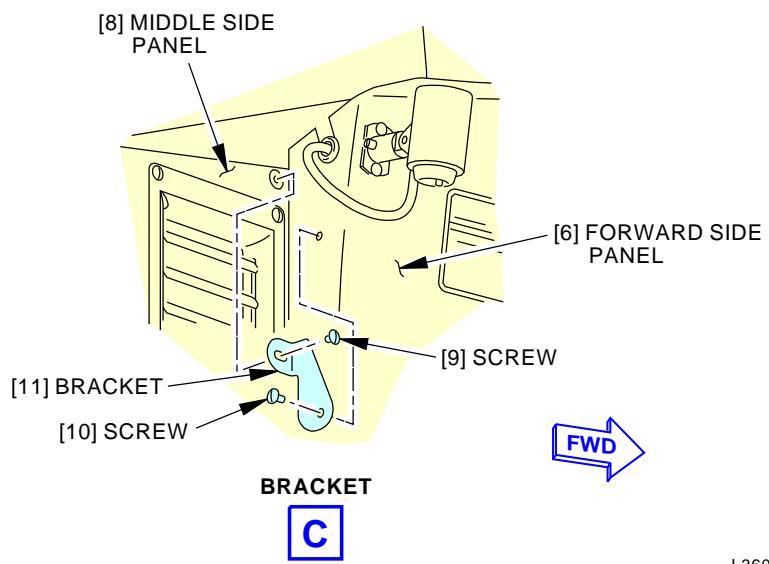
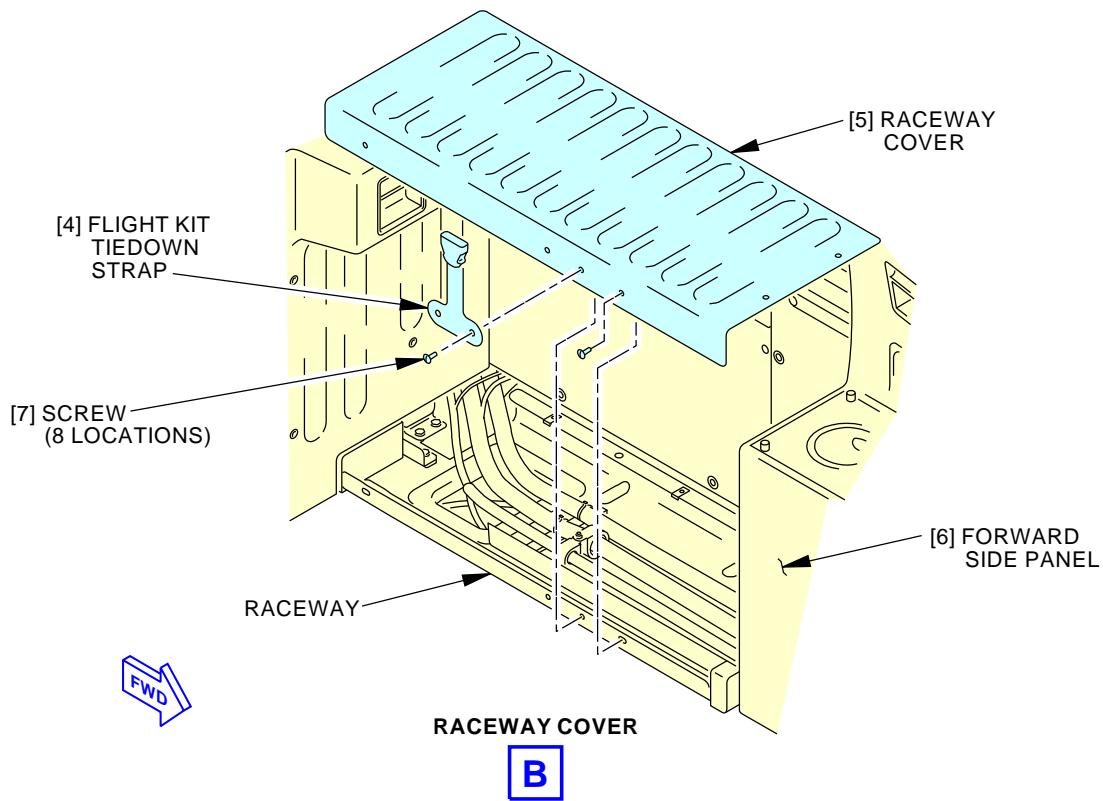
Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 1 of 8)

EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

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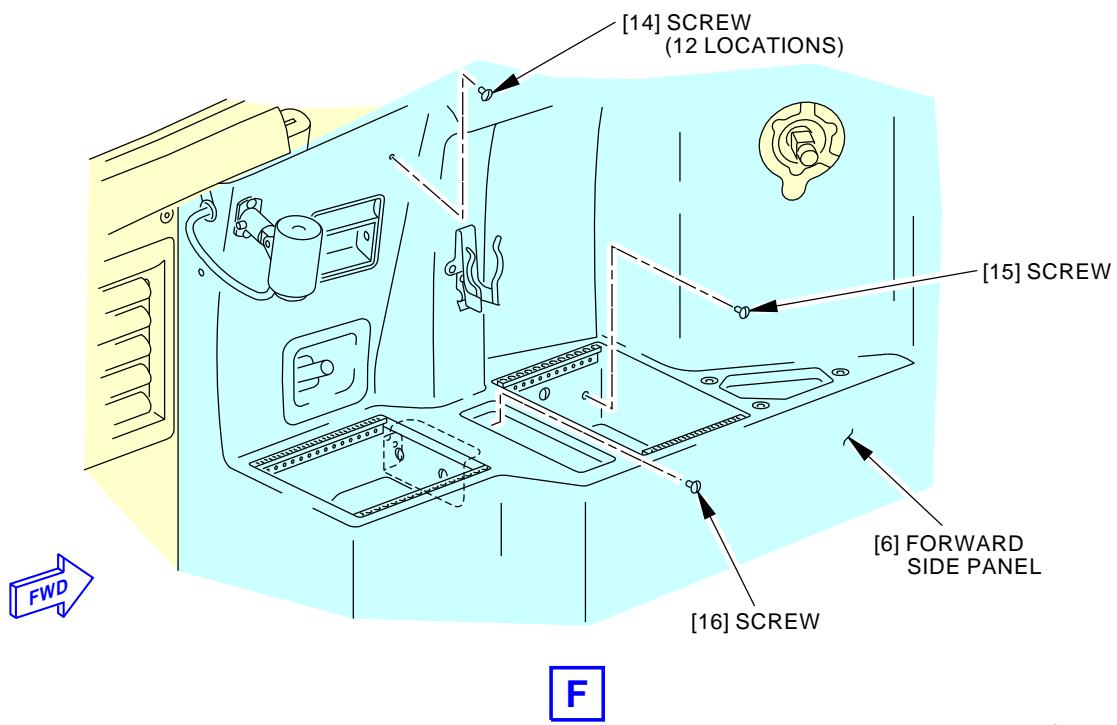
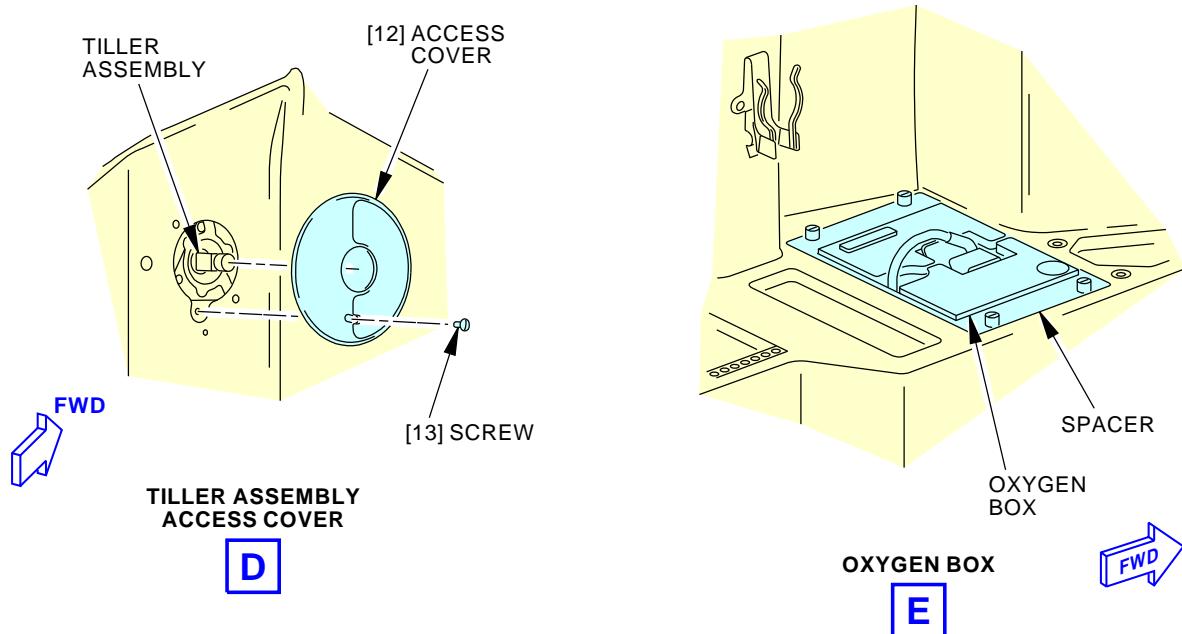
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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 2 of 8)

EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 3 of 8)

EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

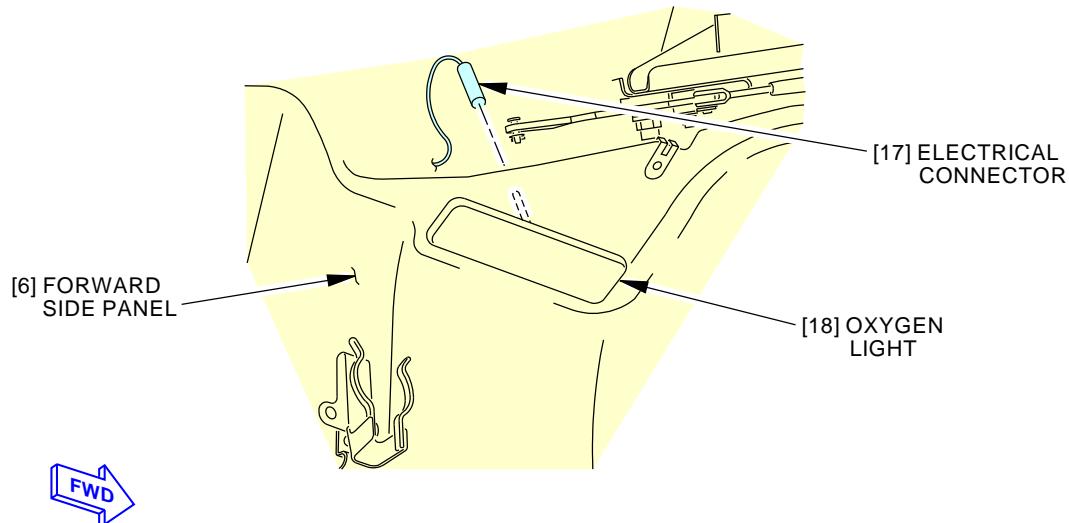
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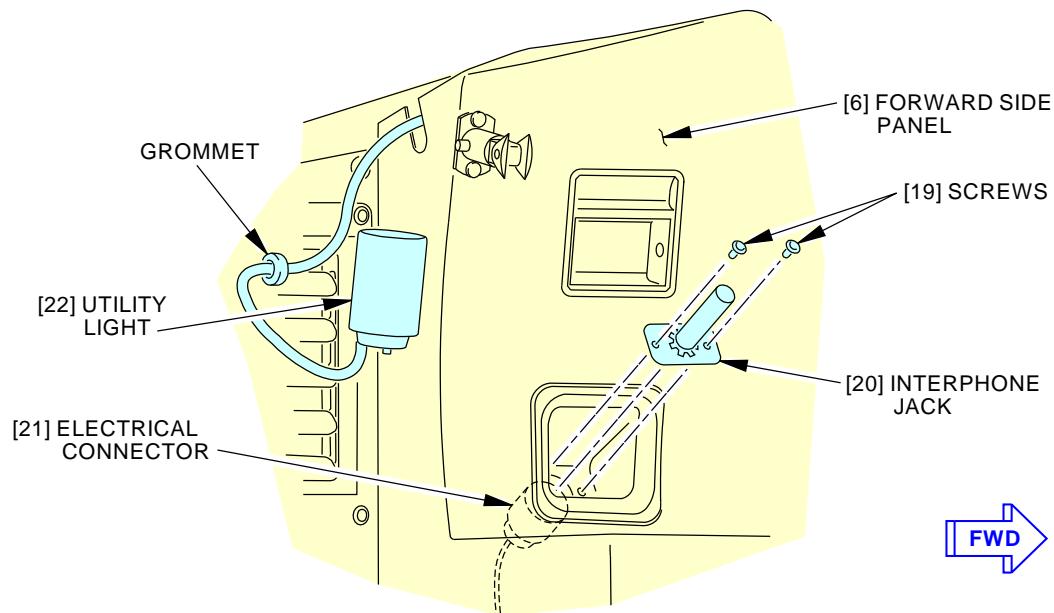


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OXYGEN LIGHT

G



UTILITY LIGHT AND INTERPHONE JACK

H

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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 4 of 8)

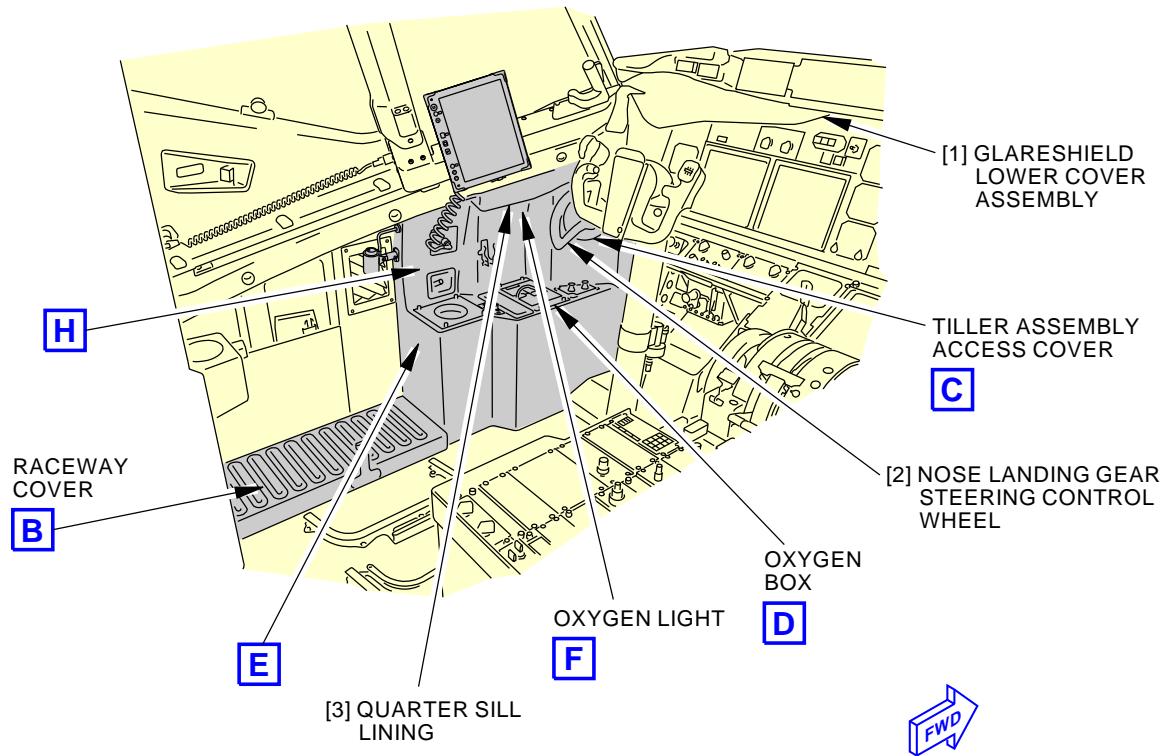
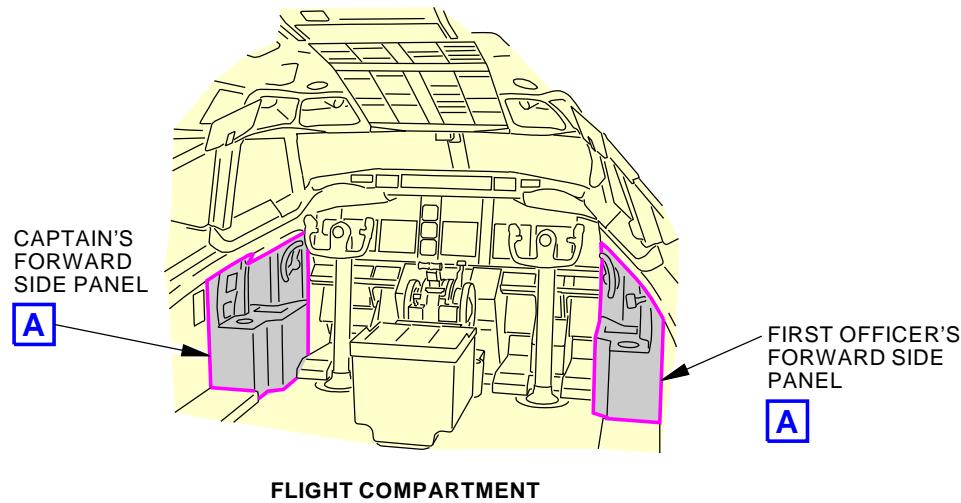
EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

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**Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 5 of 8)**

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

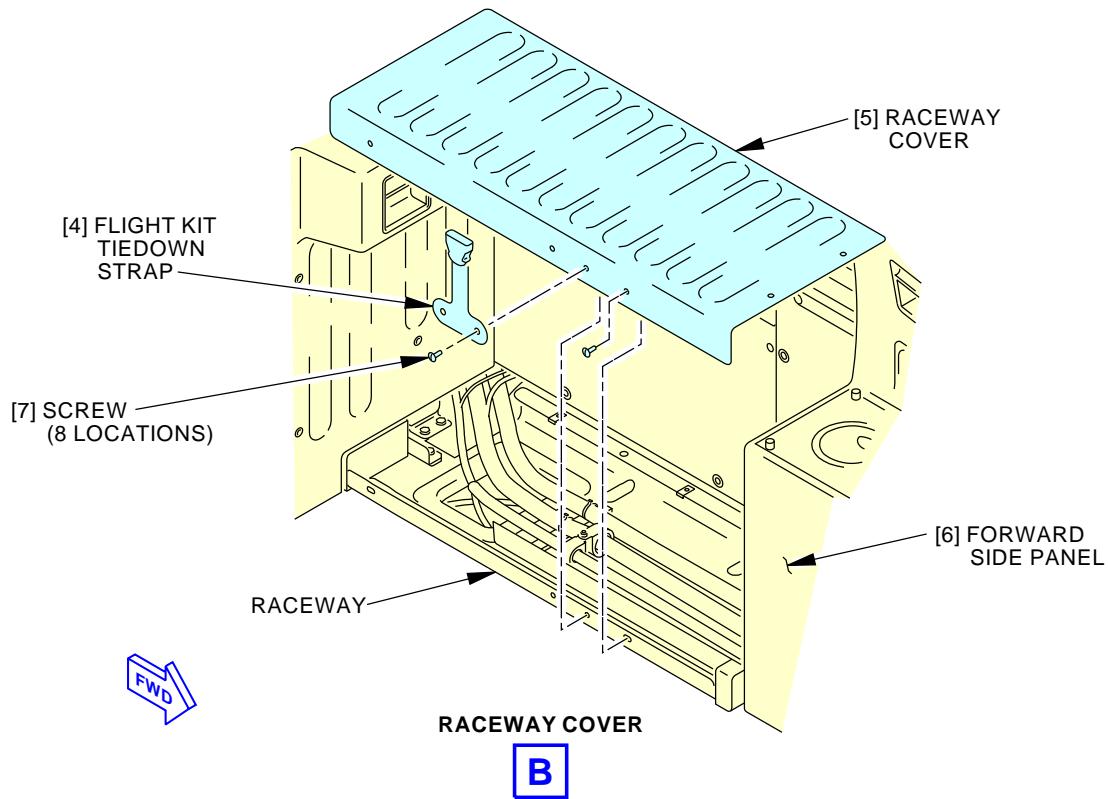
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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 6 of 8)

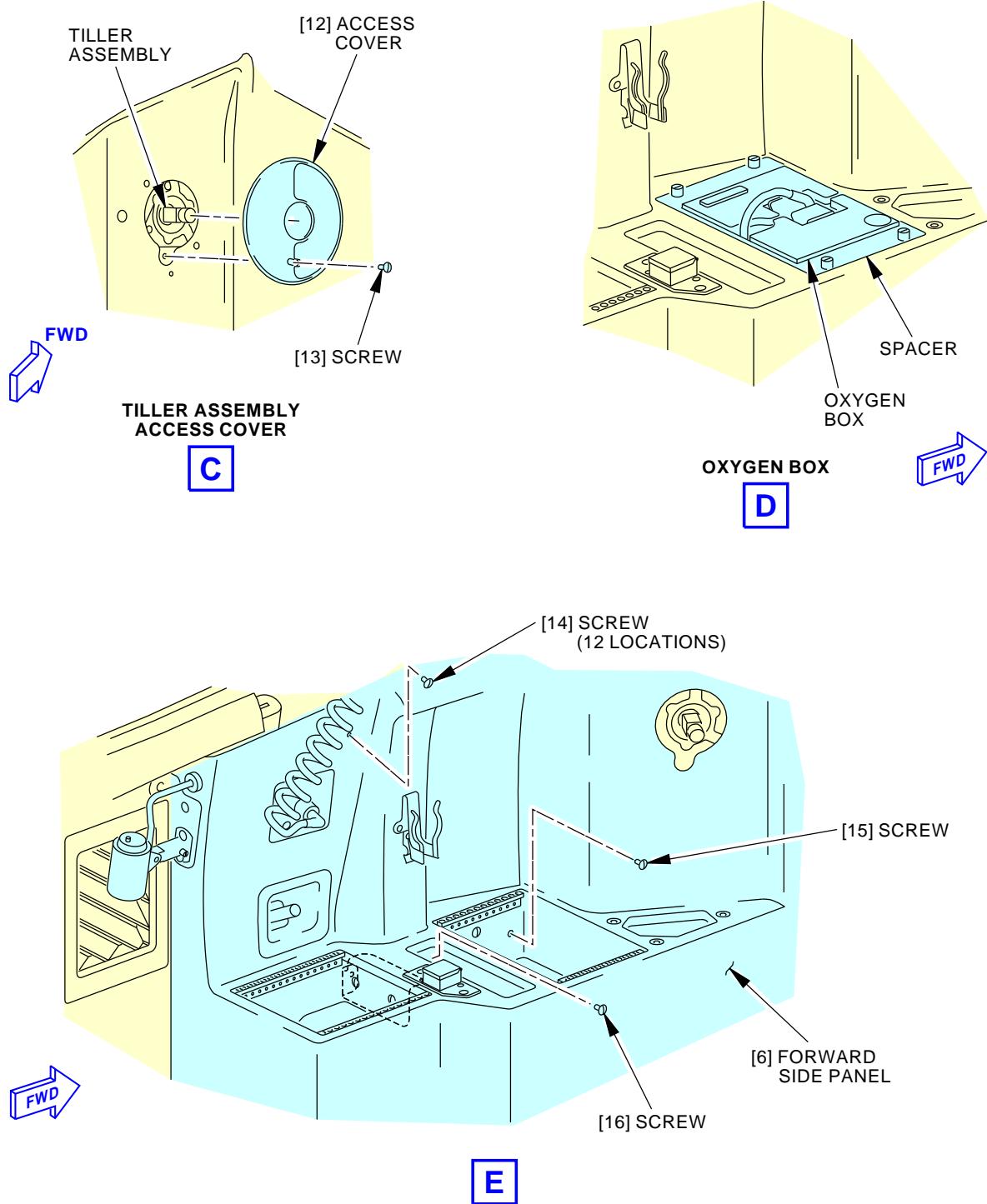
EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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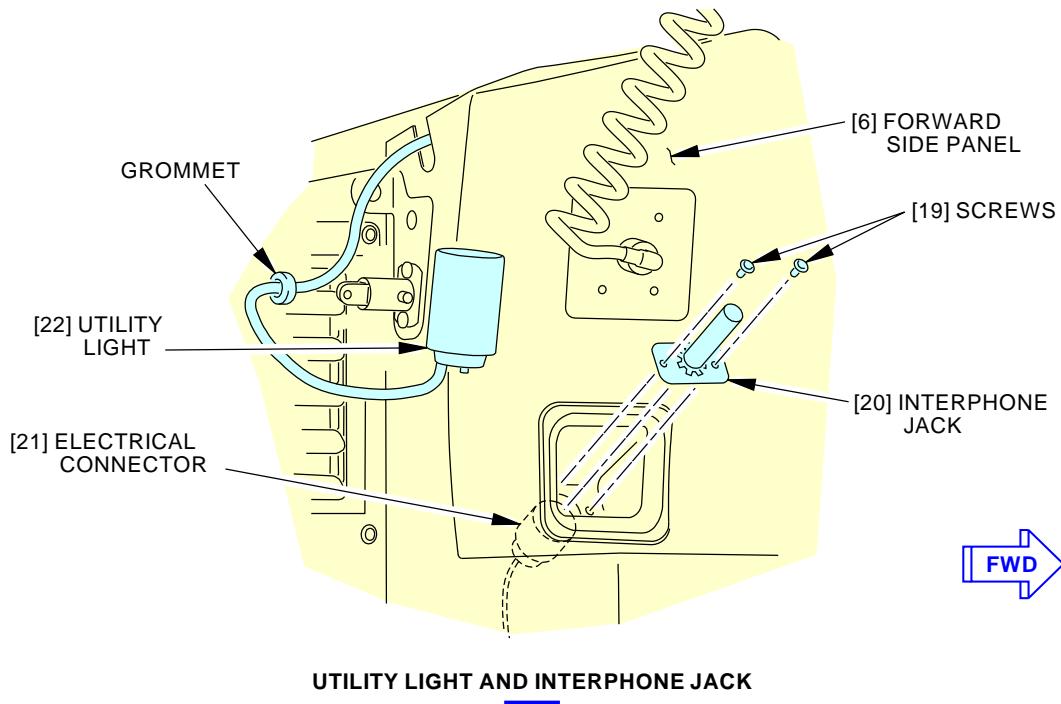
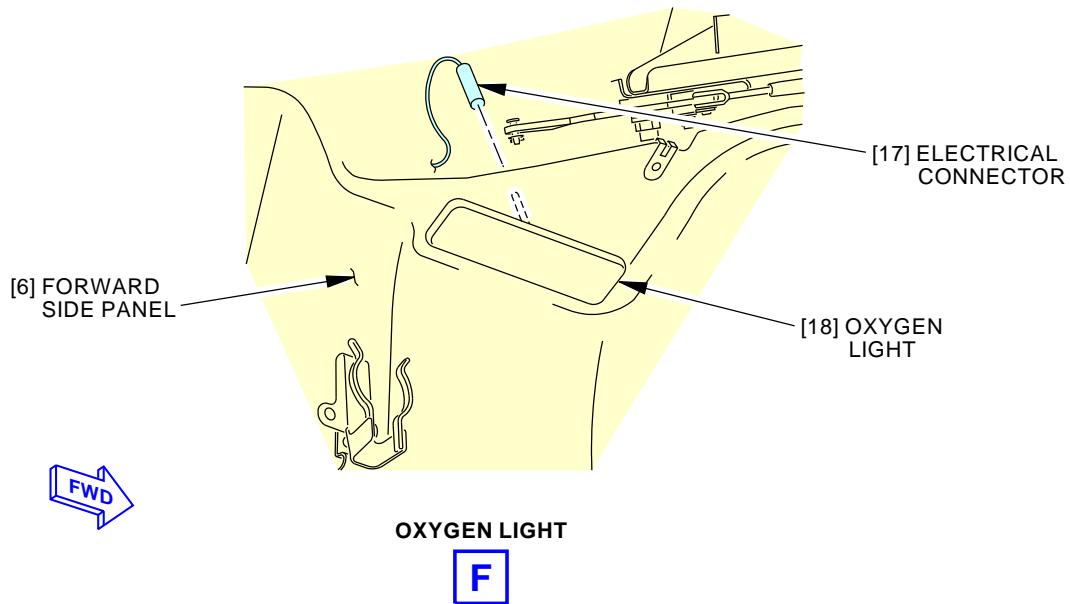
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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 7 of 8)
EFFECTIVITY
 AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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Flight Compartment Forward Side Panels
Figure 401/25-11-22-990-801 (Sheet 8 of 8)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-11-22

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CLOSEOUT SEAL - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) The installation of the closeout seal.
 - (2) The reinstallation of the closeout seal if it has come out of the retainer.

TASK 25-21-01-400-801

2. Installation of the Closeout Seal

A. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-21-01-020-001

- (1) If applicable, remove the installed foam seal.
 - (a) Remove the remaining adhesive.

SUBTASK 25-21-01-020-002

- (2) Where two seals connect, do the steps that follow:
 - (a) Do not use adhesive.
 - (b) Cut the end off one seal until the coupler on the other seal overlaps it.
 - (c) Where a coupler is not available at the end of a seal, install a coupler.

NOTE: The coupler dimensions must agree with the largest mating seal.

SUBTASK 25-21-01-420-001

- (3) Push the seal locking device into the installed retainer until the locking device engages.
 - (a) Push the seal tightly until a click is heard or you can feel it snapping into the retainer.
 - (b) Do not use adhesive.

SUBTASK 25-21-01-420-002

- (4) Apply adhesive, A00027 to fill spaces that stay after all other seals are installed.

SUBTASK 25-21-01-350-001

- (5) Trim the seal to fit.

SUBTASK 25-21-01-420-003

- (6) Bond one side of the seal and push the pointed end into the gap until only the decorative endcap can be seen.

SUBTASK 25-21-01-020-003

- (7) Where the seal turns a corner:
 - (a) Remove the non-decorative cross section if necessary to install the seal.

SUBTASK 25-21-01-020-004

- (8) Trim the seal to fit the installation space.

EFFECTIVITY
AKS ALL

25-21-01



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SUBTASK 25-21-01-020-005

- (9) If there is interference between the seal and wires or support structure:
(a) Trim the seal to remove the interference.

NOTE: Do not trim the seal so far that the relief can be seen in the cabin interior.

———— END OF TASK ————

TASK 25-21-01-400-802

3. Reinstallation of Closeout Seals

A. Consumable Materials

Reference	Description	Specification
A50055	Adhesive - Two-Part, RT Cure, Urethane	BAC5010 Type 89 (BMS5-105)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-21-01-210-001

- (1) Make sure that the retainer is not damaged or missing.

SUBTASK 25-21-01-420-004

- (2) Install the seal:

- (a) Push the seal locking device into the installed retainer until the locking device engages.
1) Push the seal tightly until a click is heard or you can feel it snapping into the retainer.

- 2) Do not use adhesive.

- (b) If necessary, add some urethane adhesive, A50055 to some locations to help with the seal staying in its position.

NOTE: During removal, this can cause damage to the seal or retainer. This is optional if the seal only needs to be removed at high time/cycle intervals.

———— END OF TASK ————



25-21-01



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WINDOW SHADE AND REVEAL ASSEMBLY - REMOVAL/INSTALLATION

1. **General**

A. This procedure contains these tasks:

- (1) Snap In Window Shade and Reveal Assembly Removal
- (2) Snap In Window Shade and Reveal Assembly Installation
- (3) Emergency Exit Door Snap In Window Shade and Reveal Assembly Removal
- (4) Emergency Exit Door Snap In Window Shade and Reveal Assembly Installation

TASK 25-21-12-000-804

2. **Snap In Window Shade and Reveal Assembly Removal**

A. **General**

- (1) This procedure includes steps to remove the window shade and reveal assembly, or to remove only the window shade.

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Procedure**

SUBTASK 25-21-12-000-003

- (1) To remove the window shade and reveal do these steps:

NOTE: THE SKIN WEDGE TOOL MUST BE PLACED ON ONE AT A TIME TOP OF THE 6 REVEAL TABS TO RELEASE WINDOW REVEAL.

- (a) Move the shade to the closed position.
- (b) Start with one of the sidewall tabs first.
- (c) Put the skin wedge release tool between the sidewall panel and the window reveal.
- (d) Push the sidewall panel outboard with the skin wedge.
- (e) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-020-015

- (2) Disengage the top two reveal tabs from the sidewall panel.

- (a) Disengage the top tab that is closest to the first disengaged side tab.
- (b) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
- (c) Push the sidewall panel outboard with the skin wedge.
- (d) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.
- (e) Disengage the other top reveal tab.

SUBTASK 25-21-12-020-016

- (3) Disengage the other side reveal tab from the sidewall panel.

- (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
- (b) Push the sidewall panel outboard with the skin wedge.

EFFECTIVITY
AKS ALL

25-21-12



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- (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-020-017

- (4) With one hand hold the top of the window reveal and pull up.

SUBTASK 25-21-12-020-018

- (5) Disengage the two lower corner reveal tabs from the sidewall panel.
- (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
 - (b) Push the sidewall panel outboard with the skin wedge.
 - (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.
 - (d) Move the sidewall panel to flex the lip away from the corner tabs.

SUBTASK 25-21-12-020-019

- (6) Disengage the lower reveal I tab from the sidewall panel.
- (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
 - (b) Push the sidewall panel outboard with the skin wedge.
 - (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-000-004

- (7) Carefully shake the window reveal free and remove it.

SUBTASK 25-21-12-020-021

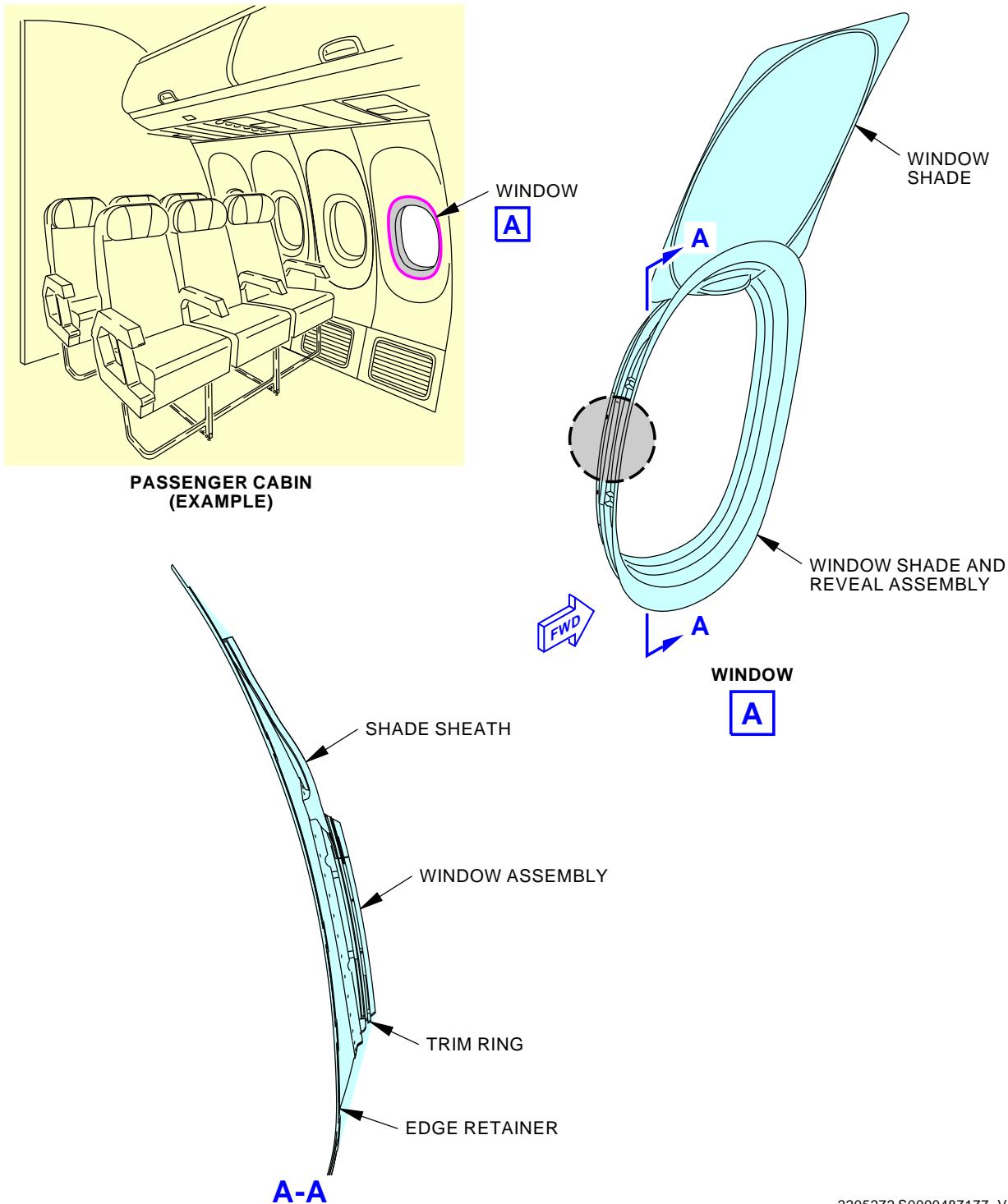
- (8) If it is necessary to remove the window inner pane, do these steps:
- (a) Carefully spread apart the upper lips of the inner pane tracks on the window reveal.
NOTE: This will prevent sliding contact damage to the window inner pane.
 - (b) Slide the window inner pane out from the window reveal.

———— END OF TASK ————

EFFECTIVITY	AKS ALL
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25-21-12

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Window Shade and Reveal Installation
Figure 401/25-21-12-990-809EFFECTIVITY
AKS ALL**25-21-12**

D633A101-AKS

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TASK 25-21-12-400-805

3. Snap In Window Shade and Reveal Assembly Installation

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-12-420-010

- (1) If it is necessary, do these steps to install the window inner pane:

NOTE: No special tools are necessary for installation.

- (a) Carefully spread apart the upper lips the inner pane tracks on the window reveal.
- (b) Carefully spread apart the upper lips of the inner pane tracks on the window reveal.
- (c) Put the window inner pane into the window reveal.

SUBTASK 25-21-12-400-002

- (2) To install the window shade and reveal, do these steps:

- (a) Put the window reveal into the window opening.

- (b) The top of the shade will guide itself into the shade sheath.

NOTE: Do not engage the top two reveal tabs to the top of the sidewall panel.

- (c) Pull up on the shade to make space to install the lower three reveal tabs.

- (d) Push the two lower corner tabs outboard one at a time to engage the window reveal tabs.

- (e) The tabs must move past the window opening.

- (f) Push the lower center reveal tab outboard to engage the window reveal tab.

- (g) The tab must move past the window opening.

- (h) Pull down on the window reveal until the three lower tabs are fully engaged against the sidewall window panel.

NOTE: When installed correctly, the bottom of the window reveal will fit tightly against the sidewall panel.

- (i) At one of the reveal side tab locations, push the reveal outboard and away from the window center.

- (j) Engage the top tab that is closest to the first engaged side tab.

- (k) Push the reveal outboard and away from the window center.

- (l) Engage the other top reveal tab.

- 1) push the reveal outboard and away from the window center.

- (m) Engage the second side reveal tab.

- 1) Push the reveal outboard and away from the window center.

- (n) Pull up on the top of the window reveal to make sure that all of the tabs are fully engaged.

- (o) Move the window shade up and down to make sure that the shade operates smoothly.

— END OF TASK —

EFFECTIVITY
AKS ALL

25-21-12



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TASK 25-21-12-000-805

4. Emergency Exit Door Snap In Window Shade and Reveal Assembly Removal

A. General

- (1) This procedure includes steps to remove the window shade and reveal assembly, or to remove only the window shade.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-21-12-000-001

- (1) To remove the window shade and reveal do these steps:

NOTE: THE SKIN WEDGE TOOL MUST BE PLACED ON ONE AT A TIME TOP OF THE 6 REVEAL TABS TO RELEASE WINDOW REVEAL.

- (a) Move the shade to the closed position.
- (b) Start with one of the sidewall tabs first.
- (c) Put the skin wedge release tool between the sidewall panel and the window reveal.
- (d) Push the sidewall panel outboard with the skin wedge.
- (e) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-020-010

- (2) Disengage the top two reveal tabs from the sidewall panel.

- (a) Disengage the top tab that is closest to the first disengaged side tab.
- (b) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
- (c) Push the sidewall panel outboard with the skin wedge.
- (d) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.
- (e) Disengage the other top reveal tab.

SUBTASK 25-21-12-020-011

- (3) Disengage the other side reveal tab from the sidewall panel.

- (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
- (b) Push the sidewall panel outboard with the skin wedge.
- (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-020-012

- (4) With one hand hold the top of the window reveal and pull up.

SUBTASK 25-21-12-020-013

- (5) Disengage the two lower corner reveal tabs from the sidewall panel.

- (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
- (b) Push the sidewall panel outboard with the skin wedge.

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- (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.
- (d) Move the sidewall panel to flex the lip away from the corner tabs.

SUBTASK 25-21-12-020-014

- (6) Disengage the lower reveal I tab from the sidewall panel.
 - (a) Put the skin wedge release tool between the sidewall panel and one of the top two window reveal tabs.
 - (b) Push the sidewall panel outboard with the skin wedge.
 - (c) At the same time, carefully and quickly push the skin wedge handle in the direction of the center of the window.

SUBTASK 25-21-12-000-002

- (7) Carefully shake the window reveal free and remove.

———— END OF TASK ————

TASK 25-21-12-400-806

| 5. **Emergency Exit Door Snap In Window Shade and Reveal Assembly Installation**

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-12-400-001

NOTE: NO SPECIAL TOOLS ARE REQUIRED FOR INSTALLATION.

- (1) To install the window shade and reveal do these steps:

- (a) Put the window reveal into the window opening.
 - (b) The top of the shade will guide itself into the shade sheath.

NOTE: DO NOT ENGAGE THE TOP TWO REVEAL TABS TO THE TOP OF THE SIDEWALL PANEL.

- (c) Pull up on the shade to make space to install the lower three reveal tabs.
 - (d) Push the two lower corner tabs outboard one at a time to engage the window reveal tabs.
 - (e) The tabs must move past the window opening.
 - (f) Push the lower center reveal tab outboard to engage the window reveal tab.
 - (g) The tab must move past the window opening.
 - (h) Pull down on the window reveal until the three lower tabs are fully engaged against the sidewall window panel.

NOTE: WHEN INSTALLED CORRECTLY THE BOTTOM OF THE WINDOW REVEAL WILL FIT TIGHTLY AGAINST THE SIDEWALL PANEL.

- (i) At one of the reveal side tab locations push the reveal outboard and away from the window center.
 - (j) Engage the top tab that is closest to the first engaged side tab.
 - (k) Push the reveal outboard and away from the window center.
 - (l) Engage the other top reveal tab.

- 1) push the reveal outboard and away from the window center.

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- (m) Engage the second side reveal tab.
 - 1) Push the reveal outboard and away from the window center.
- (n) Pull up on the top of the window reveal to make sure that all of the tabs are fully engaged.
- (o) Move the window shade up and down to make sure that the shade operates smoothly.

———— END OF TASK ————

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EMERGENCY EXIT DOORWAY LINING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Emergency Exit Doorway Lining Removal,
 - (2) Emergency Exit Doorway Lining Installation.

TASK 25-21-20-000-801

2. Emergency Exit Doorway Lining Removal

(Figure 401)

A. References

<u>Reference</u>	<u>Title</u>
25-21-46-000-801	Sidewall Panel - Removal (P/B 401)

B. Location Zones

<u>Zone</u>	<u>Area</u>
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Procedure

SUBTASK 25-21-20-860-001

- (1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C01280	DOOR AREA HTR-FWD

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	11	C00594	WINDOW LIGHT RIGHT
E	12	C00776	WINDOW LIGHT LEFT

SUBTASK 25-21-20-010-001

WARNING: MAKE SURE THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

- (2) Open the emergency exit door.

SUBTASK 25-21-20-010-002

- (3) Remove the seat intrusion control block [15], if applicable.
 - (a) Remove the screws [16] and the washers [17].
 - (b) Remove the seat intrusion control block [15].

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SUBTASK 25-21-20-010-003

- (4) Remove a sidewall panel adjacent to the emergency exit door. To remove a sidewall panel, do this task: Sidewall Panel - Removal, TASK 25-21-46-000-801.

SUBTASK 25-21-20-020-001

- (5) Remove the closeout lining assembly [1].
- Pull the closeout lining assembly [1] up and inboard.
 - Remove the screws [2] and the washers [3].
 - Disconnect the heater blanket electrical lead [4].
 - Remove the closeout lining assembly [1].

SUBTASK 25-21-20-020-002

- (6) Remove the trim strip assemblies [8] and [9].

NOTE: The trim strip assembly [8] is opposite the trim strip assembly [9]. Use the same procedure to remove the trim strip assemblies.

- Remove the screw [6] and the dimpled washer [7].
- Remove the nuts [10] and the washers [11] and [12].
- Disconnect the heater blanket electrical wiring.
- Remove the trim strip assemblies [8] and [9].

SUBTASK 25-21-20-020-003

- (7) Remove the upper lining assembly [5].

- Disengage the zipper that attaches the seal on the upper lining assembly [5] to the moisture control seal.
- Remove the screws [13] and the washers [14].
- Disconnect the emergency exit light wiring.
- Remove the upper lining assembly [5].

———— END OF TASK ————

TASK 25-21-20-400-801

3. Emergency Exit Doorway Lining Installation

(Figure 401)

A. References

Reference	Title
25-21-46-400-801	Sidewall Panel - Installation (P/B 401)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

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C. Procedure

SUBTASK 25-21-20-860-002

- (1) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C01280	DOOR AREA HTR-FWD

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	11	C00594	WINDOW LIGHT RIGHT
E	12	C00776	WINDOW LIGHT LEFT

SUBTASK 25-21-20-420-001

- (2) Install the upper lining assembly [5].

CAUTION: MAKE CERTAIN ELECTRICAL CONNECTORS ARE NOT CROSSED DURING INSTALLATION.

- (a) Connect the emergency exit light wiring.
- (b) Bend the clips on the upper lining assembly [5] a small amount to install them below the sidewall that is installed.
NOTE: Make sure that the electrical wires are put behind the upper lining assembly [5].
- (c) Put the top of the upper lining assembly [5] into the slot in the A/C extrusion.
NOTE: Use the slotted holes to adjust the upper lining assembly [5] to touch the A/C extrusion.
- (d) Install the screws [13] and the washers [14].
NOTE: Do not tighten the screws [13].

SUBTASK 25-21-20-420-002

- (3) Install the trim strip assemblies [8] and [9].

NOTE: The trim strip assembly [8] is opposite the trim strip assembly [9]. Use the same procedure to install the trim strip assemblies.

CAUTION: MAKE CERTAIN ELECTRICAL CONNECTORS ARE NOT CROSSED DURING INSTALLATION.

- (a) Connect the heater blanket electrical wiring.
- (b) Put the top of the trim assemblies [8] and [9] below the upper lining assembly [5].
- (c) Install the screw [6] and the dimpled washer [7].
- (d) Install the washers [11] and [12] and the nuts [10].

NOTE: Add or remove the washers [12] to make sure that the distance between the linings on the forward and the aft sides is the same.

SUBTASK 25-21-20-420-003

- (4) Complete the installation of the upper lining assembly [5].

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- (a) Push up on the upper lining assembly [5] and tighten the screws [13].
- (b) Engage the zipper to attach the seal on the upper lining assembly [5] to the moisture seal.

SUBTASK 25-21-20-420-004

- (5) Install the closeout lining assembly [1].

CAUTION: MAKE CERTAIN ELECTRICAL CONNECTORS ARE NOT CROSSED DURING INSTALLATION.

- (a) Connect the heater blanket electrical lead [4].
- (b) Engage the bottom of the trim assembly [8] and [9] into the closeout lining assembly [1].
- (c) Install the screws [2] and the washers [3].

SUBTASK 25-21-20-410-001

- (6) Do this task: Sidewall Panel - Installation, TASK 25-21-46-400-801.

SUBTASK 25-21-20-410-002

- (7) Install the seat intrusion control block [15], if applicable.
 - (a) Install the washers [16] and the washers [17].

NOTE: Install the washers [17] between the air grille and the seat intrusion control block [15] as necessary to fill in the space between the air grilles.

SUBTASK 25-21-20-410-003

- (8) Close the emergency exit door.
 - (a) Engage the prop support assembly on the rear side of the closeout lining assembly [1].
 - (b) Close the emergency exit door.

SUBTASK 25-21-20-860-003

- (9) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C01280	DOOR AREA HTR-FWD

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	11	C00594	WINDOW LIGHT RIGHT
E	12	C00776	WINDOW LIGHT LEFT

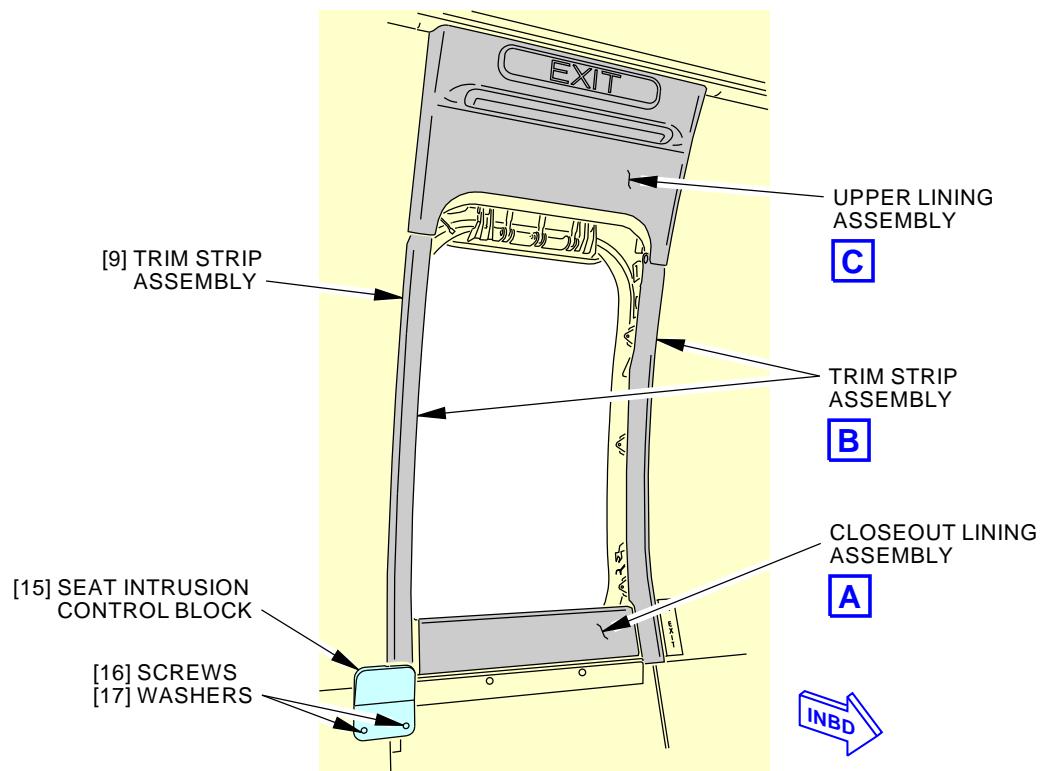
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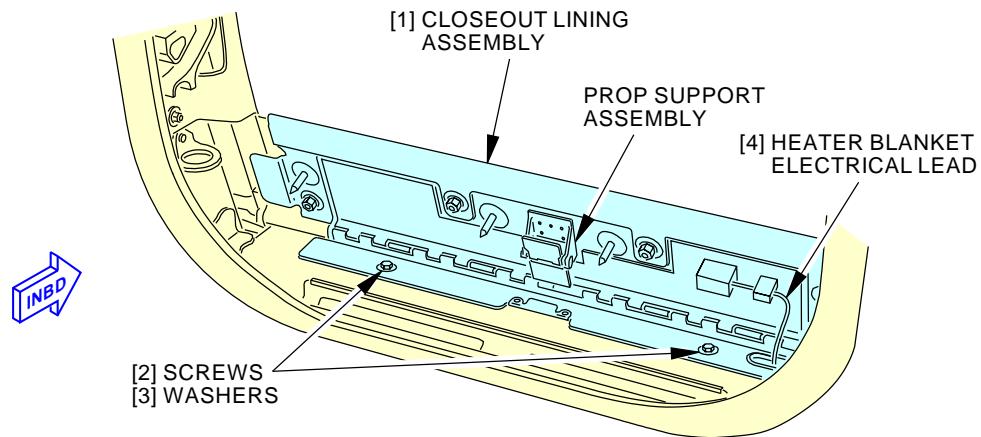
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EMERGENCY EXIT DOOR
(EXAMPLE)



CLOSEOUT LINING ASSEMBLY
(EXAMPLE)

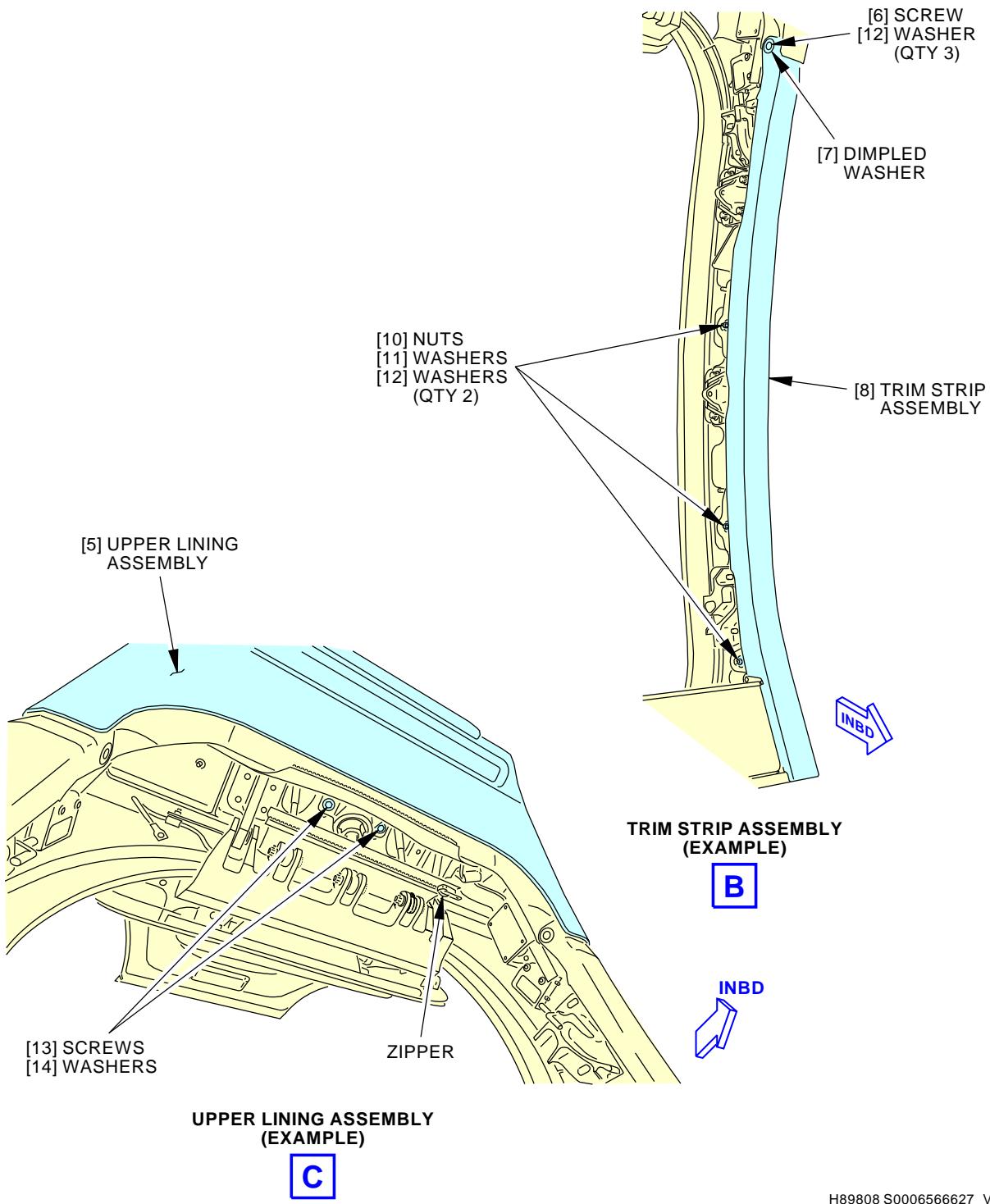
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Emergency Exit Doorway Lining Installation
Figure 401/25-21-20-990-801 (Sheet 1 of 2)

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Emergency Exit Doorway Lining Installation
Figure 401/25-21-20-990-801 (Sheet 2 of 2)

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AFT DOOR DOORWAY HEADER PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the aft door doorway header panel
 - (2) Installation of the aft door doorway header panel
- B. These tasks are applicable to the left and the right aft doors.

TASK 25-21-24-000-801

2. Aft Door Doorway Header Panel - Removal

(Figure 401)

A. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

B. Panel Removal

SUBTASK 25-21-24-020-001

- (1) Remove the seal depressor [8] and retainers [7]. To remove them, pull back the seal depressor [8] and remove the screws [9].

SUBTASK 25-21-24-020-002

- (2) Remove the plug buttons [5] that are along the top edge of the panel [2].

SUBTASK 25-21-24-020-003

- (3) Hold the panel up and remove the bolts [4] at the top edge of the panel and the screws [6] at the door opening.

SUBTASK 25-21-24-020-004

- (4) Lower the panel [2] until you can disconnect the ECS duct and the electrical connector.

SUBTASK 25-21-24-020-005

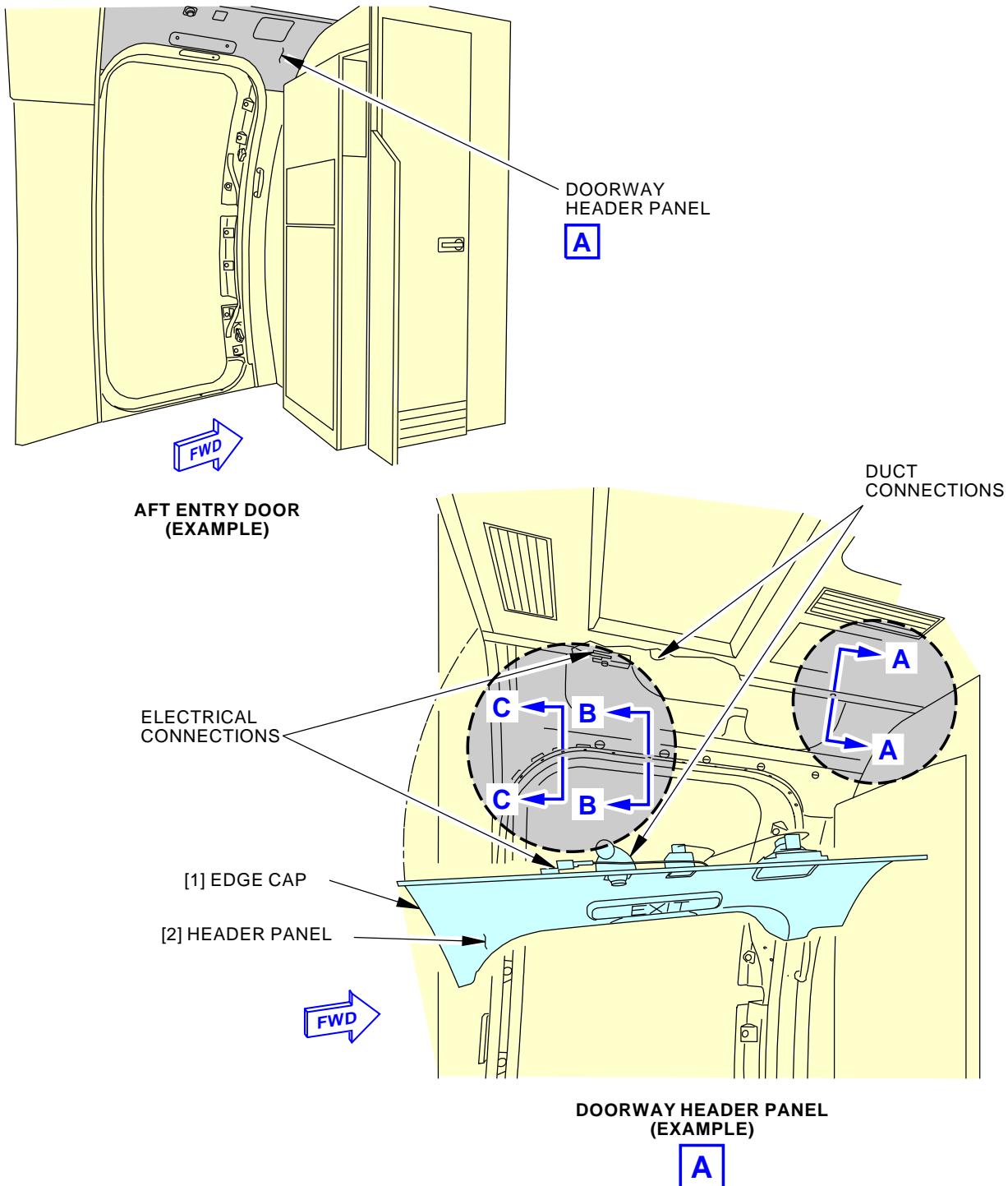
- (5) Remove the panel [2].

———— END OF TASK ————

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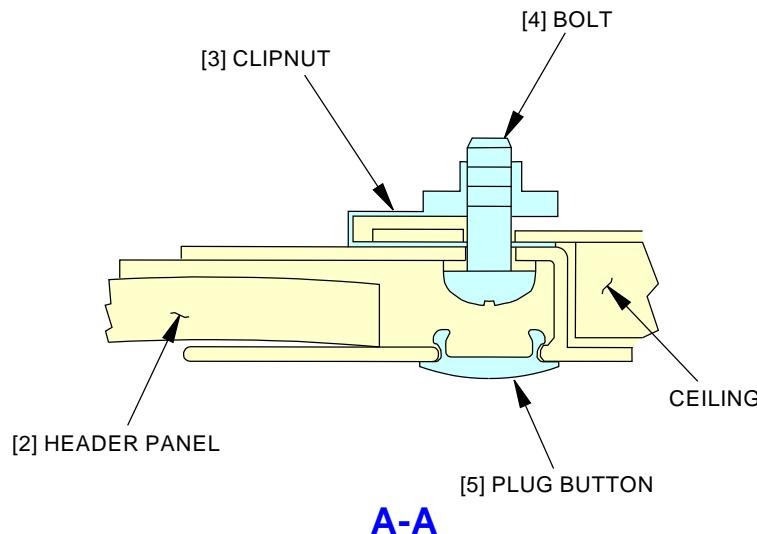
Aft Doorway Header Panel Installation
Figure 401/25-21-24-990-801 (Sheet 1 of 2)

 EFFECTIVITY
 AKS ALL

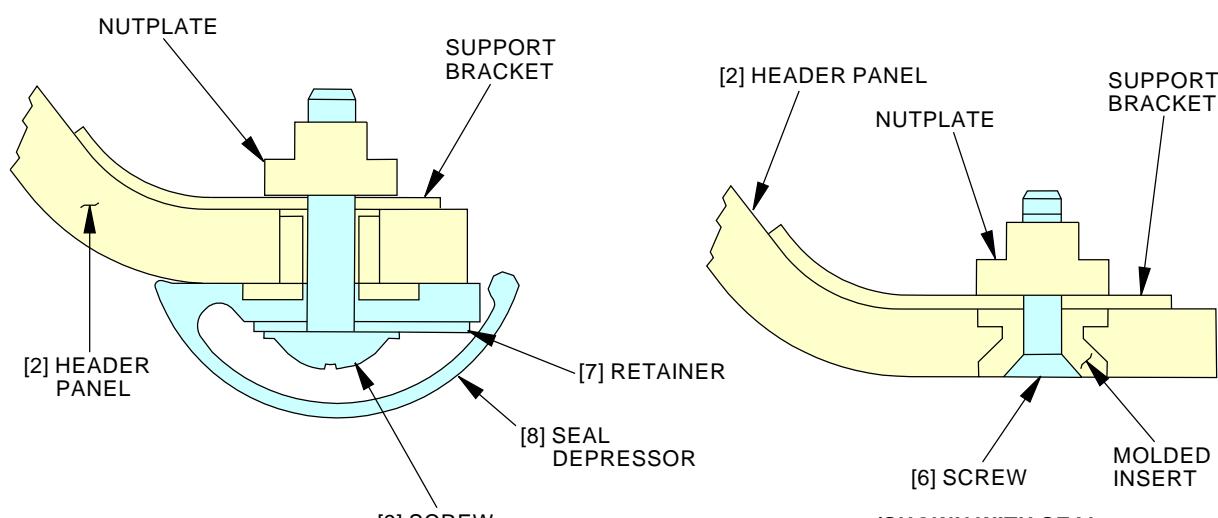
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A-A



B-B

C-C

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Aft Doorway Header Panel Installation
Figure 401/25-21-24-990-801 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-21-24-400-801

3. Aft Door Doorway Header Panel - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

B. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

C. Prepare for the Installation

SUBTASK 25-21-24-420-001

- (1) To install a new panel [2], do these steps:

- (a) Apply adhesive, A00027 (clear grade 2), to the back edge of the panel where you will install the edge cap [1].
- (b) Put the edge cap [1] on the panel.
- (c) After you install the panel (per the steps below) adjust the edge cap [1] so that it touches the adjacent wall.

SUBTASK 25-21-24-420-002

- (2) To install the same panel [2] that you removed, do these steps:

- (a) Hold the panel in its position and make sure the edge cap [1] aligns with the adjacent wall satisfactorily.
- (b) If there is a large clearance between the edge cap and the wall, or if the screw holes in the panel will not align with the nut plates (because the edge cap touches the wall), then do these steps:
 - 1) Remove the edge cap [1] from the panel. It is held with adhesive, A00027.
 - 2) Apply new adhesive, A00027 (clear grade 2), to the back edge of the panel.
 - 3) Put the edge cap [1] back on the panel.
 - 4) After you install the panel (per the steps below) adjust the edge cap [1] so that it touches the adjacent wall.

D. Panel Installation

SUBTASK 25-21-24-420-003

- (1) Hold the panel [2] up and connect the electrical connector and the ECS duct.

SUBTASK 25-21-24-420-004

- (2) Install the bolts [4] at top of the panel, and the screws [6] around the door opening.

SUBTASK 25-21-24-420-005

- (3) Install the seal depressor [8] and retainers [7] with the screws [9].

SUBTASK 25-21-24-420-006

- (4) Install the plug buttons [5] along the top edge of the panel [2].

— END OF TASK —



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AFT ENTRY AND AFT SERVICE DOORWAYS SIDEWALL LINING PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the Aft Entry and Service Doorways Sidewall Lining Panel
 - (2) Installation of the Aft Entry and Service Doorways Sidewall Lining Panel

TASK 25-21-25-020-801

2. Aft Entry and Service Doorways Sidewall Lining Panel - Removal

(Figure 401)

A. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

B. Prepare for the Removal

SUBTASK 25-21-25-840-001

- (1) Open this circuit breaker and install safety tag:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
E	9	C00119	VAC OUTLET AFT

SUBTASK 25-21-25-840-002

- (2) Remove the cover for the aft electrical outlet.

SUBTASK 25-21-25-840-003

- (3) Remove the passenger equipment if it is necessary to get access to the sidewall lining [2].

C. Panel Removal

SUBTASK 25-21-25-020-009

- (1) Unfold the rubber seal [3] that covers the seal retainer [1].

SUBTASK 25-21-25-020-010

- (2) Remove the screws [4] and washers [5] that attach the seal retainer [1] to the reveal assembly.

SUBTASK 25-21-25-020-004

- (3) Remove the lining that is aft of the door.

- (a) Move the lining forward and remove it.

SUBTASK 25-21-25-020-005

- (4) Remove the lining around the top part of the door opening.

- (a) Move the lining down and inboard and remove the lining.

SUBTASK 25-21-25-020-006

- (5) Remove the aid handle that is forward of the entry door, if installed.

SUBTASK 25-21-25-020-008

- (6) Remove the lining that is forward of the door.

- (a) Move the lining aft and inboard and remove it.

———— END OF TASK ————

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TASK 25-21-25-420-801

3. Aft Entry and Service Doorways Sidewall Lining Panel - Installation

(Figure 401)

A. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

B. Panel Installation

SUBTASK 25-21-25-420-001

- (1) Move the lining edges into the slot at the trim angle and onto the reveal assembly.

SUBTASK 25-21-25-420-003

- (2) Install the rubber seal [3] around the door opening.

SUBTASK 25-21-25-420-007

- (3) Install the seal retainer [1] over the bottom of the rubber seal [3].

SUBTASK 25-21-25-420-008

- (4) Attach the seal retainer [1] to the reveal assembly with screws [4] and washers [5].

SUBTASK 25-21-25-420-004

- (5) Install the aid handle that is forward of the entry door, if applicable.

C. Put the Airplane Back to Its Usual Condition.

SUBTASK 25-21-25-420-006

- (1) Install any equipment which you may have removed to gain access.

SUBTASK 25-21-25-840-005

- (2) Install the cover for the aft electrical outlet.

SUBTASK 25-21-25-840-006

- (3) Remove the safety tag and close this circuit breaker:

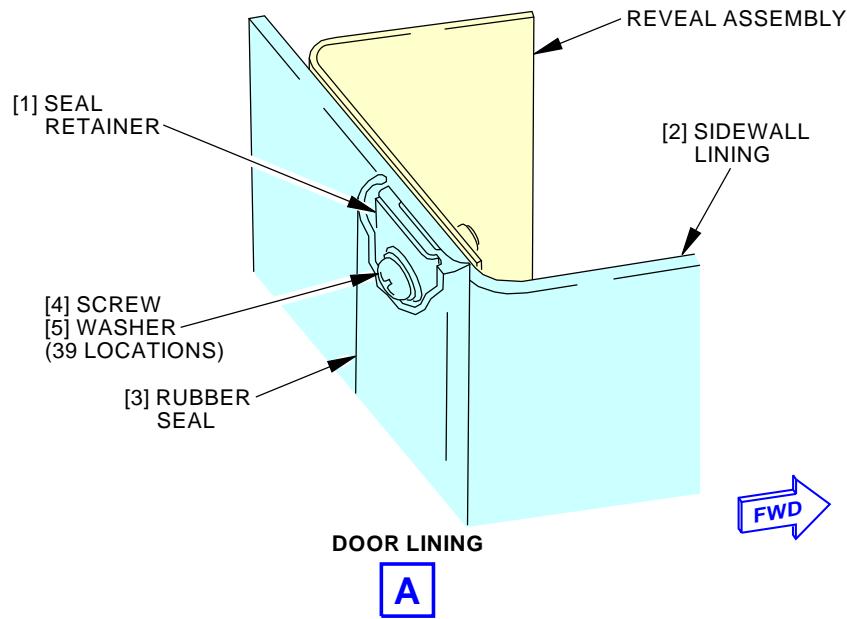
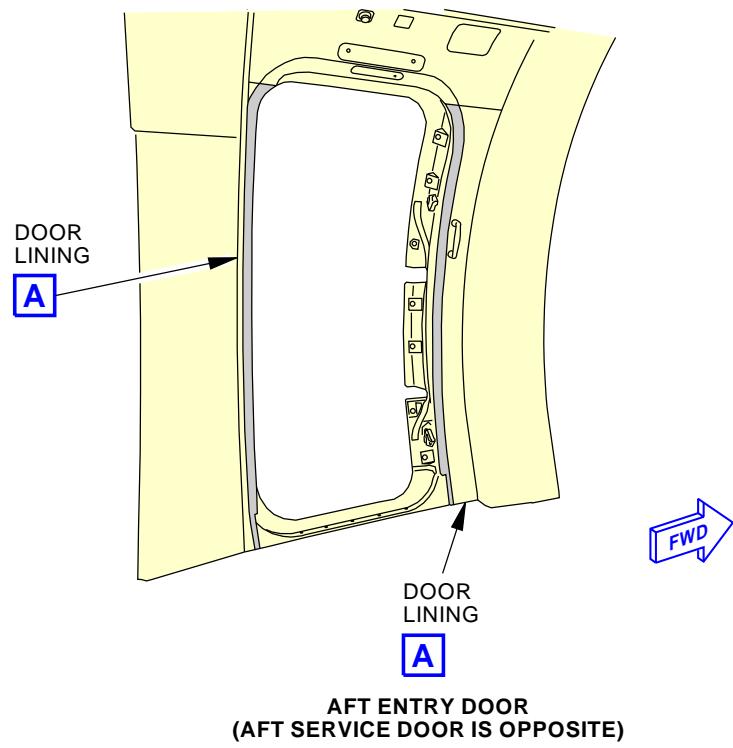
Power Distribution Panel Number 2, P92

Row	Col	Number	Name
E	9	C00119	VAC OUTLET AFT

———— END OF TASK ————



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Aft Entry and Service Door Sidewall Lining Panels Installation
Figure 401/25-21-25-990-801

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FORWARD ENTRY DOOR DOORWAY HEADER PANEL, - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the Forward entry door doorway header panel
 - (2) Installation of the Forward entry door doorway header panel

TASK 25-21-30-020-801

2. Forward Entry Door Doorway Header Panel - Removal

(Figure 401)

A. Panel Removal

SUBTASK 25-21-30-020-001

- (1) Remove the seal depressor [8] and retainers [7]. To remove them, pull back the seal depressor [8] and remove the screws [9].

SUBTASK 25-21-30-020-002

- (2) Remove the plug buttons [5] that are along the top edge of the panel [2].

SUBTASK 25-21-30-020-003

- (3) Hold the panel up and remove the bolts [4] at the top edge of the panel and the screws [6] at the door opening.

SUBTASK 25-21-30-020-004

- (4) Lower the panel [2] until you can disconnect the ECS duct and the electrical connector.

SUBTASK 25-21-30-020-005

- (5) Remove the panel [2].

———— END OF TASK ————

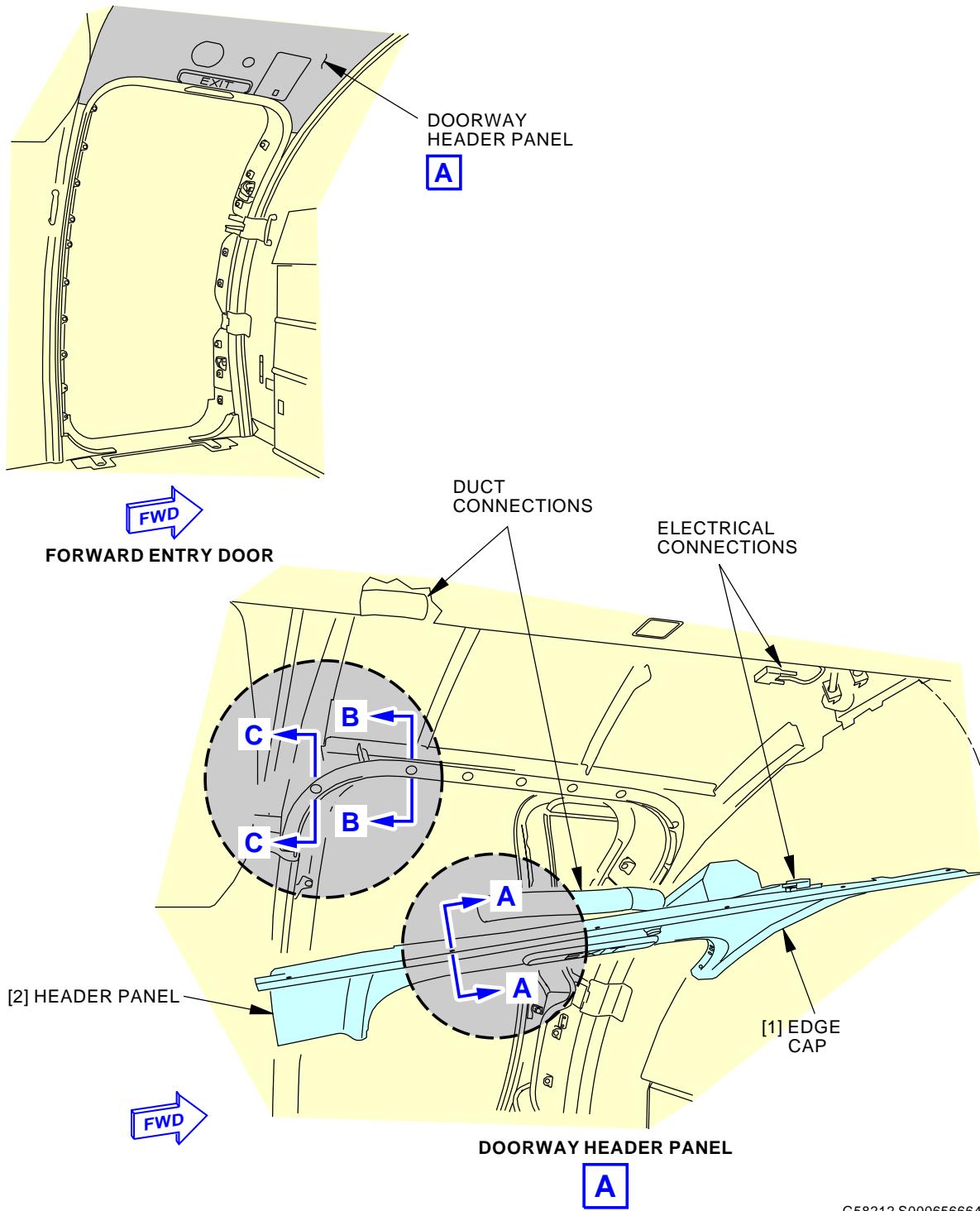
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Forward Entry Doorway Header Panel Installation
Figure 401/25-21-30-990-801 (Sheet 1 of 2)

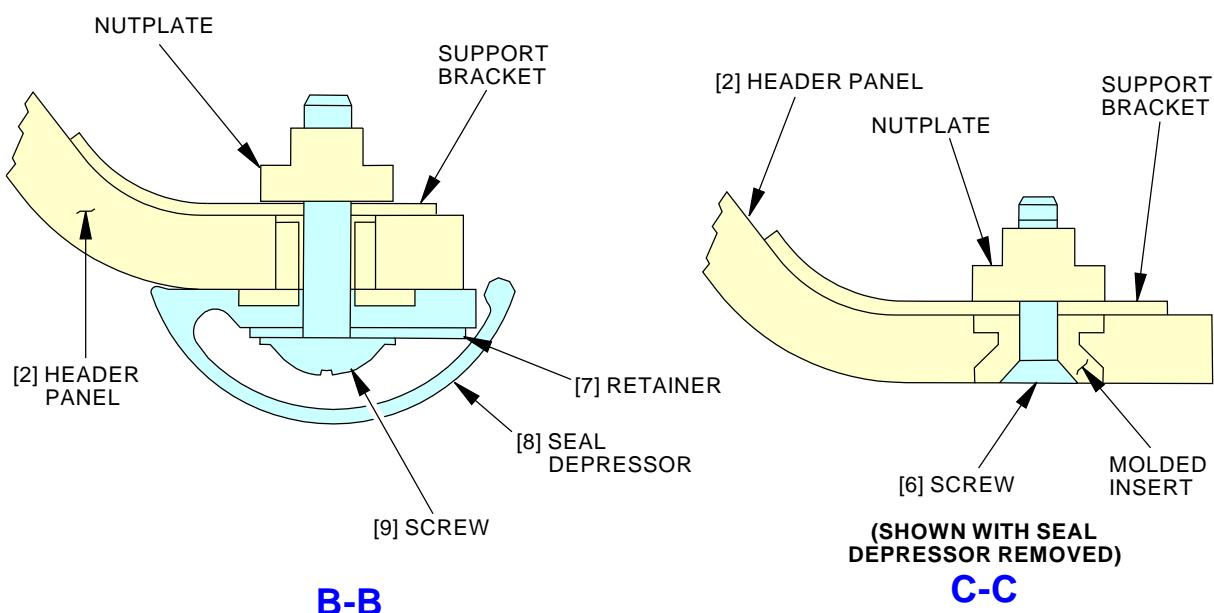
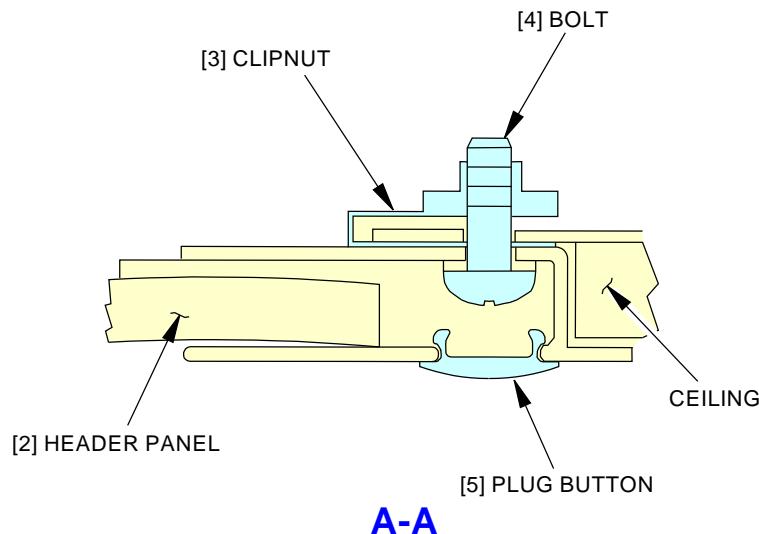
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Forward Entry Doorway Header Panel Installation
Figure 401/25-21-30-990-801 (Sheet 2 of 2)

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TASK 25-21-30-420-801

3. Forward Entry Door Doorway Header Panel - Installation

(Figure 401)

A. References

Reference	Title
35-22-00-210-801	Visual Inspection of the Oxygen Generator (P/B 501)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Header panel	25-21-30-03C-050	AKS 001-006, 009, 010, 013, 015-018, 020-025, 027
		25-21-30-09-050	AKS 007, 008, 011, 012, 014, 019, 026, 028-999

D. Prepare for the Installation

SUBTASK 25-21-30-210-001

- (1) Check that the oxygen generator is activated. Do this task: Visual Inspection of the Oxygen Generator, TASK 35-22-00-210-801

SUBTASK 25-21-30-420-001

- (2) To install a new header panel [2], do these steps:
 - (a) Apply adhesive, A00027 (clear grade 2), to the back edge of the panel where you will install the edge cap [1].
 - (b) Put the edge cap [1] on the panel.
 - (c) After you install the panel (per the steps below) adjust the edge cap [1] so that it touches the adjacent wall.

SUBTASK 25-21-30-420-002

- (3) To install the same header panel [2] that you removed, do these steps:
 - (a) Hold the panel in its position and make sure the edge cap [1] aligns with the adjacent wall satisfactorily.
 - (b) If there is a large clearance between the edge cap and the wall, or if the screw holes in the panel will not align with the nut plates (because the edge cap touches the wall), then do these steps:
 - 1) Remove the edge cap [1] from the panel. It is held with adhesive, A00027.
 - 2) Apply new adhesive, A00027 (clear grade 2), to the back edge of the panel.
 - 3) Put the edge cap [1] back on the panel.
 - 4) After you install the panel (per the steps below) adjust the edge cap [1] so that it touches the adjacent wall.

E. Doorway Header Panel Installation

SUBTASK 25-21-30-420-003

- (1) Hold the header panel [2] up and connect the electrical connector and the ECS duct.

EFFECTIVITY
AKS ALL

25-21-30



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SUBTASK 25-21-30-420-004

- (2) Install the bolts [4] at top of the panel, and the screws [6] around the door opening.

SUBTASK 25-21-30-420-005

- (3) Install the seal depressors [8] and retainers [7] with the screws [9].

SUBTASK 25-21-30-420-006

- (4) Install the plug buttons [5] along the top edge of the header panel [2].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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FORWARD ENTRY DOORWAY SIDEWALL LINING PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the Forward Entry Doorway Sidewall Lining Panel
 - (2) Installation of the Forward Entry Doorway Sidewall Lining Panel

TASK 25-21-31-420-801

2. Forward Entry Doorway Sidewall Lining Panel - Removal

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Panel Removal

SUBTASK 25-21-31-020-001

- (1) Remove the passenger equipment if it is necessary to get access to the sidewall lining panel.

SUBTASK 25-21-31-020-002

- (2) If installed, remove the aid handle that is forward of the galley door.

SUBTASK 25-21-31-020-003

- (3) Remove the rubber seal from the retainer around the door opening.

SUBTASK 25-21-31-020-004

- (4) Remove the screws that attach the trim angle.
 - (a) Remove the trim angles with the seal retainer.

SUBTASK 25-21-31-020-005

- (5) Remove the fasteners that attach the panel to the sidewall structure.

SUBTASK 25-21-31-020-006

- (6) Remove the forward and aft kick plates.

SUBTASK 25-21-31-020-007

- (7) Remove the panel that is forward of the door.
 - (a) Move the panel aft and remove it.

————— END OF TASK ————

TASK 25-21-31-420-802

3. Forward Entry Doorway Sidewall Lining Panel - Installation

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Panel Installation

SUBTASK 25-21-31-420-001

- (1) Install the panel that is aft of the door.
 - (a) Move the panel aft below the trim strip.

EFFECTIVITY
AKS ALL

25-21-31



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SUBTASK 25-21-31-420-002

- (2) Install the panel that is forward of the door.
 - (a) Move the panel aft into the slot on the open strip and attach fasteners.

SUBTASK 25-21-31-420-003

- (3) Install the trim angles and the seal retainer.

SUBTASK 25-21-31-420-004

- (4) Install the rubber seal.

SUBTASK 25-21-31-420-005

- (5) Install the kick plates.

SUBTASK 25-21-31-420-006

- (6) Install the aid handle, if applicable.

SUBTASK 25-21-31-420-007

- (7) Install the hinge cover panel.

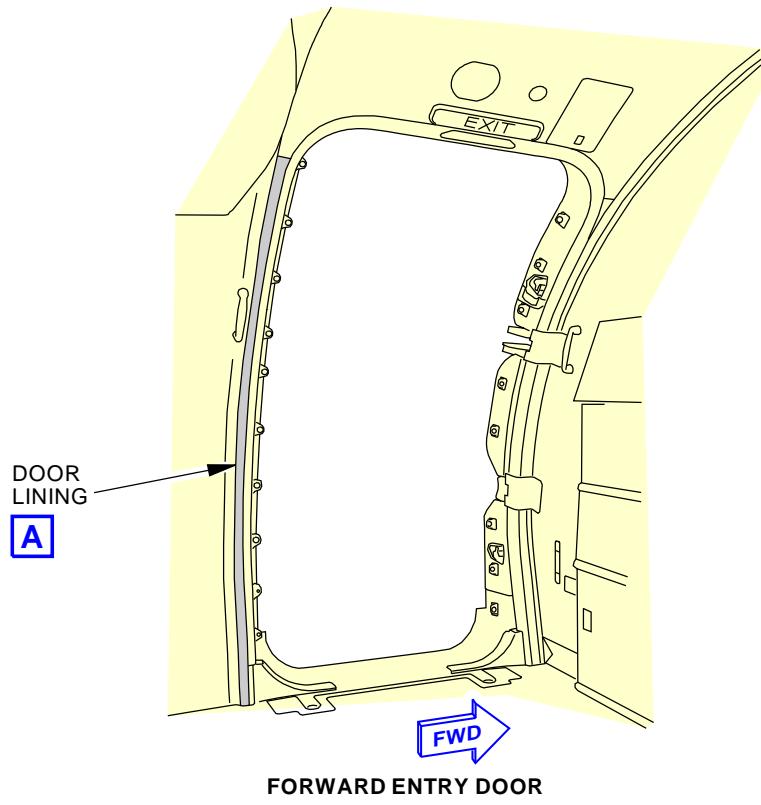
SUBTASK 25-21-31-420-008

- (8) Install all the passenger equipment which you removed for access to doorway lining panels.

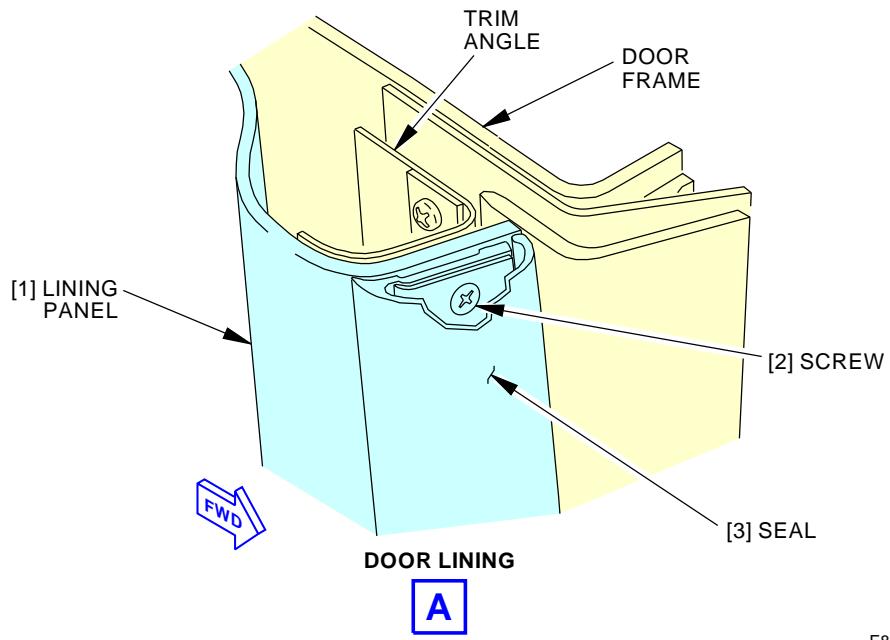
———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-21-31



FORWARD ENTRY DOOR



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Forward Entry Doorway Sidewall Lining Panels Installation
Figure 401/25-21-31-990-801EFFECTIVITY
AKS ALL**25-21-31**



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DOORWAY HEADER PANEL, FORWARD GALLEY DOOR - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A task to remove the doorway header panel from the forward galley door,
 - (2) A task to install the doorway header panel at the forward galley door.

TASK 25-21-34-000-801

2. Forward Galley Door Doorway Header Panel - Removal

(Figure 401)

A. Panel Removal

SUBTASK 25-21-34-020-001

- (1) Remove the seal depressor [8] and retainers [7]. To remove them, pull back the seal depressor [8] and remove the screws [6].

SUBTASK 25-21-34-020-002

- (2) Remove the plug buttons [5] that are along the top edge of the panel [1].

SUBTASK 25-21-34-020-003

- (3) Hold the panel up and remove the bolts [4] at the top edge of the panel and the screws [6] at the door opening.

SUBTASK 25-21-34-020-004

- (4) Lower the panel [1] until you can disconnect the ECS duct and the electrical connector.

SUBTASK 25-21-34-020-005

- (5) Remove the panel [1].

———— END OF TASK ————

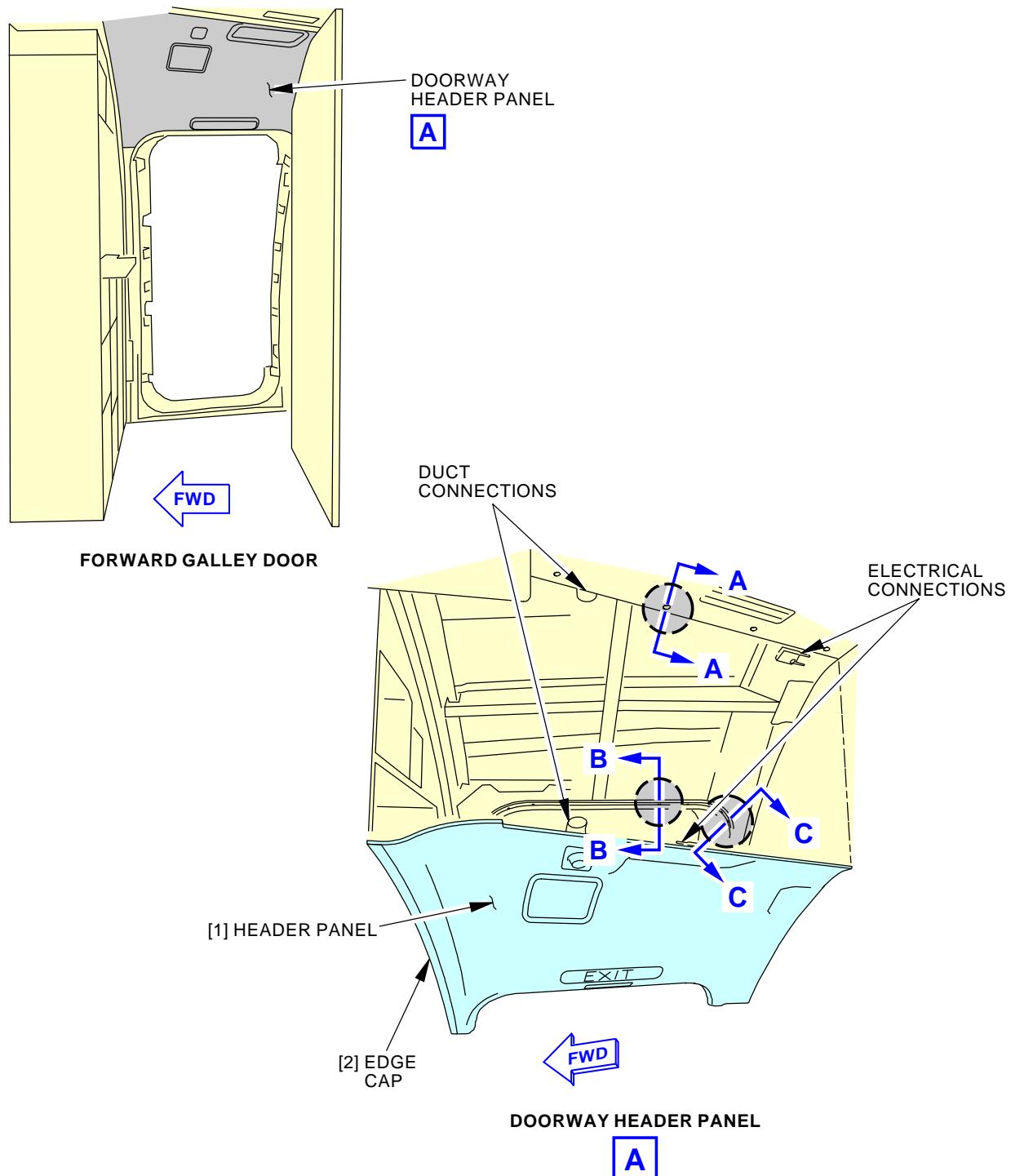
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Forward Galley Doorway Header Panel Installation
Figure 401/25-21-34-990-801 (Sheet 1 of 2)

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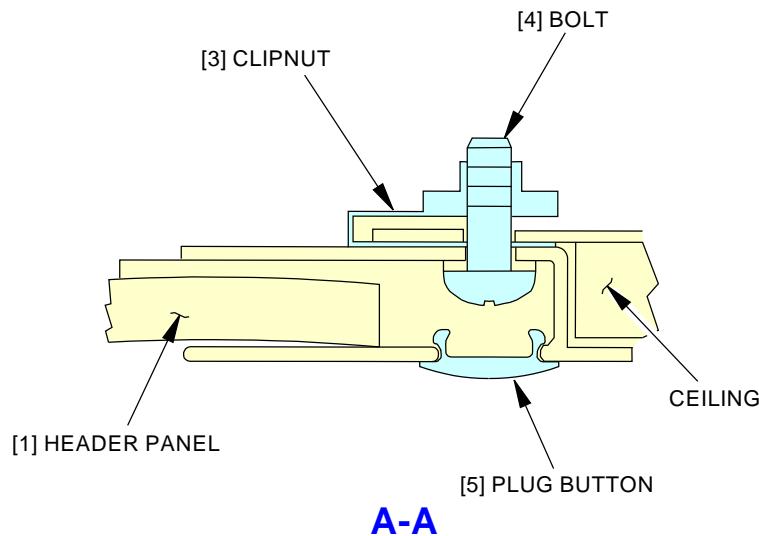
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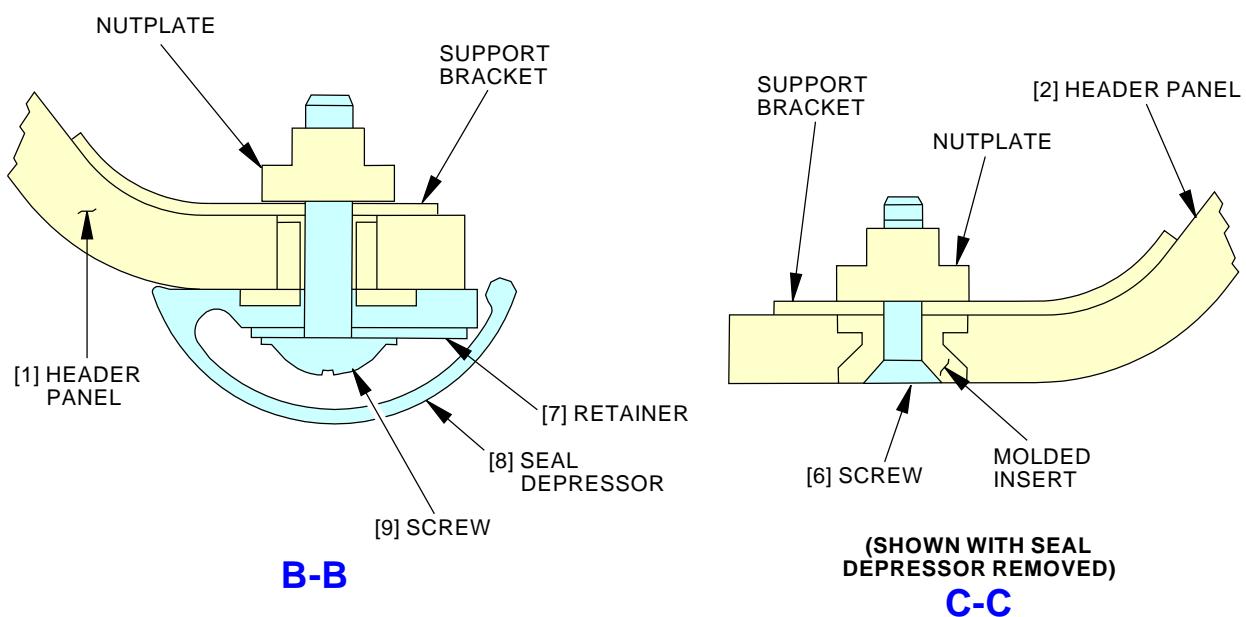
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A-A



(SHOWN WITH SEAL
DEPRESSOR REMOVED)

C-C

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Forward Galley Doorway Header Panel Installation
Figure 401/25-21-34-990-801 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-21-34-400-801

3. Forward Galley Door Doorway Header Panel - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

B. Prepare for the Installation

SUBTASK 25-21-34-420-001

- (1) To install a new panel [1], do these steps:
 - (a) Apply adhesive, A00027 (clear grade 2), to the back edge of the panel where you will install the edge cap [2].
 - (b) Put the edge cap [2] on the panel.
 - (c) After you install the panel (per the steps below) adjust the edge cap [2] so that it touches the adjacent wall.

SUBTASK 25-21-34-420-002

- (2) To install the same panel [1] that you removed, do these steps:
 - (a) Hold the panel in its position and make sure the edge cap [2] aligns with the adjacent wall satisfactorily.
 - (b) If there is a large clearance between the edge cap and the wall, or if the screw holes in the panel will not align with the nut plates (because the edge cap touches the wall), then do these steps:
 - 1) Remove the edge cap [2] from the panel. It is held with adhesive, A00027.
 - 2) Apply new adhesive, A00027 (clear grade 2), to the back edge of the panel.
 - 3) Put the edge cap [2] back on the panel.
 - 4) After you install the panel (per the steps below) adjust the edge cap [2] so that it touches the adjacent wall.

C. Panel Installation

SUBTASK 25-21-34-420-003

- (1) Hold the panel [1] up and connect the electrical connector and the ECS duct.

SUBTASK 25-21-34-420-004

- (2) Install the bolts [4] at top of the panel, and the screws [6] around the door opening.

SUBTASK 25-21-34-420-005

- (3) Install the seal depressor [8] and retainers [7] with the screws [9].

SUBTASK 25-21-34-420-006

- (4) Install the plug buttons [5] along the top edge of the panel [1].

———— END OF TASK ————



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FORWARD GALLEY DOORWAY SIDEWALL LINING PANELS - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Removal of the Forward Galley Doorway Surround Panel
 - (2) Installation of the Forward Galley Doorway Surround Panel

TASK 25-21-35-020-801

2. **Forward Galley Doorway Sidewall Lining Panel - Removal**

(Figure 401)

A. **General**

- (1) This procedure only applies to the door surround panel installed on the structure around the forward galley doorway.

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Panel Removal**

SUBTASK 25-21-35-020-001

- (1) Remove the passenger equipment if it is necessary to get access to the door surround lining panels.

SUBTASK 25-21-35-020-002

- (2) Remove the screws common to the seal and seal retainer.
 - (a) Remove the seal and seal retainer.

SUBTASK 25-21-35-020-003

- (3) Remove the remaining countersunk screws located under the seal.

SUBTASK 25-21-35-020-004

- (4) Remove the fasteners that attach the panel to the sidewall structure if they are installed.

SUBTASK 25-21-35-020-005

- (5) Remove the panel that is forward of the door.
 - (a) Move the panel up approximately one inch then aft to remove it.

SUBTASK 25-21-35-020-006

- (6) Remove the panel that is aft of the door.
 - (a) Move the panel up approximately one inch then forward to remove it

————— END OF TASK ————

TASK 25-21-35-420-801

3. **Forward Galley Doorway Sidewall Lining Panel - Installation**

(Figure 401)

A. **General**

- (1) This procedure only applies to the sidewall lining panels installed on the structure around the forward galley doorway.

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B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Panel Installation

SUBTASK 25-21-35-420-001

- (1) Install the panel that is aft of the door.
 - (a) Move the panel aft below the trim strip.

SUBTASK 25-21-35-420-002

- (2) Install the panel that is forward of the door.
 - (a) Move the panel into the slot on the trim strip.

SUBTASK 25-21-35-420-003

- (3) Install the rubber seal and the seal retainer.

SUBTASK 25-21-35-420-004

- (4) Install the passenger equipment removed for access to the sidewall lining panels.

———— END OF TASK ————

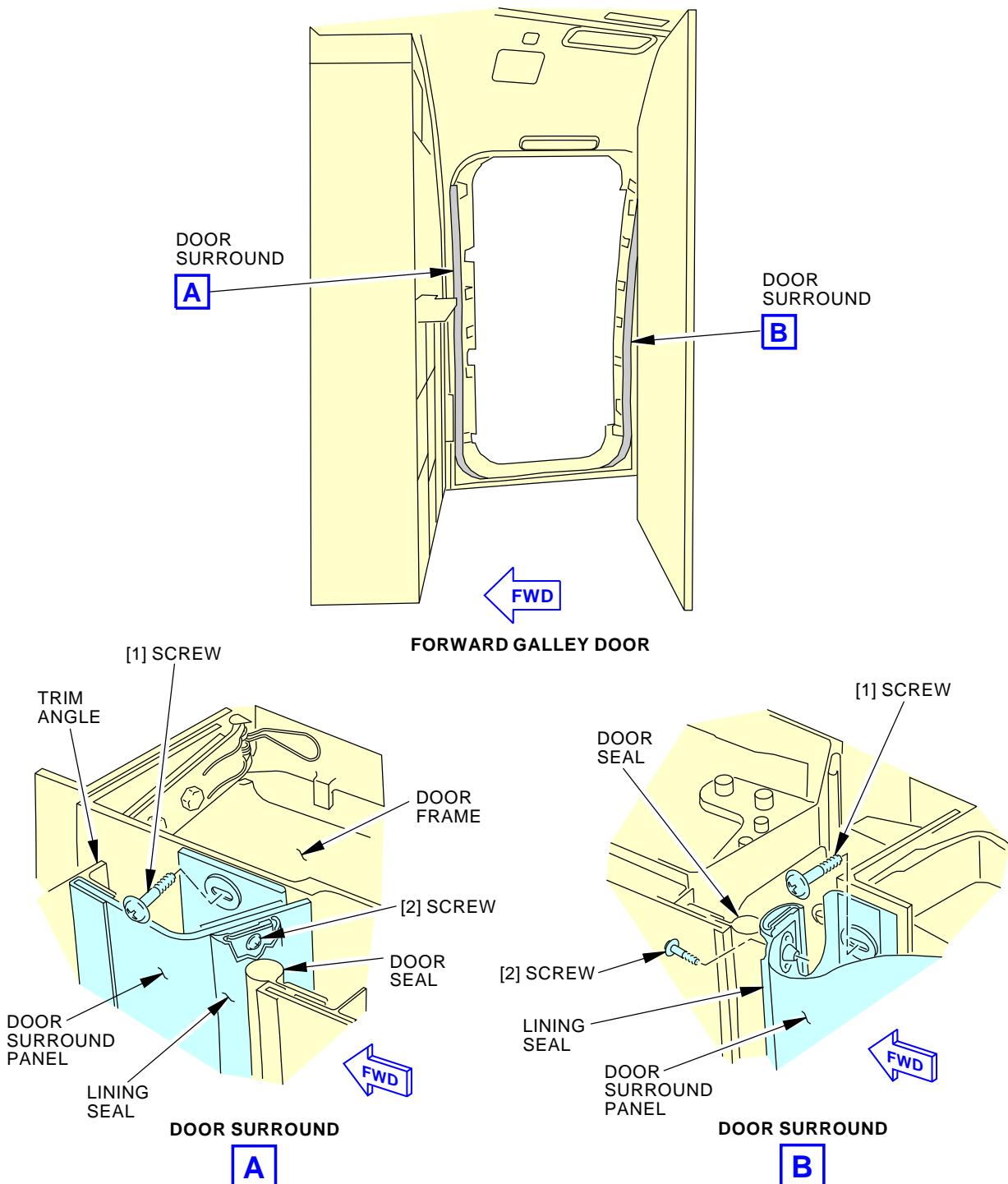
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Forward Galley Doorway Surround Panels Installation
Figure 401/25-21-35-990-801

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CEILING PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Main Ceiling Panel Removal
 - (2) Main Ceiling Panel Installation
 - (3) Forward Cove Bullnose Ceiling Panel Removal
 - (4) Forward Cove Bullnose Ceiling Panel Installation
 - (5) Forward Lowered Horseshoe Ceiling Panel Removal
 - (6) Forward Lowered Horseshoe Ceiling Panel Installation
 - (7) Aft Cove Bullnose Lowered Ceiling Panel Removal
 - (8) Aft Cove Bullnose Lowered Ceiling Panel Installation
 - (9) Aft Cove Bullnose Horseshoe Ceiling Panel Removal
 - (10) Aft Cove Bullnose Horseshoe Ceiling Panel Installation
 - (11) Aft Entry Lowered Ceiling Panel Removal
 - (12) Aft Entry Lowered Ceiling Panel Installation

TASK 25-21-45-000-803-001

2. Main Ceiling Panel - Removal

Figure 401

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Ceiling Panel Removal

SUBTASK 25-21-45-020-009-001

- (1) Do these steps to remove the aft air grill [8] first, then the forward air grill [8]:

NOTE: You must remove two air grills [8] to remove one ceiling panel.

- (a) Pull down the end of the latch [13] that you can see through the air grill [8].
- (b) Slide the air grill [8] aft approximately two inches to clear the latch [13].
- (c) Lower the air grill [8].

SUBTASK 25-21-45-020-010-001

- (2) Remove the emergency exit sign and the attached bar, if it is necessary.

SUBTASK 25-21-45-020-011-001

- (3) Do these steps to open the inboard panel [7] or outboard panel [1] of the main ceiling:

- (a) Turn the latches [9] on the panel [7], [1] while you hold it up.
- (b) Slowly lower the panel [7], [1] and let it hang by the lanyards [3].

SUBTASK 25-21-45-020-012-001

- (4) Disconnect the lanyards [3] from the latches [9] on the panel [7], [1].

SUBTASK 25-21-45-020-013-001

- (5) If there is electrical equipment mounted on the panel [7], do these steps to disconnect the electrical connector [4]:

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- (a) With your thumb and index finger, squeeze the serrated areas on the connector [4] to release the tabs.
- (b) Disconnect the electrical connector [4].

SUBTASK 25-21-45-010-001-001

- (6) Lift the panel [7], [1] out of the hinges [6].

SUBTASK 25-21-45-010-002-001

- (7) Remove the panel [7], [1].

———— END OF TASK ————

TASK 25-21-45-400-803-001

3. Main Ceiling Panel - Installation

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-13566	Installation/Removal Tool - 737 BSI Ceiling Panels Part #: C25002-1 Supplier: 81205

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Do these tasks to install the ceiling panel:

SUBTASK 25-21-45-410-001-001

- (1) Align the ceiling panel [1], [7] with the smaller of the two hinge halves [6], engage the hinge pins.

SUBTASK 25-21-45-410-002-001

- (2) Engage the hinge halves [6] of the ceiling panel [1], [7] to the mating halves on the center bin trough [15].

SUBTASK 25-21-45-420-009-001

- (3) Insert the most inboard hinge pin to the inboard slot, of the hinge half, on the trough [15].

SUBTASK 25-21-45-410-003-001

- (4) Move the ceiling panel [1], [7] up to engage the outboard hinge pin to its slot on the mating hinge half.

SUBTASK 25-21-45-420-010-001

- (5) When the hinge halves [6] are correctly engaged, the panel [1], [7] will be at the full down position.

NOTE: Be careful to not damage the hinge.

SUBTASK 25-21-45-410-004-001

CAUTION: DO NOT PUSH THE LATCH TOO HARD TO ENGAGE THE LATCH STRIKE. DAMAGE TO THE PLENUM OR CEILING LATCHES CAN OCCUR.

- (6) Push with light force inboard and move the panel to its correct position.

SUBTASK 25-21-45-420-011-001

- (7) Roll excess gap seal [16] on the inboard edge, upward along the trough.



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SUBTASK 25-21-45-420-012-001

- (8) Attach the end of the lanyard [3] on the ceiling panel [1], [7] latch half, to the hole in the plenum [11] latch half.

SUBTASK 25-21-45-210-001-001

- (9) Make sure these hinge pins align correctly to prevent damage to the hinge half.

NOTE: The latch will not lock if the hinge pins are not aligned.

SUBTASK 25-21-45-410-005-001

- (10) Install the outboard edge of the ceiling panel [1], [7] to the strongback.

SUBTASK 25-21-45-860-005-001

- (11) Let the ceiling panel hang by the lanyards [3] or move the panel to the down position.

SUBTASK 25-21-45-420-013-001

- (12) Connect the electrical connectors [4].

SUBTASK 25-21-45-410-006-001

- (13) Lift the panel [1], [7] into position against the nylon pad on the air grill support.

SUBTASK 25-21-45-420-025

- (14) If necessary, do these steps to use the installation/removal tool, SPL-13566:

- (a) Put the hook end of the tool around the outboard edge of the panel, in the middle.
 - (b) Pull inboard and down.

SUBTASK 25-21-45-420-014-001

- (15) Engage the latch [9], [13] on the plenum [11] to the ceiling panel latch strike.

NOTE: Do not force latch to engage latch strike. Make sure the latch smoothly engages latch strike with light contact or else damage may occur to ECS plenum.

- (a) Remove the installation/removal tool, SPL-13566 if used.

SUBTASK 25-21-45-210-002-001

- (16) Make sure the lanyards [3] and wire connectors [4] do not touch the latch [9], [13].

SUBTASK 25-21-45-420-015-001

- (17) Put the gap cover up on the adjacent panel [7], [1].

D. Latch and Hinge Adjustment

SUBTASK 25-21-45-820-001-001

- (1) Adjust the latch [9], [13] with adjustment screw [2] if necessary.

NOTE: Do not push the latch lever too hard on the latch strike or else damage may occur.

SUBTASK 25-21-45-820-002-001

- (2) Adjust the hinge [6] with adjustment screw [5] if necessary.

SUBTASK 25-21-45-210-003-001

- (3) Do a visual inspection of the gap seal [16].

SUBTASK 25-21-45-820-003-001

- (4) Interference can occur when the latch lever [9], [13] engages the panel strike. Use shims to decrease unwanted noise if necessary.

SUBTASK 25-21-45-420-016-001

- (5) Install the emergency exit sign and attached bar if they were removed.

SUBTASK 25-21-45-410-007-001

- (6) Put the gap cover up on the adjacent panel [7], [1].

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SUBTASK 25-21-45-210-004-001

- (7) Do a visual check to make sure you cannot see the red flag on the latches [13].

E. Air Grill Installation

SUBTASK 25-21-45-410-008-001

- (1) Do these steps to install the air grills [8] between the inboard panel [7] and the outboard panel [1]:
- Install the forward air grill [8] first before you install the one with the emergency light [10].
 - Put the forward hooks [14] for the air grill [8] outboard of the plenum walls [11], between the plenum walls [11] and lower angles.
 - Lift the air grill [8] up and put the other hooks [14] outboard of the plenum walls [11].
 - Push the air grill [8] forward.
 - Push the end of the latch [13] up until you can not see the red flag.
 - Do these steps again to install the aft grill [8].
 - Put the gap cover up on the adjacent air grill [8].

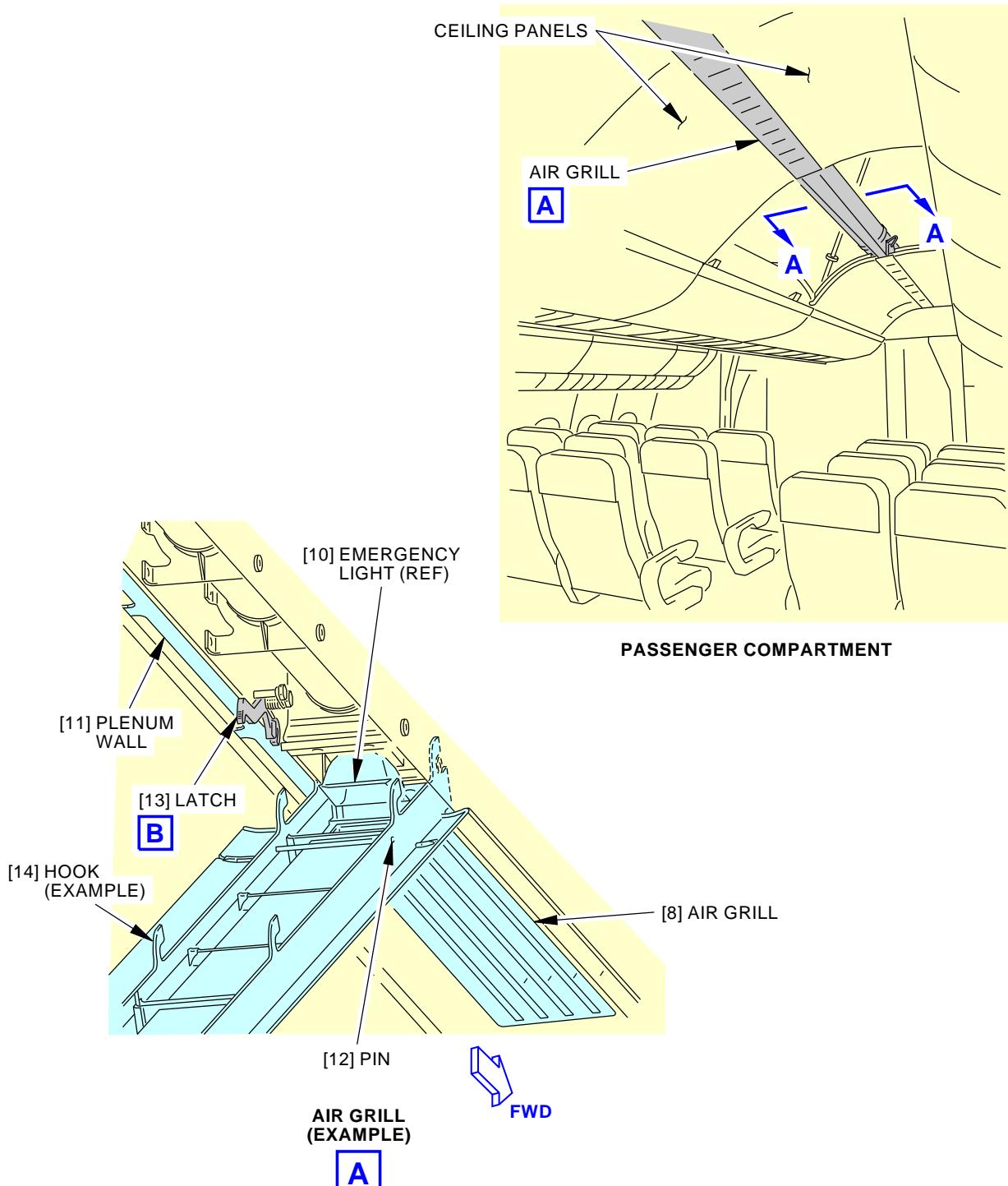
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Ceiling Panel Installation
Figure 401/25-21-45-990-804 (Sheet 1 of 2)

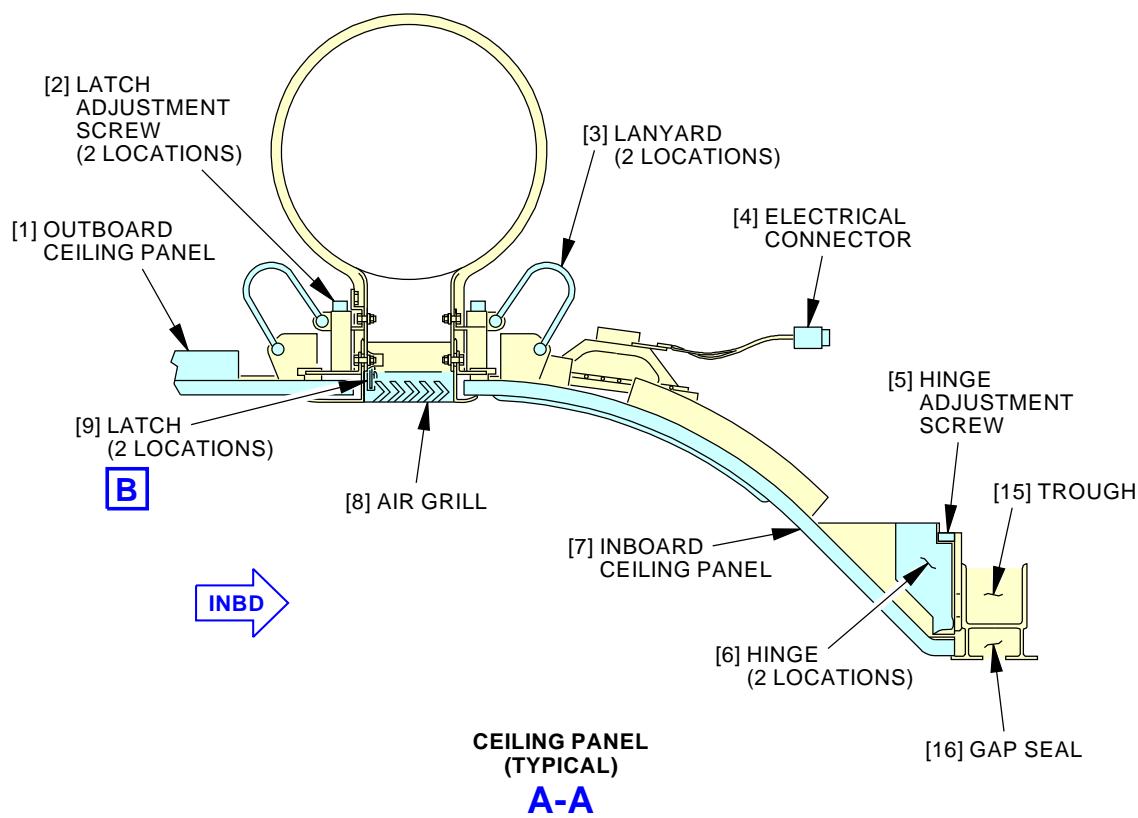
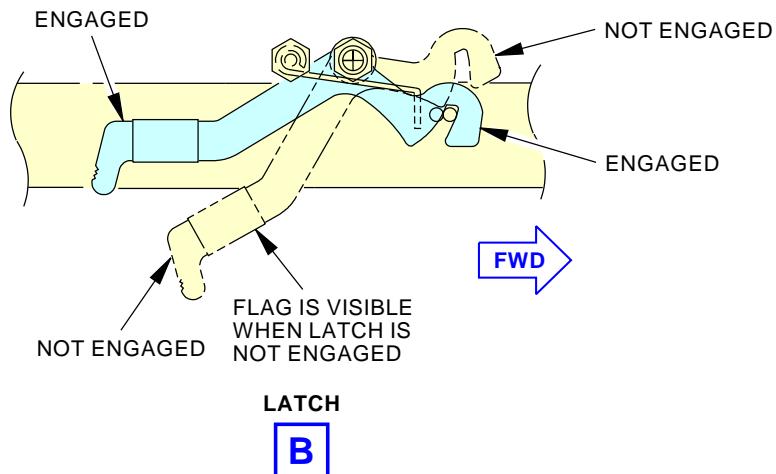
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Ceiling Panel Installation
Figure 401/25-21-45-990-804 (Sheet 2 of 2)

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TASK 25-21-45-000-804-001

4. Forward Cove Bullnose Ceiling Panel - Removal

Figure 402

A. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Removal

SUBTASK 25-21-45-860-006-001

- (1) Open all the associated circuit breakers and attached DO-NOT-CLOSE tags.

SUBTASK 25-21-45-010-003-001

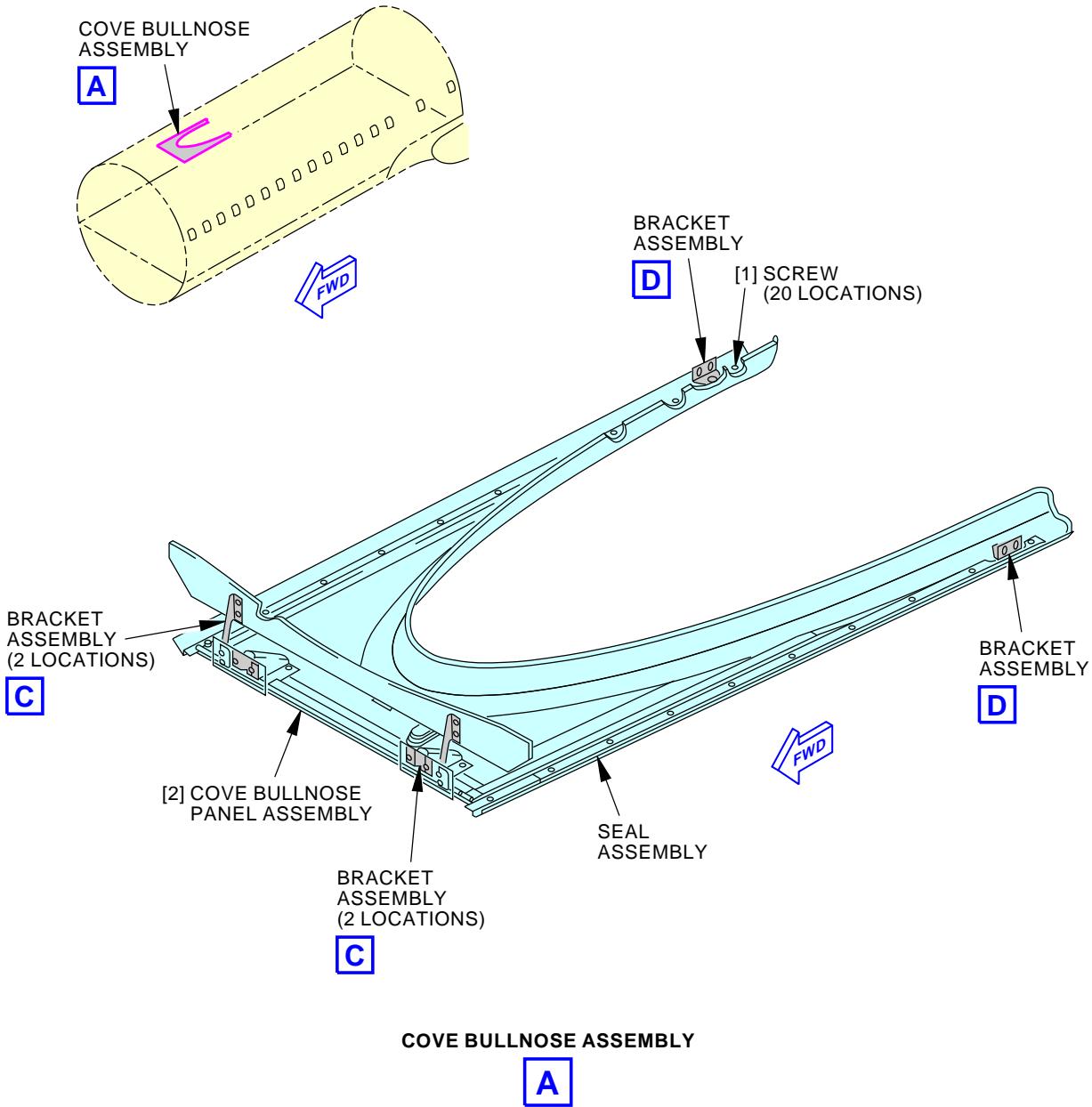
- (2) Remove overhead stowage bins, overhead stowage bin modules, or main ceiling panels as necessary to gain access: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001, Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-21-45-020-014-001

- (3) Do these steps to remove the cove bullnose panel [2]:
- If necessary, disconnect the electrical connectors above the cove bullnose panels.
 - Remove the screws [1] that connect the cove bullnose panel assembly to the seal assembly.
 - Remove the screws [11], [13] and washers [12] from each of the brackets (View B, C, and D, Fig 401).
 - Save this hardware for the installation.
 - Remove the cove bullnose panel [2].

———— END OF TASK ————





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Forward Cove Bullnose Ceiling Panel Installation
Figure 402/25-21-45-990-805-001 (Sheet 1 of 2)

 EFFECTIVITY
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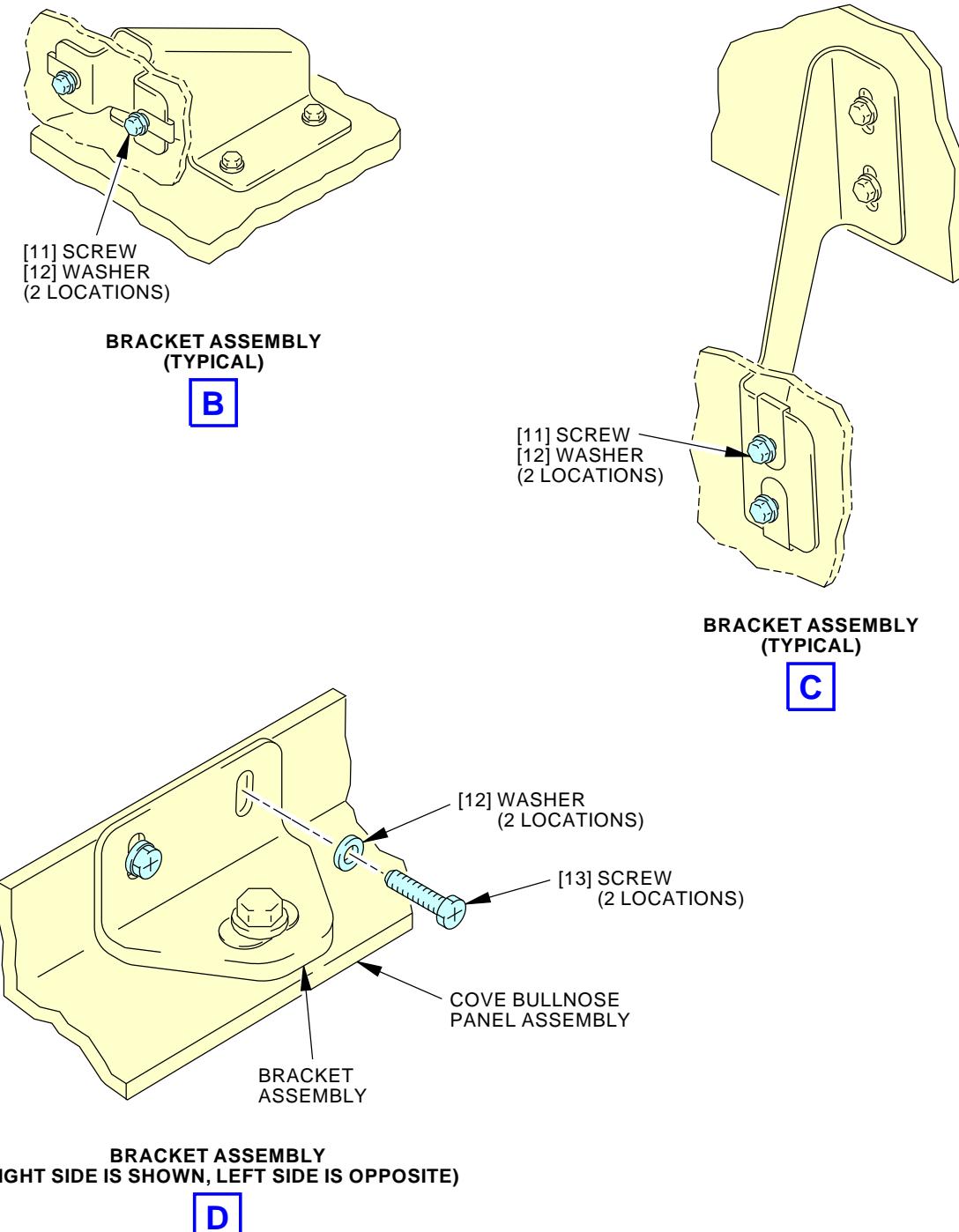
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Forward Cove Bullnose Ceiling Panel Installation
Figure 402/25-21-45-990-805-001 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 25-21-45-400-804-001

5. Forward Cove Bullnose Ceiling Panel - Installation

Figure 402

A. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Installation

SUBTASK 25-21-45-420-017-001

- (1) Do these steps to install the cove bullnose panel [2].
 - (a) If necessary, apply new bulb seal and loop tape to the seal assembly.
 - (b) Position the cove bullnose panel on the seal assembly.
 - (c) Install the screws [1] to connect the cove bullnose panel [2] to the seal assembly but do not tighten.
 - (d) Install the washers [12] and screws [11], [13] to each of the brackets (View B, C, D, Fig 401)
 - (e) When the ceiling panel alignment is completed tighten all the screws [11], [13].
 - (f) If necessary, connect the electrical connectors.

SUBTASK 25-21-45-860-007-001

- (2) Remove the DO-NOT-CLOSE tags and close all the associated circuit breakers.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-45-410-009-001

- (1) If necessary, install the overhead stowage bins, overhead stowage bin modules, or main ceiling panels: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001, Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

— END OF TASK —

TASK 25-21-45-000-805-001

6. Forward Lowered Horseshoe Ceiling Panel - Removal

Figure 403

A. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage



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C. Ceiling Panel Removal

SUBTASK 25-21-45-860-008-001

- (1) Open all the associated circuit breakers and attached DO-NOT-CLOSE tags.

SUBTASK 25-21-45-010-004-001

- (2) Remove overhead stowage bins, overhead stowage bin modules, or main ceiling panels as necessary to gain access: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001, Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-21-45-020-015-001

- (3) Do these steps to remove the lowered horseshoe panel [2]:

- (a) If necessary, disconnect the electrical connectors.
- (b) Remove the bolts [11], [15], [17], washers [12], bushings [13], [16], nuts [14], and washers [12] from each of the tie rod assemblies (View B, C, and D, Fig 401).
 - 1) Save this hardware for the installation.
 - 2) Move the tie rods up to allow for clearance.
- (c) Remove the outboard and aft screws [1] that connect the lowered horseshoe panel to the rails.
- (d) Remove the forward screws [3] that connect the lowered horseshoe panel to the rails.
- (e) Remove the lowered horseshoe panel [2].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

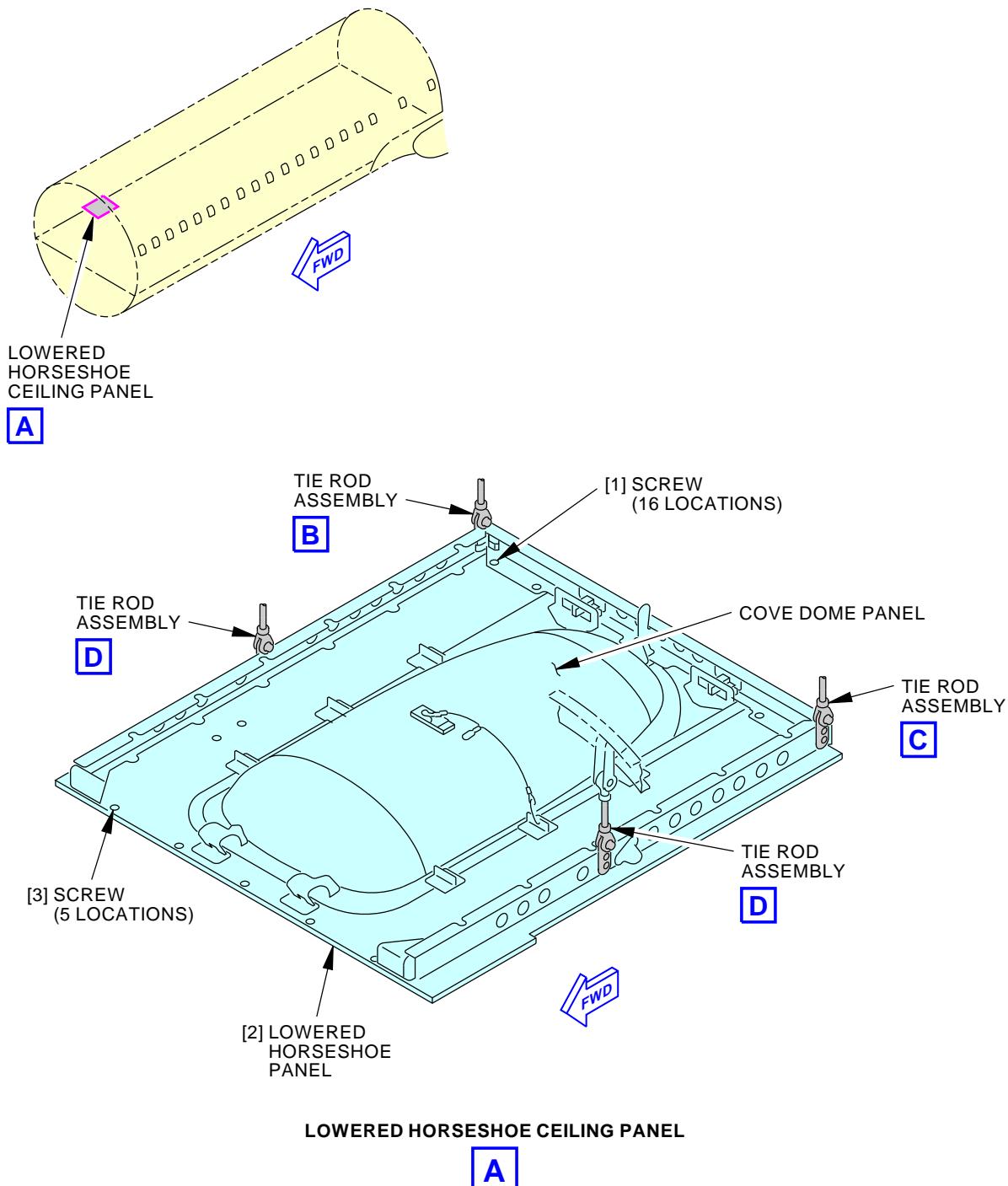
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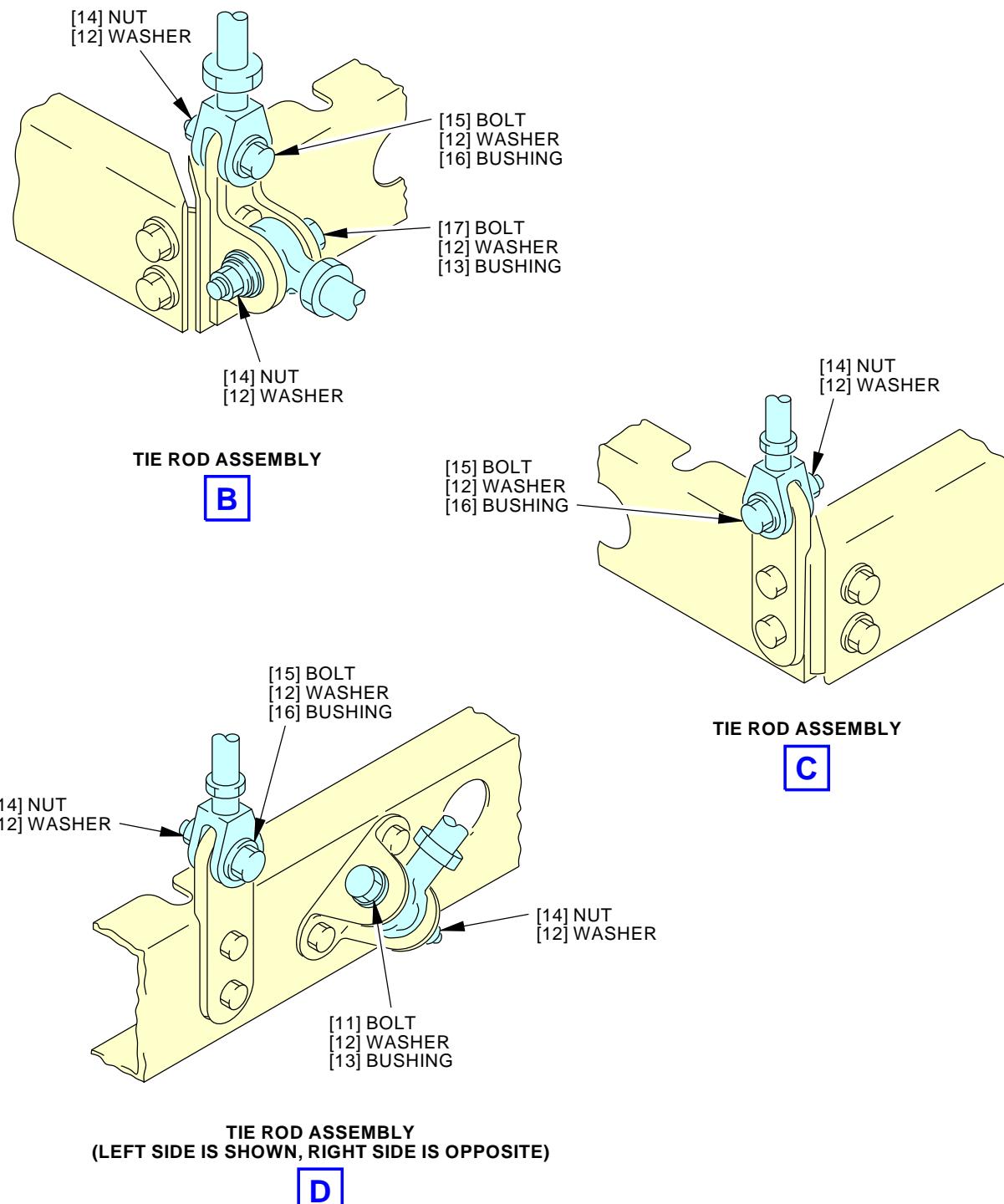
Forward Lowered Horseshoe Ceiling Panel Installation
Figure 403/25-21-45-990-806-001 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

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Forward Lowered Horseshoe Ceiling Panel Installation
Figure 403/25-21-45-990-806-001 (Sheet 2 of 2)

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AKS ALL

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TASK 25-21-45-400-805-001

7. Forward Lowered Horseshoe Ceiling Panel - Installation

Figure 403

A. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Installation

SUBTASK 25-21-45-420-018-001

- (1) Do these steps to install the lowered horseshoe panel.

- (a) Position the cove bullnose panel to the rails.

- 1) Install the forward screws [3] to connect the lowered horseshoe panel to the rails but do not tighten.
- 2) Install the outboard and aft screws [1] to connect the lowered horseshoe panel to the rails but do not tighten.

- (b) Position the tie rods to the associated tie rod assembly.

- 1) Install the bushings [13], [16], washers [12], bolts [11], [15], [17], washers [12], and nuts [14] to each of the tie rods on the tie rod assemblies but do not tighten (View B, C, and D, Fig 401).
- 2) When the ceiling panel alignment is completed tighten all the screws [1], bolts [11], [15], [17], and nuts [14].

- (c) If necessary, connect the electrical connectors.

SUBTASK 25-21-45-860-009-001

- (2) Remove the DO-NOT-CLOSE tags and close all the associated circuit breakers.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-45-410-010-001

- (1) If necessary, install the overhead stowage bins, overhead stowage bin modules, or main ceiling panels: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001, Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

— END OF TASK —

TASK 25-21-45-000-806-001

8. Aft Cove Bullnose Lowered Ceiling Panel - Removal

Figure 404

A. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)



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B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Removal

SUBTASK 25-21-45-860-010-001

- (1) Open all the associated circuit breakers and attached DO-NOT-CLOSE tags.

SUBTASK 25-21-45-010-005-001

- (2) Remove overhead stowage bins, overhead stowage bin modules, or main ceiling panels as necessary to gain access: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001, Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-21-45-020-016-001

- (3) Do these steps to remove the cove bullnose lowered panel assembly [2]:
- If necessary, disconnect the electrical connectors above the cove bullnose lowered panels.
 - Remove the screws [1] that connect the cove bullnose lowered panel assembly to the seal assembly.
 - Remove the bolts [13], washers [14], slot bushings [15], and washers [16], [17], from each of the brackets (View B, Fig 401).
 - Save this hardware for the installation.
 - Remove the screws [11] and washers [12] from each of the brackets (View C and D, Fig 401).
 - Save this hardware for the installation.
 - Remove the cove bullnose lowered panel assembly [2].

———— END OF TASK ————



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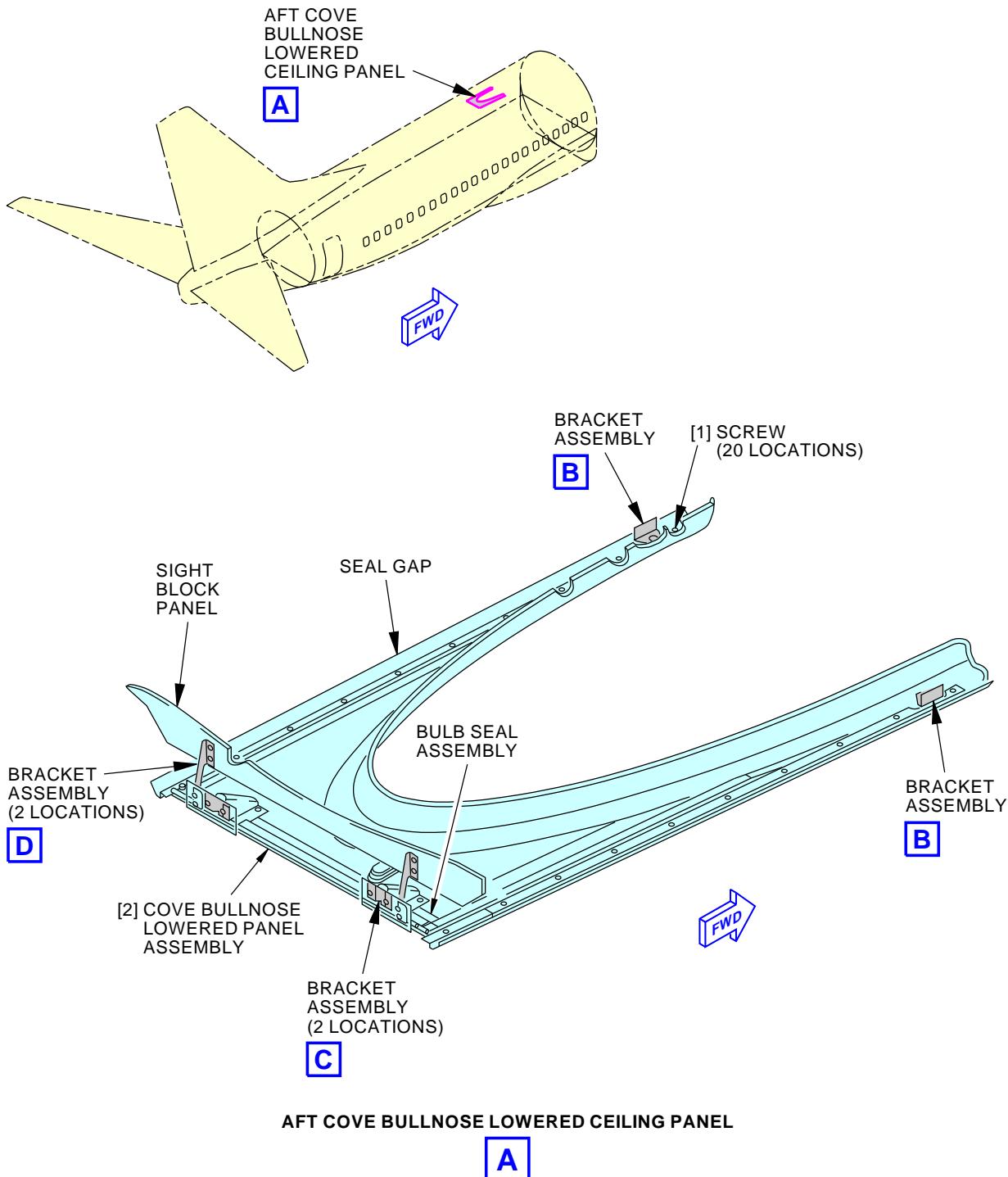
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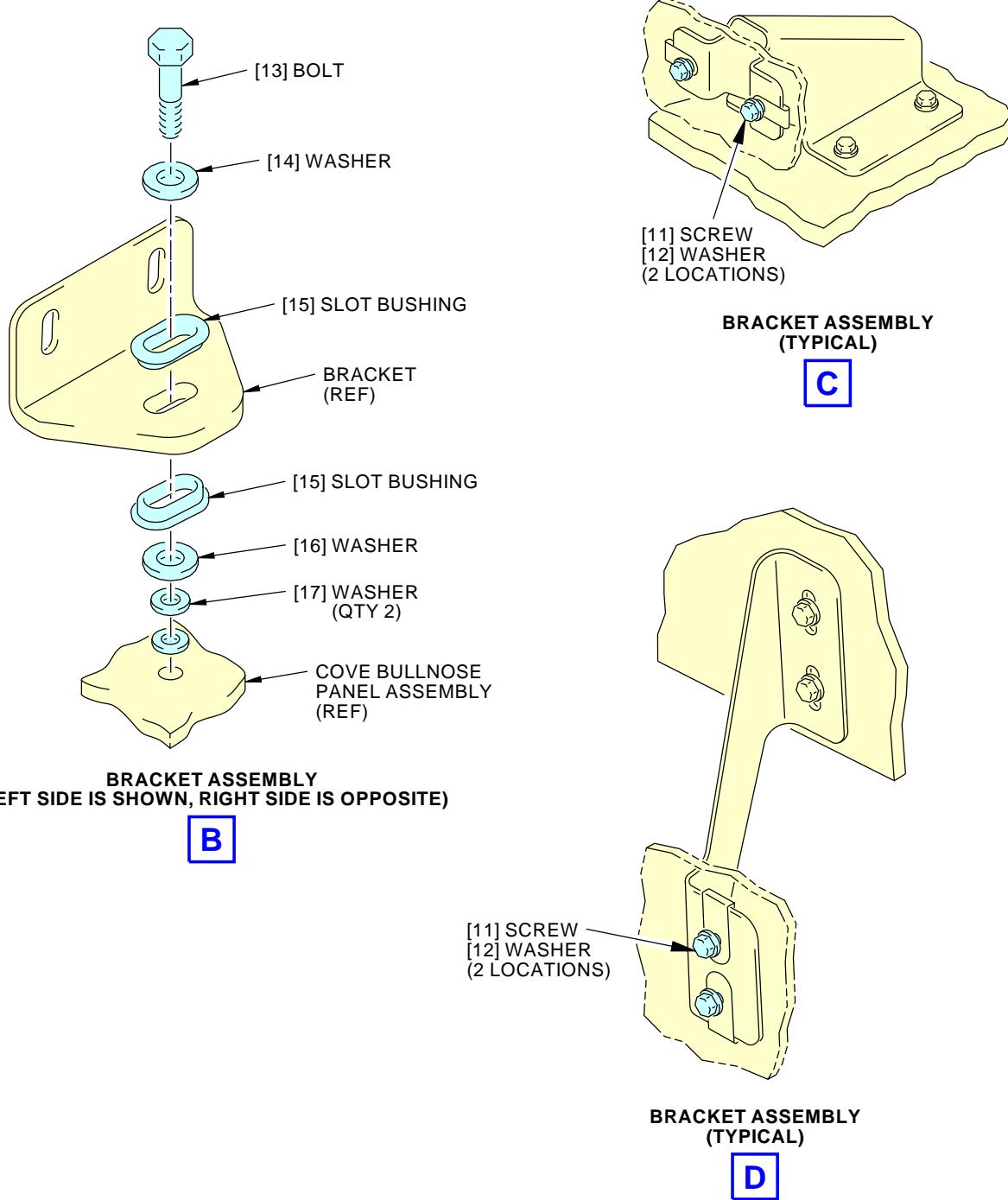
Aft Cove Bullnose Lowered Ceiling Panel Installation
Figure 404/25-21-45-990-807-001 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

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Aft Cove Bullnose Lowered Ceiling Panel Installation
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 EFFECTIVITY
 AKS ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 25-21-45-400-806-001

9. Aft Cove Bullnose Lowered Ceiling Panel - Installation

Figure 404

A. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Installation

SUBTASK 25-21-45-420-019-001

- (1) Do these steps to install the cove bullnose lowered panel [2].
 - (a) If necessary, apply new bulb seal and loop tape to the seal assembly.
 - (b) Position the cove bullnose lowered panel on the seal assembly.
 - 1) Install the screws [1] to connect the cove bullnose lowered panel [2] to the seal assembly but do not tighten.
 - (c) Install the slot bushings [15], bolts [13], washers [14], washers [16], washers [17], to each of the brackets but do not tighten (View B, Fig 401).
 - (d) Install the washers [12] and screws [11] to each of the brackets but do not tighten (View C and D, Fig 401).
 - (e) When the ceiling panel alignment is completed tighten all the screws [1], [11] and bolts [13].
 - (f) If necessary, connect the electrical connectors.

SUBTASK 25-21-45-860-011-001

- (2) Remove the DO-NOT-CLOSE tags and close all the associated circuit breakers.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-45-410-011-001

- (1) If necessary, install the overhead stowage bins, overhead stowage bin modules, or main ceiling panels: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001, Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

———— END OF TASK ————

TASK 25-21-45-000-807-001

10. Aft Cove Bullnose Horseshoe Ceiling Panel - Removal

Figure 405

A. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)





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B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Removal

SUBTASK 25-21-45-860-012-001

- (1) Open all the associated circuit breakers and attached DO-NOT-CLOSE tags.

SUBTASK 25-21-45-010-006-001

- (2) Remove overhead stowage bins, overhead stowage bin modules, or main ceiling panels as necessary to gain access: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001, Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-21-45-020-017-001

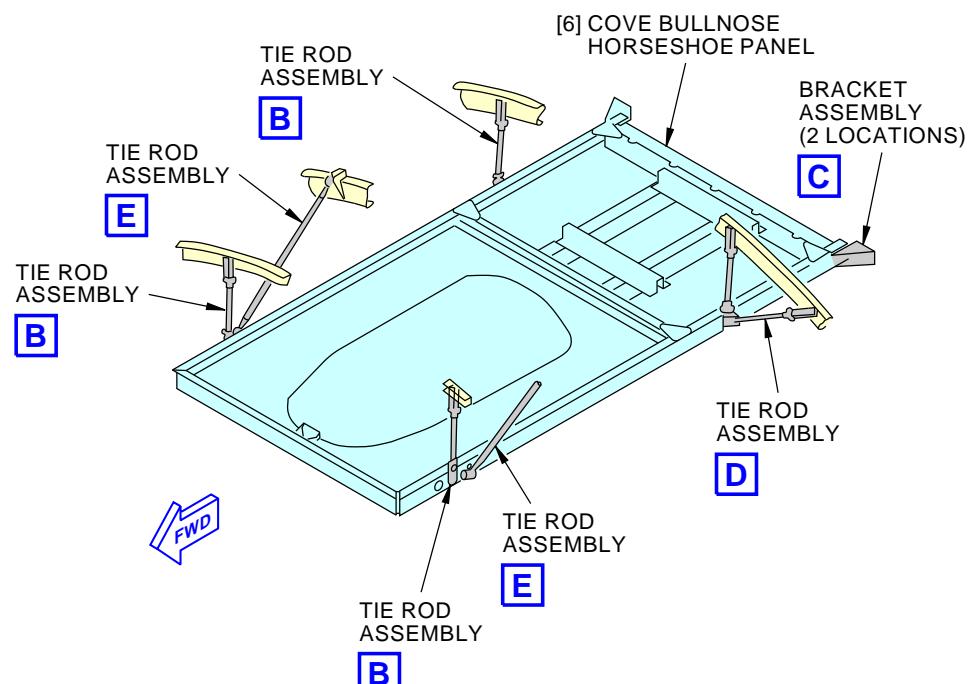
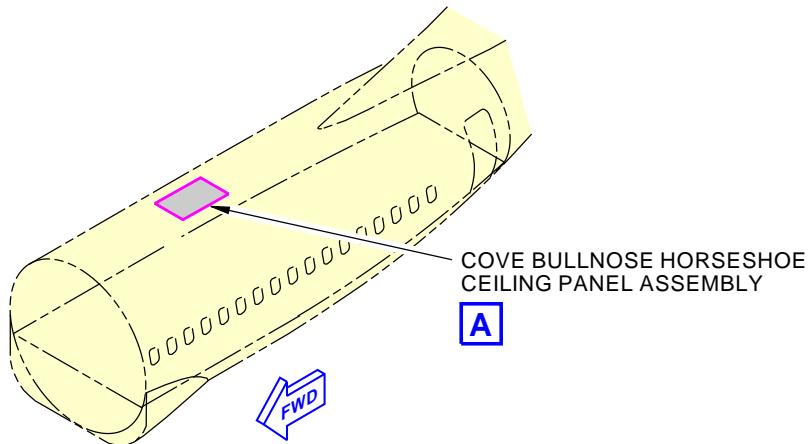
- (3) Do these steps to remove the cove bullnose horseshoe panel [6]:
 - (a) If necessary, disconnect the electrical connectors.
 - (b) Remove the bolts [3], [11], [13], washers [2], [12], bushings [4], [14], nuts [1], and washers [2] from each of the tie rod assemblies (View B, D, and E, Fig 401).
 - 1) Save this hardware for the installation.
 - 2) Move the tie rods [5] up to allow for clearance.
 - (c) Remove the bolts [11] and washers [12] that connect the cove bullnose horseshoe panel to the main ceiling panel (View C, Fig 401).
 - (d) Remove the cove bullnose horseshoe panel [6].

———— END OF TASK ————





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COVE BULLNOSE HORSESHOE
CEILING PANEL ASSEMBLY



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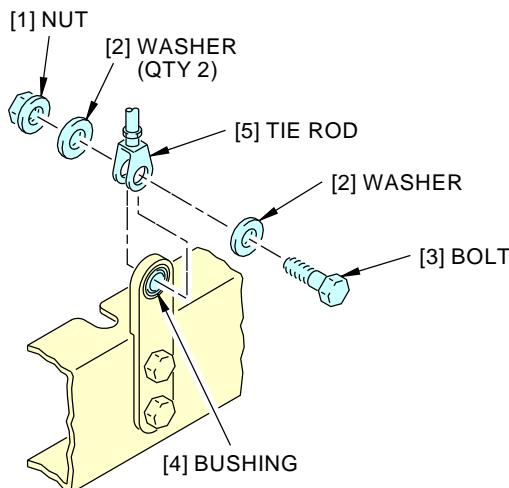
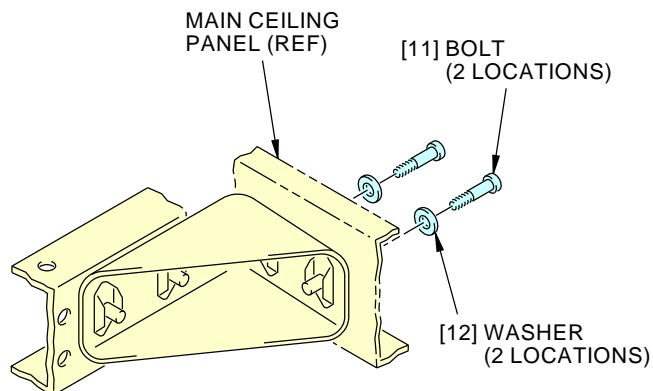
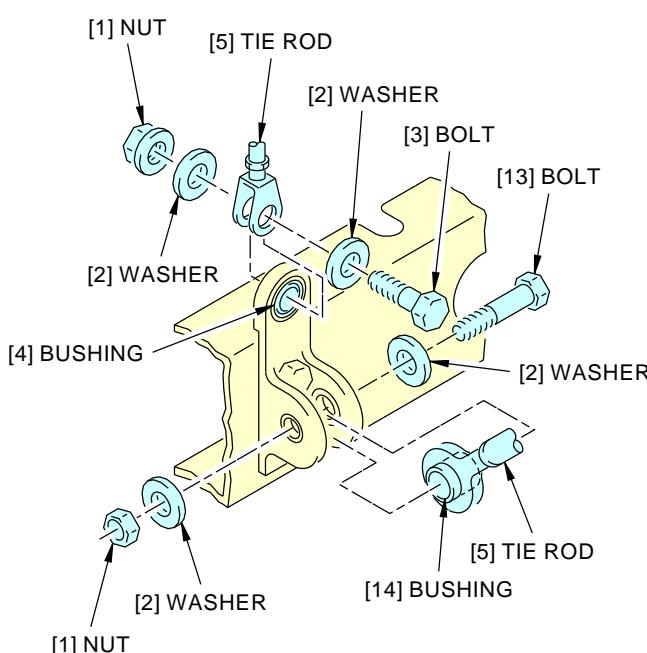
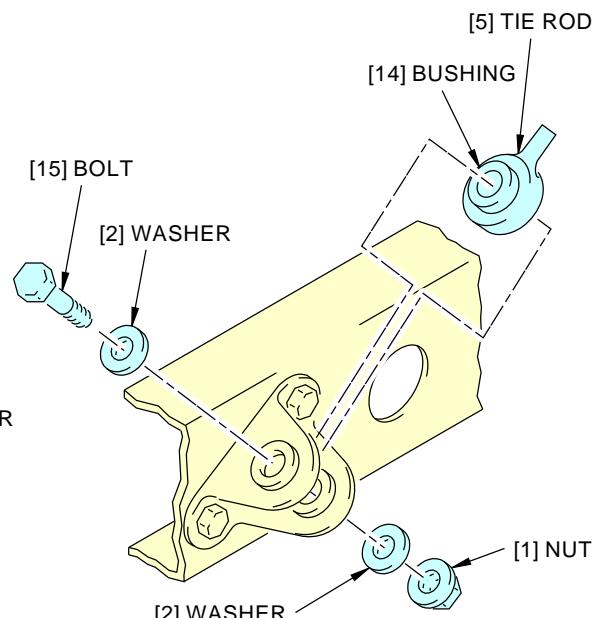
Aft Cove Bullnose Horseshoe Ceiling Panel Installation
Figure 405/25-21-45-990-808-001 (Sheet 1 of 2)

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**TIE ROD ASSEMBLY
(TYPICAL)**
B

**BRACKET ASSEMBLY
(TYPICAL)**
C

TIE ROD ASSEMBLY
D

**TIE ROD ASSEMBLY
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)**
E

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Aft Cove Bullnose Horseshoe Ceiling Panel Installation
Figure 405/25-21-45-990-808-001 (Sheet 2 of 2)

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TASK 25-21-45-400-807-001

11. Aft Cove Bullnose Horseshoe Ceiling Panel - Installation

Figure 405

A. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Installation

SUBTASK 25-21-45-420-020-001

- (1) Do these steps to install the cove bullnose horseshoe panel [6].
 - (a) Position the cove bullnose horseshoe panel to the main ceiling panel.
 - 1) Install the bolts [11] and washers [12] to connect the cove bullnose horseshoe panel to the main ceiling panel but do not tighten (View C, Fig 401).
 - (b) Position the tie rods to the associated tie rod assembly.
 - 1) Install the washers [2], bolts [3], [13], [15], washers [2], and nuts [1] to each of the tie rods on the tie rod assemblies but do not tighten (View B, D, and E, Fig 401).
 - (c) When the ceiling panel alignment is completed tighten all the bolts [3], [11], [13], [15], and nuts [1].
 - (d) If necessary, connect the electrical connectors.

SUBTASK 25-21-45-860-013-001

- (2) Remove the DO-NOT-CLOSE tags and close all the associated circuit breakers.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-45-410-012-001

- (1) If necessary, install the overhead stowage bins, overhead stowage bin modules, or main ceiling panels: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001, Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

— END OF TASK —

TASK 25-21-45-000-808-001

12. Aft Entry Lowered Ceiling Panel - Removal

Figure 406

A. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
AKS ALL



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C. Ceiling Panel Removal

SUBTASK 25-21-45-860-014-001

- (1) Open all the associated circuit breakers and attached DO-NOT-CLOSE tags.

SUBTASK 25-21-45-010-007-001

- (2) Remove overhead stowage bins, overhead stowage bin modules, or main ceiling panels as necessary to gain access: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001, Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-21-45-010-008-001

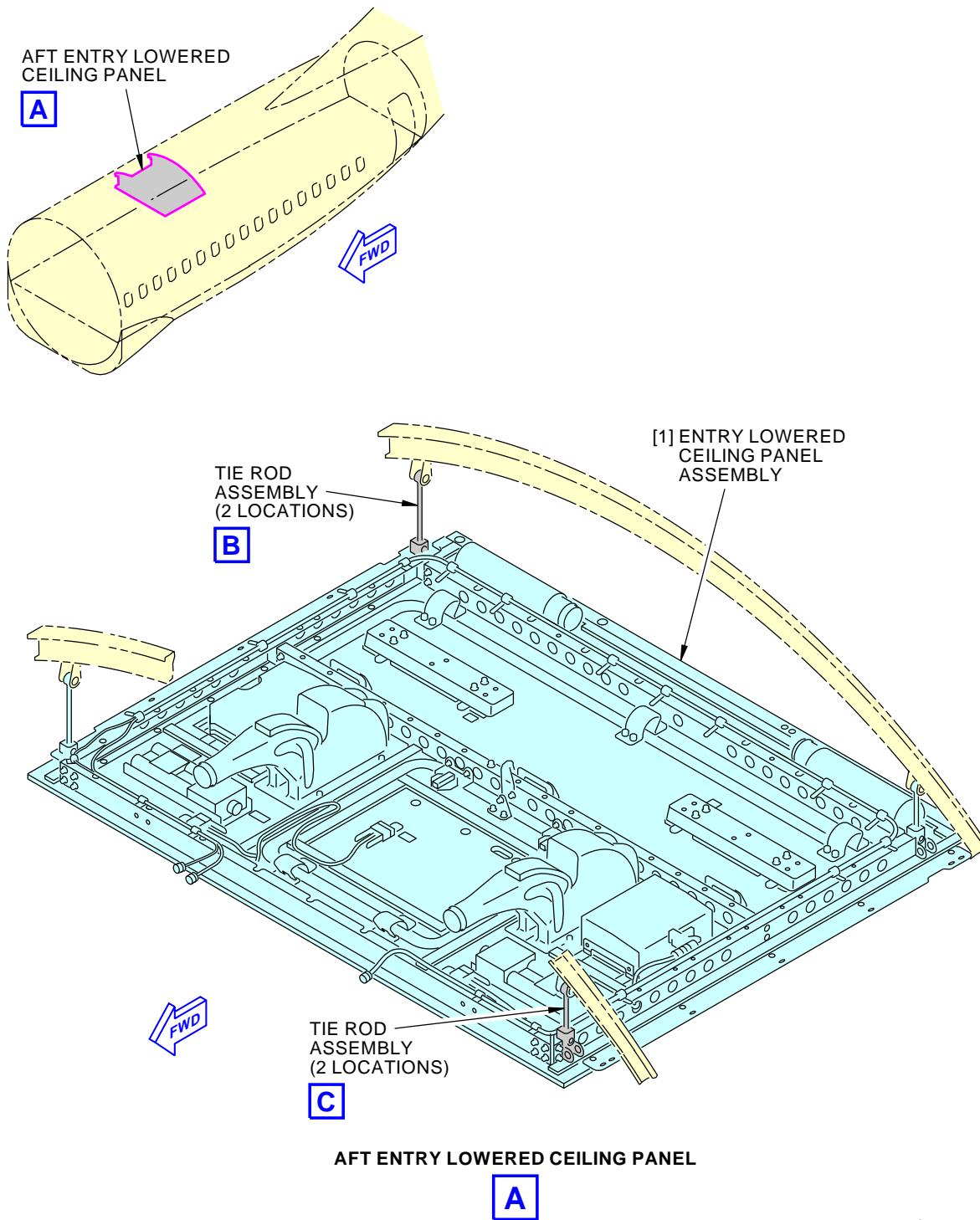
- (3) On the oxygen box, if necessary, do this task to disconnect the breathable oxygen lines: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801.

SUBTASK 25-21-45-020-018-001

- (4) Do these steps to remove the entry lowered ceiling panel [1]:
 - (a) If necessary, disconnect the electrical connectors.
 - (b) Remove the bolts [12], [17], washers [13], washers [16], nuts [15], and bushings [14], [18] from each of the tie rods [11] on the tie rod assemblies (View B and C, Fig 401).
 - 1) Save this hardware for the installation.
 - 2) Move the tie rods [11] up to allow for clearance.
 - (c) Remove the entry lowered ceiling panel [1].

———— END OF TASK ———





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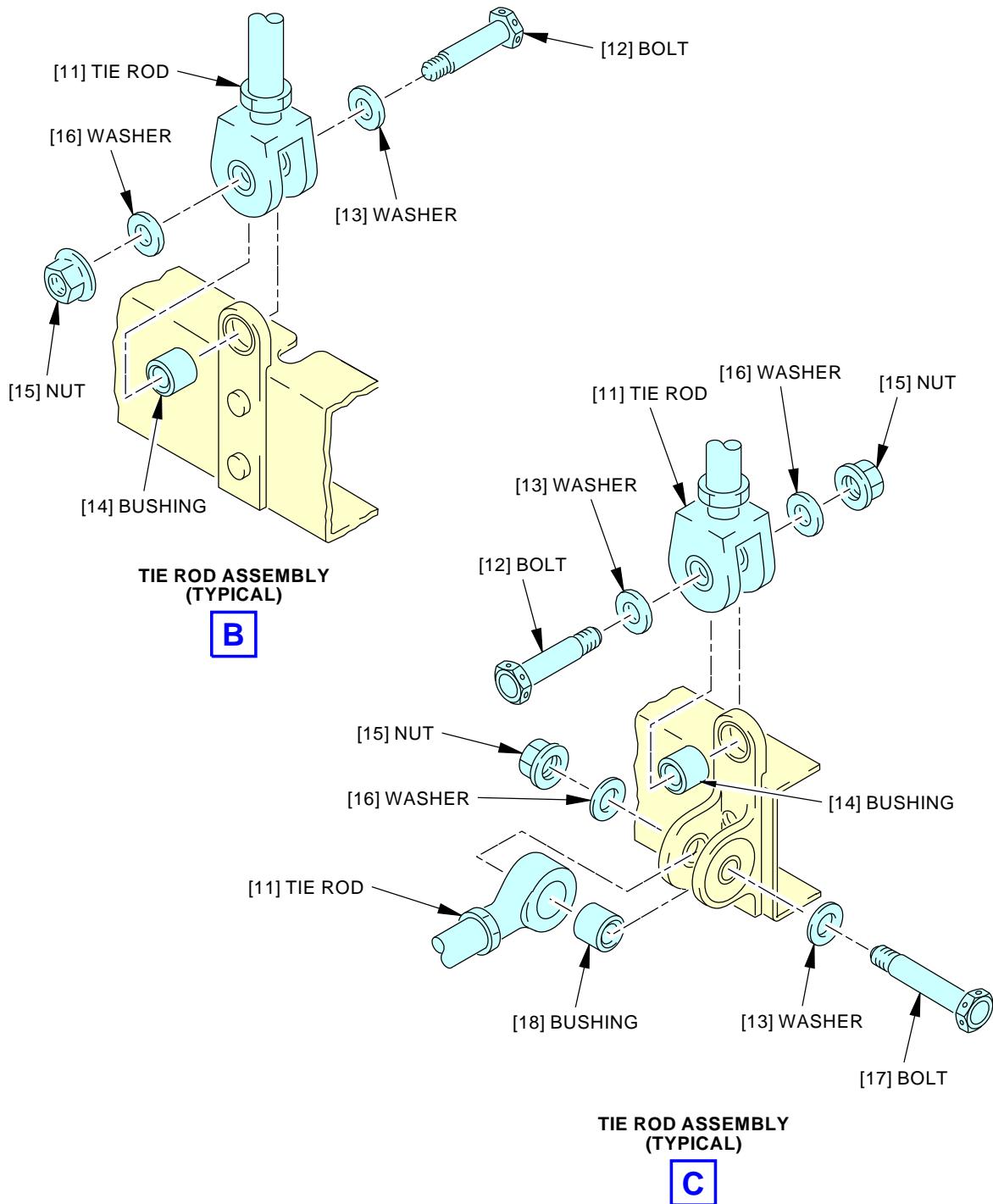
Aft Entry Lowered Ceiling Panel Installation
Figure 406/25-21-45-990-809-001 (Sheet 1 of 2)

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 AKS ALL

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Aft Entry Lowered Ceiling Panel Installation
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TASK 25-21-45-400-808-001

13. Aft Entry Lowered Ceiling Panel - Installation

Figure 406

A. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)
35-22-00-210-801	Visual Inspection of the Oxygen Generator (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Ceiling Panel Installation

SUBTASK 25-21-45-210-005

- (1) Check that the oxygen generator is activated (Visual Inspection of the Oxygen Generator, TASK 35-22-00-210-801).

SUBTASK 25-21-45-420-021-001

- (2) Do these steps to install the entry lowered ceiling panel [1].
 - (a) Position the entry lowered ceiling panel to tie rods assemblies.
 - (b) Position the tie rods to the associated tie rod assembly.
 - (c) Install the bushings [14], [18], washers [13], bolts [12], [17], washers [16], and nuts [15] to each of the tie rods [11] on the tie rod assemblies but do not tighten (View B and C, Fig 401).
 - (d) When the ceiling panel alignment is completed tighten all the bolts [12], [117] and nuts [15].
 - 1) Add shims where necessary if the gap is larger than 0.008 in. (0.2 mm).
 - (e) If necessary, connect the electrical connectors.

SUBTASK 25-21-45-410-013-001

- (3) On the oxygen box, if necessary, do this task to connect the breathable oxygen lines: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801.

SUBTASK 25-21-45-860-015-001

- (4) Remove the DO-NOT-CLOSE tags and close all the associated circuit breakers.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-45-410-014-001

- (1) If necessary, install the overhead stowage bins, overhead stowage bin modules, or main ceiling panels: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001, Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

———— END OF TASK ————





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SIDEWALL PANEL ASSEMBLY - REMOVAL/INSTALLATION

1. **General**

- A. This procedure contains these tasks:
- (1) Sidewall Panel Removal,
 - (2) Sidewall Panel Installation.

TASK 25-21-46-000-801

2. **Sidewall Panel - Removal**

(Figure 401)

A. **References**

Reference	Title
21-23-03-000-801	Return Air Grille Removal (P/B 201)
24-22-00-860-812	Remove Electrical Power (P/B 201)
25-21-12-000-804	Snap In Window Shade and Reveal Assembly Removal (P/B 401)
25-22-00-000-801	Passenger Seat - Removal (P/B 401)

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Prepare for the Removal**

SUBTASK 25-21-46-860-001

- (1) Do this task if it is necessary: Remove Electrical Power, TASK 24-22-00-860-812

SUBTASK 25-21-46-020-001

- (2) Remove the passenger seats to gain access to the panels if it is necessary. Do this task: Passenger Seat - Removal, TASK 25-22-00-000-801.

NOTE: Remove the window shade and reveal - TASK 25-21-12-000-804 - before the removal of the sidewall panel if you do not remove the passenger seats.

D. **Remove the Panel**

SUBTASK 25-21-46-020-002

CAUTION: DO NOT SCRATCH OR HIT THE SIDEWALL PANEL ASSEMBLIES WHEN YOU REMOVE THE TRIM STRIPS. YOU CAN EASILY CAUSE DAMAGE TO THE SIDEWALL PANELS.

- (1) Remove the trim strips [2].
 - (a) Remove the air grille from below the panel. Do this task: Return Air Grille Removal, TASK 21-23-03-000-801.
 - (b) Remove the trim strips [2] down on each side of the panel until they are clear of the sidewall panel [1].

SUBTASK 25-21-46-020-003

- (2) Hold the sidewall panel [1] and remove the screws [3] at the shock mounts [6].

SUBTASK 25-21-46-020-004

- (3) Move the sidewall panel [1] down until the top edge of the panel disengages from the air outlet extrusion.

EFFECTIVITY
AKS ALL

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SUBTASK 25-21-46-020-005

- (4) Remove the electrical connector from the sidewall light if required.

SUBTASK 25-21-46-020-006

CAUTION: DO NOT SCRATCH OR HIT THE SIDEWALL PANEL ASSEMBLIES WHEN YOU REMOVE THEM. YOU CAN EASILY CAUSE DAMAGE TO THE SIDEWALL PANELS.

- (5) Remove the sidewall panel [1].

———— END OF TASK ————

TASK 25-21-46-400-801

3. Sidewall Panel - Installation

(Figure 401)

A. References

Reference	Title
21-23-03-400-802	Return Air Grille Installation (P/B 201)
24-22-00-860-811	Supply Electrical Power (P/B 201)
25-22-00-400-802	Passenger Seat - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the Sidewall Panel

SUBTASK 25-21-46-420-001

- (1) Install the sidewall panel [1].

NOTE: The panel can be trimmed to fit if necessary. Trim only the edge of the panel that contacts a monument.

SUBTASK 25-21-46-420-002

- (2) Connect the electrical connector to the sidewall light if required.

SUBTASK 25-21-46-420-003

- (3) Put the top edge of the sidewall panel [1] into the air outlet extrusion.

SUBTASK 25-21-46-420-004

- (4) Align and hold the sidewall panel [1] and install the screws [3] and the washers [6].

SUBTASK 25-21-46-420-005

- (5) Put the trim strips [2] into the bottom edges of the sidewall panel [1] and lift to the lower shock mounts [6].

SUBTASK 25-21-46-420-006

- (6) Tighten the screws [3] at the lower shock mounts.

SUBTASK 25-21-46-420-007

- (7) Tighten the screws [3] as you install the trim strips [2] to align the sidewall panel [1].

SUBTASK 25-21-46-400-001

- (8) Install the air grilles. Do this task: Return Air Grille Installation, TASK 21-23-03-400-802



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D. Put the Airplane Back to its Usual Condition

SUBTASK 25-21-46-420-009

- (1) Install the passenger seats if they were removed. Do this task: Passenger Seat - Installation, TASK 25-22-00-400-802

SUBTASK 25-21-46-860-002

- (2) Supply electrical power if it is necessary. Do this task: Supply Electrical Power, TASK 24-22-00-860-811

SUBTASK 25-21-46-710-001

- (3) Do an operational check of the applicable electrical equipment.

———— END OF TASK ————

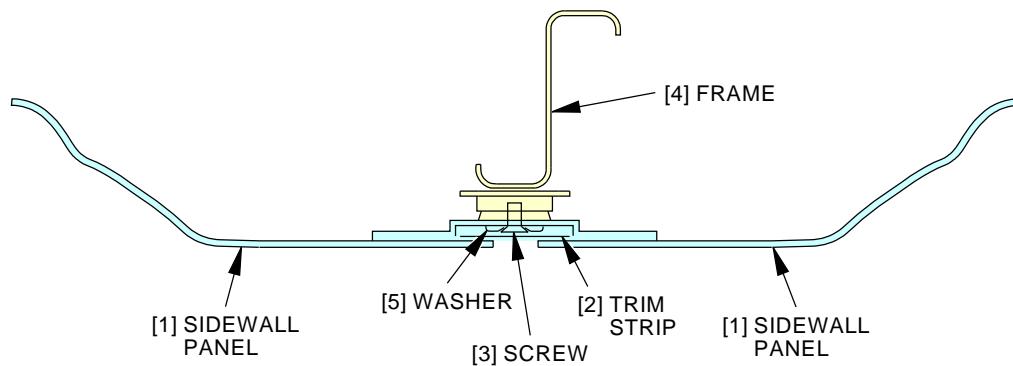
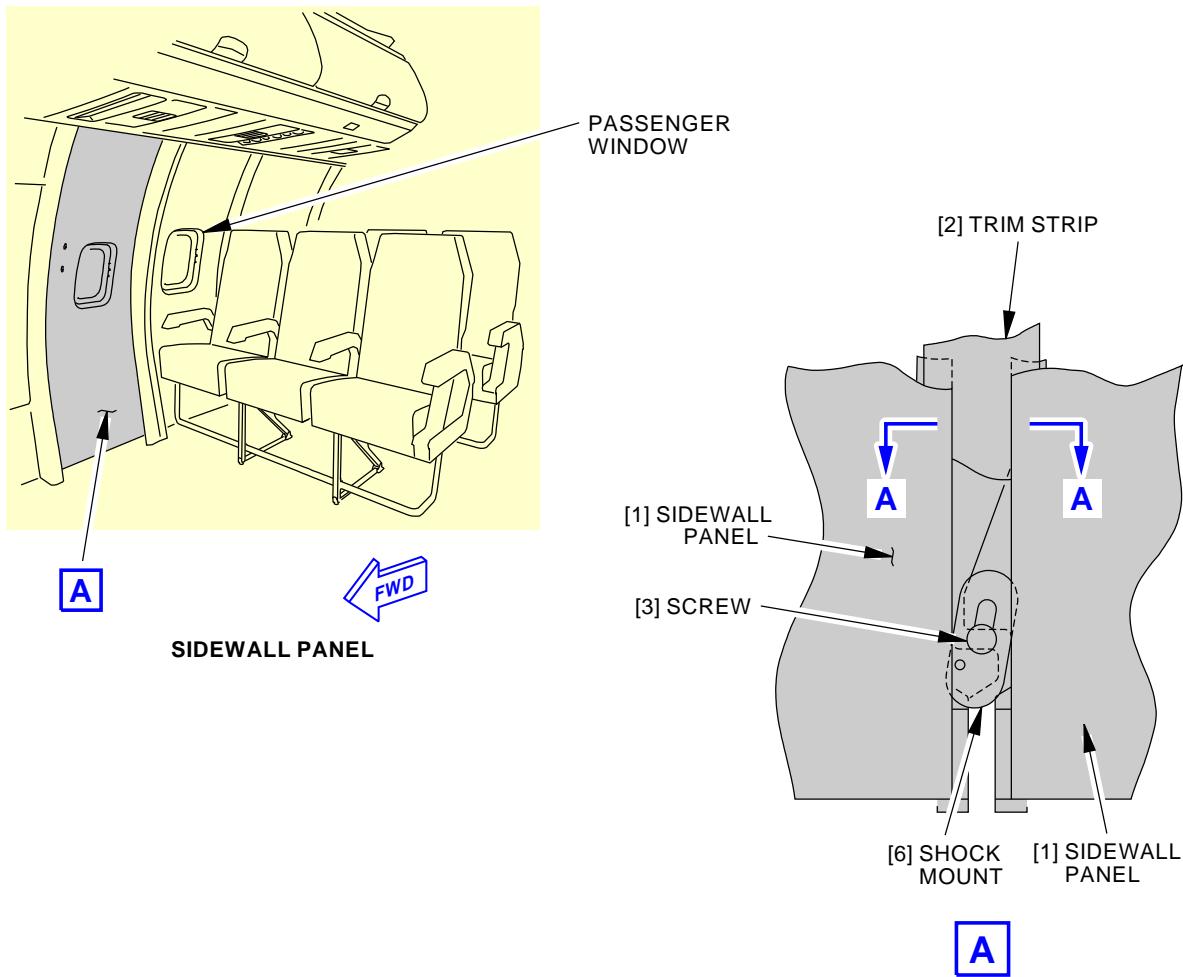
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A-A

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Sidewall Panel Installation
Figure 401/25-21-46-990-801

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FORWARD AND AFT LOWERED CEILING PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Lowered Ceiling Removal. This task is a combination of the other tasks in this procedure.
 - (2) Lowered Ceiling Installation. This task is a combination of the other tasks in this procedure.
 - (3) Prepare to Remove the Lowered Ceiling Panels. This task is the first step in the tasks below.
 - (4) Bullnose Panel Removal.
 - (5) Bullnose Panel Installation.
 - (6) Plug Panel Removal.
 - (7) Plug Panel Installation.
 - (8) Horseshoe Panel Removal.
 - (9) Horseshoe Panel Installation.
 - (10) Close Out Panel Removal, Forward Lowered Ceiling.
 - (11) Close Out Panel Installation, Forward Lowered Ceiling.
 - (12) Close Out Panel Removal, Aft Lowered Ceiling.
 - (13) Close Out Panel Installation, Aft Lowered Ceiling.
 - (14) Entry Panel Removal.
 - (15) Entry Panel Installation.
 - (16) Put the Airplane Back to Its Usual Condition. This task is the last step in the tasks above.

TASK 25-21-71-000-801

2. Lowered Ceiling Removal

(Figure 401, Figure 402)

A. General

- (1) Remove the individual parts of the lowered ceiling in the order shown in this procedure.

B. References

Reference	Title
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)

C. Procedure

SUBTASK 25-21-71-020-001

- (1) Do this task: Bullnose Panel Removal, TASK 25-21-71-000-802.

SUBTASK 25-21-71-020-002

- (2) Do this task: Plug Panel Removal, TASK 25-21-71-000-803.

SUBTASK 25-21-71-020-030

- (3) If necessary, do this task: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001.

SUBTASK 25-21-71-020-003

- (4) Do this task: Horseshoe Panel Removal, TASK 25-21-71-000-804.

SUBTASK 25-21-71-020-004

- (5) Remove the close out panel [10], if applicable.

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These are the tasks:

Close Out Panel Removal, Forward Lowered Ceiling, TASK 25-21-71-000-805,

Close Out Panel Removal, Aft Lowered Ceiling, TASK 25-21-71-000-806.

SUBTASK 25-21-71-020-005

- (6) Do this task: Entry Panel Removal, TASK 25-21-71-000-807.

———— END OF TASK ——

TASK 25-21-71-400-801

3. Lowered Ceiling Installation

(Figure 401, Figure 402)

A. General

- (1) Install the individual parts of the lowered ceiling in the order shown in this procedure.

B. References

Reference	Title
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

C. Procedure

SUBTASK 25-21-71-420-001

- (1) Do this task: Entry Panel Installation, TASK 25-21-71-400-807.

SUBTASK 25-21-71-420-002

- (2) Install the close out panel [10], if applicable.

These are the tasks:

Close Out Panel Installation, Forward Lowered Ceiling, TASK 25-21-71-400-805,

Close Out Panel Installation, Aft Lowered Ceiling, TASK 25-21-71-400-806.

SUBTASK 25-21-71-420-003

- (3) Do this task: Horseshoe Panel Installation, TASK 25-21-71-400-804.

SUBTASK 25-21-71-420-004

- (4) Do this task: Plug Panel Installation, TASK 25-21-71-400-803.

SUBTASK 25-21-71-420-005

- (5) Do this task: Bullnose Panel Installation, TASK 25-21-71-400-802.

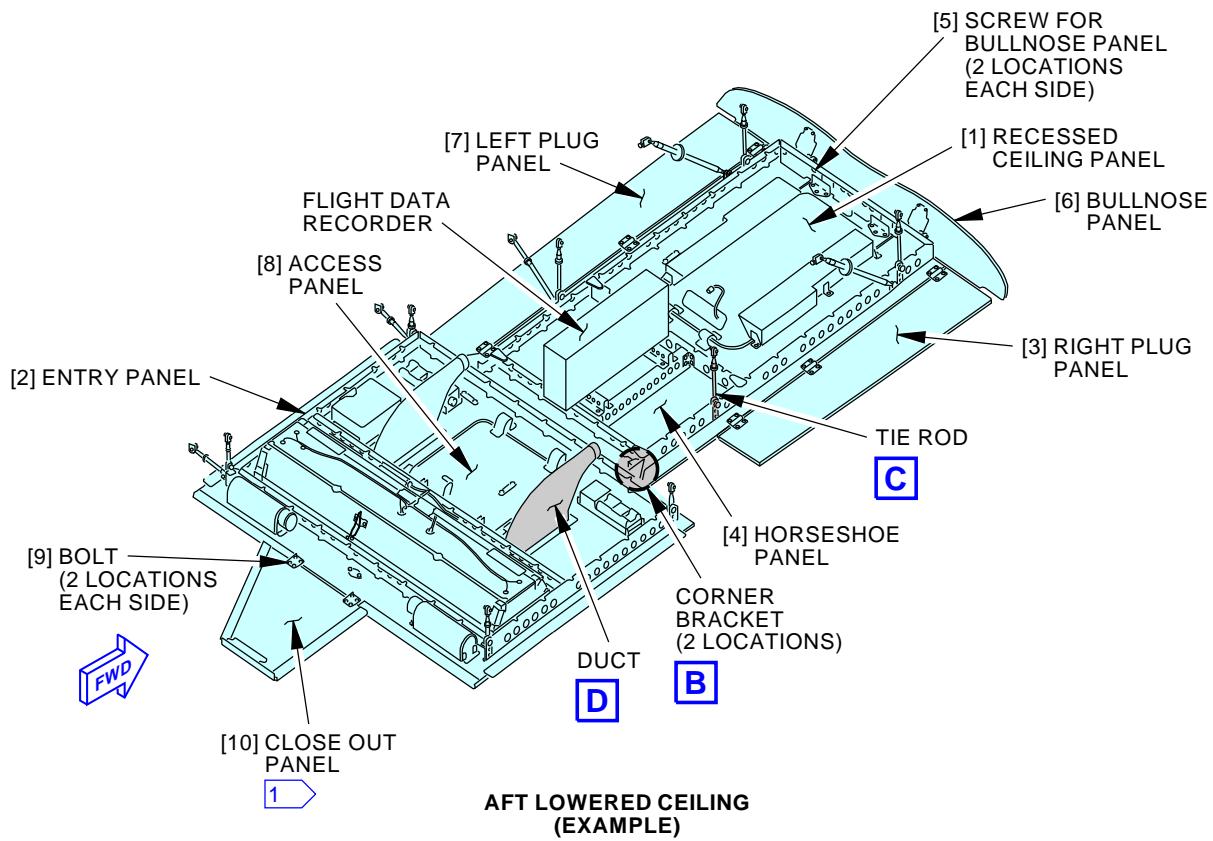
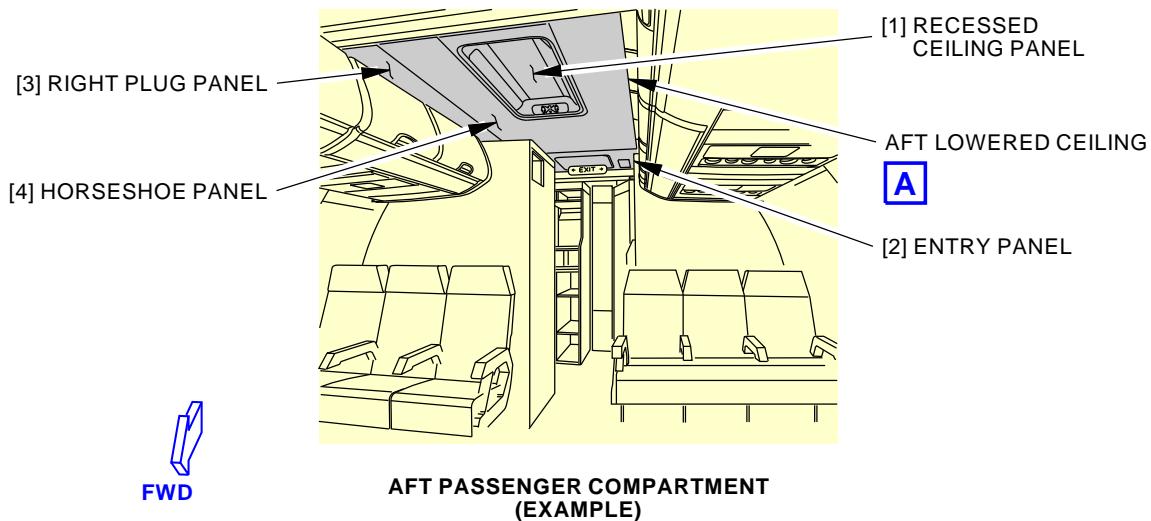
SUBTASK 25-21-71-400-001

- (6) If necessary, do this task: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or
Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001.

———— END OF TASK ——



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NOTE:

NOT ON ALL AIRPLANES

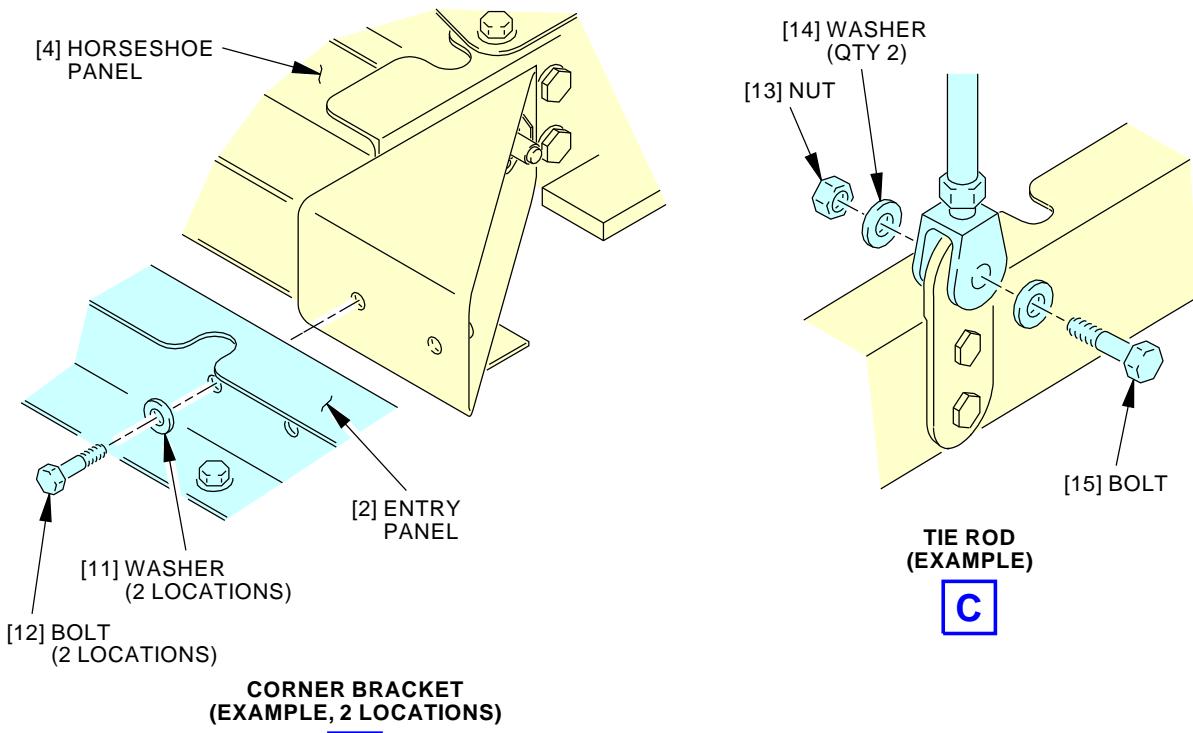
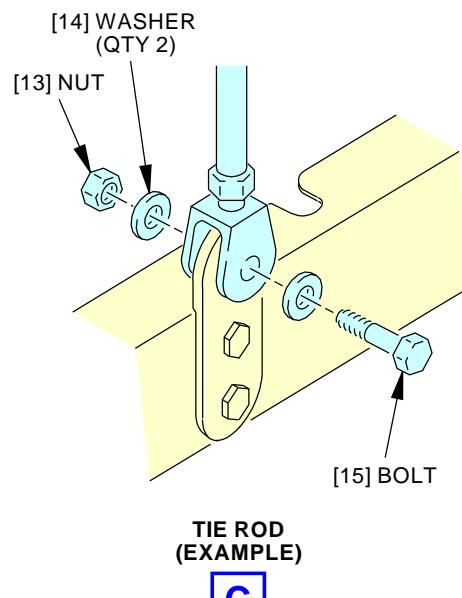
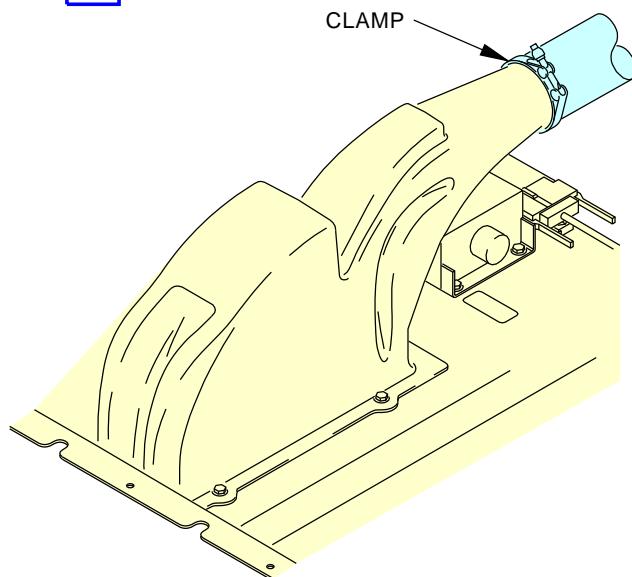
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Aft Lowered Ceiling Installation
Figure 401/25-21-71-990-803 (Sheet 1 of 2)

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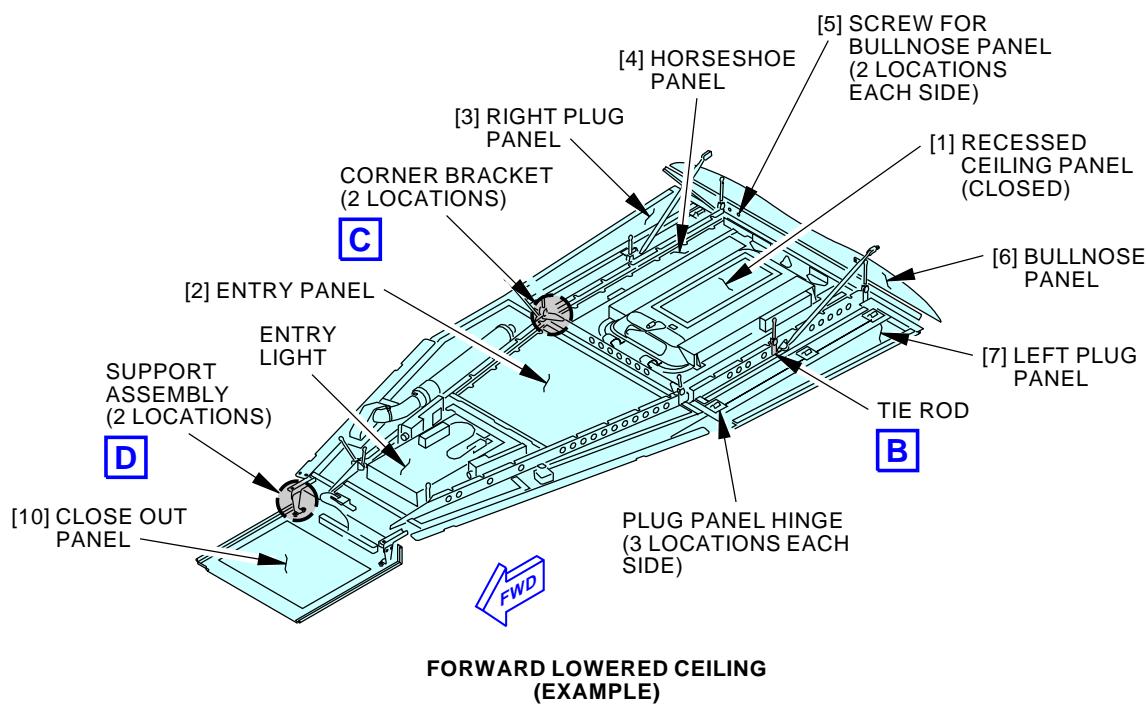
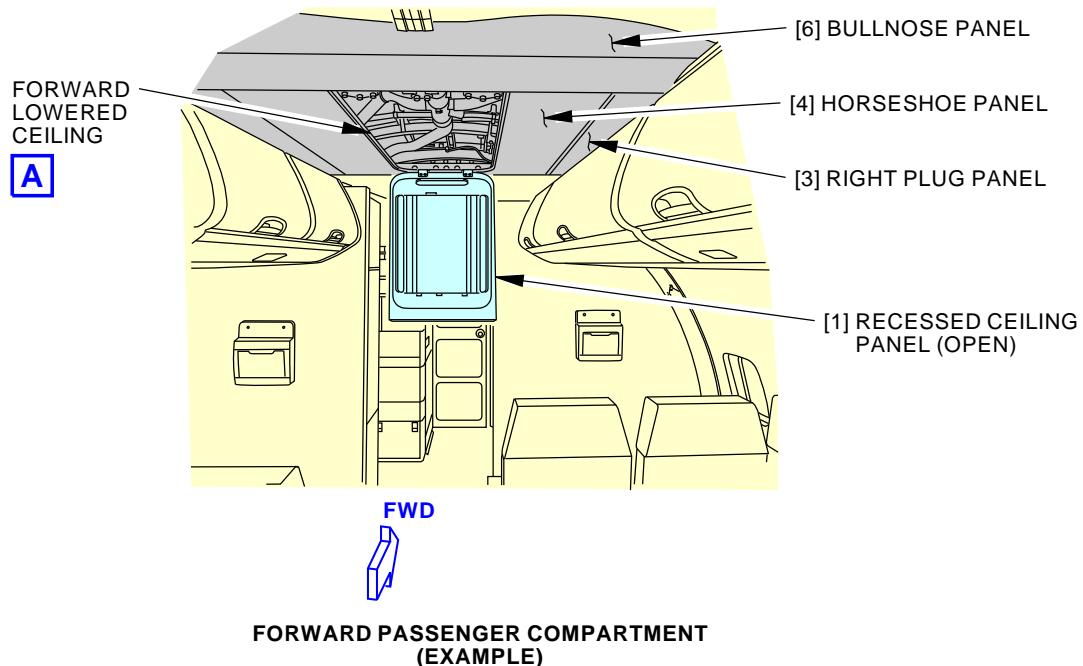

B

C

DUCT (EXAMPLE)
D

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Aft Lowered Ceiling Installation
Figure 401/25-21-71-990-803 (Sheet 2 of 2)

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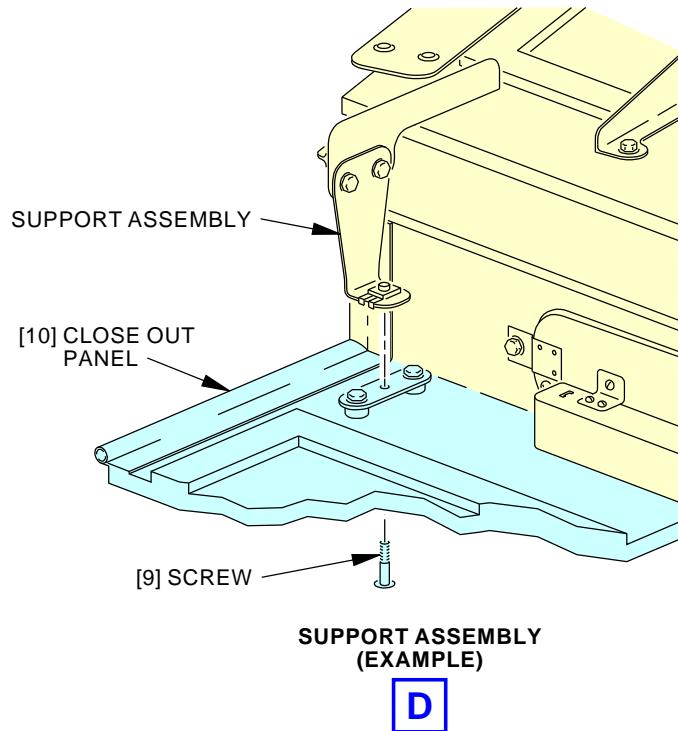
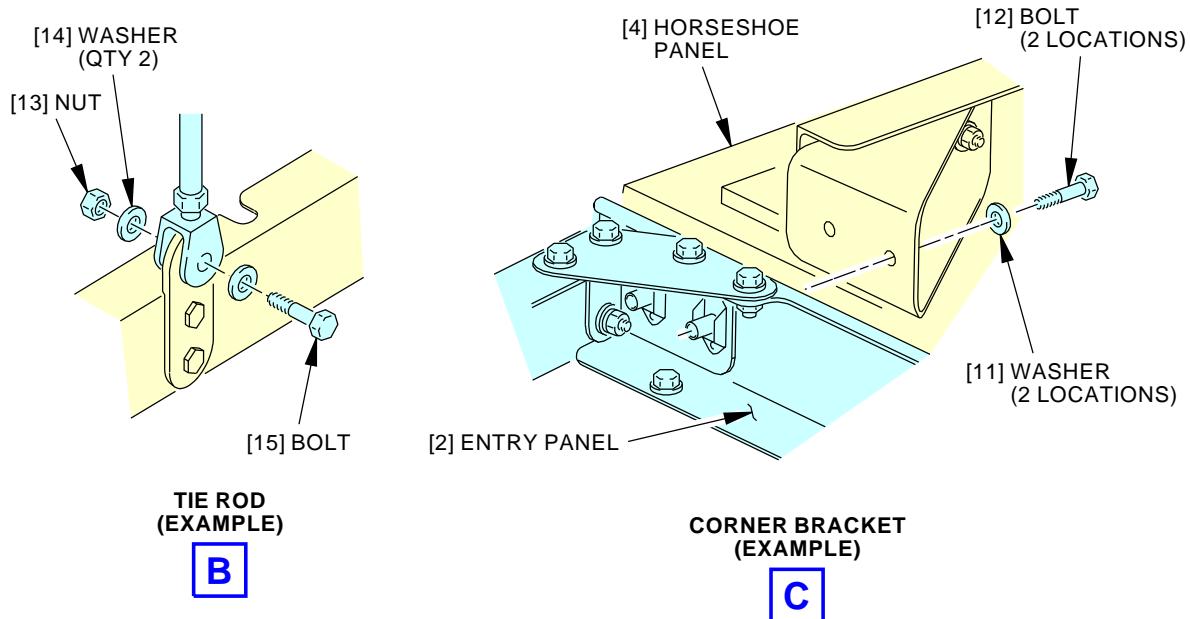
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Forward Lowered Ceiling Installation
Figure 402/25-21-71-990-804 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

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Forward Lowered Ceiling Installation
Figure 402/25-21-71-990-804 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-21-71-840-801

4. Prepare to Remove the Lowered Ceiling Panels

A. Procedure

SUBTASK 25-21-71-010-001

- (1) If necessary, remove all equipment or furnishings which prevent the panel removal.

———— END OF TASK ————

TASK 25-21-71-000-802

5. Bullnose Panel Removal

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft bullnose panel [6].

B. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

C. Procedure

SUBTASK 25-21-71-840-001

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.

SUBTASK 25-21-71-010-002

- (2) Remove the passenger compartment transition panels and gap cover.

SUBTASK 25-21-71-010-003

- (3) Remove the light valance from the bin top.

SUBTASK 25-21-71-010-004

- (4) Do these steps to open the recessed ceiling panel [1] that is in the center of the horseshoe panel [4]:

- (a) Locate the two clearance holes in the panel gap.

- (b) Put a 1/8-inch allen wrench through the access hole.

- (c) Turn the allen wrench 90° counterclockwise to release the latches.

NOTE: This will allow the door to open a few inches.

- (d) Disconnect the lanyard and open the recessed ceiling panel [1] fully.

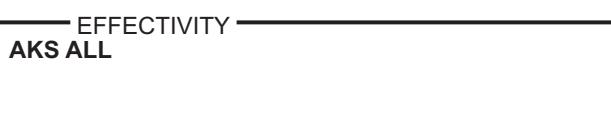
SUBTASK 25-21-71-020-006

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (5) Remove the four screws [5] and washers that attach the support brackets for the bullnose panel [6] to the cross member for the horseshoe panel [4].

- (a) Rotate the panel out of position.

———— END OF TASK ————



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TASK 25-21-71-400-802

6. Bullnose Panel Installation

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft bullnose panel [6].

B. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

C. Procedure

SUBTASK 25-21-71-420-006

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (1) Put the bullnose panel [6] into position.

- (a) Install the four screws [5] and washers that attach the bullnose support brackets to the cross member for the horseshoe panel [4].

SUBTASK 25-21-71-410-001

- (2) Do these steps to close the recessed ceiling panel [1]:

- (a) Attach the lanyard and close the recessed ceiling panel [1].

- (b) Do these steps to lock the two latches:

- 1) Put a 1/8-inch allen wrench in the latch access hole.

- 2) Turn the allen wrench 90° clockwise.

SUBTASK 25-21-71-410-002

- (3) Install the light valance at the bin top.

SUBTASK 25-21-71-410-003

- (4) Install the passenger compartment transition panels and gap cover.

SUBTASK 25-21-71-840-002

- (5) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ————

TASK 25-21-71-000-803

7. Plug Panel Removal

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or the aft right plug panel [3] and the left plug panel [7].

B. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

C. Procedure

SUBTASK 25-21-71-840-003

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.

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SUBTASK 25-21-71-010-005

- (2) Do these steps to open the recessed ceiling panel [1] that is in the center of the horseshoe panel [4]:
 - (a) Locate the two clearance holes in the panel gap.
 - (b) Put a 1/8-inch allen wrench through the access hole.
 - (c) Turn the allen wrench 90° counterclockwise to release the latches.
NOTE: This will allow the door to open a few inches.
 - (d) Disconnect the lanyard and open the recessed ceiling panel [1] fully.

SUBTASK 25-21-71-020-007

- (3) Remove the two screws and washers at each hinge location.

SUBTASK 25-21-71-020-008

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (4) Rotate the panel out of position.

———— END OF TASK ————

TASK 25-21-71-400-803

8. Plug Panel Installation

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or the aft right plug panel [3] and the left plug panel [7].

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-21-71-420-007

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (1) Put the plug panel into its correct position.

NOTE: There will be approximately a 1/4 inch (6 mm) clearance between the plug panel and the horseshoe panel [4] and the bullnose panel [6].

SUBTASK 25-21-71-420-008

- (2) Install the two screws and washers at each hinge location.

SUBTASK 25-21-71-410-004

- (3) Do these steps to close the recessed ceiling panel [1]:

- (a) Attach the lanyard and close the recessed ceiling panel [1].
- (b) Do these steps to lock the two latches:
 - 1) Put a 1/8-inch allen wrench in the latch access hole.
 - 2) Turn the allen wrench 90° clockwise.

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SUBTASK 25-21-71-840-004

- (4) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ——

TASK 25-21-71-000-804

9. Horseshoe Panel Removal

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft horseshoe panel [4].

B. References

Reference	Title
31-31-11-000-802	Flight Data Recorder Removal (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-21-71-840-005

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.

SUBTASK 25-21-71-020-009

- (2) You must remove the bullnose panel [6] before you remove the horseshoe panel [4]. If you have not removed the bullnose panel [6], then, do this task: Bullnose Panel Removal, TASK 25-21-71-000-802.

SUBTASK 25-21-71-020-028

- (3) You must remove the right plug panel [3] and the left plug panel [7] before you remove the horseshoe panel [4]. If you have not removed the plug panels [3] and [7], then, do this task: Plug Panel Removal, TASK 25-21-71-000-803.

SUBTASK 25-21-71-010-006

- (4) Do these steps to open the recessed ceiling panel [1] that is in the center of the horseshoe panel [4]:
- Locate the two clearance holes in the panel gap.
 - Put a 1/8-inch allen wrench through the access hole.
 - Turn the allen wrench 90° counterclockwise to release the latches.
NOTE: This will allow the door to open a few inches.
 - Disconnect the lanyard and open the recessed ceiling panel [1] fully.

SUBTASK 25-21-71-020-010

- (5) For the horseshoe panel [4] that is part of the aft lowered ceiling, do these steps:
- Do this task: Flight Data Recorder Removal, TASK 31-31-11-000-802.
 - Disconnect the electrical connector and bonding jumper from the shelf for the flight data recorder.

SUBTASK 25-21-71-020-011

- (6) Disconnect the electrical connector that is at one side of the recessed ceiling panel [1].

SUBTASK 25-21-71-020-012

- (7) For the horseshoe panel [4] that is part of the forward lowered ceiling, do this step:

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- (a) Remove the five screws and washers that attach the front edge of the horseshoe panel [4] to the cross member.

SUBTASK 25-21-71-020-013

- (8) Remove the two bolts [12] and washers [11] from each corner bracket.

SUBTASK 25-21-71-020-014

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (9) Hold the panel and remove the nuts [13], bolts [15], and washers [14] that attach the seven tie-rods to the horseshoe panel [4].

NOTE: Keep the nut, bolt, and washers with each tie-rod. They are not all the same.

SUBTASK 25-21-71-020-015

- (10) Lower the panel out of its position.

———— END OF TASK ———

TASK 25-21-71-400-804

10. Horseshoe Panel Installation

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft horseshoe panel [4].

B. References

Reference	Title
31-31-11-400-802	Flight Data Recorder Installation (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-21-71-420-009

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (1) Lift the horseshoe panel [4] into its correct position.

NOTE: If the plug panels [3] and [7] are attached, fold them up until you get them past the stowage bins.

SUBTASK 25-21-71-010-007

- (2) Open the recessed ceiling panel [1].

SUBTASK 25-21-71-420-010

- (3) Connect the seven tie-rods with the bolts [15], washers [14], and nuts [13].

SUBTASK 25-21-71-420-011

- (4) For the horseshoe panel [4] that is part of the forward lowered ceiling, do this step:

(a) Install the five screws and washers that attach the front edge of the horseshoe panel [4] to the cross member.

SUBTASK 25-21-71-420-012

- (5) Install the two bolts [12] and washers [11] in each corner bracket.

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SUBTASK 25-21-71-420-013

- (6) Connect the electrical connector that is adjacent to the recessed ceiling panel [1].

SUBTASK 25-21-71-420-014

- (7) For the horseshoe panel [4] that is part of the aft lowered ceiling, do these steps:
- (a) Connect the electrical connector and bonding jumper to the shelf for the flight data recorder.
 - (b) Do this task: Flight Data Recorder Installation, TASK 31-31-11-400-802.

SUBTASK 25-21-71-420-025

- (8) Do this task: Plug Panel Installation, TASK 25-21-71-400-803.

SUBTASK 25-21-71-420-015

- (9) Do this task: Bullnose Panel Installation, TASK 25-21-71-400-802.

SUBTASK 25-21-71-410-005

- (10) Do these steps to close the recessed ceiling panel [1]:
- (a) Attach the lanyard and close the recessed ceiling panel [1].
 - (b) Do these steps to lock the two latches:
 - 1) Put a 1/8-inch allen wrench in the latch access hole.
 - 2) Turn the allen wrench 90° clockwise.

SUBTASK 25-21-71-840-006

- (11) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ————

TASK 25-21-71-000-805

11. Close Out Panel Removal, Forward Lowered Ceiling

(Figure 402)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-71-840-007

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.

SUBTASK 25-21-71-020-029

- (2) Loosen the screws [9].

SUBTASK 25-21-71-020-016

- (3) Disconnect the electrical connector near the aft edge of the close out panel [10].

SUBTASK 25-21-71-020-018

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (4) Move the aft edge of the close out panel [10] aft and down to disengage the spring clips at the front edge of the panel.

———— END OF TASK ————

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TASK 25-21-71-400-805

12. Close Out Panel Installation, Forward Lowered Ceiling

(Figure 402)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-71-420-016

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (1) Put the forward edge of the close out panel [10] in the spring clips.

SUBTASK 25-21-71-420-018

- (2) Connect the electrical connector.

SUBTASK 25-21-71-420-026

- (3) Install the screws [9].

SUBTASK 25-21-71-840-008

- (4) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ————

TASK 25-21-71-000-806

13. Close Out Panel Removal, Aft Lowered Ceiling

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-71-840-009

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.

SUBTASK 25-21-71-010-009

- (2) Do these steps to get access through the entry light:

- (a) Release the three latches at the aft edge of the light. To release them, push a small screwdriver up through the small hole in the light bezel at each latch location.
- (b) Lower the aft edge of the light and disconnect the lanyard.
- (c) Fully lower the aft edge of the light.

SUBTASK 25-21-71-020-019

- (3) Disconnect the electrical connector to the exit sign near the forward edge of the entry panel [2].

SUBTASK 25-21-71-020-020

- (4) Remove the four bolts [9] that attach the close out panel [10] to the two brackets at the forward edge of the panel.



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SUBTASK 25-21-71-020-021

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (5) Move the close out panel [10] aft to release its forward edge, then lower the forward edge and move the panel forward. The back edge is held by a spring clip.

———— END OF TASK ——

TASK 25-21-71-400-806

14. Close Out Panel Installation, Aft Lowered Ceiling

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-21-71-420-019

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (1) Put the aft edge of the close out panel [10] in the spring clips. Push the panel up and aft, and then forward to engage its forward edge.

SUBTASK 25-21-71-420-020

- (2) Install the four bolts [9] at the forward edge of the panel.

SUBTASK 25-21-71-410-007

- (3) Do these steps to close the entry light:

- Lift the aft edge of the light and connect the lanyard.
- Fully close the aft edge of the light.

SUBTASK 25-21-71-840-010

- (4) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ——

TASK 25-21-71-000-807

15. Entry Panel Removal

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft entry panel [2].

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-21-71-840-011

- (1) Do this task: Prepare to Remove the Lowered Ceiling Panels, TASK 25-21-71-840-801.



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SUBTASK 25-21-71-020-022

- (2) If installed, you must remove the close out panel [10] before you remove the entry panel [2]. If you have not removed the close out panel [10], then remove the applicable close out panel.

These are the tasks:

Close Out Panel Removal, Forward Lowered Ceiling, TASK 25-21-71-000-805,

Close Out Panel Removal, Aft Lowered Ceiling, TASK 25-21-71-000-806.

SUBTASK 25-21-71-010-010

- (3) For the entry panel [2] that is part of the forward lowered ceiling, do these steps to get access through the entry light (if the light is not already open):

- (a) Unlock the two 1/4-turn fasteners for the light bezel (at the right hand side of the light).
- (b) Lower the right side of the bezel down and disconnect the lanyard.
- (c) Continue to lower the right side of the bezel until you can disengage the spring clips on the left side. Remove the bezel.
- (d) Unlock the two 1/4-turn fasteners in the light housing. There is one on each side of the light, near the forward end of the housing.
- (e) Lower the forward edge of the entry light housing and disconnect the lanyard.
- (f) Fully lower the forward edge of the light housing.
- (g) Disconnect the electrical connector for the light.
- (h) Remove the light housing. To remove it, lift it up a small amount and move it forward.

SUBTASK 25-21-71-010-011

- (4) For the entry panel [2] that is part of the aft lowered ceiling, do these steps to get access through the access panel [8]:

- (a) Release the two latches at the aft edge of the access panel [8]. To release them, use a small screwdriver.
- (b) Lower the aft edge of the access panel [8] and disconnect the lanyard.
- (c) Fully lower the aft edge of the access panel [8].

SUBTASK 25-21-71-020-023

- (5) Disconnect the electrical connector for these parts:

- (a) The electrical connectors for each battery pack
- (b) The electrical connector for the light
- (c) The electrical connector for the oxygen box (aft entry panel [2] only).

SUBTASK 25-21-71-020-024

- (6) Remove the hoses from lavatory and galley vents and from the ACS plenums.

SUBTASK 25-21-71-020-025

- (7) If the horseshoe panel [4] is installed, then do these steps to disconnect the entry panel [2] from the horseshoe panel:

- (a) Remove the two bolts [12] and washers [11] from each corner bracket.
- (b) For the entry panel [2] that is part of the forward lowered ceiling, do this step:
 - 1) Remove the five screws and washers that attach the front edge of the horseshoe panel [4] to the cross member of the entry panel [2].



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SUBTASK 25-21-71-020-026

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (8) Hold the panel and remove the nuts [13], bolts [15], and washers [14] that attach the six tie-rods to the entry panel [2].

NOTE: Keep the nut, bolt, and washers with each tie-rod. They are not all same.

SUBTASK 25-21-71-020-027

- (9) Lower the panel out of its position.

———— END OF TASK ————

TASK 25-21-71-400-807

16. Entry Panel Installation

(Figure 401, Figure 402)

A. General

- (1) This procedure is for either the forward or aft entry panel [2].

B. References

Reference	Title
35-22-00-210-801	Visual Inspection of the Oxygen Generator (P/B 501)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-21-71-210-001

- (1) For the aft entry panel, check that the oxygen generator is activated (Visual Inspection of the Oxygen Generator, TASK 35-22-00-210-801).

SUBTASK 25-21-71-420-021

CAUTION: BE CAREFUL WITH THE PANEL. YOU CAN CAUSE DAMAGE TO THE SURFACE OF THE PANEL IF YOU HIT IT OR GET IT SOILED.

- (2) Put the panel into position.

- (a) Install the bolts [15], nuts [13], and washers [14] to attach the six tie-rods.

SUBTASK 25-21-71-420-022

- (3) If the horseshoe panel [4] is installed, then do these steps to connect the entry panel [2] to the horseshoe panel:

- (a) Install the two bolts [12] and washers [11] at each corner bracket.

- (b) For the entry panel [2] that is part of the forward lowered ceiling, do this step:

- 1) Install the five screws and washers that attach the front edge of the horseshoe panel [4] to the cross member of the entry panel [2].

SUBTASK 25-21-71-420-023

- (4) Connect the hoses to the lavatory and galley ducts and to the ACS plenums.

SUBTASK 25-21-71-420-024

- (5) Connect the electrical connectors for these parts:

- (a) The electrical connectors for each battery pack

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- (b) The electrical connector for the light
- (c) The electrical connector for the oxygen box (aft entry panel [2] only).

SUBTASK 25-21-71-840-012

- (6) Do this task: Put the Airplane Back to Its Usual Condition, TASK 25-21-71-840-802.

———— END OF TASK ——

TASK 25-21-71-840-802

17. Put the Airplane Back to Its Usual Condition

A. Procedure

SUBTASK 25-21-71-410-008

- (1) Install all equipment and furnishings that you removed for access.

———— END OF TASK ——



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PASSENGER SEATS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Passenger Seat Removal.
 - (2) Passenger Seat Installation

TASK 25-22-00-000-801

2. Passenger Seat - Removal

NOTE: Figure 401

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-6918	Cart - Passenger Seat Part #: J25008-1 Supplier: 81205

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-22-00-860-006

- (1) Open the applicable circuit breakers and attach DO-NOT-CLOSE tags for the electrical equipment, if installed.

SUBTASK 25-22-00-020-001

- (2) Remove the covers on the front and rear seat tracks.

SUBTASK 25-22-00-860-002

- (3) Disconnect the electrical connectors for the electrical equipment, if installed.

AKS ALL; AIRPLANES WITH EMERGENCY LIGHTING INSTALLED ON THE SEAT

SUBTASK 25-22-00-860-003

- (4) Disconnect the electrical connectors for the emergency lighting that is installed on the seat.

AKS ALL

SUBTASK 25-22-00-020-017

- (5) Loosen the screw or the shear pin on the rear leg track fitting to the fully up position.

NOTE: Use care to not back out the fitting screw or shear pin too far, as damage can occur to the retention device.

SUBTASK 25-22-00-020-009

- (6) Loosen the anti-rattle device on the front leg stud to the fully up position.

SUBTASK 25-22-00-010-008

- (7) Move the seat forward or aft approximately 0.50 in. (12.70 mm) to align the flanges on the seat track fittings with the holes in the seat tracks.

EFFECTIVITY	AKS ALL
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SUBTASK 25-22-00-020-085

WARNING: CAREFULLY LIFT, LOWER, OR MOVE THE SEATS. BECAUSE SOME SEATS HAVE A WEIGHT OF ALMOST 250 LB (113 KG), INJURIES TO PERSONNEL CAN OCCUR.

- (8) Lift the seat and remove it.
 - (a) Use the seat cart, SPL-6918 to assist in moving the seat if it is necessary.

———— END OF TASK ————

TASK 25-22-00-400-802

3. Passenger Seat - Installation

NOTE: Figure 401

A. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

B. Passenger Seat Installation

SUBTASK 25-22-00-420-411

- (1) Make sure the front anti-rattle device and rear fitting fastener are loosened and in the fully up position.

SUBTASK 25-22-00-420-002

- (2) Put the seat in the correct position in the seat tracks.

SUBTASK 25-22-00-420-409

- (3) Move the seat in the forward or aft direction to get the correct seat pitch.

SUBTASK 25-22-00-420-410

- (4) Make sure that the flanges on the seat track fittings engage between the cutouts in the seat track.

SUBTASK 25-22-00-210-001

- (5) Tighten the seat track fittings.

| AKS 001-010, 013, 015-018, 020-025, 027

SUBTASK 25-22-00-420-420

- (6) For First Class Seats do these steps:

NOTE: This task applies to Weber Model 6810 passenger seats.

- (a) Tighten the screw on the rear leg track fitting to 45 ± 10 in-lb (5.1 ± 1.1 N·m).

NOTE: Make sure that the top of both shear pins is level with the top of the seat track fitting for correct installation.

- (b) For front row seats only, tighten the rear most shear pin first, then tighten the forward shear pin.

- (c) Tighten the screw on the forward leg track fitting to 45 ± 10 in-lb (5.1 ± 1.1 N·m).

NOTE: Make sure that anti-rattle nut assembly is level with the top of the seat track fitting for correct installation.

| AKS 019, 026, 028-999

SUBTASK 25-22-00-420-449

- (7) For Economy Class seats, do these steps:

NOTE: This task applies to B/E Aerospace Pinnacle passenger seats.

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AKS 019, 026, 028-999 (Continued)

- (a) Tighten the screw on the rear leg track fitting to 60 ± 10 in-lb (7 ± 1 N·m).

NOTE: The screw is installed correctly when the screw head is flush with the top of the seat track fitting.

- (b) Tighten the anti-rattle nut on the forward leg track fitting manually plus 1/4 turn.

AKS 001-010, 013, 015-018, 020, 021

SUBTASK 25-22-00-420-477

- (8) For Economy Class seats, do these steps:

NOTE: This task applies to the Weber Model 5751 passenger seats.

- (a) For all locations, tighten the rear screw to 45 ± 10 in-lb (5.1 ± 1.1 N·m).

- 1) For first row seats only, tighten the rear most shear pin and then the forward shear pin.

- (b) Tighten the front anti-rattle pin to 45 ± 10 in-lb (5.1 ± 1.1 N·m).

AKS ALL; AIRPLANES WITH EMERGENCY LIGHTING INSTALLED ON THE SEAT

SUBTASK 25-22-00-860-004

- (9) Connect the electrical connectors for the emergency lighting installed on the seat.

AKS ALL

SUBTASK 25-22-00-420-053

- (10) Connect the electrical connectors for the electrical equipment, if installed.

SUBTASK 25-22-00-420-006

- (11) Install the seat track covers.

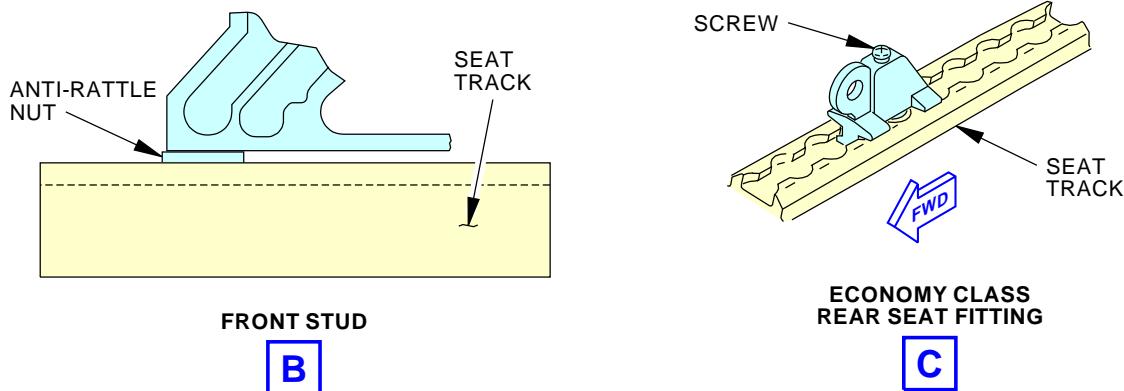
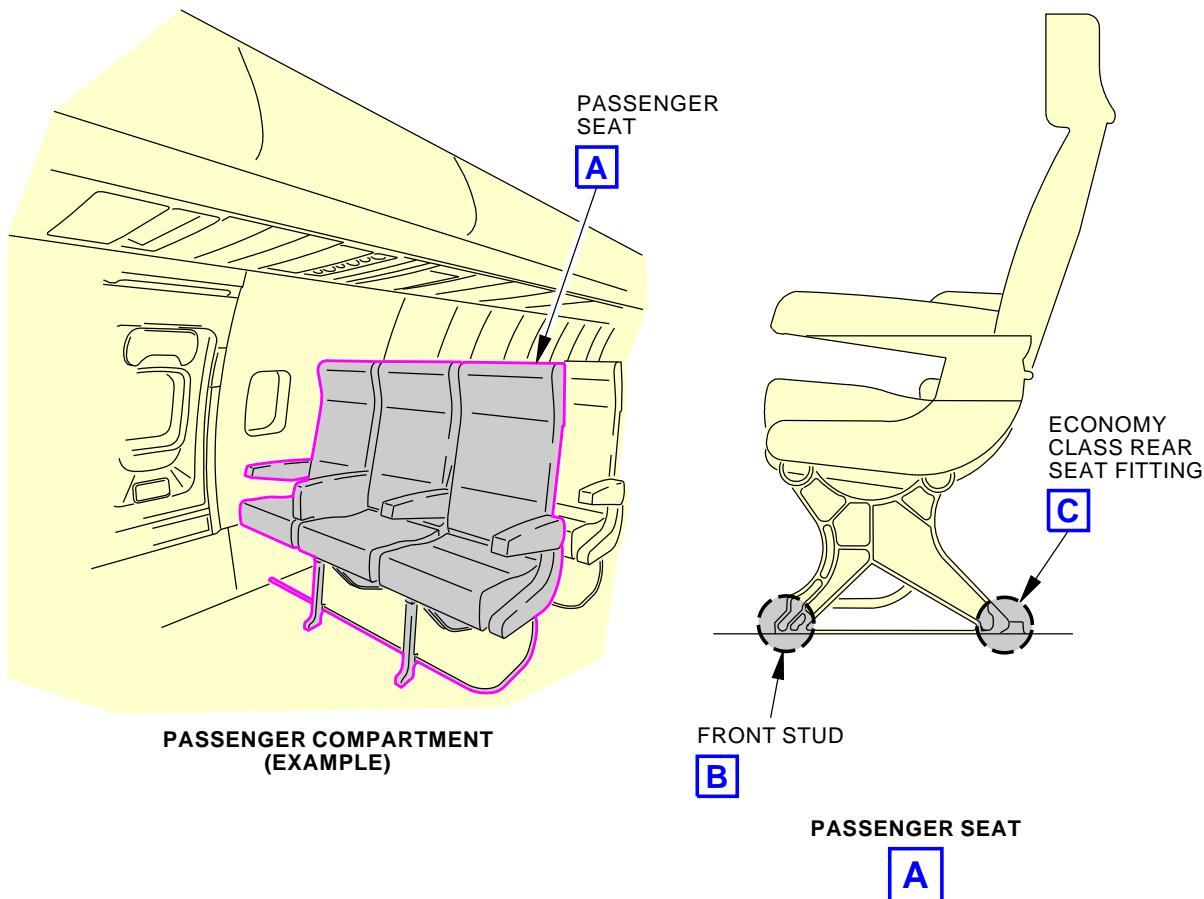
SUBTASK 25-22-00-860-005

- (12) Close the applicable circuit breakers and remove the DO-NOT-CLOSE tags for the seat electrical equipment, if installed.

———— END OF TASK ————

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AKS ALL

25-22-00



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Passenger Seat Installation
Figure 401/25-22-00-990-801 (Sheet 1 of 4)

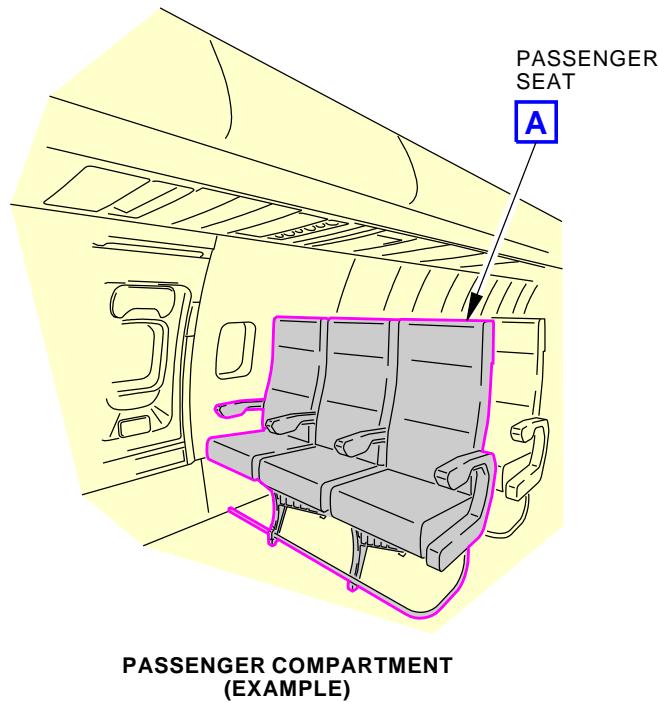
 EFFECTIVITY
 AKS 019, 026, 028-999

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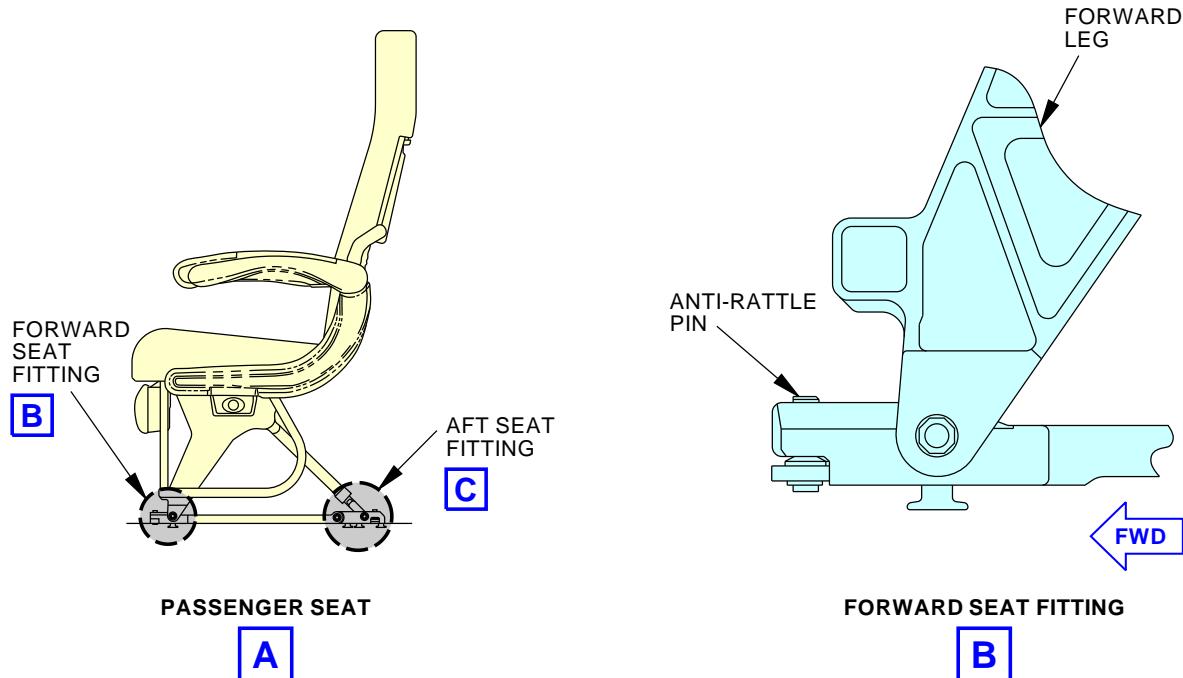
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PASSENGER COMPARTMENT
(EXAMPLE)



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Passenger Seat Installation
Figure 401/25-22-00-990-801 (Sheet 2 of 4)

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AKS 001-010, 013, 015-018, 020, 021

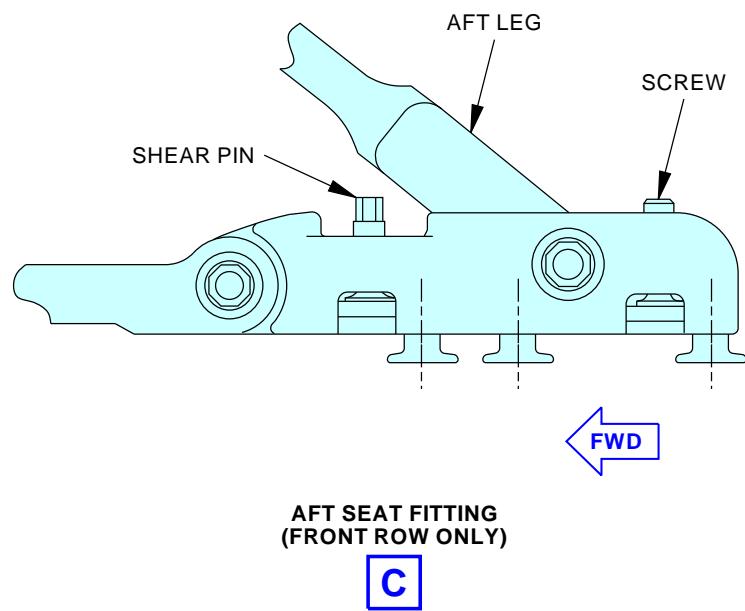
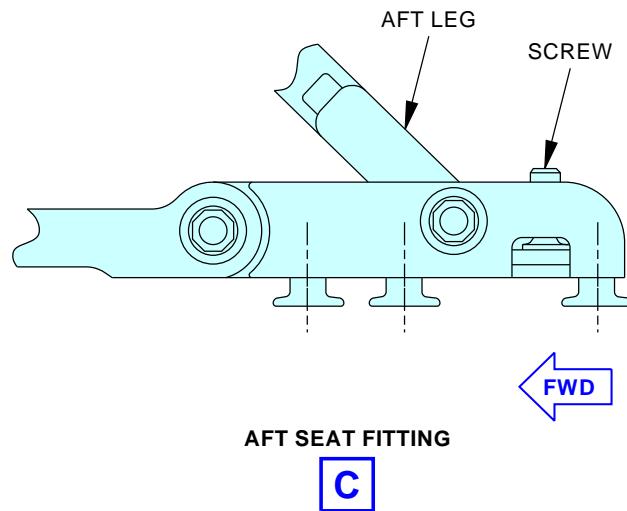
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1550948 S0000284514_V2

Passenger Seat Installation
Figure 401/25-22-00-990-801 (Sheet 3 of 4)

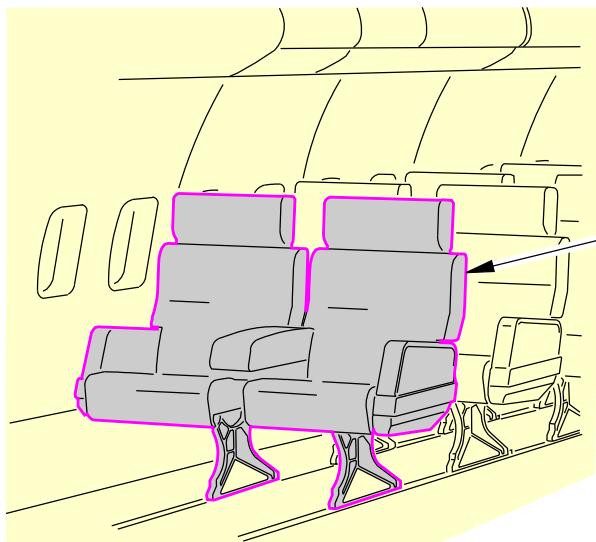
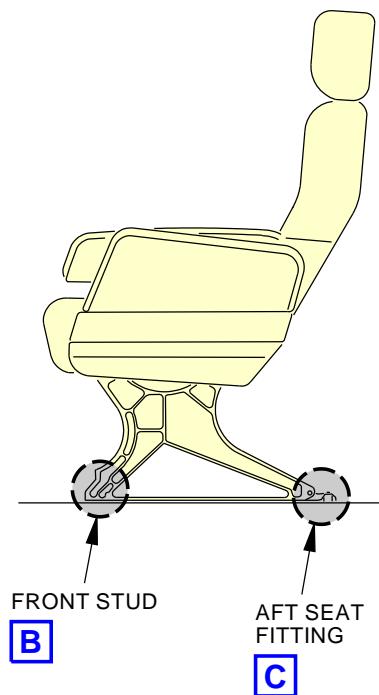
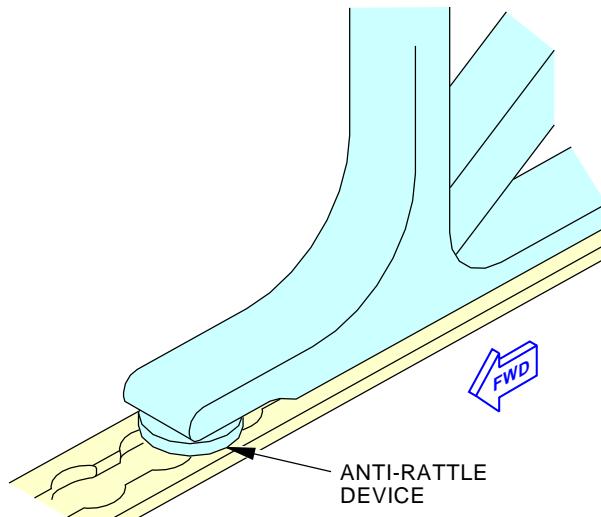
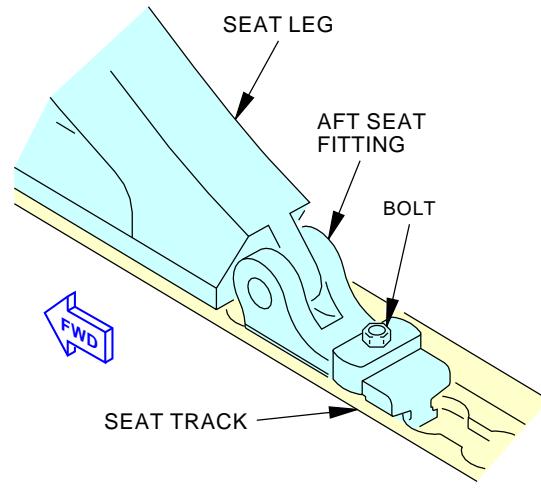
EFFECTIVITY
AKS 001-010, 013, 015-018, 020, 021

25-22-00

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**PASSENGER COMPARTMENT
(FIRST CLASS)
(EXAMPLE)**

**PASSENGER SEAT
(FIRST CLASS)**
A

FRONT STUD
B

AFT SEAT FITTING
C

J61049 S0000173358_V2

Passenger Seat Installation
Figure 401/25-22-00-990-801 (Sheet 4 of 4)
EFFECTIVITY
AKS 001-010, 013, 015-018, 020-025, 027

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PASSENGER SEATS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Passenger Seat Belt Check,
 - (2) Passenger Seat Recline Operational Check and Inspection,
 - (3) Passenger Seat Breakover Check at Emergency Exits,
 - (4) Passenger Seat Recline Restriction Check at Emergency Exits,
 - (5) Track-mounted Passenger Seat Check and Inspection.

TASK 25-22-00-200-801

2. Passenger Seat Belt Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-22-00-210-002

- (1) Do a visual check to make sure the seat belts are not worn, frayed, or damaged.

SUBTASK 25-22-00-280-003

- (2) Pull on the seat belts to make sure they are attached tightly to the seat.

SUBTASK 25-22-00-280-002

- (3) Do these steps to make sure the seat belt operates correctly:

- (a) Put the tongue end of the belt in the buckle.

NOTE: You can hear a click when the tongue is engaged in the buckle.

- (b) Lift the release handle on the buckle to disengage the belt halves.

———— END OF TASK ————

TASK 25-22-00-710-801

3. Passenger Seat Recline Operational Check and Inspection

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-22-00-710-001

- (1) Push the recline button and push on the back of the seat.

- (a) Make sure the seat back reclines.

SUBTASK 25-22-00-710-002

- (2) Release the recline button and the back of the seat.

- (a) Make sure the seat back stays reclined.

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SUBTASK 25-22-00-710-003

- (3) Push the recline button.
 - (a) Make sure the seat back moves to its upright position.

SUBTASK 25-22-00-710-004

- (4) Release the recline button, and push on the back of the seat.
 - (a) Make sure the seat back does not recline.

———— END OF TASK ————

TASK 25-22-00-710-802

4. Passenger Seat Breakover Check at Emergency Exits

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-22-00-980-001

- (1) Make sure the passenger seats that are forward and aft of all the emergency exits do not breakover into the pathways of the emergency exits.

NOTE: The Interior Configuration Specification for your airplanes should show requirements for the emergency exit aisles.

———— END OF TASK ————

TASK 25-22-00-710-803

5. Passenger Seat Recline Restriction Check at Emergency Exits

Figure 601

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right

B. Procedure

SUBTASK 25-22-00-211-001

- (1) Make sure that the passenger seats that are in the area of the emergency exit doors do not recline into the emergency exist aisles as defined by these dimensions.
 - (a) The minimum dimension of the emergency exit aisle for a triple seat is 13 in. (33 cm).
 - (b) The minimum dimension of the emergency exit aisle for a double seat is 6 in. (15.2 cm).

———— END OF TASK ————

EFFECTIVITY
AKS ALL

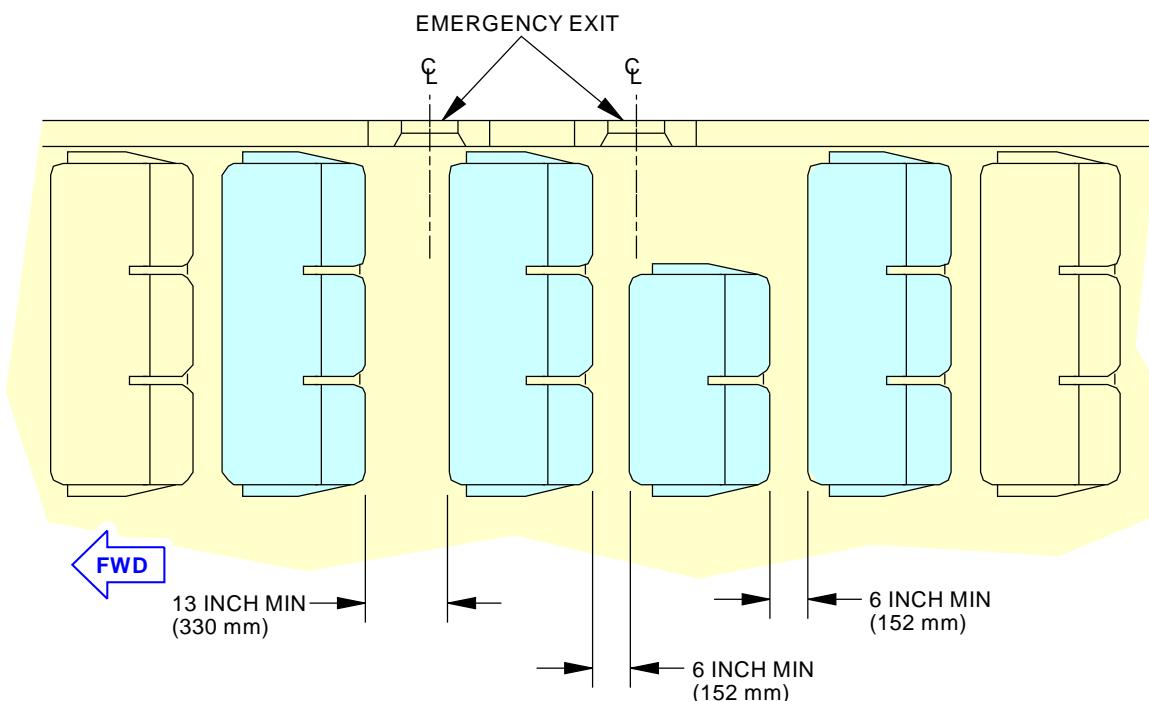
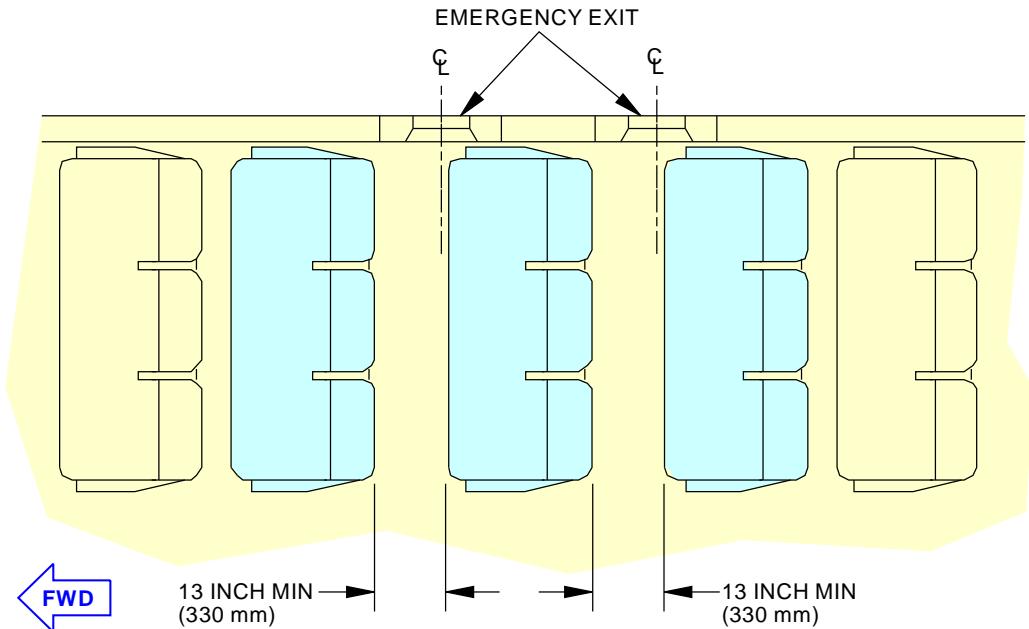
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Minimum Emergency Exit Aisle Dimensions
Figure 601/25-22-00-990-841



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TASK 25-22-00-200-804

6. Track-mounted Passenger Seat Check and Inspection

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-22-00-210-016

- (1) Make sure the seat track fittings are installed correctly.

SUBTASK 25-22-00-700-001

- (2) Hold the seat back and try to move the seat forward and aft. The seat assembly must not move at the seat track fittings.

SUBTASK 25-22-00-010-004

- (3) Remove the seat track covers if the seat moves.

SUBTASK 25-22-00-430-018

- (4) Tighten the rear seat track fitting to the recommended torque.

SUBTASK 25-22-00-430-019

- (5) Tighten the forward anti-rattle device manually plus 1/4 turn. If there is no anti-rattle, tighten front fitting to the recommended torque.

SUBTASK 25-22-00-800-001

- (6) Make sure that the seat bottom cushion does not block the exit hatch opening by more than 3.70 in. (93.98 mm).

———— END OF TASK ————

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ATTENDANT/LAVATORY SERVICE UNITS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Attendant/Lavatory Service Units Removal
 - (2) Attendant/Lavatory Service Units Installation

TASK 25-23-13-000-801

2. Attendant/Lavatory Service Unit - Removal

Figure 401

A. General

- (1) The attendant service unit contains emergency oxygen masks and an oxygen generator.

AKS 001-006

- (2) The lavatory service unit contains emergency oxygen masks and an oxygen generator.

AKS 007-999

- (3) The lavatory service unit contains emergency oxygen masks and an oxygen cylinder.

AKS ALL

- (4) The attendant and lavatory service units are also called oxygen boxes.
- (5) You can remove the oxygen masks and oxygen generator with the attendant service unit installed.

AKS 001-006

- (6) You can remove the oxygen masks and oxygen generator with the lavatory service unit installed.

AKS 007-999

- (7) You can remove the oxygen masks and oxygen cylinder with the lavatory service unit installed.

AKS ALL

B. References

Reference	Title
35-22-11-000-811-001	Oxygen Generator Deactivation (P/B 201)
35-22-51-040-801	Oxygen Cylinder (CDS) Deactivation (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-13800	Bit - Screwdriver, Special Part #: D72D72684-111 Supplier: 1TGN3

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

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AKS ALL

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E. Service Unit Removal

SUBTASK 25-23-13-040-003

- (1) Deactivate the applicable attendant passenger service unit [1]. Do this task: Oxygen Generator Deactivation, TASK 35-22-11-000-811-001.

AKS 001-006

SUBTASK 25-23-13-040-001

- (2) Deactivate the applicable lavatory passenger service unit [1]. Do this task: Oxygen Generator Deactivation, TASK 35-22-11-000-811-001.

AKS 007-999

SUBTASK 25-23-13-040-002

- (3) Deactivate the applicable lavatory passenger service unit [1]. Do this task: Oxygen Cylinder (CDS) Deactivation, TASK 35-22-51-040-801.

AKS ALL

SUBTASK 25-23-13-010-001

- (4) Remove the panel
(a) Put special screwdriver bit, SPL-13800 into fasteners.
(b) Loosen the fasteners.

SUBTASK 25-23-13-020-001

- (5) Remove the screws [2] from the side of the passenger service unit [1].

NOTE: The screws are on the inner edge of the oxygen box.

NOTE: Some service units have easy access to the rear (top) side. Examples of these would be the one in the aft lowered ceiling, and the ones in lavatories where the lavatory ceiling can be opened. If necessary, you can remove these service units by removing the screws from the rear (top) side of the ceiling panel.

SUBTASK 25-23-13-020-002

- (6) Move the passenger service unit [1] inboard and disconnect the electrical connector.

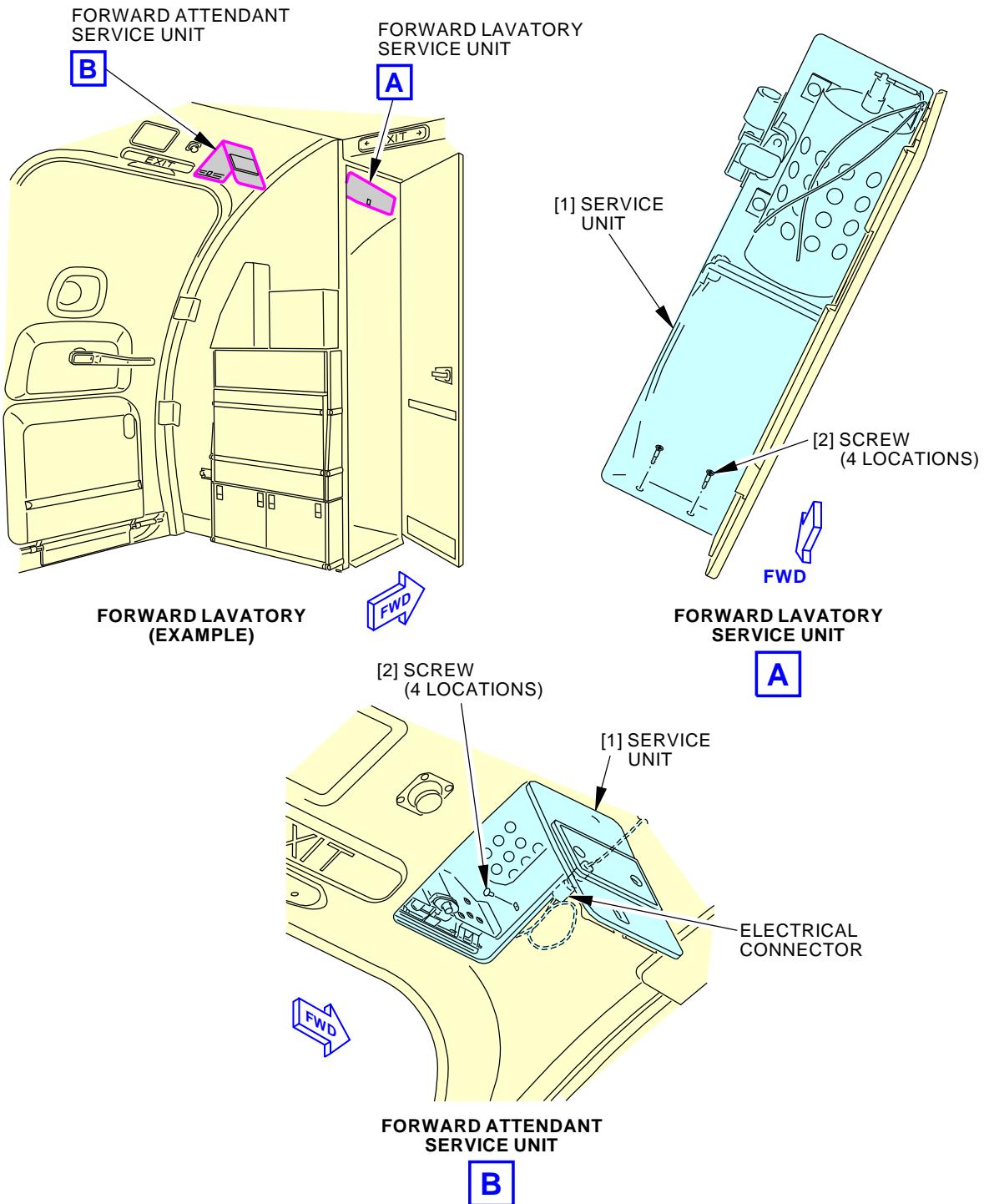
SUBTASK 25-23-13-020-003

- (7) Remove the passenger service unit [1].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-23-13

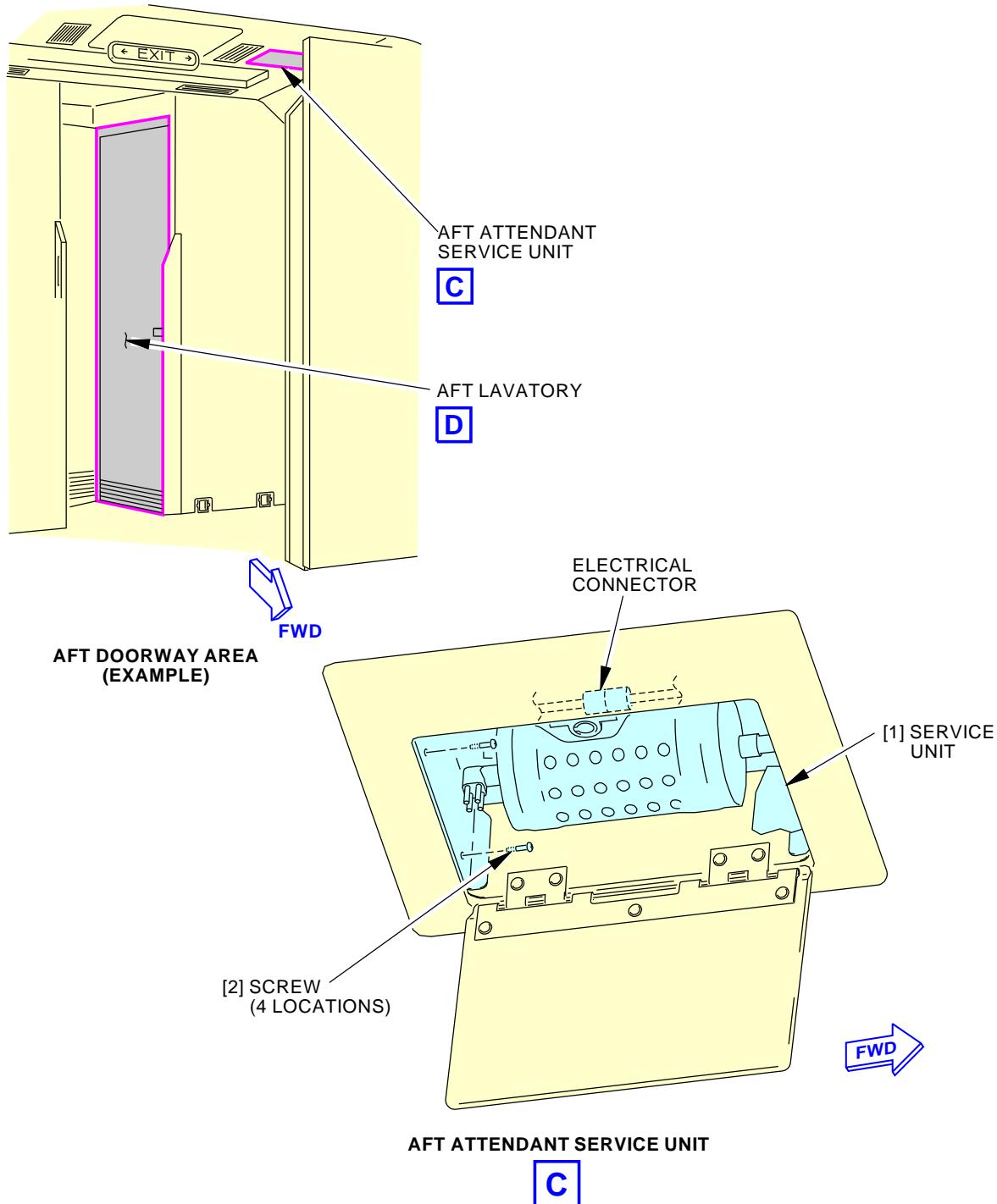
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**Attendant and Lavatory Service Unit Installation
Figure 401/25-23-13-990-801 (Sheet 1 of 3)**

 EFFECTIVITY
 AKS ALL

25-23-13



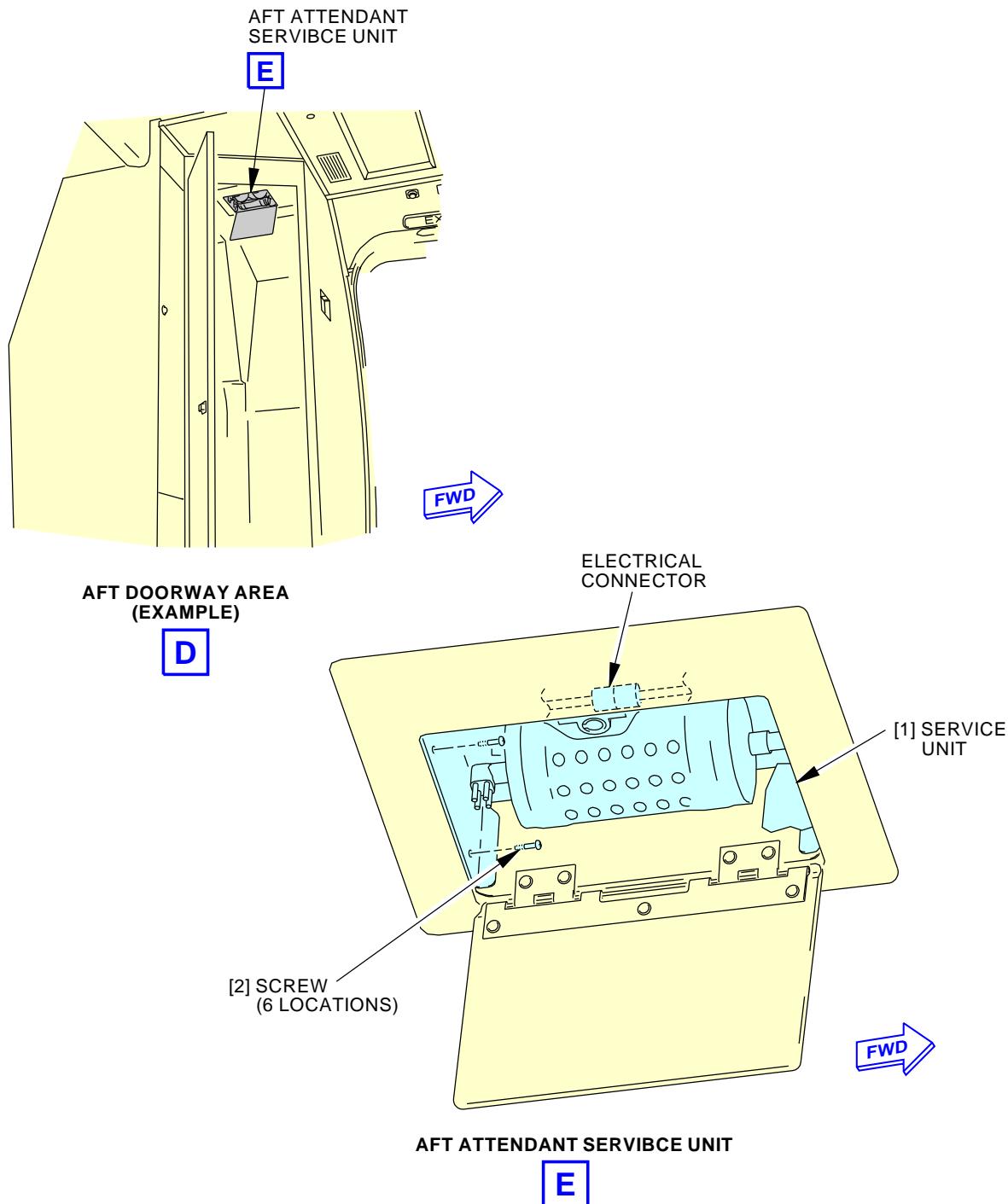
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Attendant and Lavatory Service Unit Installation
Figure 401/25-23-13-990-801 (Sheet 2 of 3)

 EFFECTIVITY
 AKS ALL

25-23-13

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Attendant and Lavatory Service Unit Installation
Figure 401/25-23-13-990-801 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

25-23-13



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TASK 25-23-13-400-801

3. Attendant/Lavatory Service Unit - Installation

(Figure 401)

A. General

- (1) The attendant service unit contains emergency oxygen masks and an oxygen generator.

AKS 001-006

- (2) The lavatory service unit contains emergency oxygen masks and an oxygen generator.

AKS 007-999

- (3) The lavatory service unit contains emergency oxygen masks and an oxygen cylinder.

AKS ALL

- (4) The attendant and lavatory service units are also called oxygen boxes.
(5) You can remove the oxygen masks and oxygen generator with the attendant service unit installed.

AKS 001-006

- (6) You can remove the oxygen masks and oxygen generator with the lavatory service unit installed.

AKS 007-999

- (7) You can remove the oxygen masks and oxygen cylinder with the lavatory service unit installed.

AKS ALL

B. References

Reference	Title
25-21-30 P/B 401	FORWARD ENTRY DOOR DOORWAY HEADER PANEL, - REMOVAL/INSTALLATION
25-21-34 P/B 401	DOORWAY HEADER PANEL, FORWARD GALLEY DOOR - REMOVAL/INSTALLATION
35-22-00-700-801	Passenger Oxygen System - Automatic Actuation Functional Test (P/B 501)
35-22-11-400-811-001	Oxygen Generator Activation (P/B 201)
35-22-51-440-801	Oxygen Cylinder (CDS) Activation (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-13800	Bit - Screwdriver, Special Part #: D72D72684-111 Supplier: 1TGN3

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
AKS ALL

25-23-13



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E. Service Unit Installation

SUBTASK 25-23-13-420-001

- (1) Connect the electrical connector for the passenger service unit [1].

SUBTASK 25-23-13-420-002

- (2) Put the passenger service unit [1] into the opening in the ceiling panel.

SUBTASK 25-23-13-210-001

- (3) Make sure that the unit is correctly aligned in the ceiling panel.

SUBTASK 25-23-13-200-001

- (4) To align the oxygen box door do the following:

- (a) Make sure that there are three equal gaps between the oxygen box door and the ceiling panel cutout. Make sure that there is a slightly larger gap at the hinge side of the oxygen box assembly.
- (b) To adjust the alignment of the door in the panel assembly, the doorway header panel that contains the oxygen box assembly can be removed.
 - 1) Do the applicable task in this procedure: FORWARD ENTRY DOOR DOORWAY HEADER PANEL, - REMOVAL/INSTALLATION, PAGEBLOCK 25-21-30/401.
 - 2) Do the applicable task in this procedure: DOORWAY HEADER PANEL, FORWARD GALLEY DOOR - REMOVAL/INSTALLATION, PAGEBLOCK 25-21-34/401.

SUBTASK 25-23-13-420-003

- (5) Install the screws [2].

SUBTASK 25-23-13-400-001

- (6) Install the panel.

- (a) Put special screwdriver bit, SPL-13800 into the fasteners.
- (b) Tighten fasteners.

SUBTASK 25-23-13-440-003

- (7) Activate the attendant passenger service unit [1]. Do this task: Oxygen Generator Activation, TASK 35-22-11-400-811-001.

AKS 001-006

SUBTASK 25-23-13-440-001

- (8) Activate the lavatory passenger service unit [1]. Do this task: Oxygen Generator Activation, TASK 35-22-11-400-811-001.

AKS 007-999

SUBTASK 25-23-13-440-002

- (9) Activate the lavatory passenger service unit [1]. Do this task: Oxygen Cylinder (CDS) Activation, TASK 35-22-51-440-801.

AKS ALL

SUBTASK 25-23-13-720-001

- (10) Do this task: Passenger Oxygen System - Automatic Actuation Functional Test, TASK 35-22-00-700-801.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-23-13



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PASSENGER SERVICE UNIT (PSU) - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
 - (1) Passenger Service Unit Removal
 - (2) Passenger Service Unit Installation
 - (3) Passenger Cabin Temperature Sensor Panel Removal
 - (4) Passenger Cabin Temperature Sensor Panel Installation
- B. The PSU has these functions:
 - (1) Oxygen Unit
 - (2) Reading Lights
 - (3) NS / FSB Sign
 - (4) Air Gaspers
 - (5) Speaker
 - (6) Attendant Call Button

TASK 25-23-61-000-804

2. Passenger Service Unit - Removal

Figure 401

A. References

Reference	Title
25-23-13-000-801	Attendant/Lavatory Service Unit - Removal (P/B 401)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)
35-22-11-000-811-001	Oxygen Generator Deactivation (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare to Remove the PSU

SUBTASK 25-23-61-860-011

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
B	1	C00094	PASS READING LIGHTS-RIGHT STA340-451
B	2	C00095	PASS READING LIGHTS-RIGHT
B	3	C00096	PASS READING LIGHTS-RIGHT
B	4	C00097	PASS READING LIGHTS-RIGHT
B	5	C00098	PASS READING LIGHTS-RIGHT
B	6	C00099	PASS READING LIGHTS-RIGHT
B	7	C00774	PASS READING LIGHTS-RIGHT
B	8	C01437	PASS READING LIGHTS-R STA768-880
B	9	C01438	PASS READING LIGHTS-R STA880-937



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SUBTASK 25-23-61-860-012

- (2) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C00087	PASS READING LIGHTS LEFT
B	2	C00088	PASS READING LIGHTS-LEFT
B	3	C00089	PASS READING LIGHTS-LEFT
B	4	C00090	PASS READING LIGHTS-LEFT
B	5	C00091	PASS READING LIGHTS-LEFT
B	6	C00092	PASS READING LIGHTS-LEFT
B	7	C00773	PASS READING LIGHTS-LEFT
B	8	C01152	PASS READING LIGHTS-LEFT STA768-880
B	9	C01153	PASS READING LIGHTS-L STA880-937

SUBTASK 25-23-61-860-013

- (3) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	8	C01403	PASSENGER CABIN PASS CALL LEFT
B	8	C01404	PASSENGER CABIN PASS CALL RIGHT
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
C	9	C01405	PASS CABIN SIGNS FASTEN SEAT BELT L
AKS 007, 008, 011, 012			
C	10	C01408	PASS CABIN SIGNS NO SMOKING RIGHT
C	11	C01407	PASS CABIN SIGNS NO SMOKING LEFT
AKS ALL			
D	11	C00442	PASSENGER CABIN SIGNS PASS SIGN CONT
F	8	C00785	OXYGEN MAN CONT
F	9	C00784	OXYGEN PASS RIGHT
F	10	C00783	OXYGEN PASS LEFT

These circuit breakers are inoperative and should remain open:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-006, 009, 010, 013-999			
C	10	C01408	PASS CABIN SIGNS NO SMOKING R (INOP)
C	11	C01407	PASS CABIN SIGNS NO SMOKING L (INOP)

AKS ALL

SUBTASK 25-23-61-010-007

- (4) To remove the attendant or lavatory service unit do this task: Attendant/Lavatory Service Unit - Removal, TASK 25-23-13-000-801.

SUBTASK 25-23-61-010-005

- (5) Do these steps to open the PSU:
(a) Put an Allen wrench in the PSU release holes.



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- (b) Push up to release the latch (2 places).

NOTE: Most of the PSUs have two latches. If the PSU has a small width, then it may only have one latch.

AKS 001-007 WITHOUT EXTRA PSU LANYARDS; PSU WITH SINGLE LANYARD

- (c) Disconnect the lanyard from the PSU rail.

AKS 008-999; AKS 001-007 WITH EXTRA PSU LANYARDS; PSU WITH EXTRA LANYARDS

- (d) Disconnect the lanyards from the PSU rail.

AKS ALL

- (e) Let the PSU hang from the opposite end.

SUBTASK 25-23-61-040-001

CAUTION: MAKE SURE THAT THE RELEASE PIN FOR THE CHEMICAL OXYGEN GENERATOR STAYS ENGAGED IN THE FIRING PIN. IF THE CHEMICAL OXYGEN GENERATOR ACCIDENTALLY OPERATES, IT IS MANDATORY THAT YOU REPLACE IT.

- (6) Do this task: Oxygen Generator Deactivation, TASK 35-22-11-000-811-001.

NOTE: This task isolates the oxygen generator and installs the safety pin. This task must be done prior to removal.

D. Remove the PSU

SUBTASK 25-23-61-020-009

- (1) On the oxygen generator, do this task to disconnect the breathable oxygen lines: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801.
- (2) On the gasper, disconnect the clamp from the flexible duct.
- (3) Remove the flexible duct from the manifold.
- (4) Disconnect the electrical connector.
- (5) Release the latches located near the rail.
 - (a) Push in latches to release pins from rail.
- (6) Remove the unit from the rail.

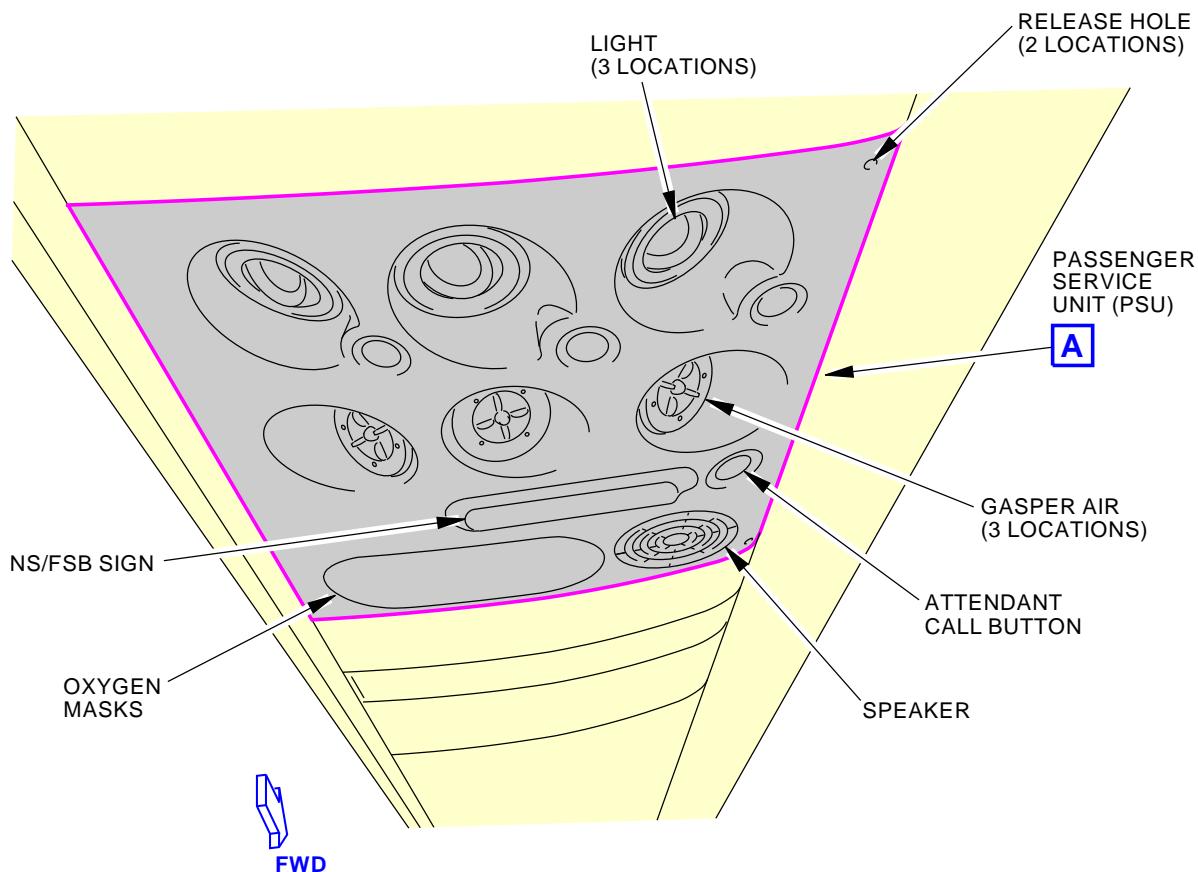
———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-23-61



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| PASSENGER SERVICE UNIT (PSU)
(LEFT SIDE PASSENGER SERVICE UNIT IS SHOWN,
RIGHT SIDE IS EQUIVALENT)

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Passenger Service Unit (Sky Interior)
Figure 401/25-23-61-990-804 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

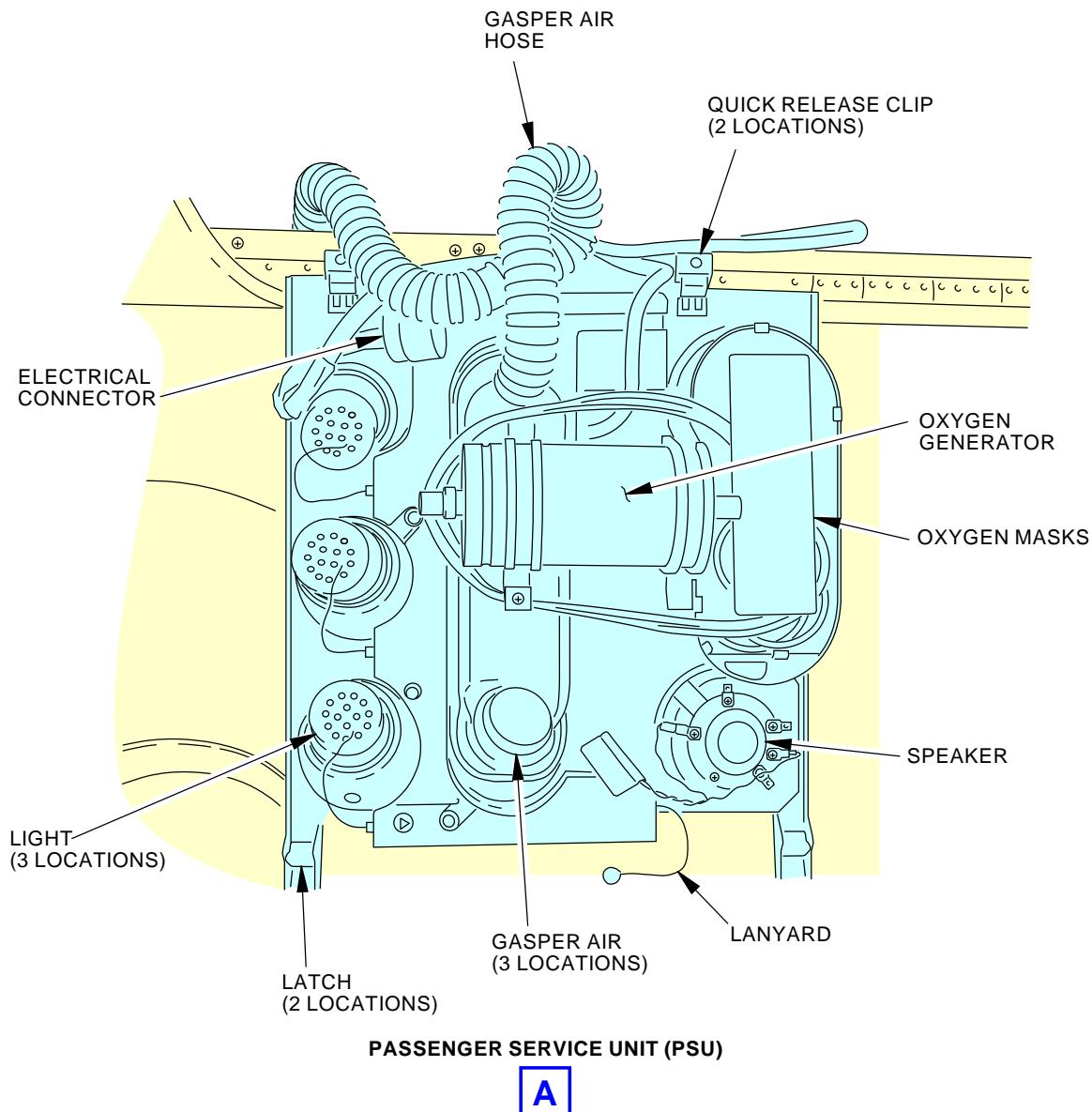
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Passenger Service Unit (Sky Interior)
Figure 401/25-23-61-990-804 (Sheet 2 of 3)

EFFECTIVITY
AKS 001-007 WITHOUT EXTRA PSU LANYARDS;
PSU WITH SINGLE LANYARD

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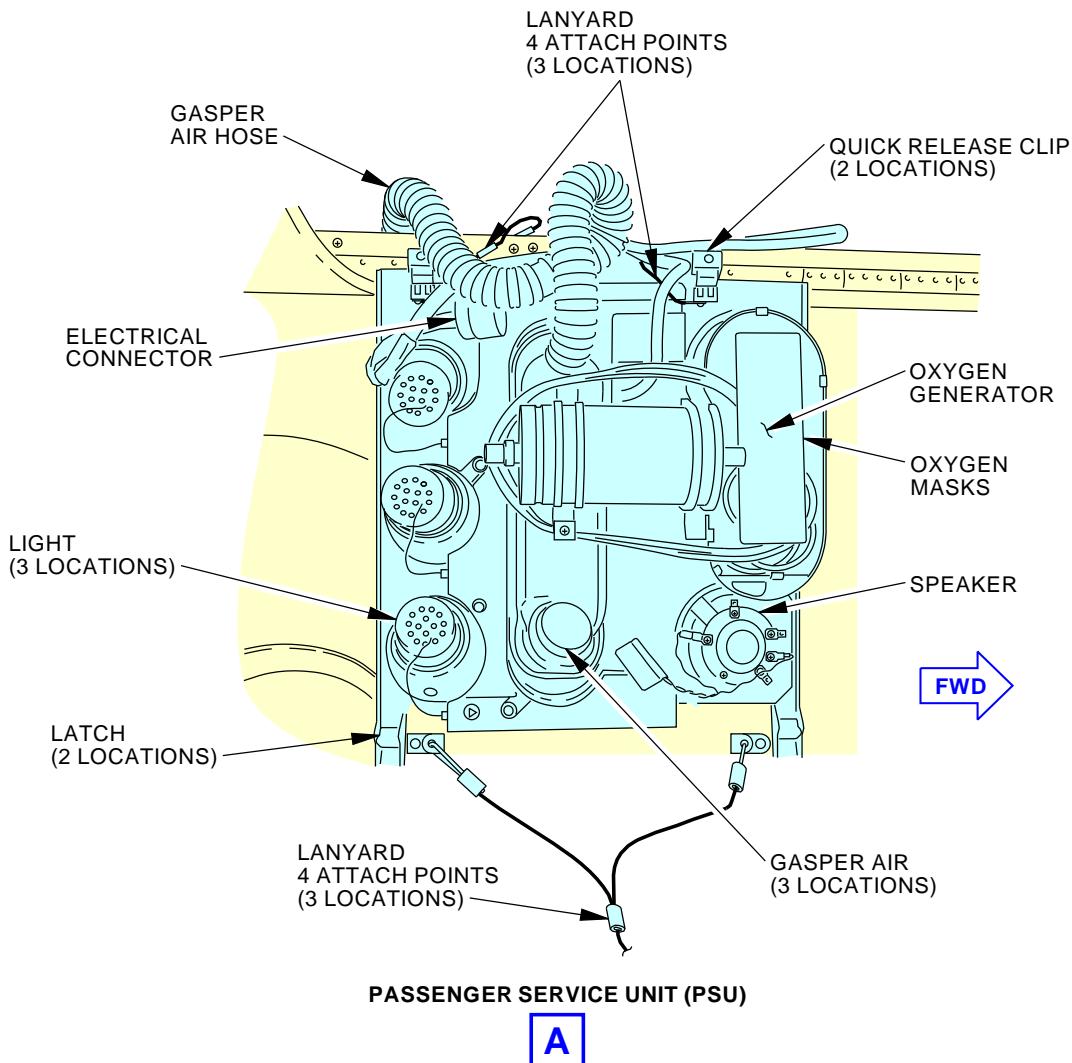
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Passenger Service Unit (Sky Interior)
Figure 401/25-23-61-990-804 (Sheet 3 of 3)

EFFECTIVITY
AKS 008-999; AKS 001-007 WITH EXTRA PSU
LANYARDS; PSU WITH EXTRA LANYARDS

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TASK 25-23-61-400-804

3. Passenger Service Unit - Installation

Figure 401

A. References

Reference	Title
24-22-00-860-811	Supply Electrical Power (P/B 201)
24-22-00-860-812	Remove Electrical Power (P/B 201)
25-23-13-400-801	Attendant/Lavatory Service Unit - Installation (P/B 401)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)
35-22-00-700-802	Passenger Oxygen System - Manual Deploy Functional Test (P/B 501)
35-22-11-400-811-001	Oxygen Generator Activation (P/B 201)
AIPC 25-23-61	Service Unit

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the PSU

SUBTASK 25-23-61-420-020

- (1) To install the attendant or lavatory service unit do this task: Attendant/Lavatory Service Unit - Installation, TASK 25-23-13-400-801.

SUBTASK 25-23-61-420-021

- (2) PSU Installation

- (a) Locate the correct placement for the PSU type.

NOTE: There are several types of PSU's. The location of the PSU types can be different on each plane.

NOTE: For PSU location, refer to AIPC 25-23-61.

- (b) Put the panel in the correct position.

- (c) Engage latches to PSU rail.

- 1) Make sure pins are engaged. You may have to wiggle the panel slightly to ensure pins are engaged.

- (d) Let the PSU hang freely from the outboard side

- (e) Install the flexible air duct to the manifold.

- (f) Connect the clamp to the flexible duct.

- (g) Do this task to connect the breathable oxygen lines: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801.

- (h) Connect the electrical connector.

SUBTASK 25-23-61-440-002

- (3) Do this task: Oxygen Generator Activation, TASK 35-22-11-400-811-001.

SUBTASK 25-23-61-410-002

- (4) Do these steps to close the PSU:

AKS 001-007 WITHOUT EXTRA PSU LANYARDS; PSU WITH SINGLE LANYARD

- (a) Connect the lanyard to the PSU rail.

EFFECTIVITY
AKS ALL

25-23-61



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AKS 008-999; AKS 001-007 WITH EXTRA PSU LANYARDS; PSU WITH EXTRA LANYARDS

- (b) Connect the lanyards to the PSU rail.

AKS ALL

- (c) Push the PSU up until you hear the latch or latches engage in the PSU rail.

WARNING: MAKE SURE THAT THE PSU LATCHES ARE ENGAGED. IF YOU DO NOT CORRECTLY ENGAGE THE LATCHES, THE PSU CAN FALL AND CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

- (d) If there is more than one latch, lightly pull down on the edges of the PSU to make sure the latches are engaged.

SUBTASK 25-23-61-860-014

- (5) Close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	8	C01403	PASSENGER CABIN PASS CALL LEFT
B	8	C01404	PASSENGER CABIN PASS CALL RIGHT
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
C	9	C01405	PASS CABIN SIGNS FASTEN SEAT BELT L
AKS 007, 008, 011, 012			
C	10	C01408	PASS CABIN SIGNS NO SMOKING RIGHT
C	11	C01407	PASS CABIN SIGNS NO SMOKING LEFT

AKS ALL

D	11	C00442	PASSENGER CABIN SIGNS PASS SIGN CONT
F	8	C00785	OXYGEN MAN CONT
F	9	C00784	OXYGEN PASS RIGHT
F	10	C00783	OXYGEN PASS LEFT

These circuit breakers are inoperative and should remain open:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-006, 009, 010, 013-999			
C	10	C01408	PASS CABIN SIGNS NO SMOKING R (INOP)
C	11	C01407	PASS CABIN SIGNS NO SMOKING L (INOP)

AKS ALL

SUBTASK 25-23-61-860-015

- (6) Close these circuit breakers:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C00087	PASS READING LIGHTS LEFT
B	2	C00088	PASS READING LIGHTS-LEFT
B	3	C00089	PASS READING LIGHTS-LEFT
B	4	C00090	PASS READING LIGHTS-LEFT
B	5	C00091	PASS READING LIGHTS-LEFT
B	6	C00092	PASS READING LIGHTS-LEFT
B	7	C00773	PASS READING LIGHTS-LEFT
B	8	C01152	PASS READING LIGHTS-LEFT STA768-880



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	9	C01153	PASS READING LIGHTS-L STA880-937

SUBTASK 25-23-61-860-016

- (7) Close these circuit breakers:

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C00094	PASS READING LIGHTS-RIGHT STA340-451
B	2	C00095	PASS READING LIGHTS-RIGHT
B	3	C00096	PASS READING LIGHTS-RIGHT
B	4	C00097	PASS READING LIGHTS-RIGHT
B	5	C00098	PASS READING LIGHTS-RIGHT
B	6	C00099	PASS READING LIGHTS-RIGHT
B	7	C00774	PASS READING LIGHTS-RIGHT
B	8	C01437	PASS READING LIGHTS-R STA768-880
B	9	C01438	PASS READING LIGHTS-R STA880-937

D. Put the Airplane in its Usual Condition

SUBTASK 25-23-61-440-003

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-811.

SUBTASK 25-23-61-700-001

- (2) Do this task: Passenger Oxygen System - Manual Deploy Functional Test, TASK 35-22-00-700-802.

SUBTASK 25-23-61-040-002

- (3) Do this task: Remove Electrical Power, TASK 24-22-00-860-812.

———— END OF TASK ————

TASK 25-23-61-000-805

4. Passenger Cabin Temperature Sensor Panel - Removal

(Figure 402)

A. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

B. Prepare for the Removal

SUBTASK 25-23-61-860-017

- (1) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-4

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C01158	AIR CONDITIONING PACK CONTROL LEFT DC
A	11	C01159	AIR CONDITIONING PACK CONTROL LEFT AC
B	9	C01161	AIR CONDITIONING PACK CONT RIGHT DC
B	11	C01162	AIR CONDITIONING PACK CONT RIGHT AC



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C. Passenger Cabin Temperature Sensor Panel Removal

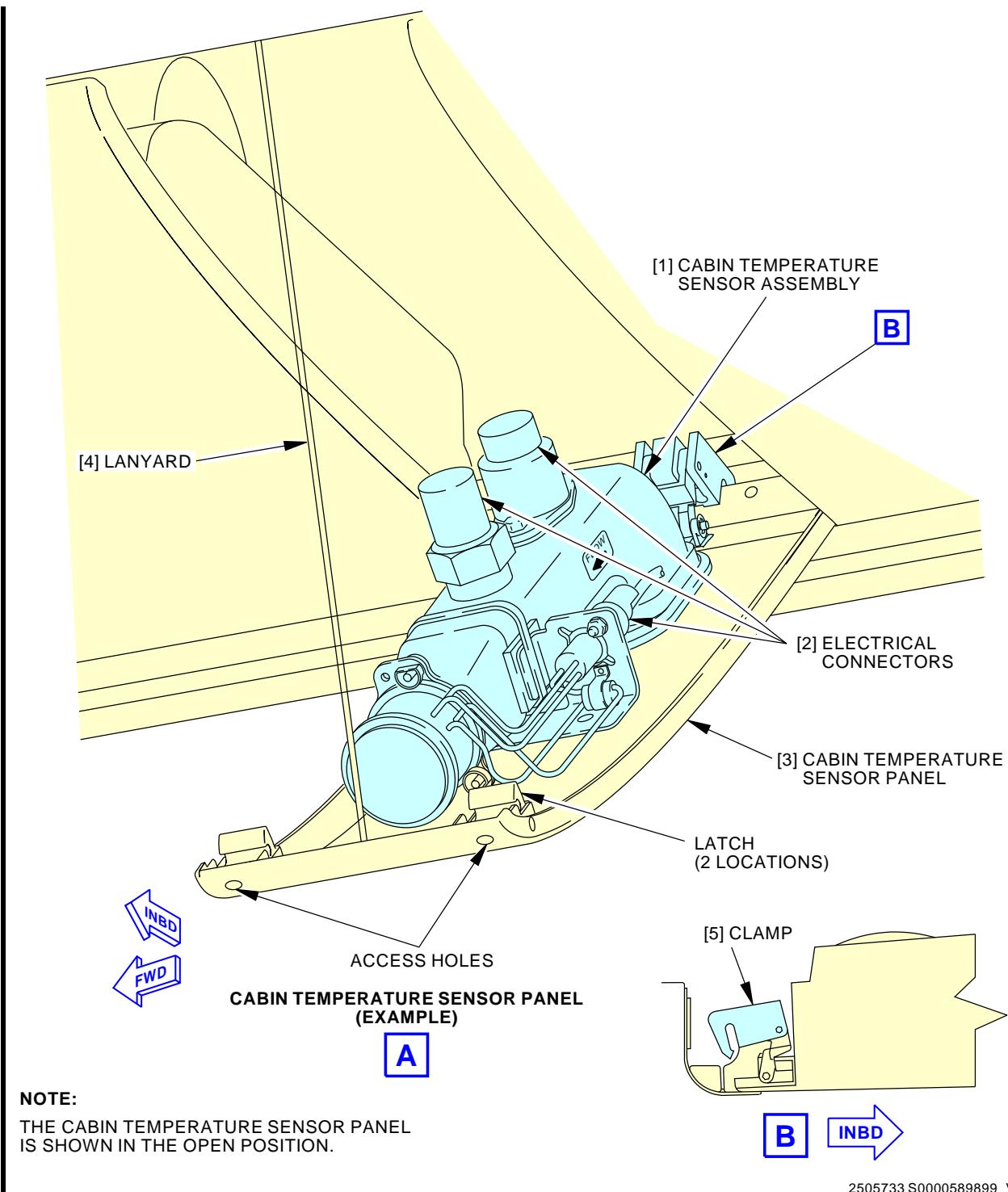
SUBTASK 25-23-61-010-008

- (1) Lower the cabin temperature sensor panel [3].
 - (a) Put a small allen wrench or other applicable tool in the access holes to release the latches.
 - (b) Partially lower the cabin temperature sensor panel [3] and disconnect the lanyard [4].
 - (c) Move the panel to the fully lowered position.
- (2) Disconnect the electrical connectors [2].
- (3) Release the clamp [5] located near the rail.
 - (a) Push in on the clamp [5] to release pin from the rail.
- (4) Remove the cabin temperature sensor panel [3] from the rail.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-23-61



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Passenger Cabin Temperature Sensor Panel - Removal

Figure 402/25-23-61-990-805

EFFECTIVITY
AKS ALL

25-23-61



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TASK 25-23-61-400-805

5. Passenger Cabin Temperature Sensor Panel - Installation

(Figure 402)

A. References

Reference	Title
21-61-00-700-806-002	Pack/Zone Temperature Controller BITE Test (P/B 501)
21-61-00-740-801-002	Pack Flow Temperature Controller BITE Test (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Passenger Cabin Temperature Sensor Panel Installation

SUBTASK 25-23-61-420-025

- (1) Locate the placement for the cabin temperature sensor panel [3].
- (2) Put the panel in the correct position.
- (3) Engage the clamp [5] on to the PSU rail.
 - (a) Make sure that the pins are engaged.

NOTE: You may have to wiggle the panel slightly to make sure that the pin is engaged.

- (4) Connect the electrical connectors [2].
- (5) Connect the lanyard [4] to the PSU rail.
- (6) Push the cabin temperature sensor panel [3] up until you hear the latches engage it the PSU rail.

WARNING: MAKE SURE THAT THE PSU LATCHES ARE ENGAGED. IF YOU DO NOT CORRECTLY ENGAGE THE LATCHES, THE PSU CAN FALL AND CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

- (7) If there is more than one latch, lightly pull down on the edges of the cabin temperature sensor panel [3] to make sure the latches are engaged.

SUBTASK 25-23-61-860-018

- (8) Remove the safety tags and close these circuit breakers:

F/O Electrical System Panel, P6-4

Row	Col	Number	Name
A	9	C01158	AIR CONDITIONING PACK CONTROL LEFT DC
A	11	C01159	AIR CONDITIONING PACK CONTROL LEFT AC
B	9	C01161	AIR CONDITIONING PACK CONT RIGHT DC
B	11	C01162	AIR CONDITIONING PACK CONT RIGHT AC

D. Cabin Temperature Sensor Test

SUBTASK 25-23-61-720-001

- (1) To do a test of the sensor that was replaced, do the steps that follow:
 - (a) Do the BITE test on the right pack/zone temperature controller M1443 if you replaced the sensor for one of these zones:
 - 1) The flight compartment zone.
 - 2) The forward passenger compartment zone.

EFFECTIVITY
AKS ALL

25-23-61



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- (b) Do the BITE test on the left pack/zone temperature controller M1442 if you replaced the sensor for the aft passenger compartment zone.
- (c) To do the BITE test, do this task: Pack/Zone Temperature Controller BITE Test, TASK 21-61-00-700-806-002 or Pack Flow Temperature Controller BITE Test, TASK 21-61-00-740-801-002.

———— END OF TASK ——

EFFECTIVITY
AKS ALL

25-23-61

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MONUMENT MOUNTED CURTAIN AND TRACK - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Monument Mounted Curtain and Track Removal,
 - (2) Monument Mounted Curtain and Track Installation.

TASK 25-24-05-000-801

2. Monument Mounted Curtain and Track Removal

(Figure 401)

A. References

Reference	Title
25-21-71-000-805	Close Out Panel Removal, Forward Lowered Ceiling (P/B 401)

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Prepare for the Procedure

SUBTASK 25-24-05-010-001

- (1) Do this task: Close Out Panel Removal, Forward Lowered Ceiling, TASK 25-21-71-000-805.

D. Procedure

SUBTASK 25-24-05-020-001

- (1) Remove the curtain [2] from the curtain track [1].

SUBTASK 25-24-05-020-002

- (2) Remove the screws [3] and washers [4] on the curtain track.

SUBTASK 25-24-05-000-001

- (3) If it is necessary to remove the support brackets [9], do the steps that follow.

- (a) Remove the screws [5], washers [6], spacers [7] and bolts [8].

— END OF TASK —

TASK 25-24-05-400-801

3. Monument Mounted Curtain and Track Installation

(Figure 401)

A. References

Reference	Title
25-21-71-400-805	Close Out Panel Installation, Forward Lowered Ceiling (P/B 401)

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right



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C. Procedure

SUBTASK 25-24-05-000-002

- (1) If the support brackets [9] were removed, do the steps that follow.
 - (a) Install the screws [5], washers [6], spacers [7] and bolts [8].

SUBTASK 25-24-05-020-003

- (2) Install the curtain track [1] to the support brackets [9], with the screws [3] and washers [4] on the curtain track.

SUBTASK 25-24-05-420-001

- (3) Install the curtain [2] on the curtain track [1].

D. Put the Airplane Back to It's Usual Condition

SUBTASK 25-24-05-410-001

- (1) Do this task: Close Out Panel Installation, Forward Lowered Ceiling, TASK 25-21-71-400-805.

———— END OF TASK ————

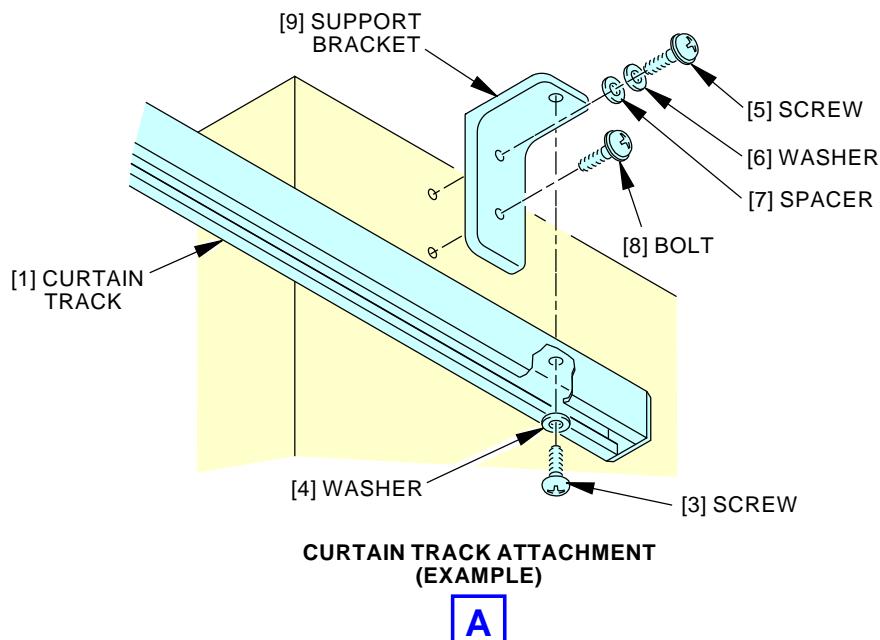
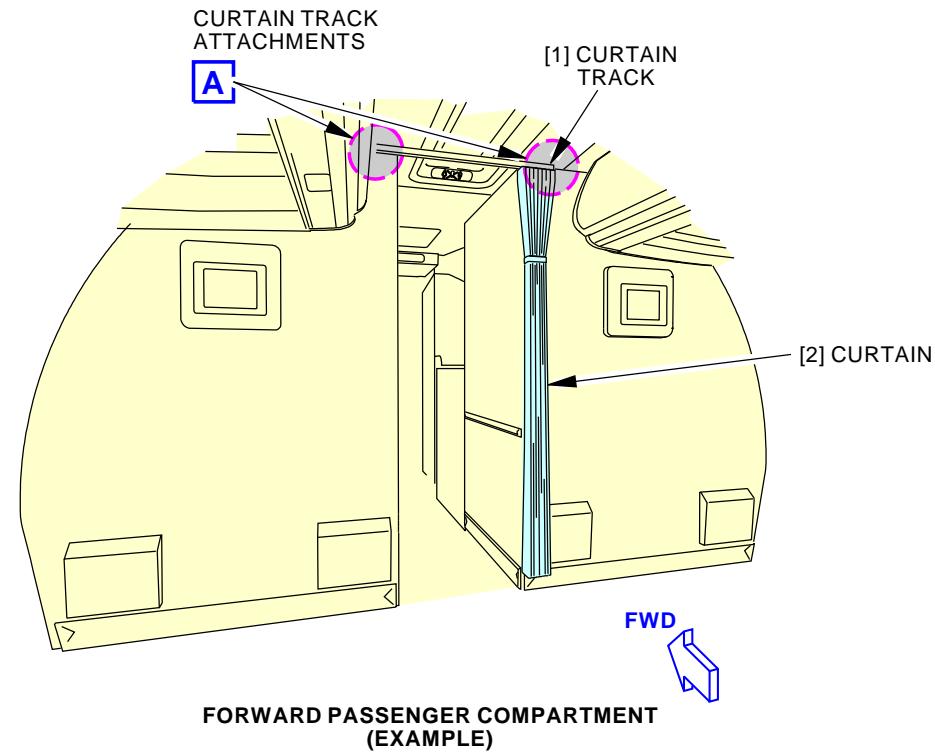


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L00684 S0006566885_V2

**Monument Mounted Curtain and Track Installation
Figure 401/25-24-05-990-801**

EFFECTIVITY
AKS ALL

25-24-05



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CEILING MOUNTED CURTAIN TRACK - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Ceiling mounted curtain track removal
 - (2) Ceiling mounted curtain track installation

TASK 25-24-07-000-801

2. Ceiling Mounted Curtain Track Removal

(Figure 401)

A. References

Reference	Title
25-21-71-000-805	Close Out Panel Removal, Forward Lowered Ceiling (P/B 401)

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Prepare for the removal

SUBTASK 25-24-07-010-001

- (1) Do this task: Close Out Panel Removal, Forward Lowered Ceiling, TASK 25-21-71-000-805.

D. Procedure

SUBTASK 25-24-07-020-005

- (1) Remove the curtain assembly [4] from the curtain track [2].

SUBTASK 25-24-07-020-006

- (2) Remove the screws [3] on the curtain track [2] from the ceiling assembly [1].

SUBTASK 25-24-07-020-007

- (3) Remove the curtain track [2].

———— END OF TASK ————

TASK 25-24-07-400-801

3. Ceiling Mounted Curtain Track Installation

(Figure 401)

A. References

Reference	Title
25-21-71-400-805	Close Out Panel Installation, Forward Lowered Ceiling (P/B 401)

B. Location Zones

Zone	Area
220	Subzone - Passenger Compartment - Body Station 259.50 to 360.00

C. Procedure

SUBTASK 25-24-07-420-003

- (1) Mount the curtain track [2] to the ceiling assembly [1].

EFFECTIVITY
AKS ALL

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SUBTASK 25-24-07-420-004

- (2) Attach the screws [3] through curtain track [2] and into the ceiling assembly [1].

SUBTASK 25-24-07-420-005

- (3) Install the curtain assembly [4] on the curtain track [2].

D. Put the Airplane Back to It's Usual Condition

SUBTASK 25-24-07-420-002

- (1) Do this task: Close Out Panel Installation, Forward Lowered Ceiling, TASK 25-21-71-400-805.

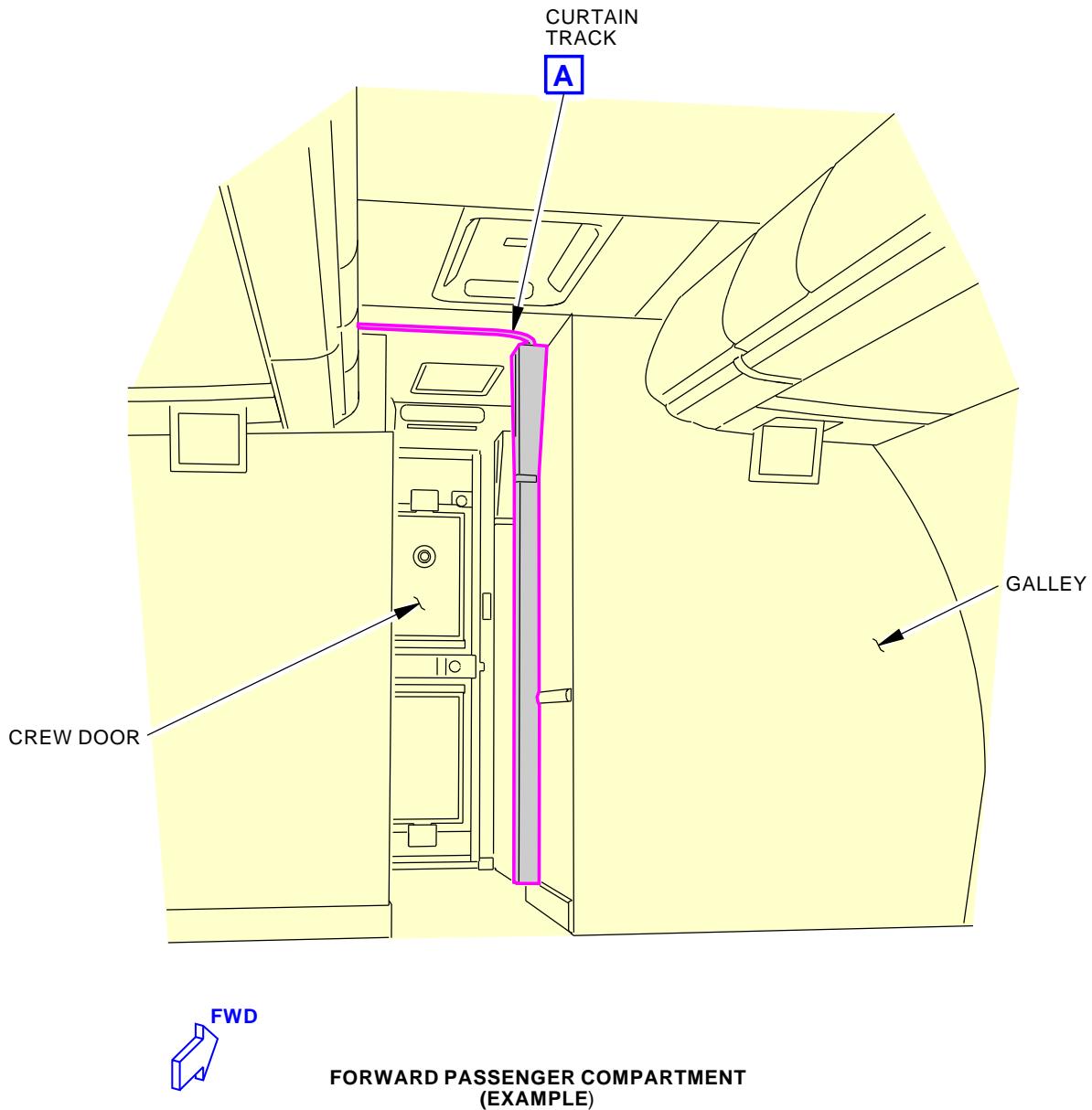
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EFFECTIVITY
AKS ALL

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W21504 S0006566891_V2

Ceiling Mounted Curtain Track Installation
Figure 401/25-24-07-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

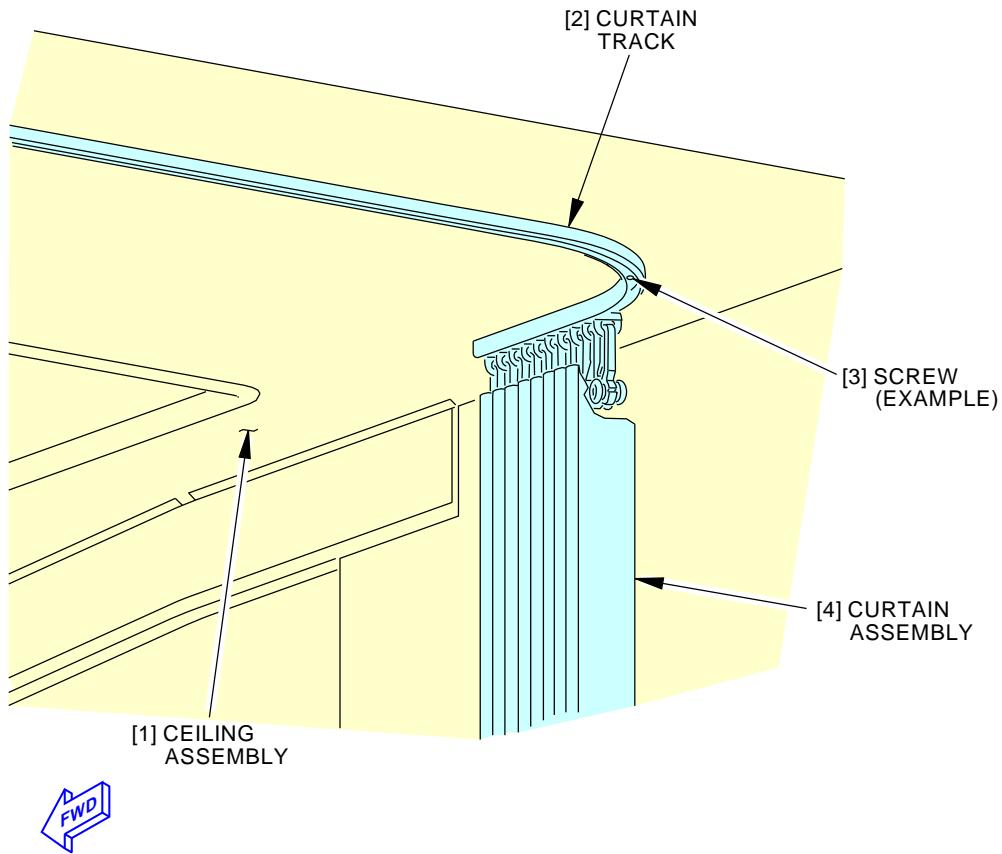
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CURTAIN TRACK
(EXAMPLE)

A

W21512 S0006566893_V2

Ceiling Mounted Curtain Track Installation
Figure 401/25-24-07-990-801 (Sheet 2 of 2)

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CLASS DIVIDER HEADER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Fixed Class Divider Header Removal,
 - (2) Fixed Class Divider Header Installation.
 - (3) Relocatable Class Divider Removal.
 - (4) Relocatable Class Divider Installation.

AKS 018-999

- (5) Center Overhead Storage (COS) Class Divider Track Removal.
- (6) Center Overhead Storage (COS) Class Divider Track Installation.

AKS ALL

- B. The fixed class divider has three components: a header assembly, a left divider assembly and right divider assembly. Each component is removed and installed independently.
- C. The relocatable class divider consists of a left and right underbin support header, left and right bin curtain and one cross aisle support header. The underbin header supports the curtains directly below the bins. The cross aisle header supports the left and right curtain. Each component is removed and installed independently.

AKS 018-999

- D. The COS class divider consists of a track assembly, a left and right divider assembly, and a left and a right curtain assembly. The track assembly attaches to the COS door. Each component is removed and installed independently.

AKS ALL

TASK 25-24-10-000-803

2. Fixed Class Divider Header - Removal

A. General

- (1) This task includes the steps to remove the fixed class divider header.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-10-010-003

- (1) To remove the curtain [3] from the header assembly [1], do these steps if it is necessary,
 - (a) Loosen the curtain tie-backs [2].
 - (b) Turn the release lever [11] on the end of the header adapter assembly [1] to the open position.
NOTE: A red mark will show when the release lever is in the correct open position.
 - (c) Move the curtain sliders [12] off of the header assembly [1].
 - (d) Remove the curtain [3].

SUBTASK 25-24-10-020-013

- (2) Remove the shroud [6] for access to the header adapter fitting [5].

EFFECTIVITY
AKS ALL

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- (a) Remove the 6 screws [7] that attach the shroud to the top of the lavatory wall.
- (b) Carefully remove the shroud [6].

SUBTASK 25-24-10-020-015

CAUTION: USE CARE WHEN HANDLING UNIT INSIDE AIRCRAFT TO PREVENT DAMAGE TO CEILING, SIDEWALL, OR INTERIOR EQUIPMENT.

- (3) Remove the quick-release pin [4] from the header adapter fitting [5].
 - (a) Carefully lower the loose end of the header down.

SUBTASK 25-24-10-020-014

- (4) To remove the header assembly [1] from the adapter fitting [10], do these steps:

NOTE: Two persons can be necessary.

- (a) Open the stowage bin door above the header assembly for access to the adapter fitting [10].
- (b) Remove the cap nut [8] and bolt [9] that connects the header assembly [1] to the header adapter fitting [10].
- (c) Carefully remove the header assembly.

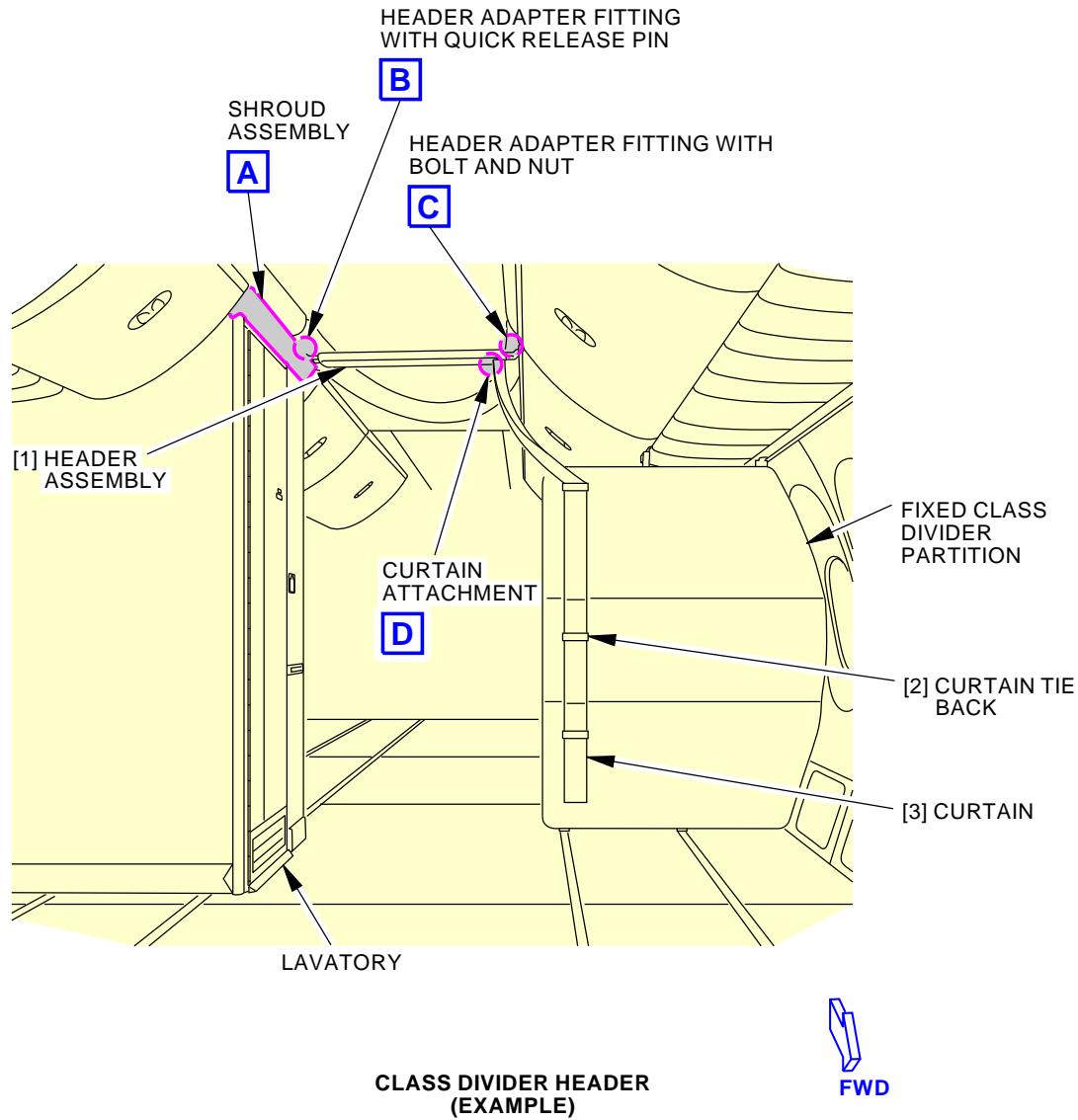
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EFFECTIVITY
AKS ALL

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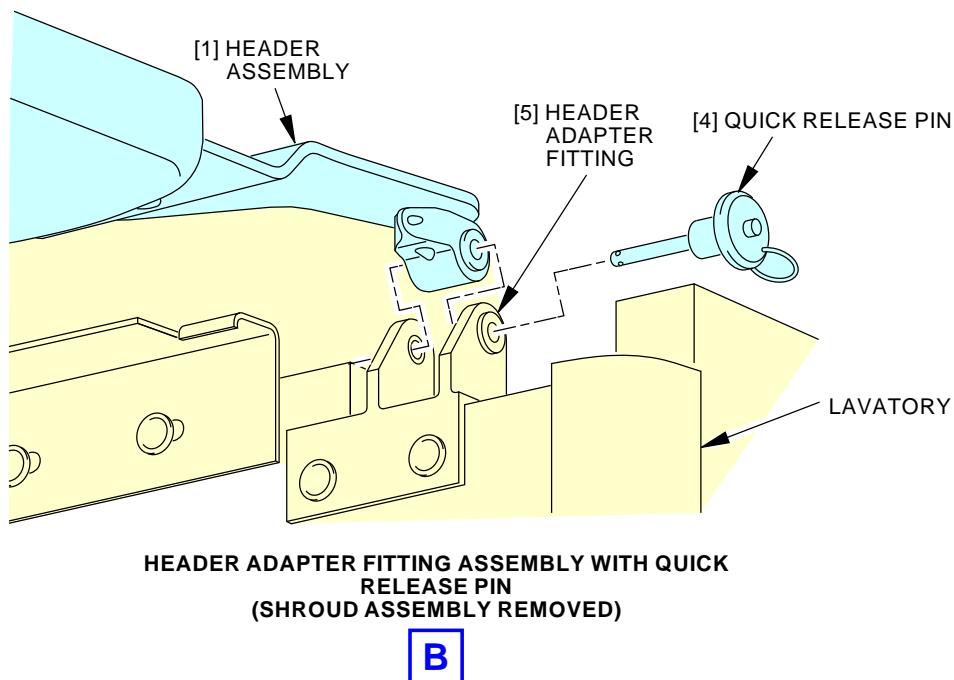
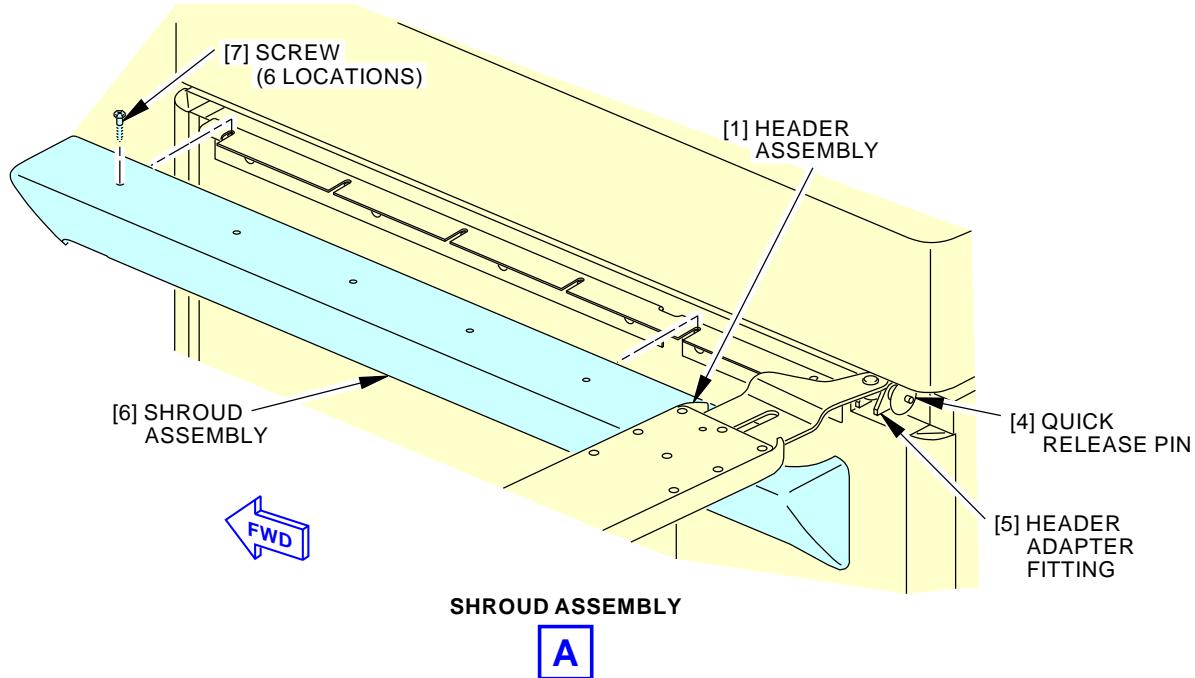
Fixed Class Divider Header Installation
Figure 401/25-24-10-990-807 (Sheet 1 of 4)

EFFECTIVITY	AKS ALL
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Fixed Class Divider Header Installation
Figure 401/25-24-10-990-807 (Sheet 2 of 4)

EFFECTIVITY
 AKS ALL

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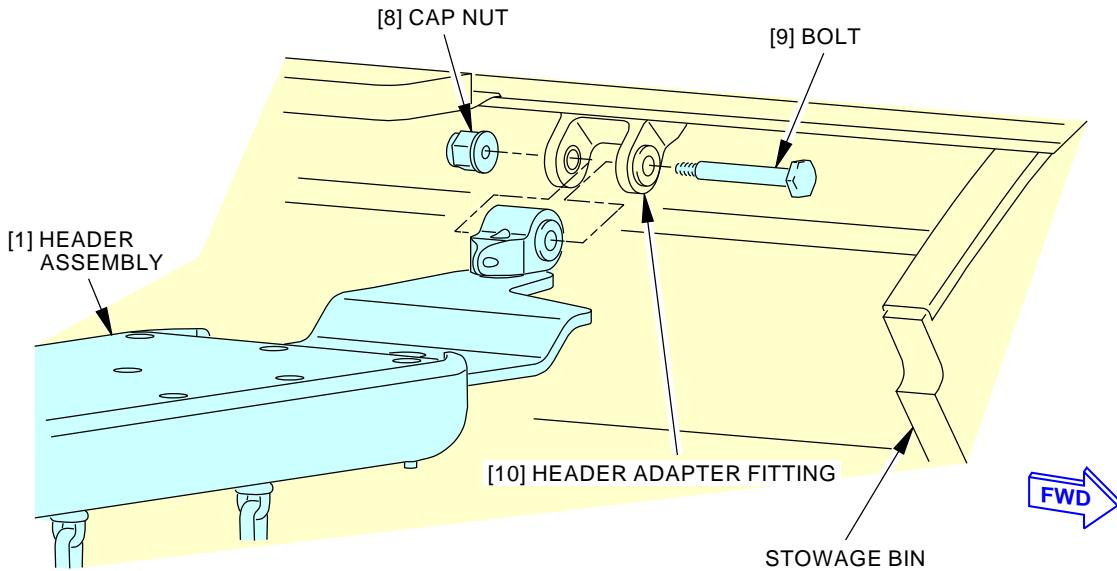
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HEADER ADAPTER FITTING WITH BOLT AND NUT
(STOWAGE BIN IN OPEN POSITION)
(BULLNOSE NOT SHOWN)

C

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Fixed Class Divider Header Installation
Figure 401/25-24-10-990-807 (Sheet 3 of 4)

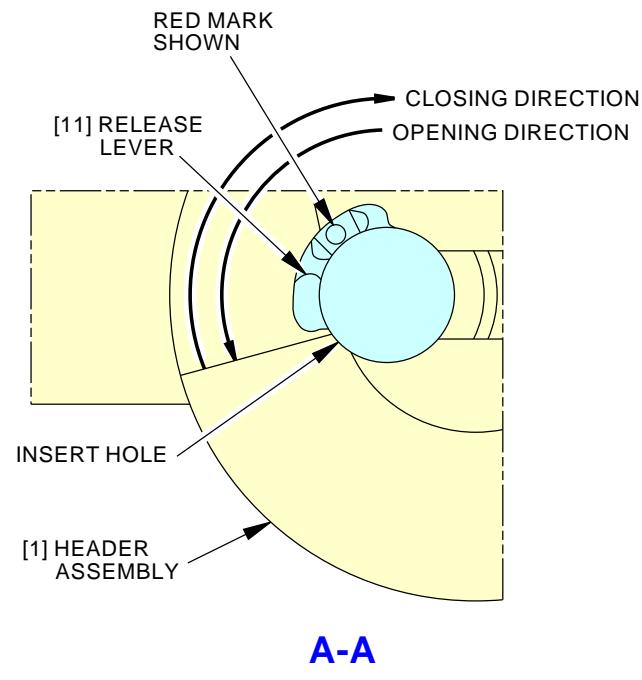
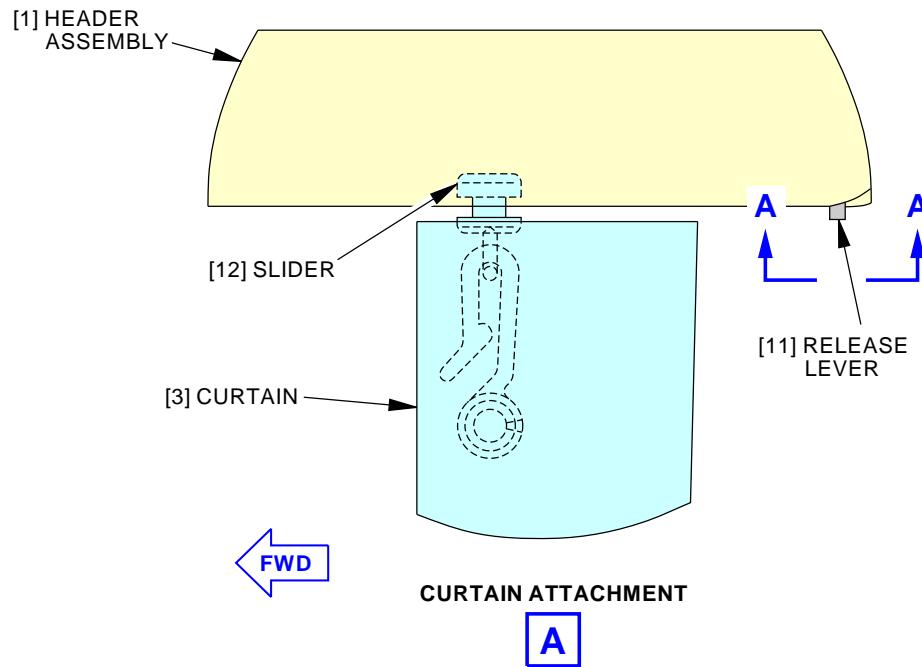
EFFECTIVITY
AKS ALL

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Fixed Class Divider Header Installation
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TASK 25-24-10-400-803

3. Fixed Class Divider Header - Installation

A. General

- (1) This task includes the steps to install the fixed class divider header.

B. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

C. Fixed Class Divider Header Installation

SUBTASK 25-24-10-400-001

- (1) Do these steps to install the header assembly [1] to the header adapter fitting [5]:
(a) Position the header assembly [1] to align the hole with the header adapter fitting [5] holes.
(b) Push the quick-release pin [4] through the header assembly [1] holes and header adapter fitting [5] holes to lock it in place.

SUBTASK 25-24-10-410-004

CAUTION: USE CARE WHEN HANDLING UNIT INSIDE AIRCRAFT TO PREVENT DAMAGE TO CEILING, SIDEWALL, OR INTERIOR EQUIPMENT.

- (2) Open the stowage bin door above the header assembly for access to the adapter fitting [10].
NOTE: Two persons can be necessary.

SUBTASK 25-24-10-420-014

- (3) Do these steps to install the header assembly [1]:
(a) Carefully lift the loose end of the header up.
(b) Align the header assembly [1] to the header adapter fitting [10].
(c) Put the bolt [9] through the adapter fitting [10] and header assembly [1].
1) Put the cap nut [8] on the end of the bolt [9] and tighten to 15 in-lb (2 N·m).
2) Tighten the bolt [9] to 35 in-lb (4 N·m).

SUBTASK 25-24-10-420-015

- (4) Do these steps to install the shroud [6]:
(a) Put the shroud [6] into position and align the attachment holes.
(b) Install the 6 screws [7] to attach the shroud [6] to the lavatory.

SUBTASK 25-24-10-420-009

- (5) Do these steps to install the curtain [3] to the header assembly [1], if it is necessary:
(a) Turn the release lever [11] to the open position on the header assembly [1].
NOTE: A red mark will show when the release lever is open.
(b) Move the sliders [12] on the header assembly [1].
(c) Turn the release lever [11] to the closed position on the header assembly [1].
NOTE: A red mark will not show when the release lever is closed.

— END OF TASK —





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TASK 25-24-10-000-804

4. Relocatable Class Divider Removal

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Relocatable Class Divider Removal

SUBTASK 25-24-10-020-010

- (1) Remove the curtain [3], if necessary.

SUBTASK 25-24-10-020-011

- (2) Remove the curtain header [1].

NOTE: Make sure that you support the curtain header assembly so it does not fall.

- (a) Remove the curtain header [1] with clevis adapter assembly [4], do these steps:

- 1) Get access to the clevis button [6] inside cover [5], push to disengage the pin.
- 2) Move the cover [5] to the left until the pin not fully engaged.
- 3) Push the clevis button [6] again to disengage.
- 4) Move the cover [5] to the left until the pin fully disengages.
- 5) Remove the curtain header [1].

- (b) Remove the curtain header [1] without clevis adapter assembly [4], do these steps:

- 1) Remove the bolt [8] and nut [9] that attach the curtains header [1] to the adapter fitting [7].
- 2) Remove the curtain header [1].

SUBTASK 25-24-10-020-012

- (3) Remove the underbin header assembly [2].

- (a) Remove the screw [12] from the coverplate [13].
- (b) Pull the coverplate [13] out to remove the underbin header [2] from the PSU rail fitting [14].
- (c) Lower the underbin header [2] out of the PSU rail fitting [14] and the AC-rail [10].
- (d) Remove the underbin header [2].

———— END OF TASK ————

TASK 25-24-10-400-804

5. Relocatable Class Divider Installation

Figure 402

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Relocatable Class Divider Installation

SUBTASK 25-24-10-420-011

- (1) Install the curtain header [1].

- (a) Install the curtain header [1] with clevis adapter assembly [4], do these steps:
 - 1) Put the curtain header [1] onto the clevis adapter fitting [15].





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- 2) Move the cover [5] to the right until the pin fully engaged.

NOTE: Make sure that the red lines on the cover [5] and the adapter fitting assembly [15] are aligned to lock.

- (b) Install the curtain header [1] without clevis adapter assembly [4], do these steps:
- 1) Put the curtain header [1] onto the adapter fitting [7].
 - 2) Install the bolt [8] and nut [9] that attach the curtains header [1] to the adapter fitting [7].

SUBTASK 25-24-10-420-012

- (2) Install the underbin header [2].

- (a) Do these steps:

- 1) Put the outboard fitting blade [11] to the AC- rail [10].
- 2) Put the underbin header [2] onto the PSU rail fitting [14].
- 3) Put the coverplace [13] back into full engagement.
- 4) Install the screw [12] to attach the coverplate [13] to the underbin header [2].

SUBTASK 25-24-10-420-013

- (3) Install the curtain [3], if removed.

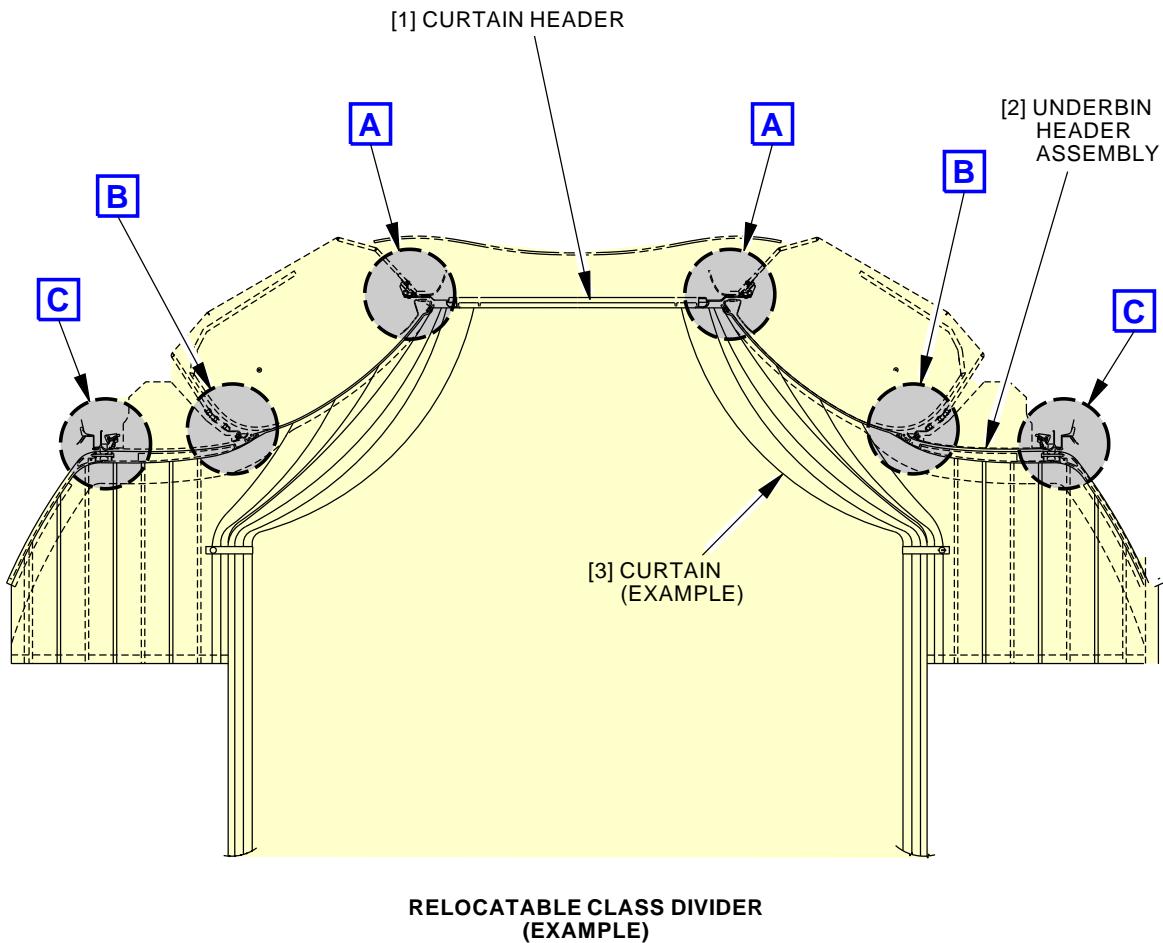
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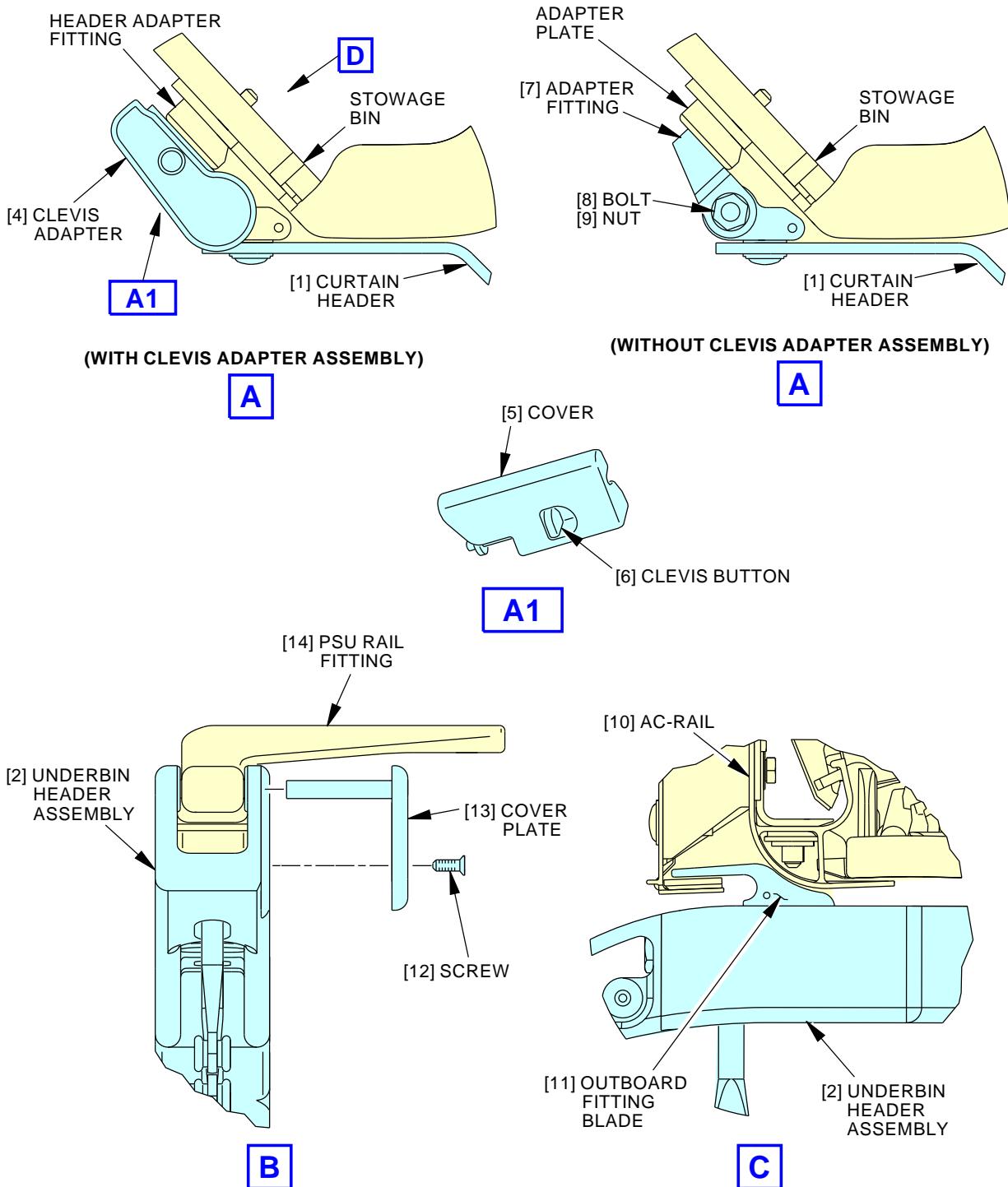
Relocatable Class Divider Installation
Figure 402/25-24-10-990-806 (Sheet 1 of 3)

 EFFECTIVITY
 AKS ALL

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**Relocatable Class Divider Installation
Figure 402/25-24-10-990-806 (Sheet 2 of 3)**

EFFECTIVITY
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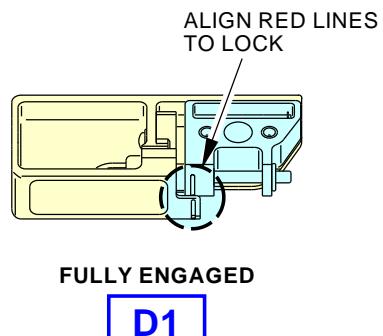
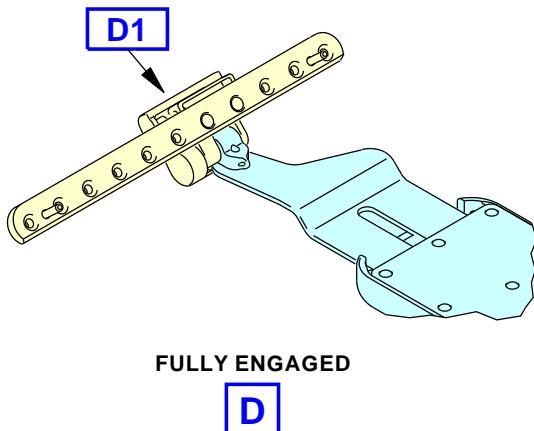
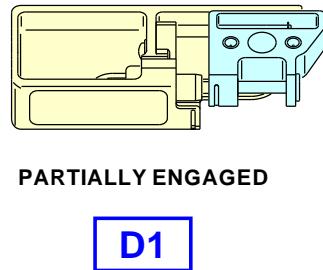
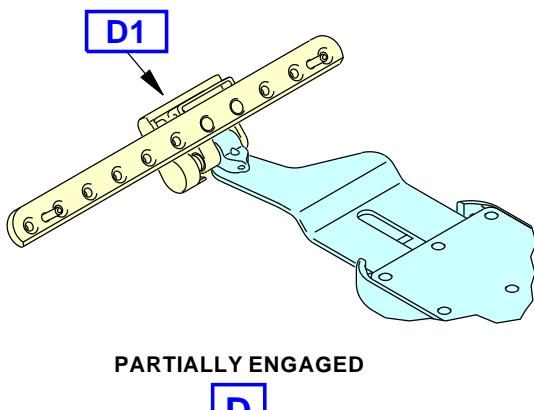
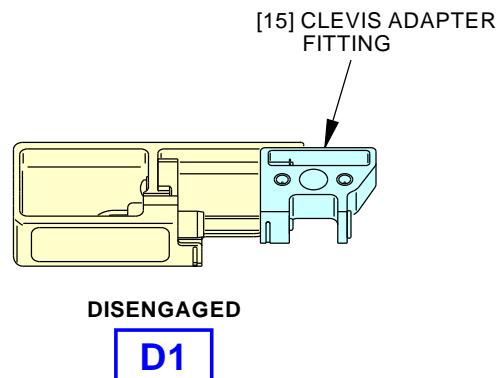
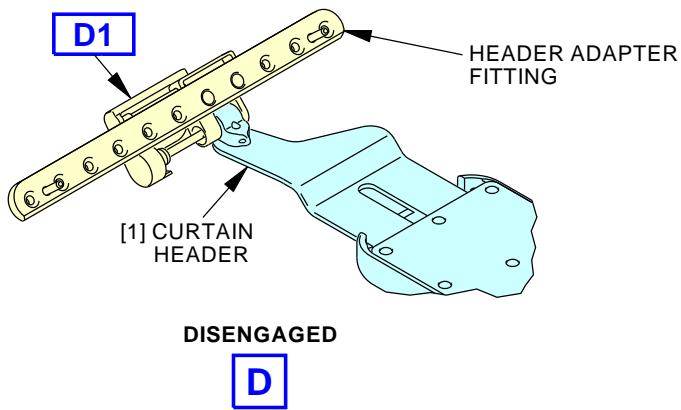
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Relocatable Class Divider Installation
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AKS ALL

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AKS 018-999

TASK 25-24-10-000-805-001

6. Center Overhead Stowage (COS) Class Divider Track - Removal
(Figure 403)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Center Overhead Storage (COS) Class Divider Track Removal

SUBTASK 25-24-10-010-006-001

- (1) Remove the curtain [3], if necessary.

SUBTASK 25-24-10-020-017-001

- (2) To remove the COS curtain header [1], do these steps:

NOTE: Make sure that you support the curtain track assembly so it does not fall.

- (a) Open the COS door.
- (b) Remove the screws [16] that attach the COS curtain header [1] to the adapter plates [17].
- (c) Remove the COS curtain header [1].
- (d) Remove the screws [18] that attach the adapter plates [17] to the COS door.
- (e) Remove the adapter plates [17].

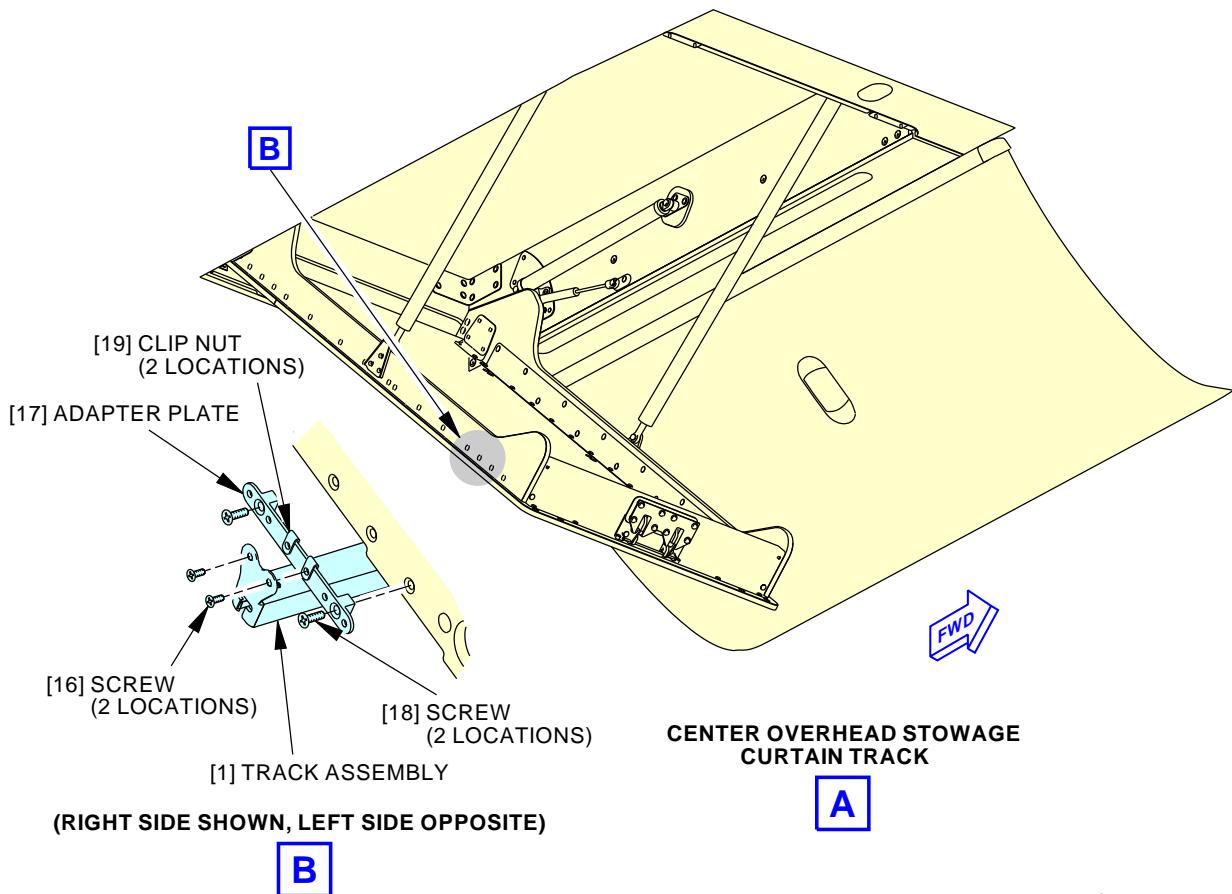
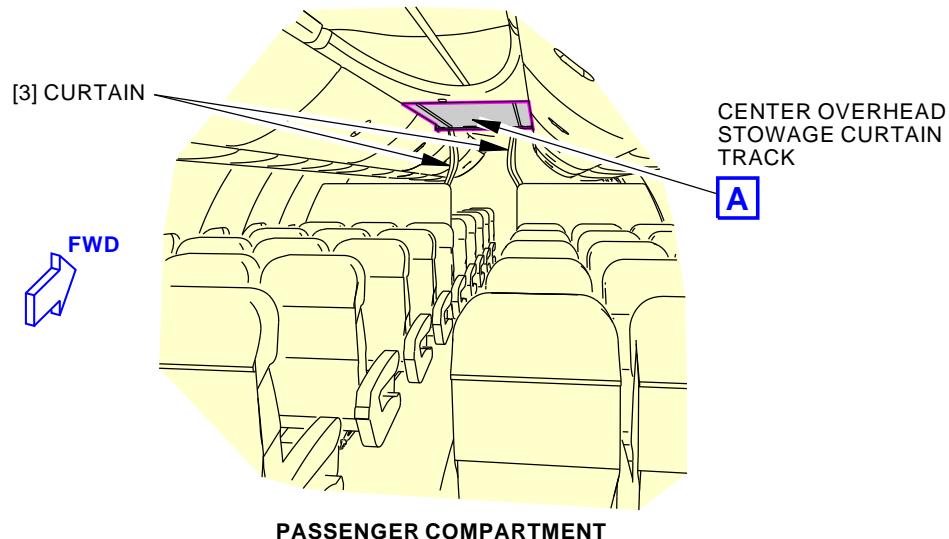
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EFFECTIVITY
AKS ALL

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Center Overhead Stowage (COS) Class Divider Track Installation
Figure 403/25-24-10-990-808-001

EFFECTIVITY
 AKS 018-999

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AKS 018-999 (Continued)

TASK 25-24-10-400-805-001

7. Center Overhead Stowage (COS) Class Divider Track - Installation

(Figure 403)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Center Overhead Stowage (COS) Class Divider Track Installation

SUBTASK 25-24-10-420-016-001

- (1) To install the COS curtain header [1], do these steps:

- (a) Assemble together the adapter plate [17] and clip nuts [19].
- (b) Use inserts to align the adapter plate [17] holes with the COS door holes.
- (c) Install the screws [18] to attach the adapter plates [17] to the COS door.
- (d) Install the screws [16] to attach the curtain header [1] to the adapter plates [17].
- (e) Close the COS door.

SUBTASK 25-24-10-410-005-001

- (2) Install the curtain [3], if removed.

———— END OF TASK ————

EFFECTIVITY

AKS ALL

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PARTITIONS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Fixed Class Divider Removal,
 - (2) Fixed Class Divider Installation.
- B. The fixed class divider has three components: a header assembly, a left divider assembly and right divider assembly. Each component is removed and installed independently.

TASK 25-24-15-000-807

2. Fixed Class Divider - Removal

Figure 401

A. General

- (1) This task includes the steps to remove the Fixed Class Divider.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-15-020-029

- (1) Disconnect the electrical connectors, if applicable.

D. Fixed Class Divider Removal

SUBTASK 25-24-15-010-003

- (1) If applicable, do these steps to remove the top attachment of the class divider [1]:
 - (a) Remove the screws [4] that attach the rail fitting [3] to the adapter wedges [2] and class divider [1].
 - (b) Remove the adapter wedges [2].
 - (c) Put the class divider [1] against the seat.
 - (d) Lower the PSU unit to get access to the PSU rail [7].
 - (e) Remove the rail fitting [3]:
 - 1) Remove the screws [6] and washers [5] that connect the rail fitting [3] and the PSU rail [7].

SUBTASK 25-24-15-020-032

- (2) If applicable, do these steps to disconnect the tie rod:
 - (a) If it is necessary, remove access covers to get access to the tie rod.
 - (b) Remove the lockpin [12], the washer(s) [11], and the pin [10].

SUBTASK 25-24-15-010-004

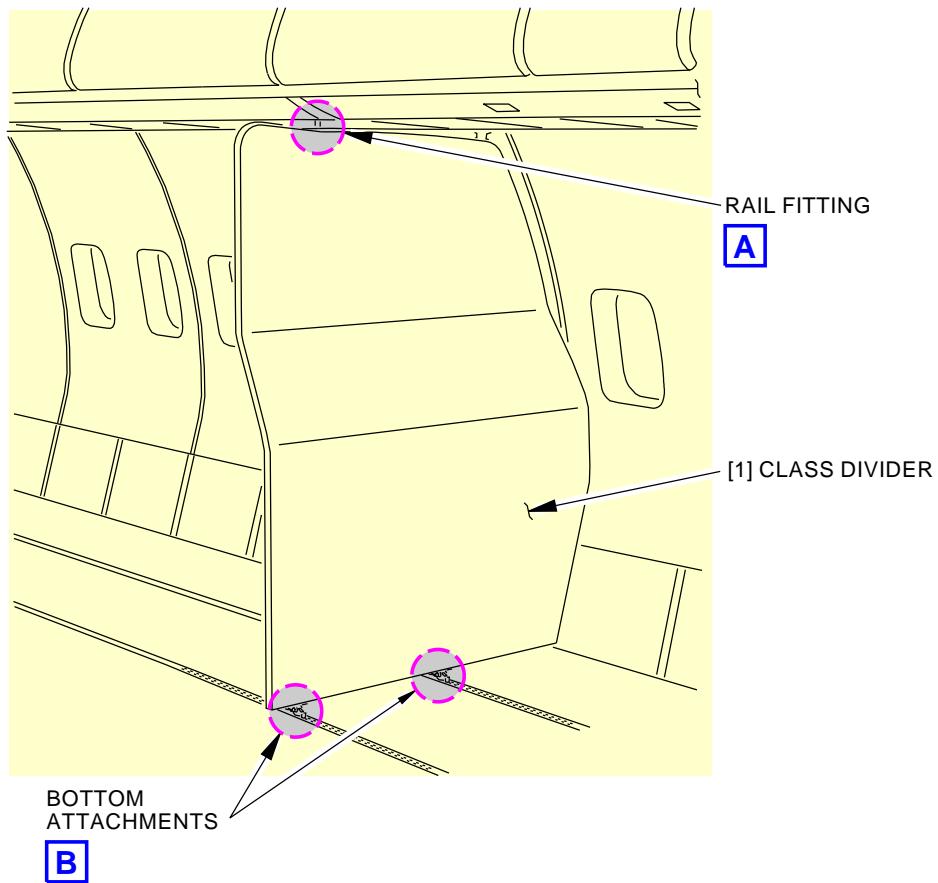
- (3) Do these steps to remove the bottom attachments of the class divider [1]:
 - (a) Loosen the anti-rattle setscrew [8].
 - (b) Disengage the shear plunger from the seat track [9].
 - (c) Move the fitting aft or forward until it moves freely out of the track.

———— END OF TASK ————

EFFECTIVITY
AKS ALL



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CLASS DIVIDER
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)
(EXAMPLE)

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Fixed Class Divider Installation
Figure 401/25-24-15-990-805 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

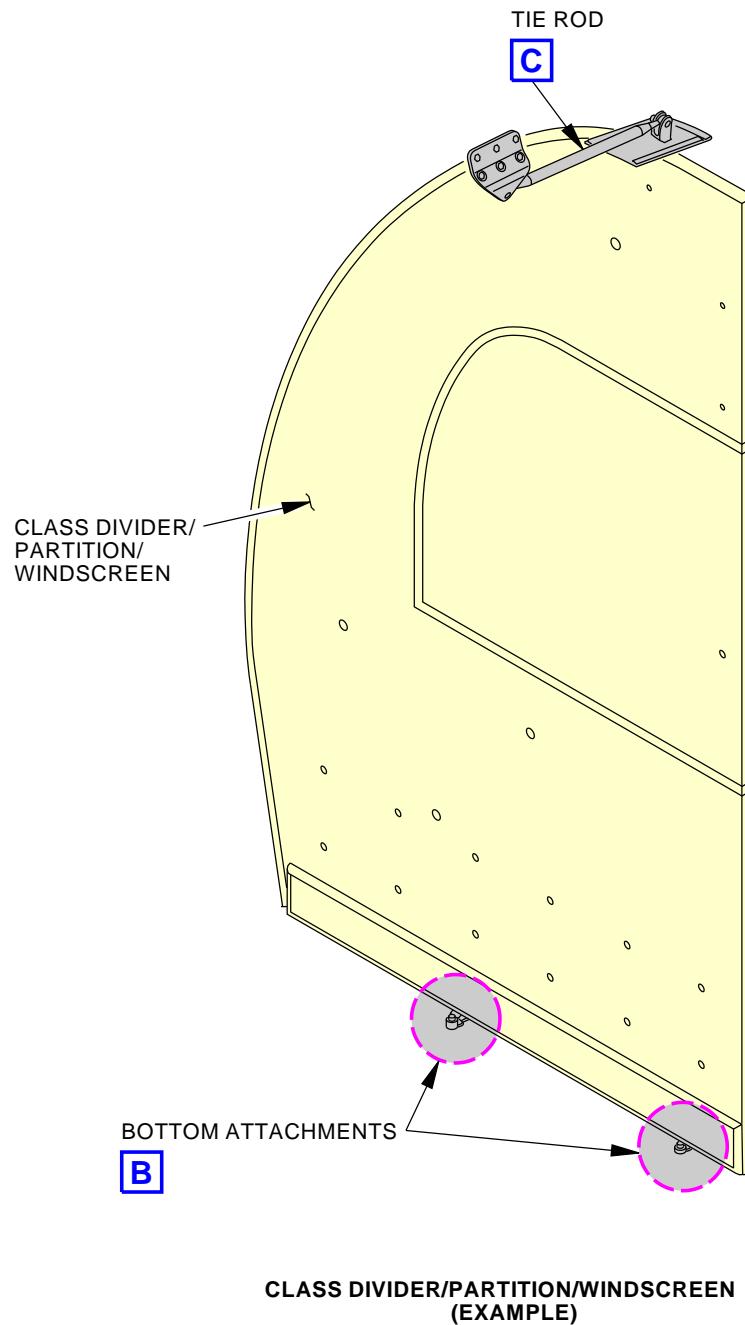
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CLASS DIVIDER/PARTITION/WINDSCREEN
(EXAMPLE)

2210510 S0000493079_V2

Fixed Class Divider Installation
Figure 401/25-24-15-990-805 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

D633A101-AKS

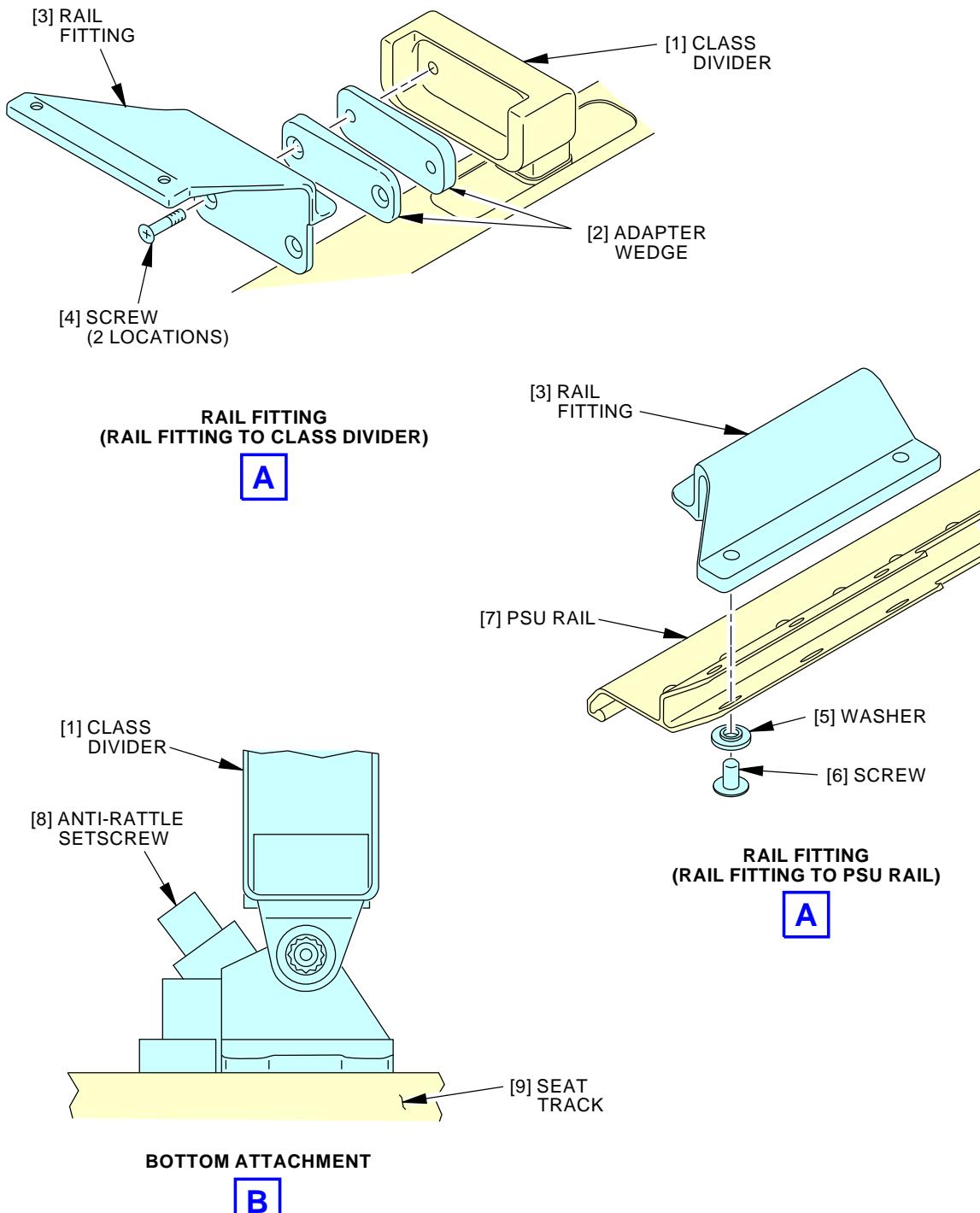
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AIRCRAFT MAINTENANCE MANUAL



2038893 S0000411389_V2

Fixed Class Divider Installation
Figure 401/25-24-15-990-805 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

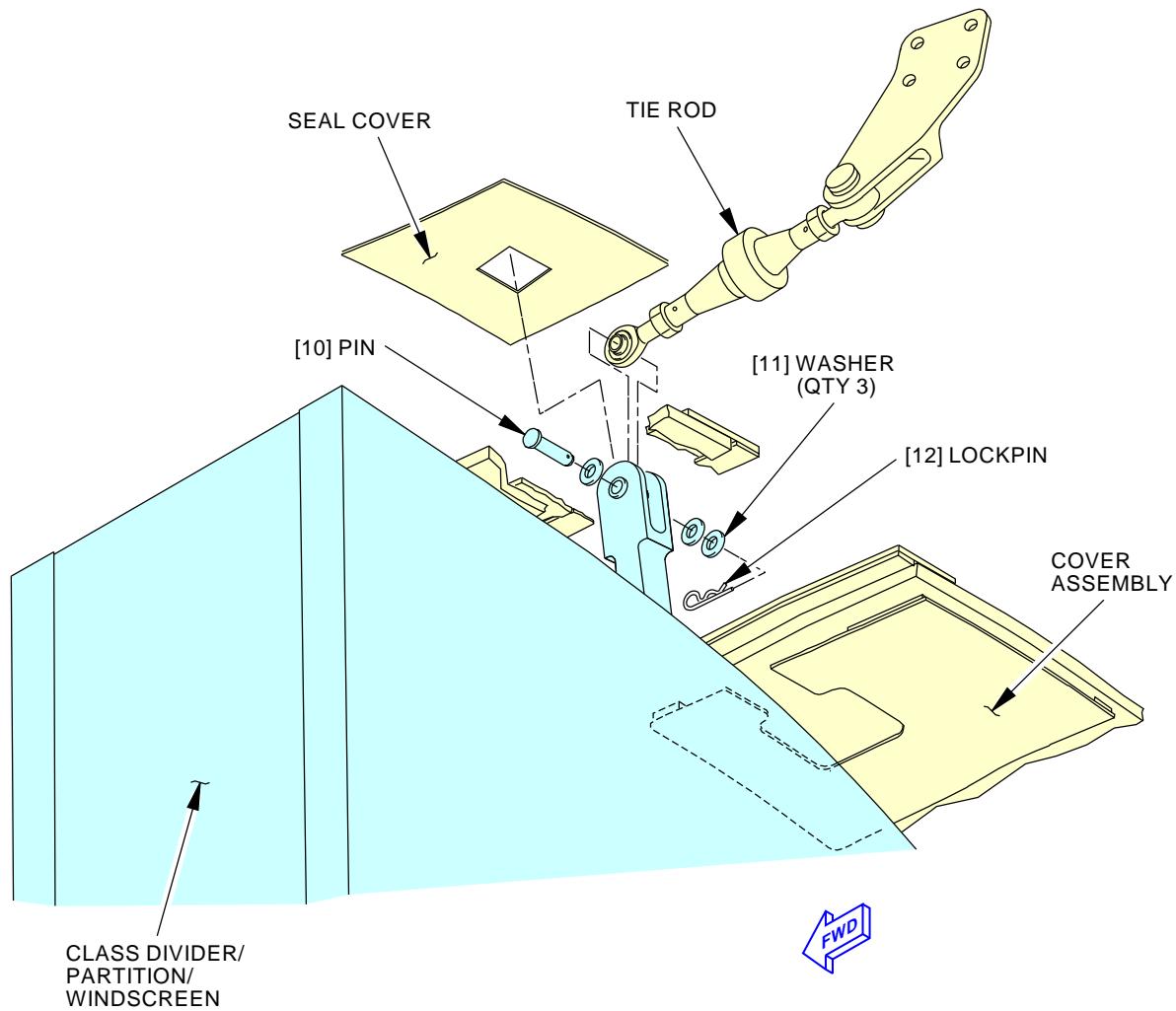
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WINDSCREEN TOP ATTACHMENT
(EXAMPLE)

C

2210557 S0000493080_V2

Fixed Class Divider Installation
Figure 401/25-24-15-990-805 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

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TASK 25-24-15-400-806

3. Fixed Class Divider - Installation

Figure 401

A. General

- (1) This task includes the steps to install the Fixed Class Divider.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Fixed Class Divider Installation

SUBTASK 25-24-15-400-001

- (1) To install the bottom attachment fittings, do these steps:
- Set the class divider [1] to the applicable location in the seat tracks [9].
 - Engage the shear plunger into the seat track [9].
 - Tighten the anti-rattle setscrew [8] to 30 ± 5 in-lb (3 ± 1 N·m).

SUBTASK 25-24-15-400-002

- (2) If applicable, do these steps to install the top attachment fitting:
- Attach the rail fitting [3] and the adapter wedges [2] to the class divider [1] with the screws [4].
 - Tighten the screws [4] to 35 in-lb (4 N·m).
 - Lower the PSU to get access the PSU rail [7].
 - Align the rail fitting [3] to the applicable location on the PSU rail [7].
 - Install the washers [5] and screws [6].
 - Tighten the screws [6] to 35 in-lb (4 N·m).

SUBTASK 25-24-15-420-036

- (3) If applicable, connect the tie rod:
- For assemblies with a lockpin, install the pin [10], washers [11], and lockpin [12].
 - Install the access covers, if applicable.

SUBTASK 25-24-15-420-037

- (4) If applicable, connect the electrical connectors.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-15-420-035

- (1) Lift the PSU to its initial position.

———— END OF TASK ———

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OVERHEAD STOWAGE BIN - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:

AKS 001-017, 019

- (1) Bin Assist Mechanism Activation

AKS 018, 020-999

- (2) Stowage Bin Lock Assembly Removal
(3) Stowage Bin Lock Assembly Installation

AKS ALL

- (4) Overhead Stowage Bin - Alternate Open Method

AKS 001-017, 019

TASK 25-24-31-440-801

2. Bin Assist Mechanism - Activation

A. General

- (1) This procedure gives instructions to activate the bin assist mechanism.

B. Activate the Bin Assist Mechanism

SUBTASK 25-24-31-440-001

- (1) To activate the bin assist mechanism, do these steps:

- (a) Turn the inboard edge of the bin bucket up 2°arc (0 rad) minimum.
(b) Use a hex wrench to tighten the bin assist screw. Tighten 20 in-lb (2 N·m) to 23 in-lb (3 N·m).

NOTE: The head of the screw will be 0.33 in. (8.38 mm) from the outer edge of the cover plate when correctly installed.

- (c) Push the assist mechanism lever.

NOTE: The assist will not activate until load is applied to the bucket.

- (d) Pull down on the threshold to apply load.

- 1) The bin assist will activate and start to pull the bin closed.

- 2) When assist is detected reapply load to threshold.

- 3) At the fully open position there should be two audible clicks.

NOTE: The assist is now reset.

- (e) The assist mechanism lever will be in its original position.

NOTE: The bin bucket will turn freely, open and closed, without activation of the assist.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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AKS 018, 020-999

TASK 25-24-31-000-803

3. Stowage Bin Lock Assembly - Removal

A. General

- (1) This task has instructions to remove the stowage bin lock assembly.
- (2) The lock assembly is located at the foremost and aftmost left or right hand stowage bin.

B. Location Zones

Zone	Area
------	------

200	Upper Half of Fuselage
-----	------------------------

C. Remove the Bin Lock Assembly

SUBTASK 25-24-31-010-005

- (1) Open the stowage bin door.

SUBTASK 25-24-31-020-039

- (2) Remove the screws that attach the torque tube cover to the threshold trim.

SUBTASK 25-24-31-020-040

- (3) Remove the screws from the torque tube cover.

SUBTASK 25-24-31-020-042

- (4) Remove the torque tube cover.

SUBTASK 25-24-31-020-043

- (5) Remove the screws that attach the lock assembly to the upper part of the latch bezel.

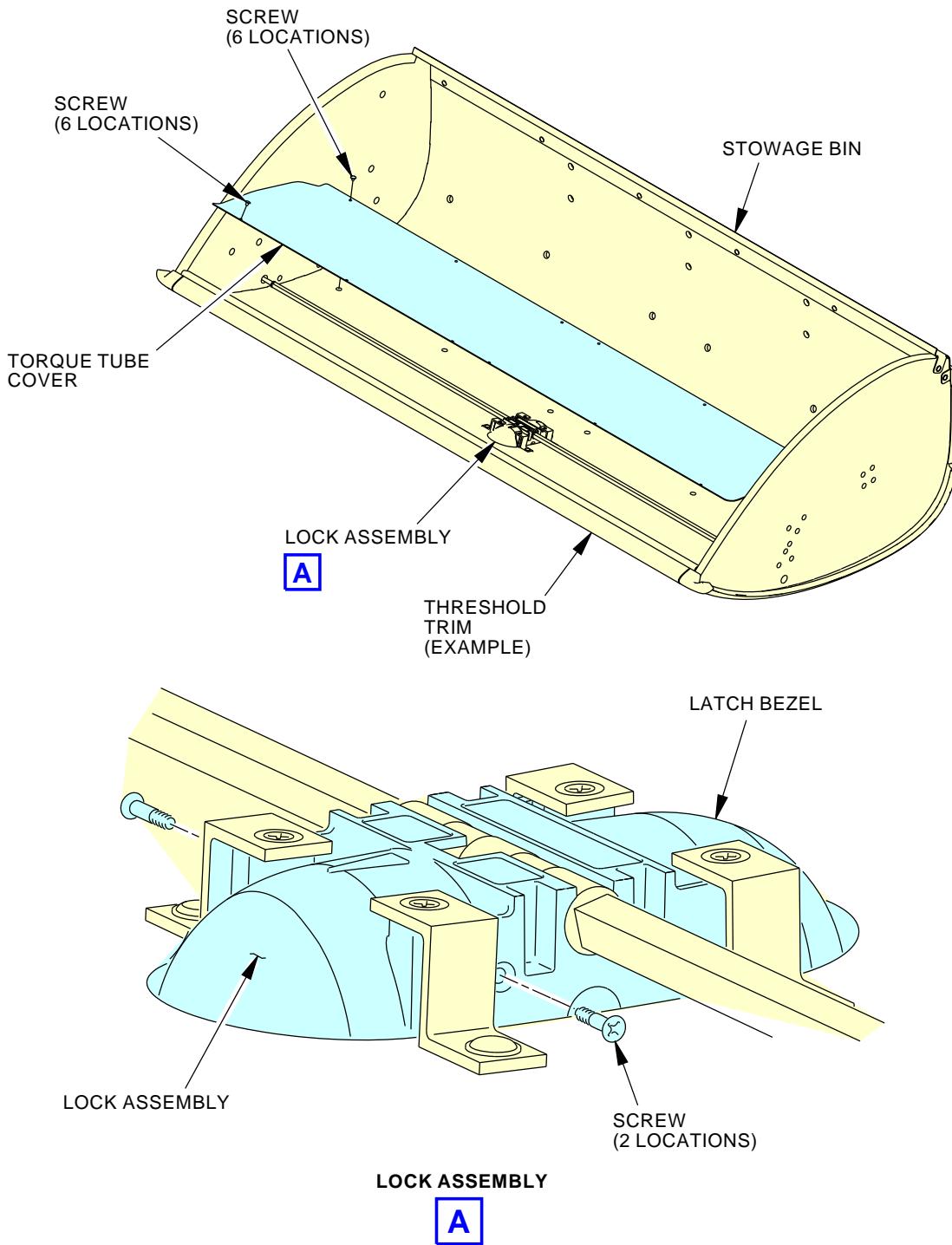
SUBTASK 25-24-31-020-044

- (6) Remove the lock assembly.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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2459792 S0000573023_V1

**Space Bin Lock Assembly Installation
Figure 201/25-24-31-990-809**

 EFFECTIVITY
 AKS 018, 020-999

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AIRCRAFT MAINTENANCE MANUAL

AKS 018, 020-999 (Continued)

TASK 25-24-31-400-805

4. Stowage Bin Lock Assembly - Installation

A. General

- (1) This task has instructions to install the stowage bin lock assembly.
- (2) The lock assembly is located at the foremost and aftmost left or right hand stowage bin.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the Bin Lock Assembly

SUBTASK 25-24-31-420-038

- (1) Put the lock assembly into its position on the upper part of the latch bezel.

SUBTASK 25-24-31-420-039

- (2) Install the screws through the latch bezel.
 - (a) Torque the screws to approximately 15 in-lb (1.69 N·m).

SUBTASK 25-24-31-420-040

- (3) Put the torque tube cover in its position.

SUBTASK 25-24-31-420-041

- (4) Install the screws that attach the torque tube cover.
 - (a) Torque the screws to approximately 15 in-lb (1.69 N·m).

SUBTASK 25-24-31-410-005

- (5) Close the stowage bin door.

AKS ALL

———— END OF TASK ————

TASK 25-24-31-820-801

5. Overhead Stowage Bin - Alternate Open Method

A. General

- (1) This task opens the overhead stowage bin with a malfunctioning latch.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-24-31-820-003

- (1) Depress the black lever on each end latch to override the mechanism.

SUBTASK 25-24-31-820-004

- (2) Replace or adjust latch if it is necessary.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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OVERHEAD STOWAGE BIN - REMOVAL/INSTALLATION

1. General

- A. The procedure has these tasks:

NOTE: The strongback assembly will be called the overhead stowage bin module in these procedures.

AKS 001-017, 019

- (1) Removal of the overhead stowage bin
(2) Installation of the overhead stowage bin

AKS 018, 020-999

- (3) Removal of the space bin.
(4) Installation of the space bin.

AKS ALL

- (5) Removal of the overhead stowage bin module
(6) Installation of the overhead stowage bin module

AKS 001-017, 019

TASK 25-24-31-000-801-001

2. Overhead Stowage Bin - Removal

Figure 401

A. References

Reference	Title
25-22-00 P/B 401	PASSENGER SEATS - REMOVAL/INSTALLATION

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-13897	Release Key - Pivot Bin Snubber, Boeing Sky Interior Part #: ST1066RB-1 Supplier: 81205

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. General

NOTE: It is recommended that two maintenance personnel do the removal of the overhead stowage bin.

E. Prepare for the Removal

SUBTASK 25-24-31-010-004-001

- (1) Do the applicable task in this procedure if it is necessary: PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-22-00/401

SUBTASK 25-24-31-020-033-001

- (2) Open the stowage bin.

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AKS 001-017, 019 (Continued)

F. Remove the Stowage bin

SUBTASK 25-24-31-020-034-001

- (1) Remove the close out cloth from the bin bucket assembly:
 - (a) Carefully use a small flat blade screwdriver to release the closeout cloth clips.
 - (b) Lift the flap on the closeout cloth
 - (c) Pull the rod from the attach clips.

SUBTASK 25-24-31-020-035-001

- (2) Loosen the bin assist screw if it is installed.
 - (a) Use an allen wrench to loosen the screw.

SUBTASK 25-24-31-020-036-001

WARNING: HOLD THE STOWAGE BIN BUCKET TIGHTLY. IF IT TURNS, IT WILL DISENGAGE FROM THE PIVOT FITTING. INJURIES TO PERSONNEL CAN OCCUR.

- (3) Disconnect the lower end of the rate control snubber from each side of the stowage bin.
 - (a) Pull down the bin bucket and hold the stowage bin tightly.
 - (b) Make sure that the rate control snubber is fully extended.
 - (c) Put the release key, SPL-13897, or 1/16th inch Standard Allen Wrench into the rate control fitting.
NOTE: The tool should stop at the internal pin releasing the spring clip.
 - (d) Move the rate control snubber away from the tool until the snubber disengages from the rate control receiver.
 - (e) Remove the tool.

SUBTASK 25-24-31-020-037-001

- (4) Turn the bin bucket assembly downward 10.0°arc (0.2 rad).

SUBTASK 25-24-31-020-038-001

- (5) Pull the bin bucket assembly from the module.

NOTE: The bin bucket pivot must disengage from the support assembly pivot.

———— END OF TASK ————

TASK 25-24-31-400-803-001

3. Overhead Stowage Bin - Installation

Figure 401

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Install the Stowage Bin

SUBTASK 25-24-31-420-031-001

- (1) Put the stowage bin in its correct position.

SUBTASK 25-24-31-420-032-001

- (2) Raise the stowage bin slightly to align the pivot halves.



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AKS 001-017, 019 (Continued)

SUBTASK 25-24-31-420-033-001

- (3) Turn the stowage bin up approximately 10 degrees until the pivot halves fully engage.

SUBTASK 25-24-31-420-034-001

- (4) Tighten the bin assist if it is installed.

- (a) Use a hex wrench to tighten the bin assist screw. Tighten 20 in-lb (2 N·m) to 23 in-lb (3 N·m).

SUBTASK 25-24-31-420-035-001

- (5) Make sure that the rate control snubber is fully extended.

SUBTASK 25-24-31-420-036-001

- (6) Install the rate control snubber to the rate control receiver on the stowage bin.

SUBTASK 25-24-31-420-037-001

- (7) Install the closeout cloth to the bin bucket:

- (a) Push the rod into the attach clips on the bin bucket.
(b) Fold down the flap and fully engage the hook and loop strips to the bin bucket.

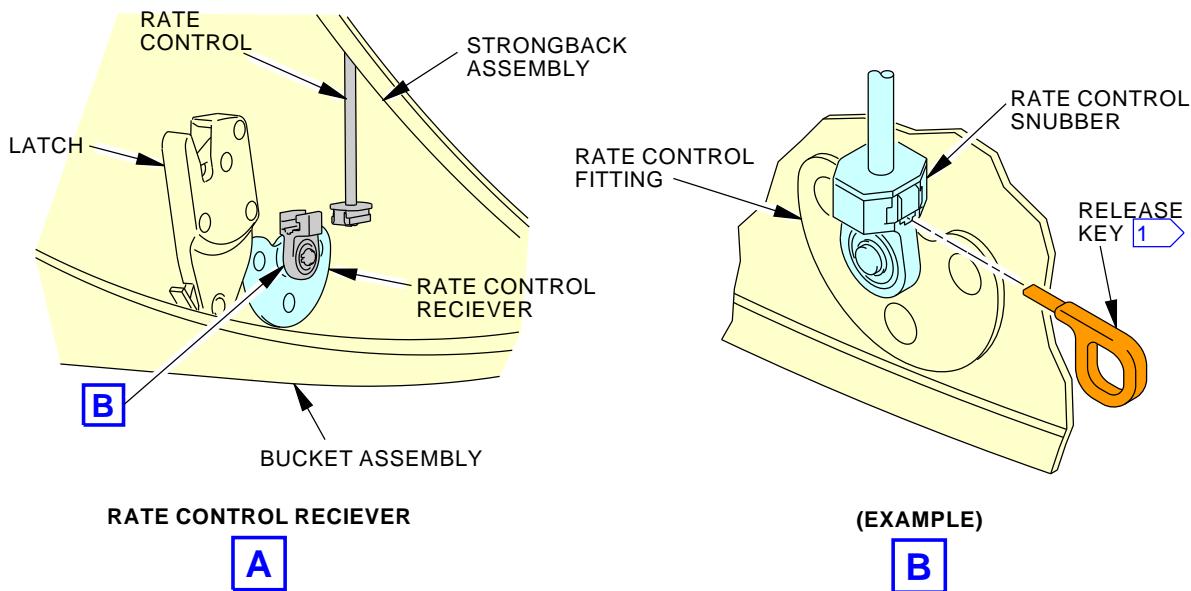
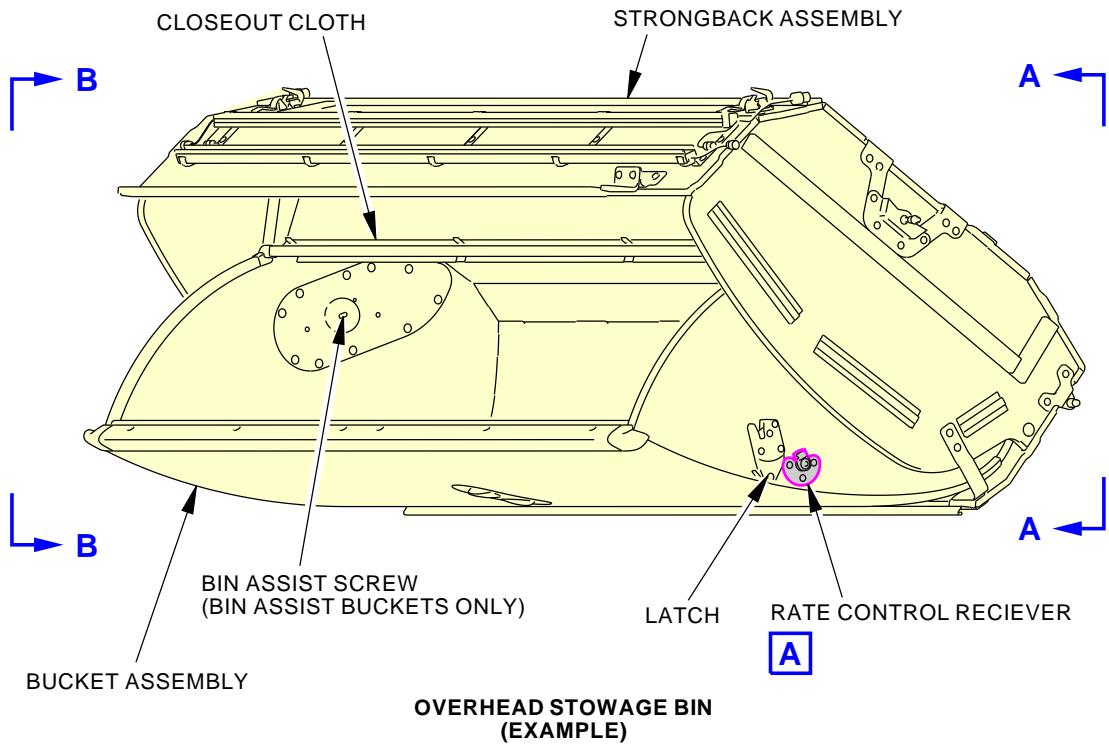
———— END OF TASK ————

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AKS ALL

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1 RELEASE KEY SPL-13897, OR 1/16TH INCH STANDARD ALLEN WRENCH.

2035878 S0000408424_V3

Overhead Stowage Bin Installation
Figure 401/25-24-31-990-807 (Sheet 1 of 2)

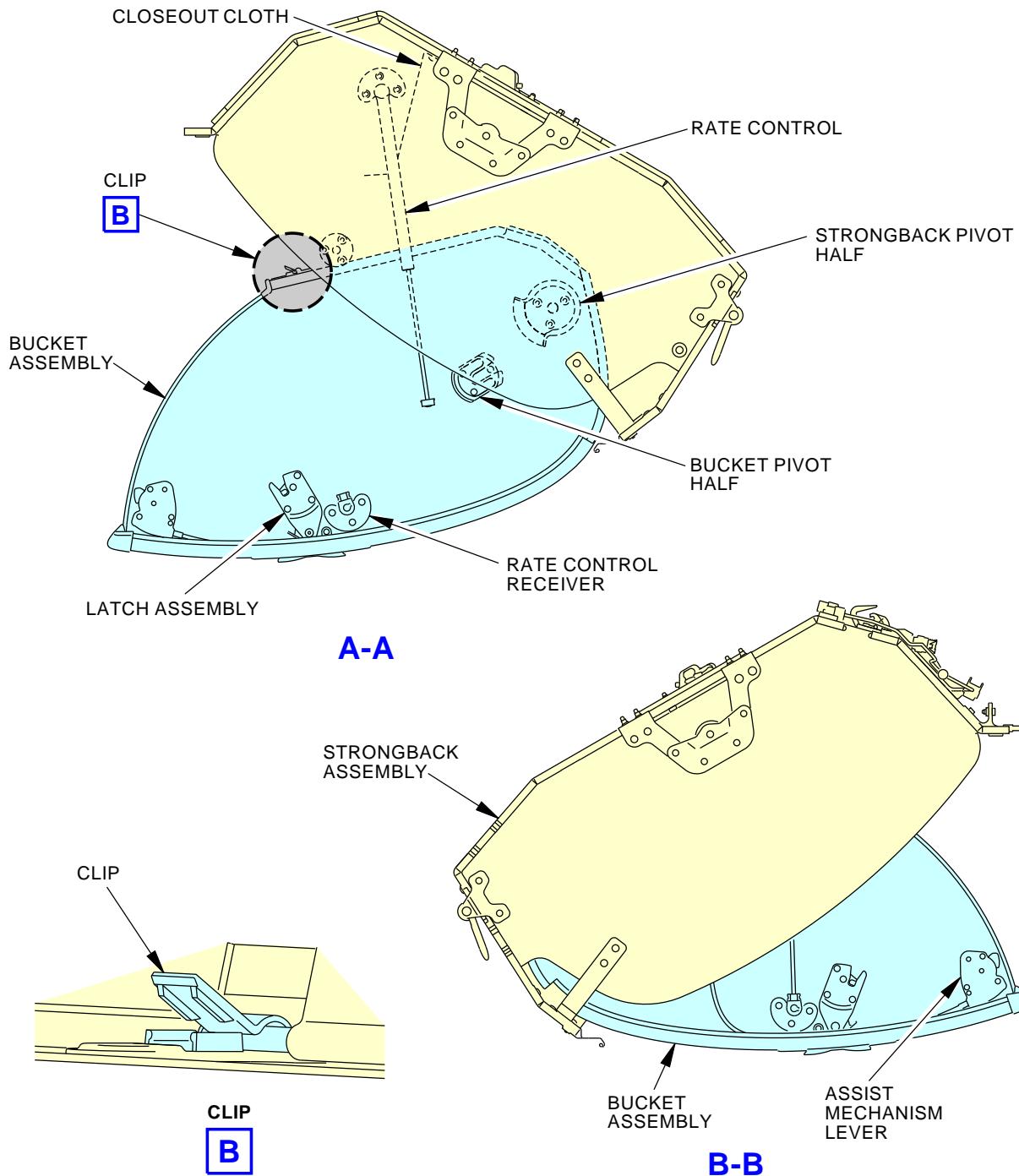
EFFECTIVITY
AKS 001-017, 019

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2035879 S0000408426_V2

Overhead Stowage Bin Installation
Figure 401/25-24-31-990-807 (Sheet 2 of 2)

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 AKS 001-017, 019

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AKS 018, 020-999

TASK 25-24-31-000-804-001

4. Space Bin - Removal

A. General

- (1) This task includes the steps to remove the Boeing Sky Interior (BSI) space bins.

NOTE: It is recommended to use two persons when removing the space bins.

B. Tools/Equipment

Reference	Description
STD-1101	Wrench - Hexagonal, 7/64 Inch, Long Shaft

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Remove the Space Bin

SUBTASK 25-24-31-010-006-001

- (1) Open the bin to gain access to the rate control snubbers and rate control receivers..

SUBTASK 25-24-31-000-008-001

- (2) Disengage the snubber ends from the rate control receivers on the bucket with a 7/64 inch long shaft hexagonal wrench, STD-1101.

NOTE: The second person must hold the space bin bucket assembly in position while the snubber ends are being removed.

SUBTASK 25-24-31-980-001-001

- (3) Turn the bin downward at a 10°arc (0.2 rad).

SUBTASK 25-24-31-000-009-001

- (4) Pull the bin bucket assembly inboard from the module (strongback).

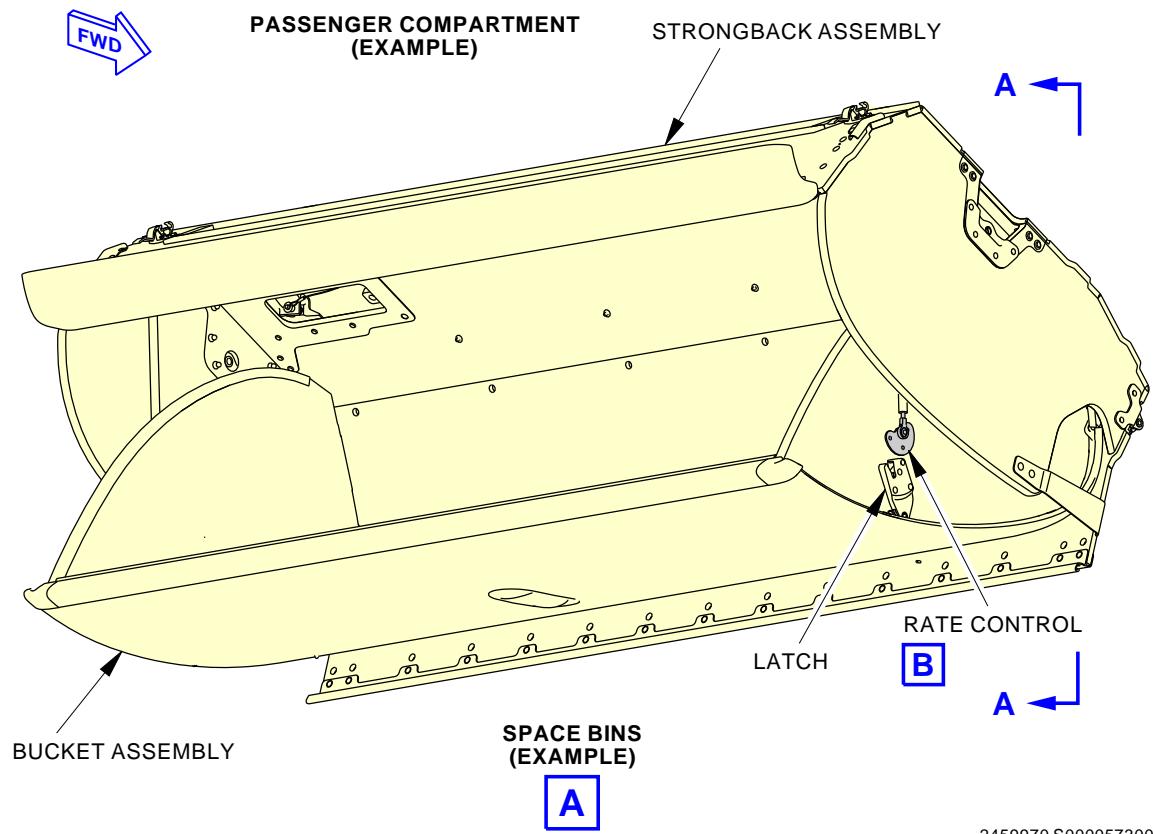
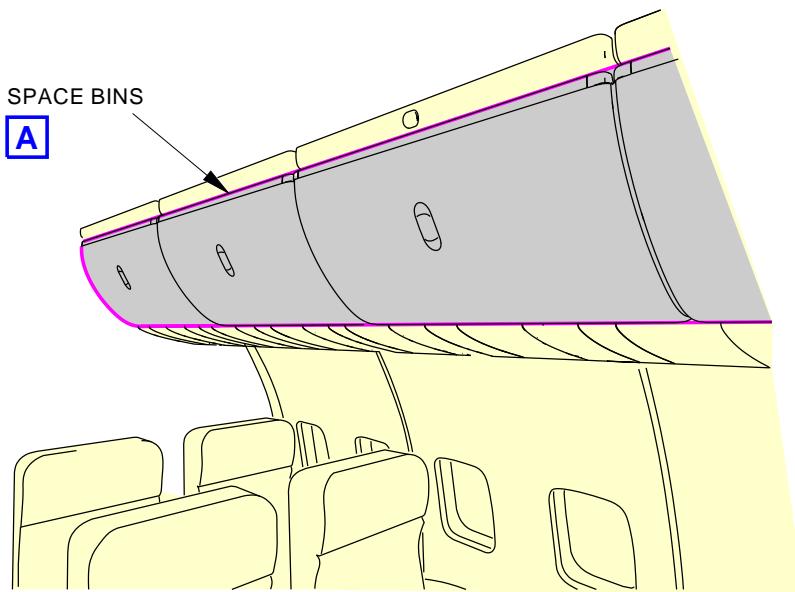
NOTE: The bin bucket pivot must disengage from the support assembly pivot.

———— END OF TASK ————

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AKS ALL



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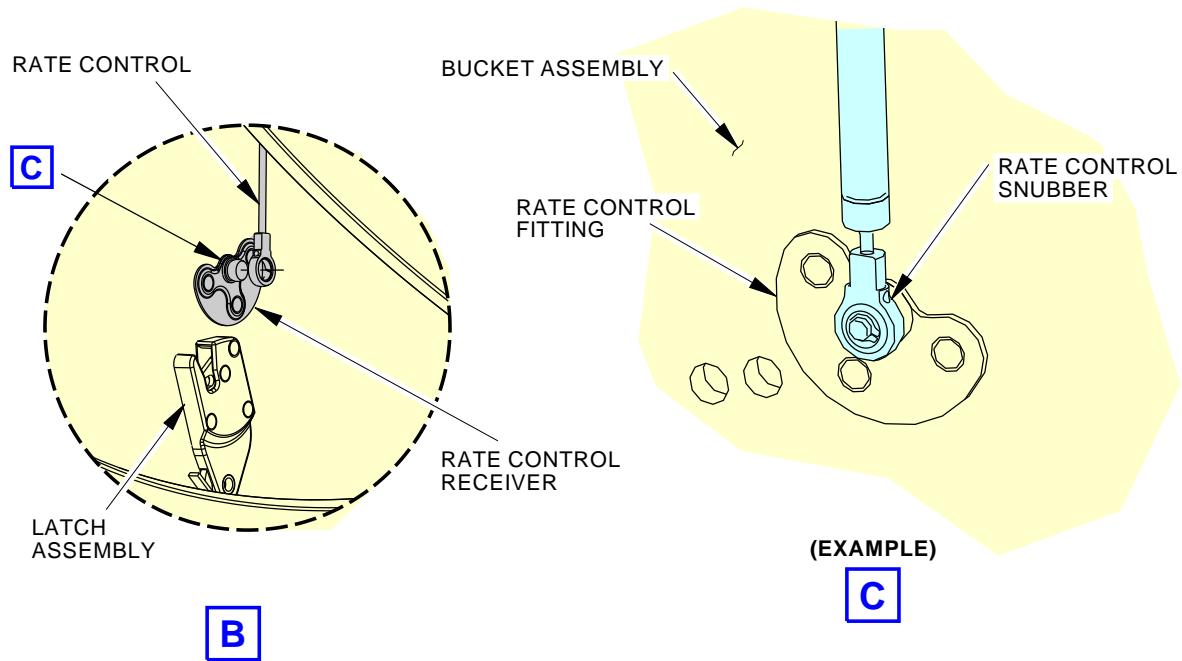
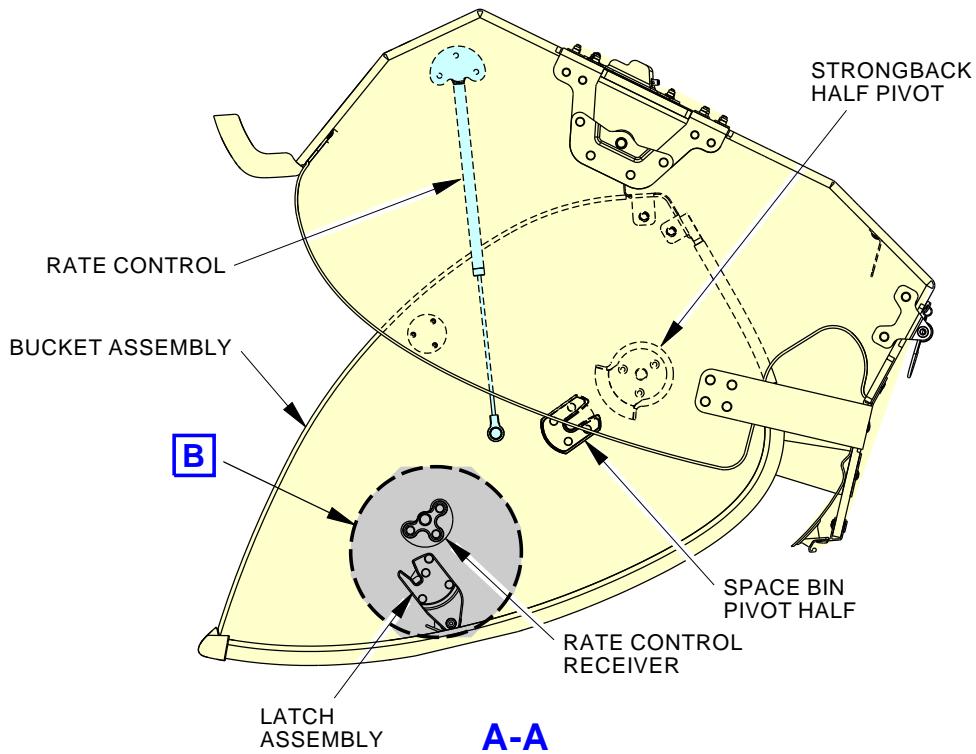
Space Bin Installation
Figure 402/25-24-31-990-810-001 (Sheet 1 of 2)

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Space Bin Installation
Figure 402/25-24-31-990-810-001 (Sheet 2 of 2)

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AKS 018, 020-999 (Continued)

TASK 25-24-31-400-806-001

5. Space Bin - Installation

A. General

- (1) This task includes the steps to install the Boeing Sky Interior (BSI) Space Bins.

NOTE: It is recommended to use two persons when installing the space bins.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the Space Bin

SUBTASK 25-24-31-540-001-001

- (1) Remove the rate controls from their stored position.
(a) Extend the rate control snubbers to their full extension.

SUBTASK 25-24-31-820-005-001

- (2) Raise the space bin and align the space bin assembly in the correct position in the bin module.

SUBTASK 25-24-31-400-008-001

- (3) Lift the space bin up and push outboard toward the bin module to align the pivot halves.

SUBTASK 25-24-31-980-002-001

- (4) Turn the space bin up approximately 10°arc (0.2 rad) until the pivot halves fully engage.

SUBTASK 25-24-31-400-009-001

- (5) Install the rate control snubber end to the rate control receiver.
(a) Place the snubber over the post on the bucket rate control receiver and apply pressure.

SUBTASK 25-24-31-980-003-001

- (6) Make sure the space bin opens and closes properly.

NOTE: It is acceptable for the bin to open slowly or to not open completely when empty.

AKS ALL

———— END OF TASK ————

TASK 25-24-31-000-802-001

6. Overhead Stowage Bin Module - Removal

Figure 403

A. References

Reference	Title
25-21-45-000-803-001	Main Ceiling Panel - Removal (P/B 401)
25-23-61-000-804	Passenger Service Unit - Removal (P/B 401)
35-00-00-420-801	Installation of Caps on Open Oxygen Lines (P/B 201)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)
35-00-00-910-802	Safety Precautions (P/B 201)



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B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-31-910-001-001

- (1) When you do maintenance to the Oxygen Systems, you must read or fully know the precautions and general instructions below:
 - (a) Follow the safety precautions.
 - 1) Do this task: Safety Precautions, TASK 35-00-00-910-802.
 - (b) Follow the general maintenance practices.
 - 1) Do this task: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801.
 - (c) Follow the procedure for the installation of the caps on the open oxygen lines.
 - 1) Do this task: Installation of Caps on Open Oxygen Lines, TASK 35-00-00-420-801.

SUBTASK 25-24-31-040-001-001

- (2) To prevent the activation of the Emergency Lighting System, do these steps:
 - (a) At the overhead panel P5, set the EMER LIGHTS switch to OFF.
 - 1) Attach a DO-NOT-OPERATE tag on the switch.
 - (b) On the master attendant switch panel (ASP), on the attendant seat headrest at door 1L or 2L (if applicable), make sure that the EMER LIGHTS switch is OFF (red LED on the switch is OFF).
 - 1) Attach a DO-NOT-OPERATE tag on the switch.

SUBTASK 25-24-31-020-022-001

- (3) Remove the ceiling panels adjacent to the stowage bin modules.
 - (a) Do this task: Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

SUBTASK 25-24-31-020-023-001

- (4) Remove the bin bucket from the stowage bin module.
 - (a) Do this task: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001

D. Stowage Bin Module Removal

SUBTASK 25-24-31-020-024-001

- (1) Remove the Passenger Service Units, if applicable.
 - (a) Do this task: Passenger Service Unit - Removal, TASK 25-23-61-000-804.

SUBTASK 25-24-31-020-025-001

- (2) Remove the applicable PSU oxygen equipment, if applicable.

SUBTASK 25-24-31-020-028-001

- (3) To remove the PSU wire bundles from the applicable stowage bin module, do these steps:
 - (a) Disconnect the electrical connector from the applicable PSU equipment.
 - (b) Remove the screws to disconnect the wire-bundle electrical connector from the stowage bin module.
 - 1) Disconnect the electrical connector from the aft-attached wire bundle.
 - (c) Disconnect the from the forward-attached wire bundle.





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- (d) Remove the clips to disconnect the PSU wire bundles from the stowage bin module.
- (e) Remove and keep the PSU wire bundles.

SUBTASK 25-24-31-020-029-001

- (4) Disconnect the wire-bundle electrical connectors from the adjacent lighting wire bundles.

SUBTASK 25-24-31-020-030-001

- (5) Remove the clamps to disconnect the air distribution ducts from the outboard stowage bin plenums.

SUBTASK 25-24-31-020-031-001

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY.
INJURIES TO PERSONS CAN OCCUR.

- (6) To remove the stowage bin module from the constant section of the airplane, do the applicable steps:

- (a) Remove the quickpins to disconnect the stowage bin module from the tie rods.

NOTE: The quickpins are at the upper and the lower 9G tie rod attachments. The attachments are located at the forward fittings on the stowage bin module.

- (b) Remove the quickpins to disconnect the outboard end of the stowage bin module from the outboard attachment brackets.

NOTE: The outboard end of the stowage bin module will move into the passenger cabin.

NOTE: The quickpins are shared between two adjacent stowage bin modules. In order to give support to the adjacent stowage bin module, it is necessary to install the quickpins.

- (c) Remove the quickpins to disconnect the stowage bin module from the tie rods.

- (d) Remove the quickpins to disconnect the inboard end of the stowage bin module from the inboard attachment brackets.

NOTE: The quickpins are shared between two adjacent stowage bin modules. In order to give support to the adjacent stowage bin module, it is necessary to install the quickpins.

- (e) Remove the stowage bin module.

SUBTASK 25-24-31-020-032-001

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY.
INJURIES TO PERSONS CAN OCCUR.

- (7) To remove a stowage bin module that is adjacent to a transition module, do these steps:

- (a) For the stowage bin module that is forward of the transition module, do these steps:

- 1) Remove the quickpins from the strut.

NOTE: The outboard end of the stowage bin module will move into the passenger cabin.

NOTE: This is a quickpin that is shared between the stowage bin module and the transition module. In order to give support to the transition module, it is necessary to install the quickpins.

- 2) Remove the quickpins from the support bridge.

- 3) Remove the stowage bin module.

- (b) For the stowage bin module that is aft of the transition module, do these steps:

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- 1) Remove the quickpins from the struts.

NOTE: The outboard end of the stowage bin module will move into the passenger cabin.

NOTE: This is a quickpin that is shared between the stowage bin module and the transition module. In order to give support to the transition module, it is necessary to install the quickpins.

- 2) Remove the stowage bin module.

————— END OF TASK ————

TASK 25-24-31-400-804-001

7. Overhead Stowage Bin Module - Installation

Figure 403

A. References

Reference	Title
25-21-45-400-803-001	Main Ceiling Panel - Installation (P/B 401)
25-23-61-400-804	Passenger Service Unit - Installation (P/B 401)
35-00-00-910-801	Oxygen System General Maintenance Practices (P/B 201)
35-00-00-910-802	Safety Precautions (P/B 201)

B. Prepare for the Installation

SUBTASK 25-24-31-910-002-001

WARNING: MAKE SURE YOU OBEY ALL LOCAL SAFETY PROCEDURES BEFORE YOU DO WORK ON THE GASEOUS OXYGEN SYSTEM. THIS WILL PREVENT INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (1) When you do maintenance to the Passenger Oxygen Systems, you must read or fully know the precautions and general instructions below:
 - (a) Follow the safety precautions.
 - 1) Do this task: Safety Precautions, TASK 35-00-00-910-802.
 - (b) Follow the general maintenance practices.
 - 1) Do this task: Oxygen System General Maintenance Practices, TASK 35-00-00-910-801

C. Outboard Stowage Bin Module Installation

SUBTASK 25-24-31-420-020-001

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.

- (1) To install the stowage bin module in the constant section of the airplane, do these steps:
 - (a) Put the inboard end of the stowage bin module in its position on the inboard attachment brackets.
 - 1) Install the quickpins to connect the inboard end of the stowage bin module to the inboard attachment brackets.
 - (b) Turn the outboard end of the stowage bin module into its position.
 - 1) Install the quickpins to connect the outboard end of the stowage bin module to the outboard attachment brackets.
 - (c) Install the quickpins to connect the tie rods to the stowage bin module.





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SUBTASK 25-24-31-420-021-001

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY.
INJURIES TO PERSONS CAN OCCUR.

- (2) To install a stowage bin module that is adjacent to a transition module, do these steps:
 - (a) For the stowage bin module that is forward of the transition module, do these steps:
 - 1) Put the inboard end of the stowage bin module in its position on the support bridge.
 - a) Install the quickpins.
 - 2) Turn the outboard end of the stowage bin module into its position.
 - a) Install the quickpins.
 - (b) For the stowage bin module that is aft of the transition module, do these steps:
 - 1) Put the inboard end of the stowage bin module in its position on the upper attachment bracket.
 - a) Install the quickpins at the upper attachment bracket.
 - b) Install the quickpins for the tie rods.
 - 2) Turn the outboard end of the stowage bin module into its position.
 - a) Install the quickpins.

SUBTASK 25-24-31-420-022-001

- (3) Make sure that the air distribution ducts are connected correctly to the plenums on the outboard stowage bin.
 - (a) Install the clamps to attach the air distribution ducts to the plenums on the outboard stowage bin.

SUBTASK 25-24-31-420-023-001

- (4) Connect the electrical connectors for the lighting-wire bundle to the adjacent lighting-wire bundles.

SUBTASK 25-24-31-420-024-001

- (5) To install the PSU wire bundles in the applicable stowage bin module, do these steps:
 - (a) Install the clips to connect the PSU wire bundles to the stowage bin module.
 - (b) Connect the electrical connector from the forward-attached wire bundle.
 - (c) Connect the electrical connector from the aft-attached wire bundle.
 - (d) Install the screws to connect the wire-bundle electrical connector.
 - (e) Connect the wire-bundle electrical connector to the applicable PSU equipment.

SUBTASK 25-24-31-420-026-001

- (6) Install the passenger air outlets if applicable.
 - (a) Do this task: Passenger Service Unit - Installation, TASK 25-23-61-400-804

SUBTASK 25-24-31-420-028-001

- (7) Install the applicable PSU oxygen equipment.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-31-420-029-001

- (1) Install the bin bucket in the stowage bin module.
 - (a) Do this task: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001.



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SUBTASK 25-24-31-420-030-001

- (2) Install the main ceiling panels that were removed for access.
 - (a) Do this task: Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

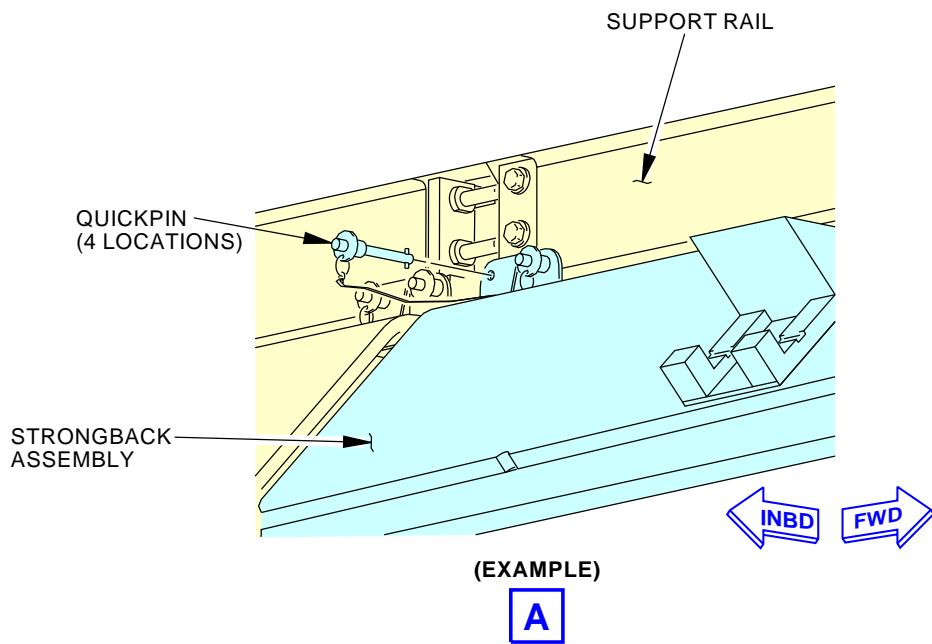
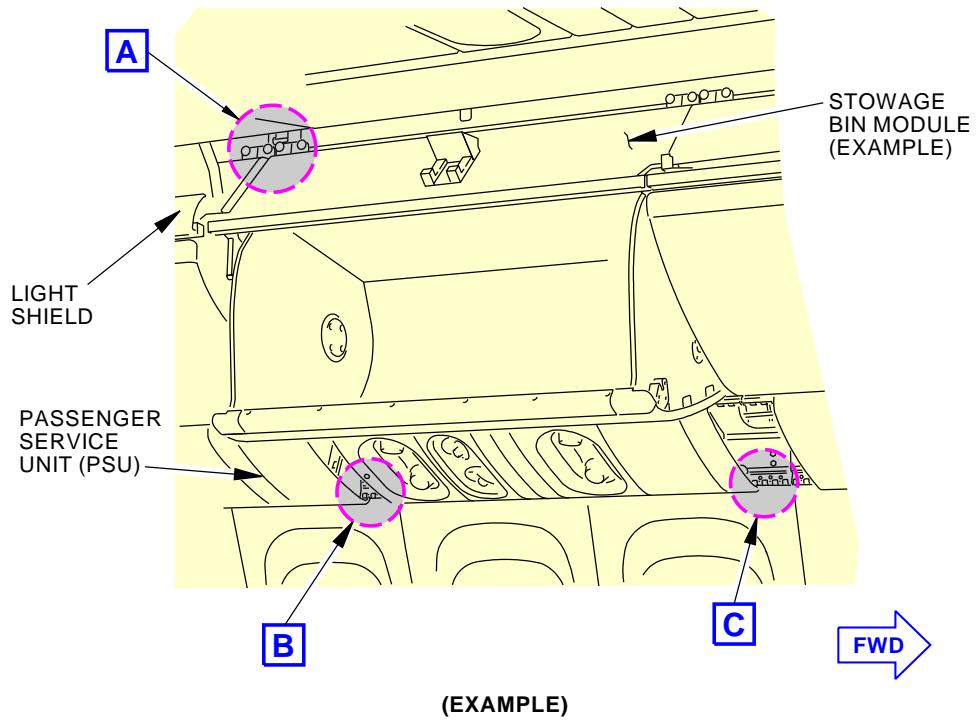
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— EFFECTIVITY —
AKS ALL

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**Overhead Stowage Bin Module Installation
Figure 403/25-24-31-990-806 (Sheet 1 of 2)**

EFFECTIVITY
AKS ALL

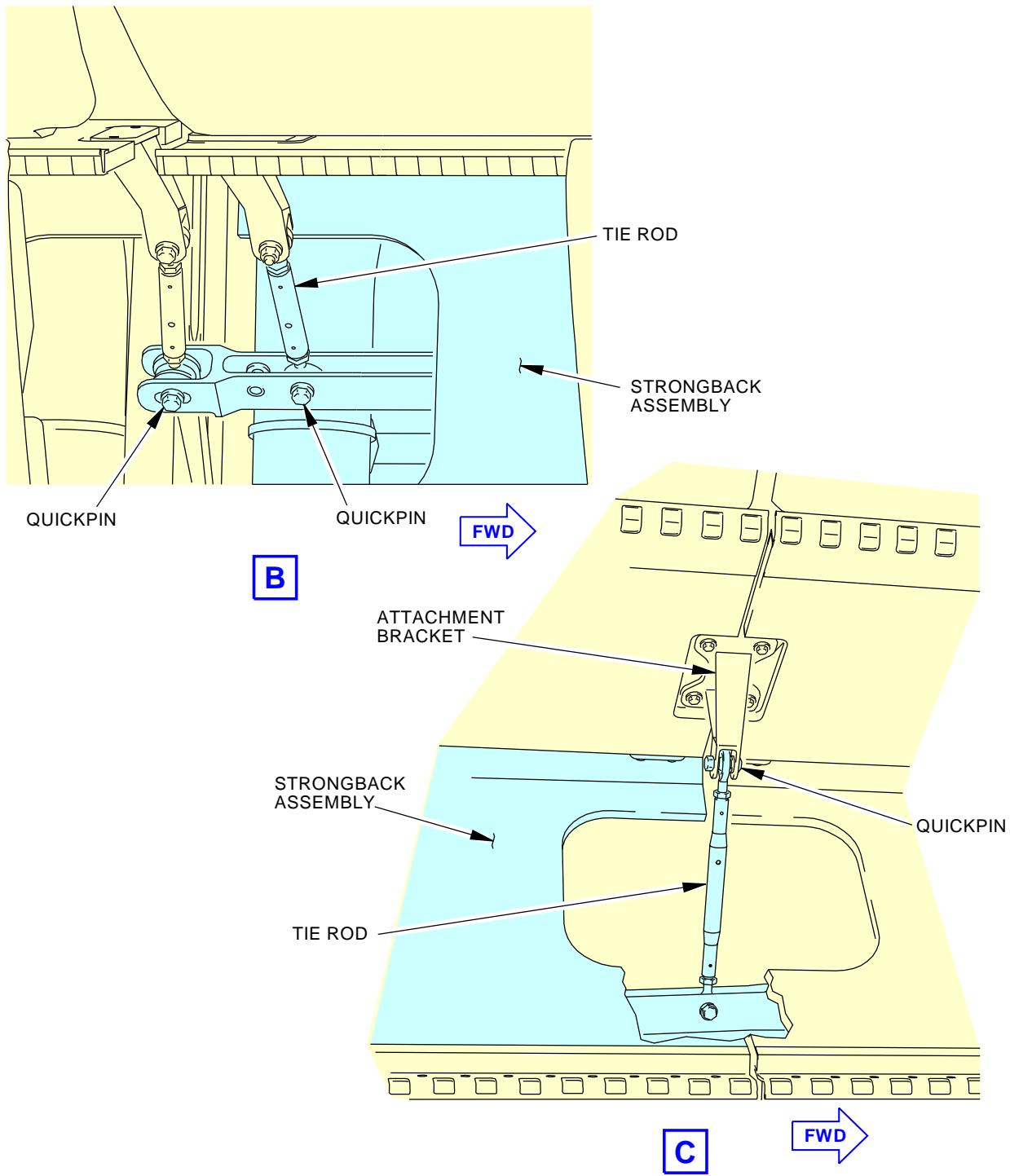
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Overhead Stowage Bin Module Installation
Figure 403/25-24-31-990-806 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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OVERHEAD STOWAGE BIN DOOR - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Overhead Stowage Bin Door Latch Assembly Removal
 - (2) Overhead Stowage Bin Door Latch Assembly Installation
 - (3) Overhead Stowage Bin Door Latch Assembly Adjustment.

TASK 25-24-36-000-803

2. Overhead Stowage Bin Latch Assembly Removal

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-24-36-020-016

- (1) Do these steps to remove the bin latch assembly: Figure 201.
 - (a) Remove the screws [1], [2] from the torque tube cover [3].
 - (b) Remove the cap screws [15] and washers [14] from the Morse taper [13] on the end latch assembly.
 - (c) Gently remove the universal [11] from the Morse taper [13].
 - (d) Slide the universal [11] through the holes of the end latch and bin.
 - (e) Remove the torque tubes [4] from the center latch [12] and slide through the same end latch and bin holes.
 - 1) Do the same to remove the opposite torque tube [4].
 - (f) Remove the screws [5] from the support brackets [6].
 - (g) Remove the center latch [12].

———— END OF TASK ————

TASK 25-24-36-400-804

3. Overhead Stowage Bin Latch Assembly Installation

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-13625	Slide hammer for component removal (1 lb) Part #: CG240-8 Supplier: 55719 Part #: CG240-9 Supplier: 5K761

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
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C. Procedure

SUBTASK 25-24-36-420-025

- (1) Do these steps to install the latch assembly: Figure 201.

- (a) Slide the center latch [12] through the hole in the center of the bin.

NOTE: Make sure the arrow molded into the back of the center latch [12] is pointed toward the upper edge of the bin.

- (b) Align each support bracket [6] with its associated insert on the back of the center latch [12].

- (c) Install the screws [5] to install the support brackets [6] but do not tighten.

- (d) Slide the torque tube [4] through the bin hole and end latch hole.

- (e) Slide the torque tube [4] into the square hole in the center latch [12].

- (f) Slide the universal [11] through the same hole and into the torque tube [4].

- (g) Install the universal [11] into the Morse taper [13].

- (h) Install the cap screw [15] and washer [14] to the Morse taper [13] but do not tighten.

- (i) Do the same to install the opposite torque tube [4] and universal [11].

- (j) Make sure the center latch [12] is centered in the bin.

AKS 018, 020-999

- 1) Torque the screws [5] on the support brackets [6] to 15 in-lb (1.69 N·m).

AKS 001-017, 019

- 2) Torque the screws [5] on the support brackets [6] to 10 in-lb (1.13 N·m)

AKS ALL

- (k) Make sure both end latches are latched.

- 1) Insert a screwdriver into the open strike in the end latch and push toward the face of the bin. A black tab will pop up that indicates the mechanism is latched.

- (l) Use a slide hammer puller, COM-13625 to gently tap the universal [11] into the Morse taper and into the mating part of the end latch.

NOTE: Use care not to scratch the surface of the torque tube [4] or the inside of the bin face.

- 1) Remove any looseness by very gently rotating the torque tube [4] toward you (as you face the bin).

- (m) Do the same to the opposite universal [11] and torque tube [4].

- (n) Make sure the door latches correctly.

- 1) Pull the handle in the center latch assembly. The bin should unlatches satisfactorily.

- 2) If the bin does not unlatch satisfactorily, gently unseat the universal [11] from the taper [13] and start again from step (3) (k) above.

- (o) Keep the torque tube [4] from rotating and tighten the cap screws [15] on both universals [11] to 15 in-lb (1.7 N·m).

- (p) Install the torque tube cover [3] with the screws [1], [2].

AKS 018, 020-999

- 1) Torque screws [1] and screws [3] to approximately 15 in-lb (1.69 N·m).

EFFECTIVITY
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AKS 001-017, 019

- 2) Torque screws [1] and screws [3] to approximately 10 in-lb (1.13 N·m).

AKS ALL

———— END OF TASK ————

TASK 25-24-36-820-802

4. Overhead Stowage Bin Door Adjustment - Closed Position

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-24-36-280-001

- (1) Open the stowage bin door [1].

SUBTASK 25-24-36-010-007

- (2) Loosen the screws [7] or [10] until you can move the door relative to the hinges.

NOTE: There are two hinges. Each hinge has four screws.

SUBTASK 25-24-36-410-002

- (3) Close the stowage bin door.

SUBTASK 25-24-36-820-005

- (4) Adjust the position of the stowage bin door until it meets these conditions:

(a) The stowage bin door [1] is aligned with the other stowage bin doors.

(b) There is approximately the same space at each end of the stowage bin door.

SUBTASK 25-24-36-420-017

- (5) Open the stowage bin door.

NOTE: Be careful not to move the door on the hinges.

SUBTASK 25-24-36-420-018

- (6) Tighten the eight screws [7] or [10].

SUBTASK 25-24-36-820-006

- (7) Close the stowage bin door.

(a) Make sure it closes correctly.

———— END OF TASK ————

TASK 25-24-36-820-803

5. Overhead Stowage Bin Door Adjustment - Open Position

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-24-36-280-002

- (1) Open the stowage bin door [1].

SUBTASK 25-24-36-010-010

- (2) Open the stowage bin doors adjacent to the door you will adjust.



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SUBTASK 25-24-36-410-003

- (3) Adjust the set screws that are above the hinge pins until the door is aligned with the adjacent doors.

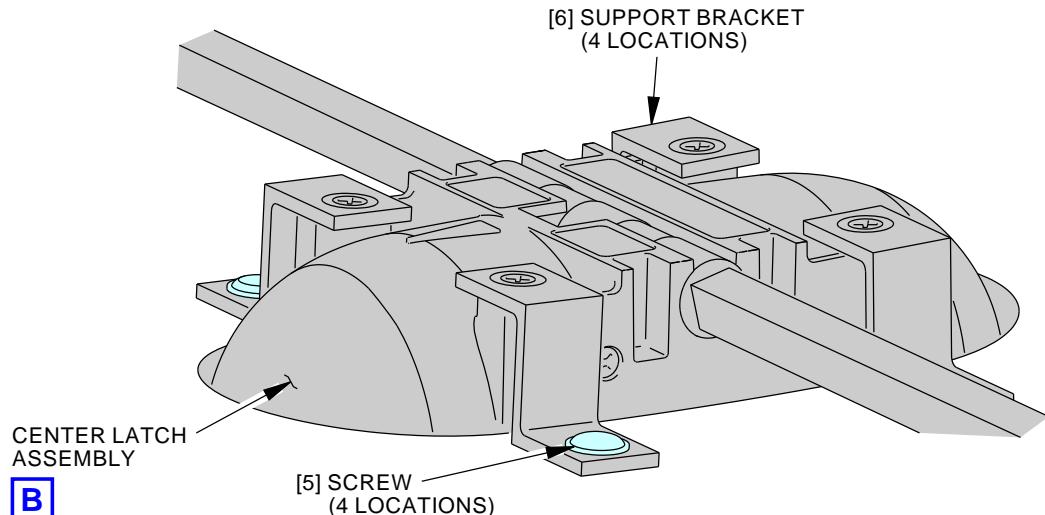
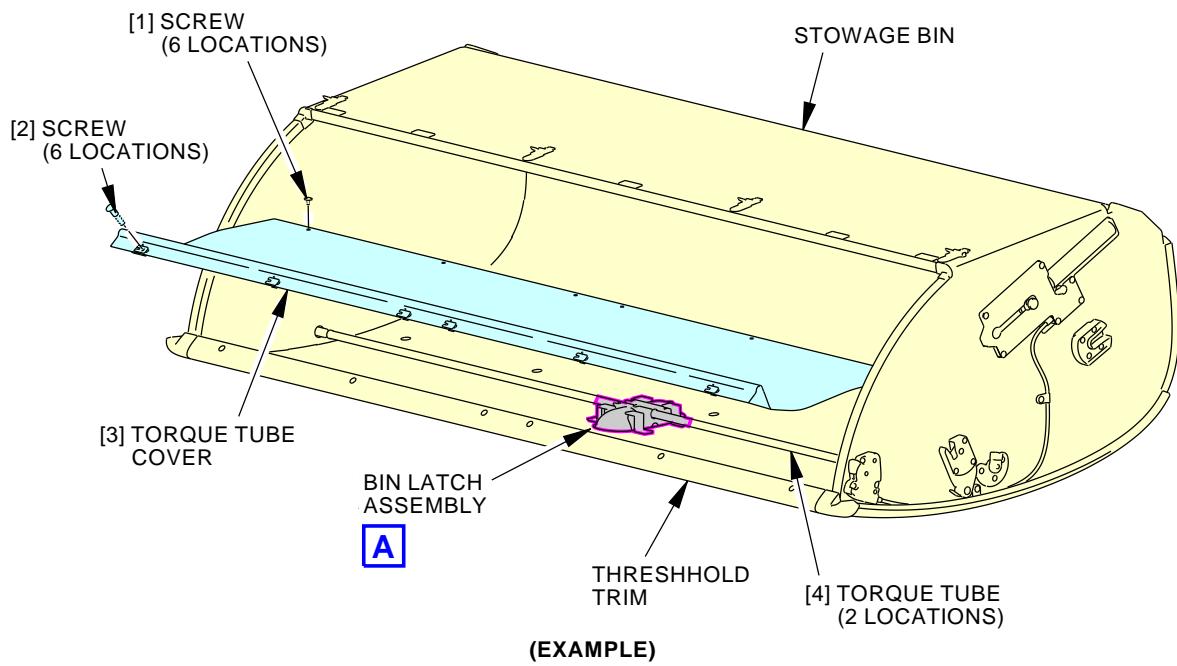
SUBTASK 25-24-36-820-008

- (4) Close the stowage bin doors.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-24-36



BIN LATCH ASSEMBLY

A

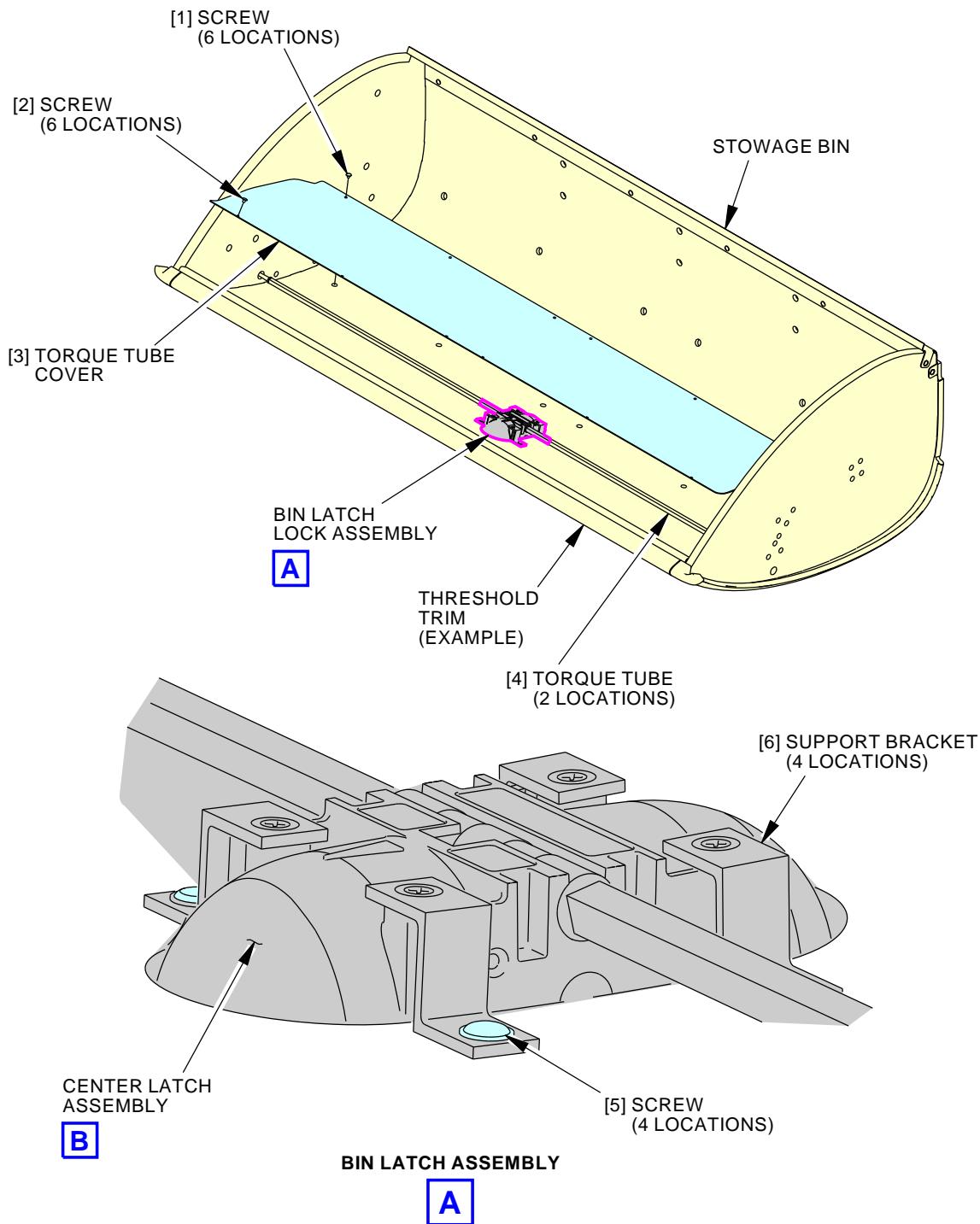
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Stowage Bin Latch Assembly Installation
Figure 201/25-24-36-990-804 (Sheet 1 of 3)

EFFECTIVITY
 AKS 001-017, 019

25-24-36

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Stowage Bin Latch Assembly Installation
Figure 201/25-24-36-990-804 (Sheet 2 of 3)

EFFECTIVITY
 AKS 018, 020-999

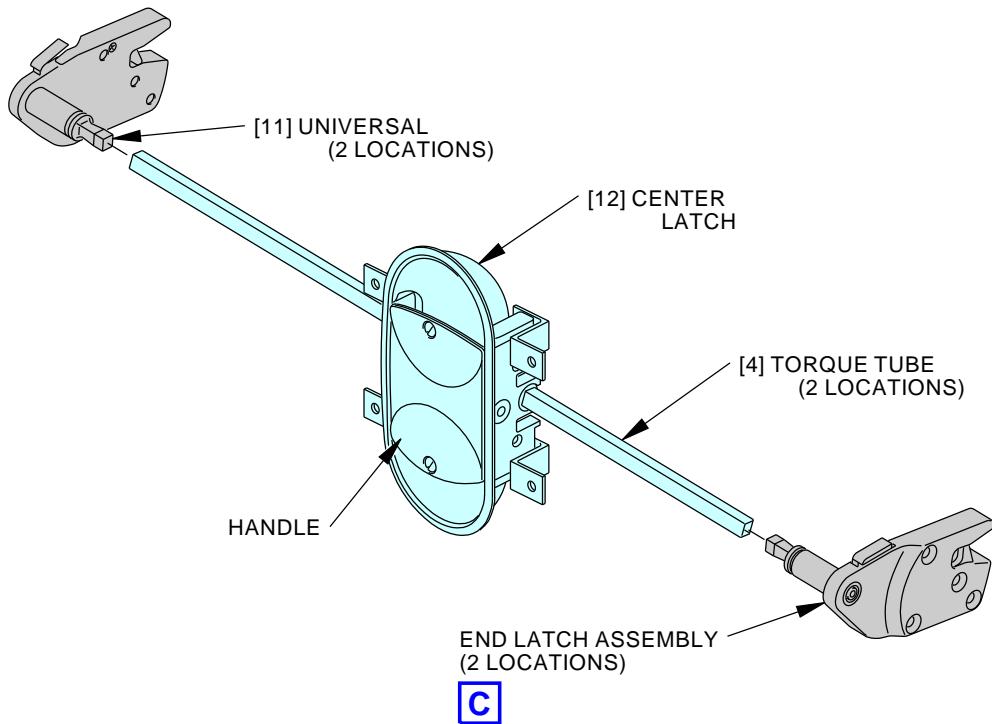
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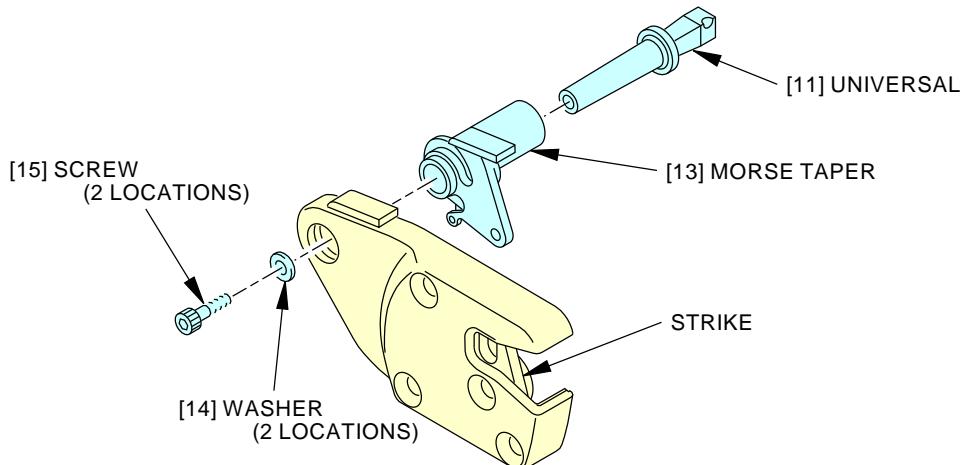


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CENTER LATCH ASSEMBLY

B



END LATCH ASSEMBLY

C

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Stowage Bin Latch Assembly Installation
Figure 201/25-24-36-990-804 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

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CENTER OVERHEAD STOWAGE BOX - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Center Overhead Stowage Box Door Latch Removal,
 - (2) Center Overhead Stowage Box Door Latch Installation,
 - (3) Center Overhead Stowage Box Door Removal,
 - (4) Center Overhead Stowage Box Door Installation,
 - (5) Center Overhead Stowage Box Actuator and Snubber Removal,
 - (6) Center Overhead Stowage Box Actuator and Snubber Installation,

TASK 25-24-40-000-802

2. Center Overhead Stowage Box Door Latch Removal

(Figure 201)

A. General

- (1) The stowage box door latch includes the threshold [5], the center bracket [9], and the door handle assembly [11].

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-40-020-015

- (1) Use the door latch handle on the stowage box door to open the door to the full open position.

SUBTASK 25-24-40-020-016

- (2) Remove all the items inside the stowage box.

D. Center Overhead Stowage Box Door Latch Removal

SUBTASK 25-24-40-020-017

- (1) Do these steps to get access to the door latch:

- (a) Remove the screws [1] and spacers [2] to release the shaft [3] that passes through the door latch assembly and the threshold [5].
- (b) Remove the shaft [3] that passes through the door latch assembly and the threshold.
- (c) Remove the screws [4] that attach the threshold [5] to the stowage box door.
- (d) Remove the threshold [5] from the stowage box door.

SUBTASK 25-24-40-020-018

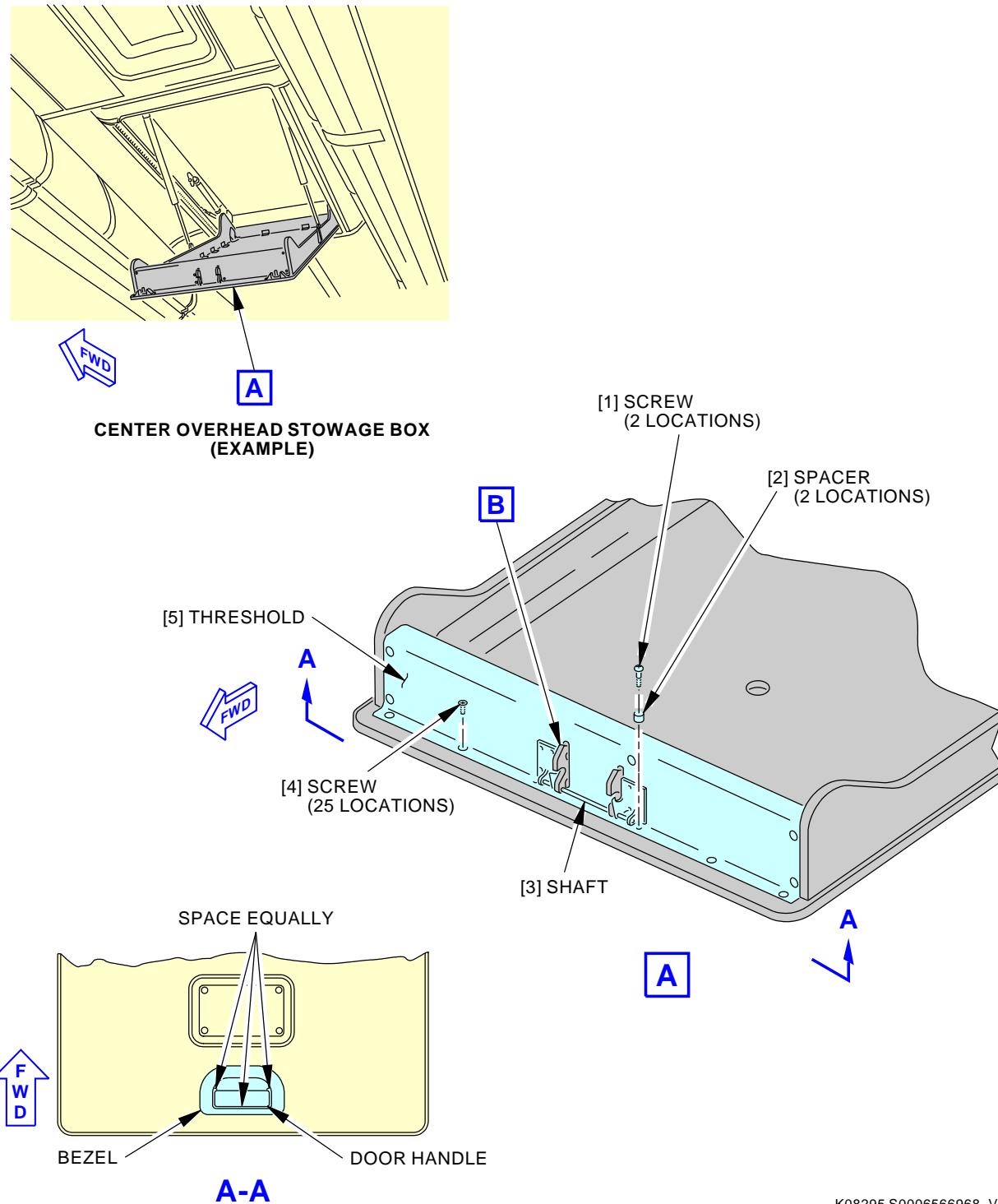
- (2) Do these steps to remove the door latch from the stowage box door:

- (a) Remove the screws [10] that attach the center bracket [9] to the stowage box door.
- (b) Remove the screws [7] and washers [8] that attach the center bracket [9] and the door handle assembly [11] to the stowage box door.
- (c) Remove the center bracket [9] from the stowage box door.
- (d) Remove the door handle assembly [11] from the stowage box door.

— END OF TASK —

EFFECTIVITY
AKS ALL

25-24-40



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Center Overhead Stowage Box Door Latch Installation
Figure 201/25-24-40-990-802 (Sheet 1 of 2)

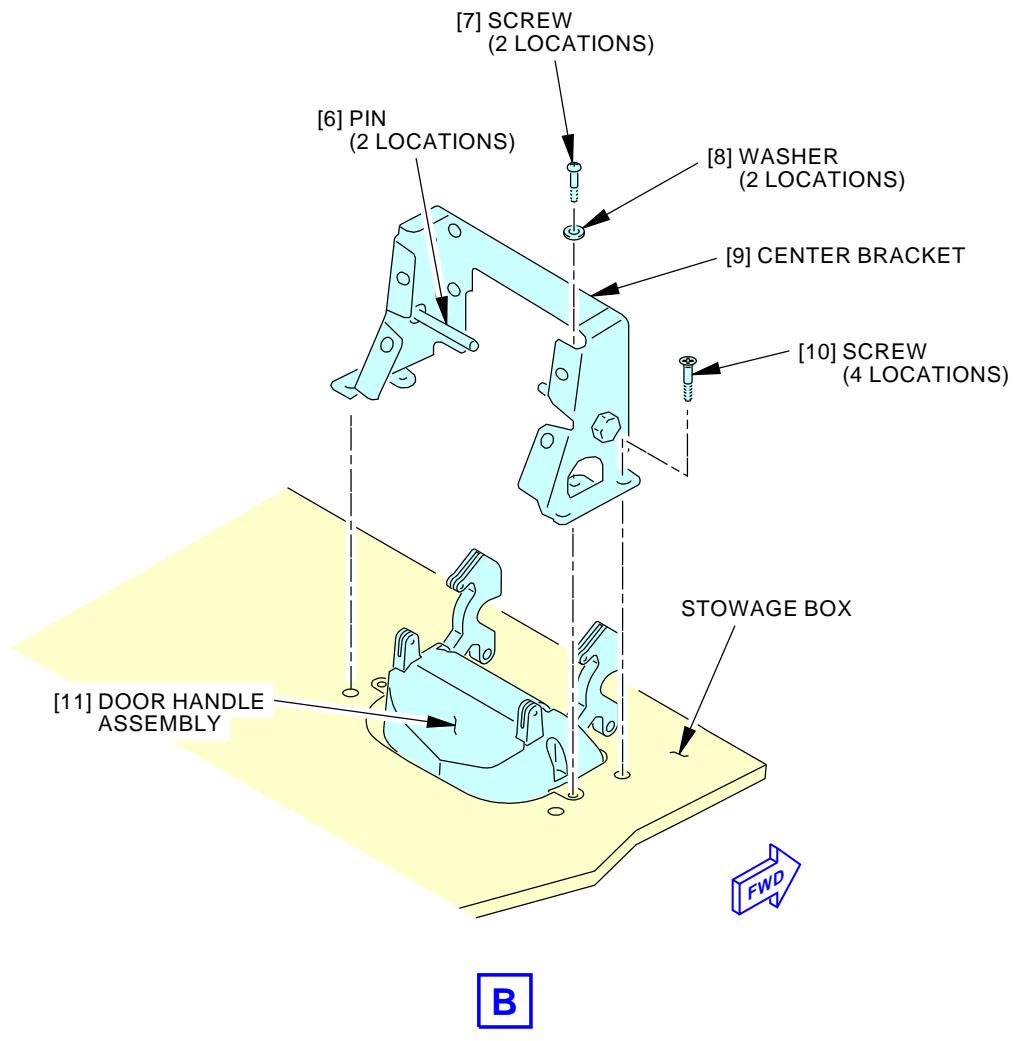
EFFECTIVITY
 AKS ALL

25-24-40

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B

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Center Overhead Stowage Box Door Latch Installation
Figure 201/25-24-40-990-802 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 25-24-40-400-802

3. Center Overhead Stowage Box Door Latch Installation

(Figure 201)

A. General

- (1) The stowage box door latch includes the threshold [5], the center bracket [9], and the door handle assembly [11].

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Overhead Stowage Box Door Latch Installation

SUBTASK 25-24-40-420-004

- (1) Do these steps to install the door latch on the stowage box door:
 - (a) Put the center bracket [9] in its position on the stowage box door.
 - (b) Install the screws [10] that attach the center bracket [9] to the stowage box door.
 - (c) Put the door handle assembly [11] in the cutout on the stowage box door.
 - (d) Install the screws [7] and washers [8] that attach the center bracket [9] and door handle assembly [11] to the stowage box door.

NOTE: Make sure the bezel is held tightly to the door, and you can adjust the clearance between the bezel and the door handle.

SUBTASK 25-24-40-410-002

- (2) Do these steps to install the threshold [5]:
 - (a) Put the threshold [5] in its position on the stowage box door.
 - (b) Put the shaft [3] in its position through the threshold [5] and the door latch assembly.
 - (c) Install the screws [1] and the spacers [2] that hold the shaft in its position.
 - (d) Install the screws [4] that attach the threshold [5] to the stowage box door.

SUBTASK 25-24-40-410-003

- (3) Adjust the bezel for equal distance around the perimeter of the door handle.

D. Center Overhead Stowage Box Door Latch Installation Test

SUBTASK 25-24-40-420-005

- (1) Make sure the door handle operates smoothly without too much noise.

SUBTASK 25-24-40-420-006

- (2) Close and open the stowage box door several times:
 - (a) Make sure the door latch engages and disengages smoothly.
 - (b) Make sure the door handle is flush with the door when the door is closed.

E. Put the Airplane in Its Usual Condition

SUBTASK 25-24-40-420-007

- (1) Install the items that were removed from the center overhead stowage box for this task.

SUBTASK 25-24-40-420-008

- (2) Close the center overhead stowage box door.

———— END OF TASK ———

EFFECTIVITY
AKS ALL

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TASK 25-24-40-000-803

4. Center Overhead Stowage Box Door Removal

(Figure 202)

A. References

Reference	Title
33-22-00-960-810	Ceiling Light, Center Overhead Stowage - LED Light Assembly Replacement (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-40-020-066

- (1) If necessary, remove the lighting on stowbin. Do this task: Ceiling Light, Center Overhead Stowage - LED Light Assembly Replacement, TASK 33-22-00-960-810.

SUBTASK 25-24-40-020-019

- (2) Use the door latch handle on the stowage box door to open the door to the full open position.

SUBTASK 25-24-40-020-020

- (3) Remove all the items inside the stowage box.

D. Center Overhead Stowage Box Door Removal

SUBTASK 25-24-40-020-043

- (1) Remove the bolt [37] and washer [38] that attach each of the rebound rate control snubbers [42] to the stowage box.

SUBTASK 25-24-40-020-021

- (2) Remove the bolt [45], washer [47], and nut [46] that attach each of the rate control snubbers [44] to the stowage box door [31].

SUBTASK 25-24-40-020-022

- (3) Lower the stowage box door [31] to a near vertical position.

SUBTASK 25-24-40-020-024

- (4) Remove the bolt [39], washers [40], and nut [41] that attach each of the actuators [43] to the stowage box door [31].

SUBTASK 25-24-40-020-025

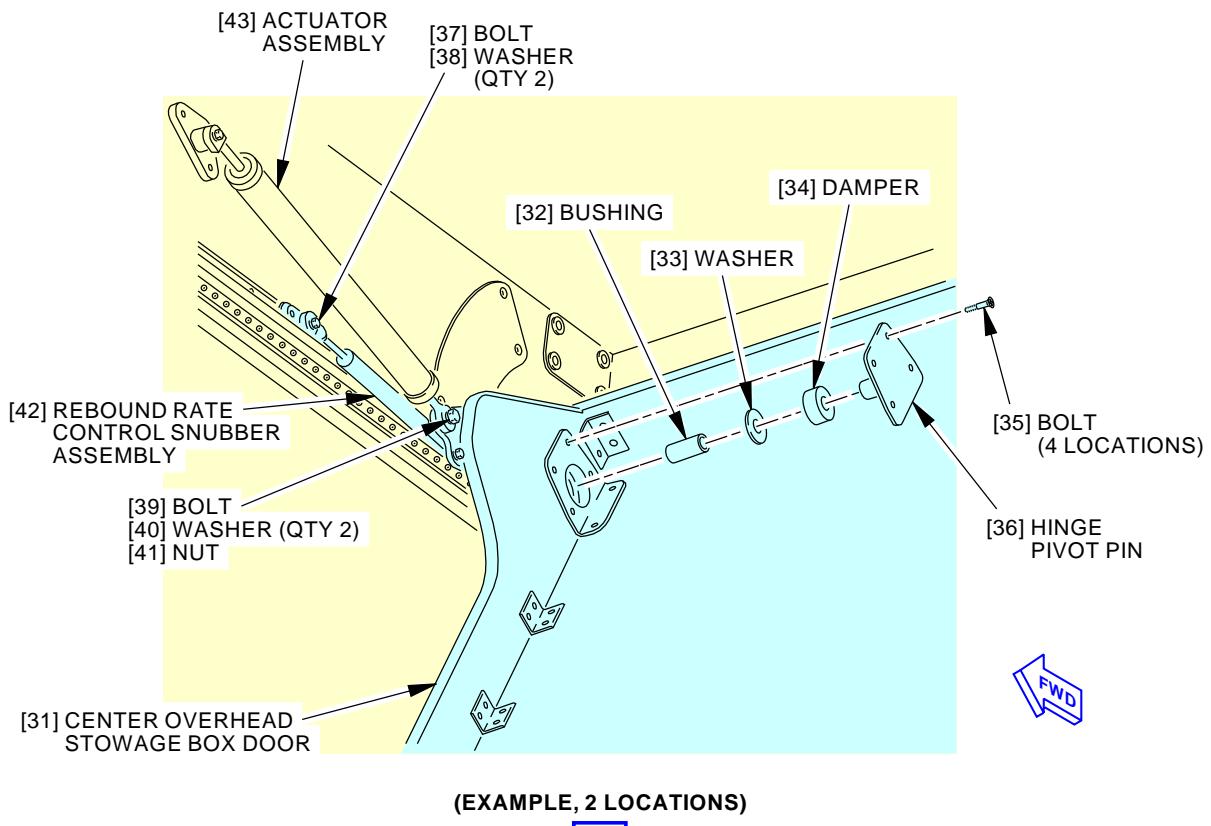
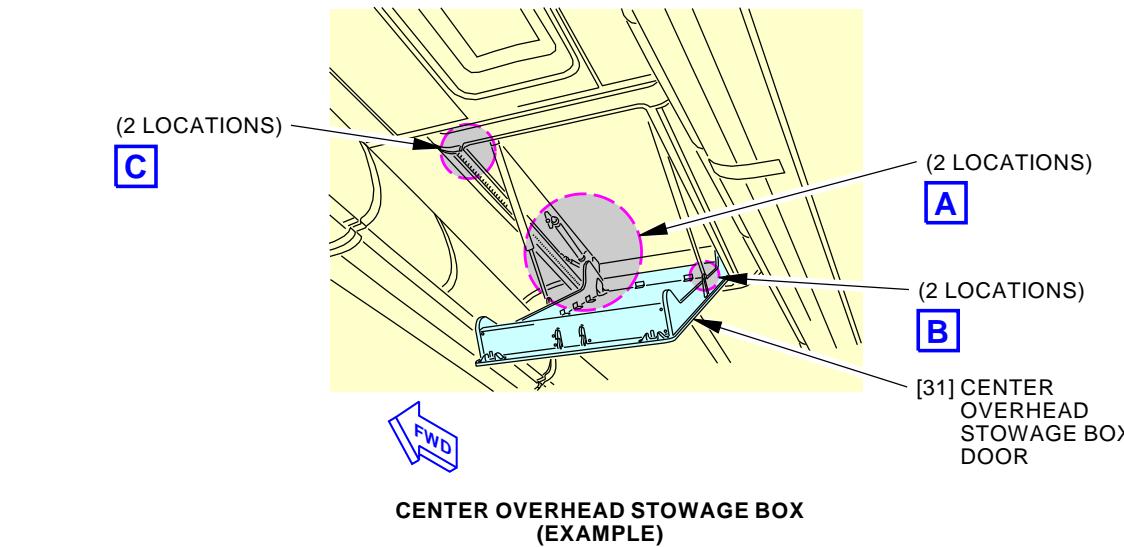
- (5) Do these steps to remove the stowage box door [31] from the center overhead stowage box assembly:

- (a) Support the door [31] while you remove the bolts [35] from the hinge pivot pin [36] on each side of the door.
- (b) Remove the hinge pivot pin [36], damper [34], washer [33], and bushing [32] from each side of the stowage box door [31].
- (c) Carefully remove the stowage box door [31] from the stowage box.

— END OF TASK —

EFFECTIVITY
AKS ALL

25-24-40



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Center Overhead Stowage Box Door Installation
Figure 202/25-24-40-990-803 (Sheet 1 of 2)

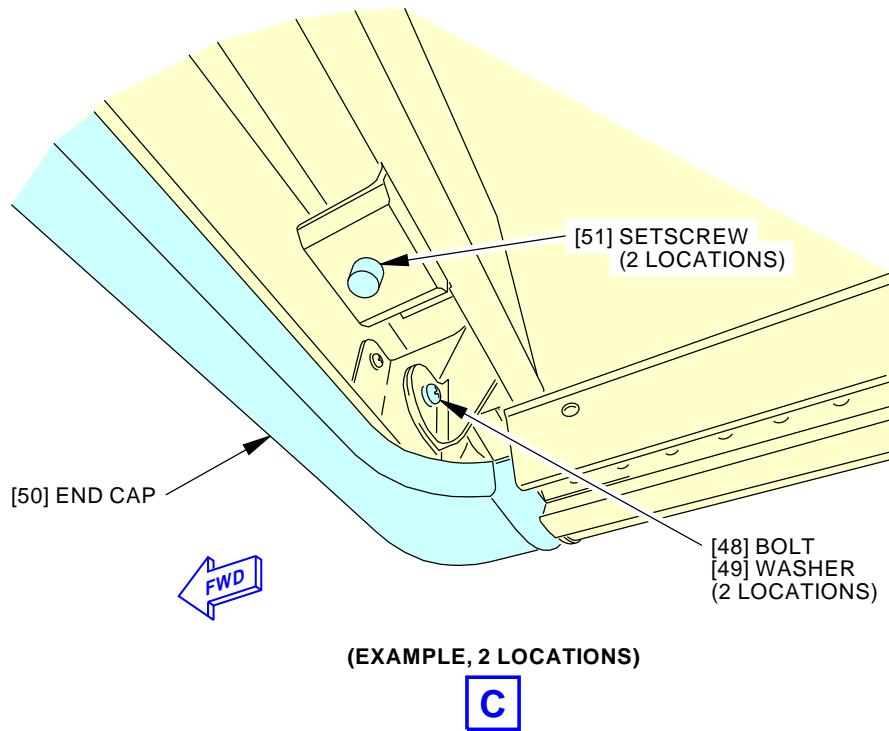
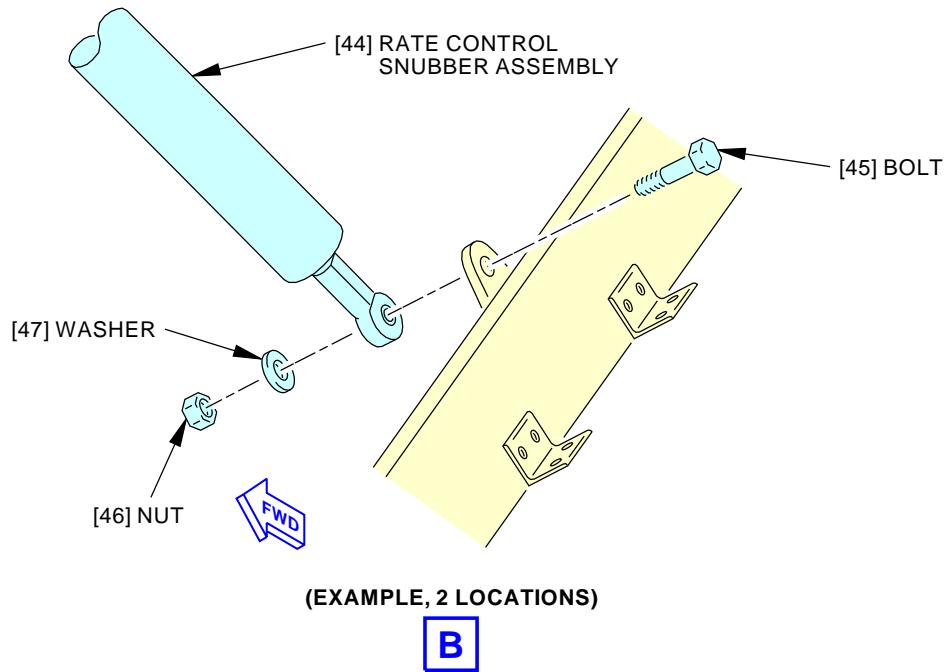
EFFECTIVITY
AKS ALL

25-24-40

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Center Overhead Stowage Box Door Installation
Figure 202/25-24-40-990-803 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-24-40-400-803

5. Center Overhead Stowage Box Door Installation

(Figure 202)

A. References

Reference	Title
33-22-00-960-810	Ceiling Light, Center Overhead Stowage - LED Light Assembly Replacement (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Overhead Stowage Box Door Installation

SUBTASK 25-24-40-420-009

- (1) Do these steps to install the stowage box door on the center overhead stowage box:
 - (a) Support the stowage box door in its position.
 - (b) Install the hinge pivot pin [36], damper [34], washer [33], and bushing [32] on each side of the stowage box door [31].
 - (c) Install the bolts [35] to attach the hinge pivot pin [36] on each side of the door.

SUBTASK 25-24-40-020-026

- (2) Install the bolt [39], washers [40], and nut [41] to attach each of the actuators [43] to the stowage box door [31].

SUBTASK 25-24-40-020-044

- (3) Install the bolt [45], washer [47], and nut [46] to attach each of the rate control snubbers [44] to the stowage box door [31].

SUBTASK 25-24-40-020-027

- (4) Install the bolt [37] and washer [38] to attach each of the rebound rate control snubbers [42] to the stowage box door [31].

D. Center Overhead Stowage Box Door Installation Test

SUBTASK 25-24-40-420-010

- (1) Close and open the stowage box door several times:
 - (a) Make sure the door touches each door stop equally when the door is closed. If the door does not touch each stop equally, do these steps:
 - 1) Hold the end cap [50] while you remove the bolts [48] and washers [49] that attach the end cap to the stowage box assembly.
 - 2) Turn the setscrew [51] up or down to get the necessary height.
 - (b) Make sure the door latch engages and disengages smoothly.
 - (c) Make sure the door handle is flush with the door when the door is closed.

E. Put the Airplane in Its Usual Condition

SUBTASK 25-24-40-420-011

- (1) Install the items that were removed from the center overhead stowage box for this task.

SUBTASK 25-24-40-420-031

- (2) Reinstall the lights along the stowbin if necessary. Do this task: Ceiling Light, Center Overhead Stowage - LED Light Assembly Replacement, TASK 33-22-00-960-810.

EFFECTIVITY
AKS ALL

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SUBTASK 25-24-40-420-012

- (3) Close the center overhead stowage box door.

———— END OF TASK ——

TASK 25-24-40-000-804

6. Center Overhead Stowage Box Actuator and Snubber Removal

(Figure 203)

A. General

- (1) There are two actuators, two rate control snubbers, and two rebound rate control snubbers installed on each overhead stowage box.

B. References

Reference	Title
25-21-45-000-803-001	Main Ceiling Panel - Removal (P/B 401)

C. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

D. Prepare for the Removal

SUBTASK 25-24-40-020-029

- (1) Use the door latch handle on the stowage box door to open the door to the full open position.

SUBTASK 25-24-40-020-030

- (2) Remove all the items stored inside the stowage box.

SUBTASK 25-24-40-020-031

- (3) Remove the sculptured ceiling panels adjacent to the stowage box. To remove the ceiling panels, do this task: Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

E. Center Overhead Stowage Box Actuator and Snubber Removal

SUBTASK 25-24-40-020-045

- (1) Remove the bolt [37] and washer [38] that attach each of the rebound rate control snubbers [42] to the stowage box door [31].

SUBTASK 25-24-40-020-032

- (2) Remove the bolt [45], washer [47], and nut [46] that attach each rate control snubber [44] to the stowage box [31].

SUBTASK 25-24-40-020-033

- (3) Lower the stowage box door to a near vertical position.

SUBTASK 25-24-40-020-034

- (4) To remove a rate control snubber [44], do these steps:

- (a) Remove the bolt [61], washers [62], and nut [63] that attach the rate control snubber [44] to the stowage box.

NOTE: Access to the nut [63] and washer [62] is above the side panel of the stowage box.

- (b) Remove the rate control snubber [44] from the stowage box.

SUBTASK 25-24-40-020-035

- (5) To remove a rebound rate control snubber [42] do these steps:

EFFECTIVITY
AKS ALL

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- (a) Remove the bolt [67] and washer [68] from each end the rebound rate control snubber [42].
- (b) Remove the rebound rate control snubber [42] from the stowage box door [31].

SUBTASK 25-24-40-020-036

- (6) To remove an actuator [43] do these steps:
 - (a) Hold the door while you remove the bolt [39], washers [40], and nut [41] that attach the actuator [43] to the stowage box door.
 - (b) Remove the bolt [64], washers [65], and nut [66] that attach the actuator [43] to the stowage box.
NOTE: Access to the nut [66] and washer [65] is above the side panel of the stowage box.
 - (c) Remove the actuator [43] from the stowage box.

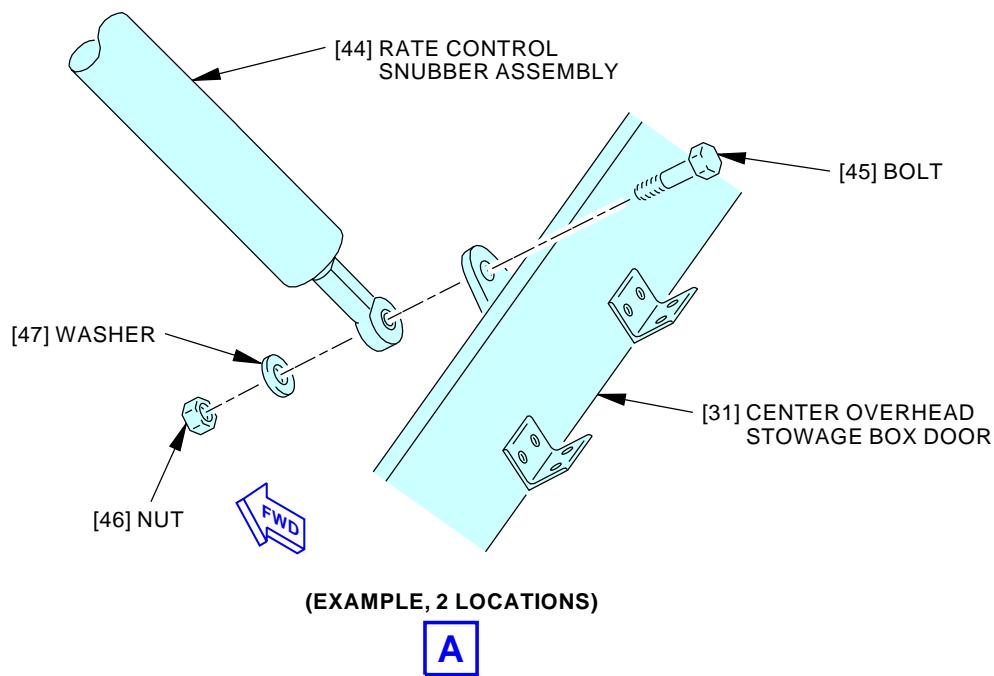
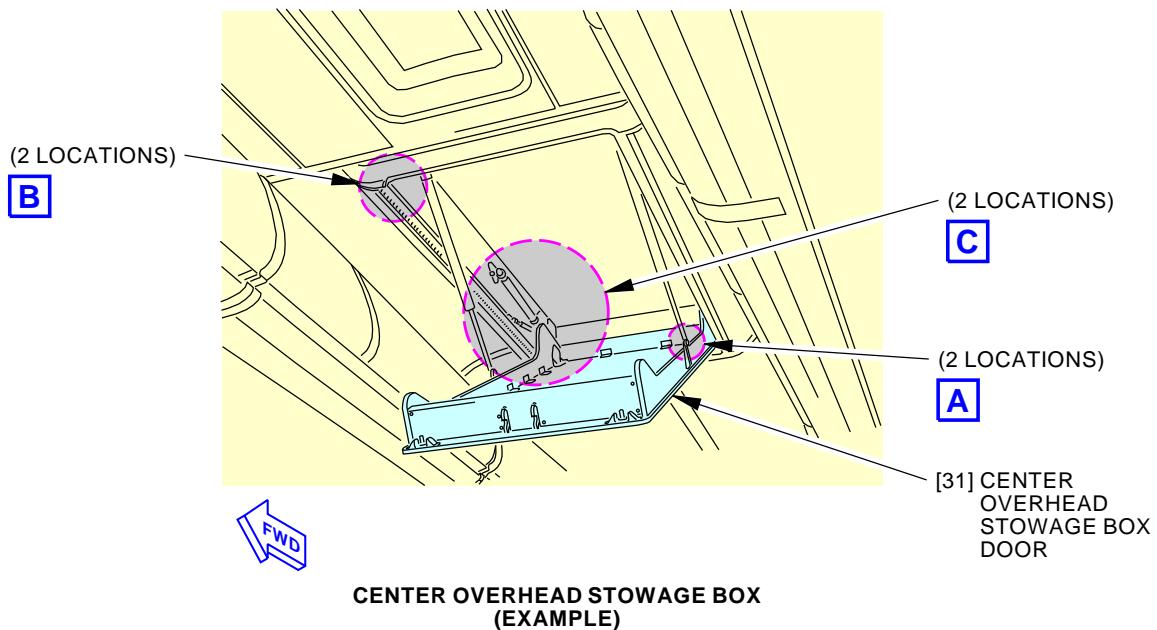
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EFFECTIVITY
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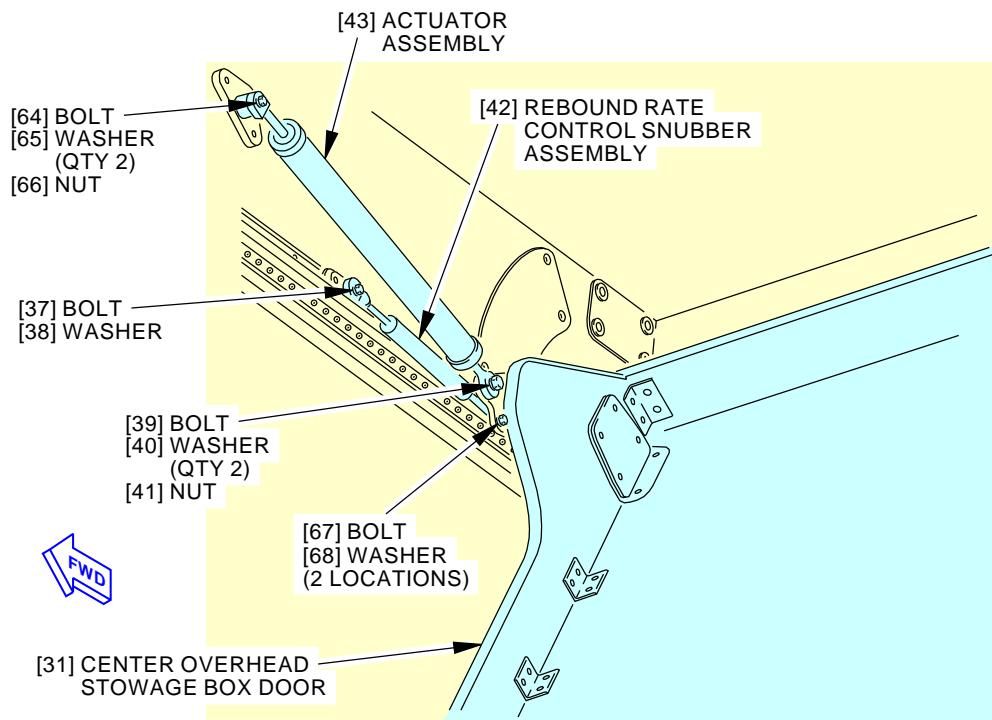
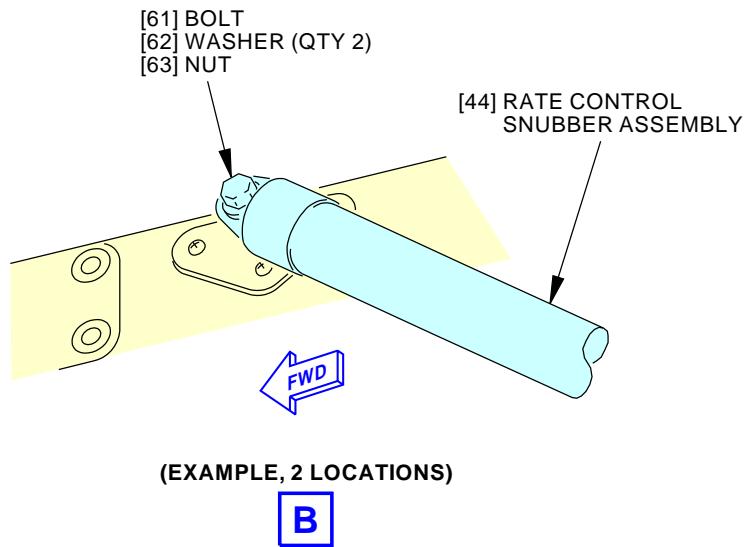
Center Overhead Stowage Box Actuator/Snubber Installation
Figure 203/25-24-40-990-804 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

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Center Overhead Stowage Box Actuator/Snubber Installation
Figure 203/25-24-40-990-804 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 25-24-40-400-804

7. Center Overhead Stowage Box Actuator and Snubber Installation

(Figure 203)

A. References

Reference	Title
25-21-45-400-803-001	Main Ceiling Panel - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Overhead Stowage Box Actuator and Snubber Installation

SUBTASK 25-24-40-020-037

- (1) To install an actuator [43], do these steps:
 - (a) Hold the actuator [43] in its position while you install the bolt [64], washers [65], and nut [66] that attach the actuator [43] to the stowage box.
 - (b) Install the bolt [39], washers [40], and nut [41] that attach the actuator [43] to the stowage box door.

SUBTASK 25-24-40-020-038

- (2) To install a rebound rate control snubber [42], do these steps:
 - (a) Hold the snubber [42] while you install the bolt [67] and washer [68] that attach the snubber [42] to the stowage box door.
 - (b) Move the stowage box door to a position that will let you attach the free end of the rebound rate control snubber [42].
 - (c) Hold the door while you install the bolt [37] and washer [38] that attach the snubber [42] to the stowage box.

SUBTASK 25-24-40-020-039

- (3) To install a rate control snubber [44], do this step:
 - (a) Hold the snubber [44] while you install the bolt [61], washers [62], and nut [63] that attach the snubber [44] to the stowage box.

SUBTASK 25-24-40-020-040

- (4) Move the stowage box door to a position that will let you attach the free end of the rate control snubber [44].

SUBTASK 25-24-40-020-041

- (5) Hold the door while you install the bolt [45], washer [47], and nut [46] that attach the snubber [44] to the stowage box door.

D. Put the Airplane in Its Usual Condition

SUBTASK 25-24-40-420-013

- (1) Install the items that were removed from the center overhead stowage box for this task.

SUBTASK 25-24-40-420-014

- (2) Close the center overhead stowage box door.

SUBTASK 25-24-40-020-042

- (3) Install the sculptured ceiling panels adjacent to the stowage box. To install the ceiling panels, do this task: Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

— END OF TASK —

EFFECTIVITY
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CENTER OVERHEAD STOWAGE BOX - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Center Overhead Stowage Box Removal,
 - (2) Center Overhead Stowage Box Installation.

TASK 25-24-40-000-801

2. Center Overhead Stowage Box Removal

(Figure 401)

A. General

- (1) Two persons are necessary to complete this task.

B. References

Reference	Title
25-21-45-000-803-001	Main Ceiling Panel - Removal (P/B 401)

C. Consumable Materials

Reference	Description	Specification
G50344	Tape - Nitto P-212HD (Formerly Permacel) Glass Cloth	

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare for the Removal

SUBTASK 25-24-40-020-001

- (1) Use the door latch handle on the stowage box door to open the door to the full open position.

SUBTASK 25-24-40-020-002

- (2) Remove the items stored inside the stowage box [1].

SUBTASK 25-24-40-020-003

- (3) Close the door of the center overhead stowage box [1].

SUBTASK 25-24-40-020-004

- (4) Remove the sculptured ceiling panels adjacent to the stowage box [1]. To remove the ceiling panels, do this task: Main Ceiling Panel - Removal, TASK 25-21-45-000-803-001.

F. Center Overhead Stowage Box Removal

AKS 001-017

SUBTASK 25-24-40-020-005

- (1) Remove the Nitto P-212HD tape, G50344 [7], that holds the flex hoses [6] to the stowage box [1].



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AKS 001-017 (Continued)

SUBTASK 25-24-40-020-006

- (2) Disconnect the flex hoses [6] from the stowage box [1].

AKS ALL

SUBTASK 25-24-40-020-007

WARNING: BE CAREFUL WHEN YOU MOVE THE STOWAGE BOX. BECAUSE THE STOWAGE BOX WEIGHS APPROXIMATELY 45 POUNDS (20 KILOGRAMS), INJURIES TO PERSONS CAN OCCUR.

WARNING: ONE PERSON MUST HOLD THE STOWAGE BOX WHILE YOU REMOVE THE HARDWARE THAT SECURES THE STOWAGE BOX TO THE AIRPLANE. THE STOWAGE BOX CAN FALL AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (3) Remove the hardware that secures the stowage box [1] to the airplane.

- (a) Remove the bolt [4], washers [3], nut [5], and bushing [2] from the tie rod assemblies.

NOTE: Tag the attachment hardware for each location because different installations are possible.

- (b) Remove the bolt [4], washers [3], nut [5], and bushing [2] from the turnbuckle assemblies.

NOTE: Tag the attachment hardware for each location because different installations are possible.

SUBTASK 25-24-40-020-008

- (4) Move each of the tie rods and turnbuckles away from the clevises on the stowage box [1].

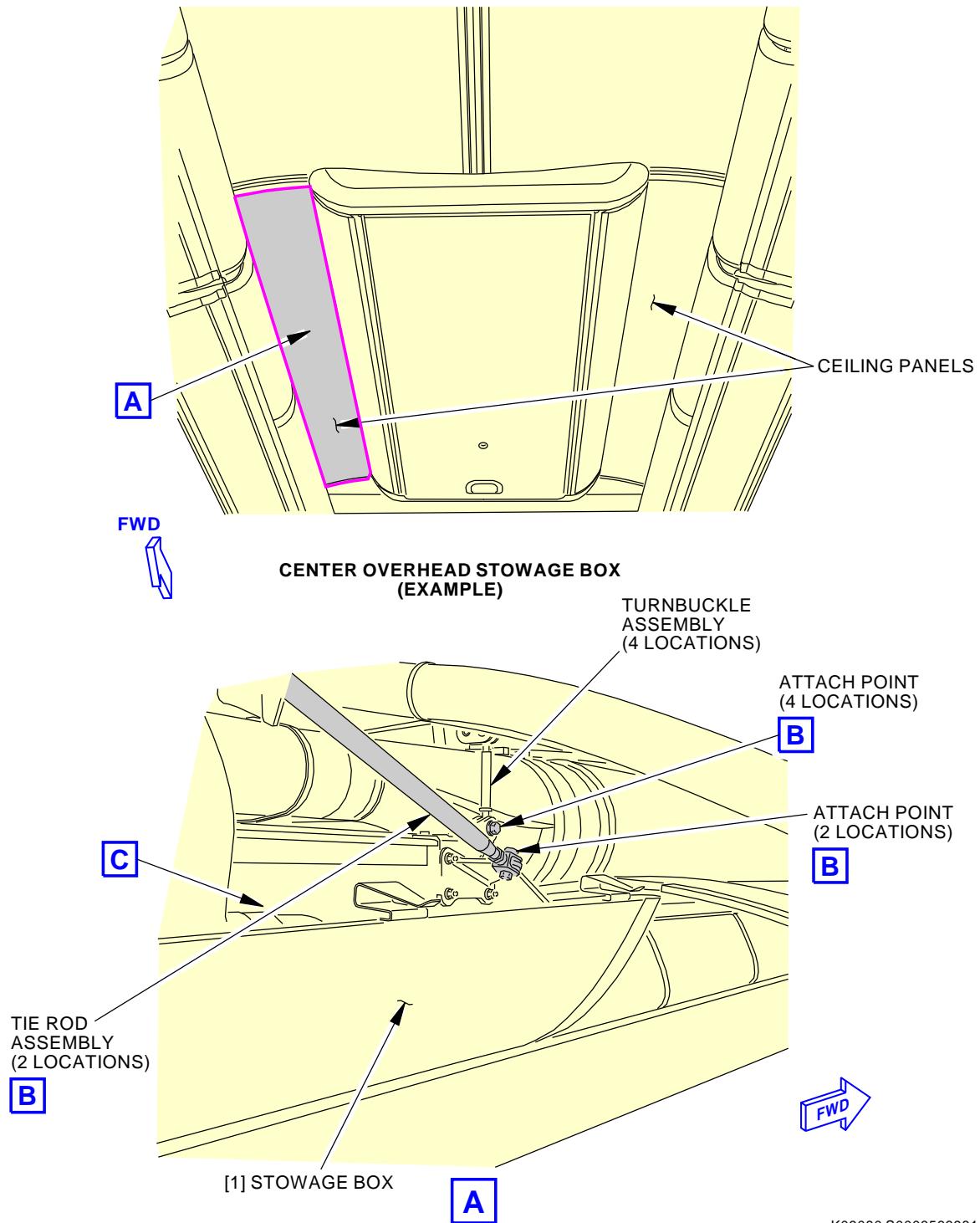
SUBTASK 25-24-40-020-009

- (5) Carefully lower the stowage box [1].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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Center Overhead Stowage Box Installation
Figure 401/25-24-40-990-801 (Sheet 1 of 2)

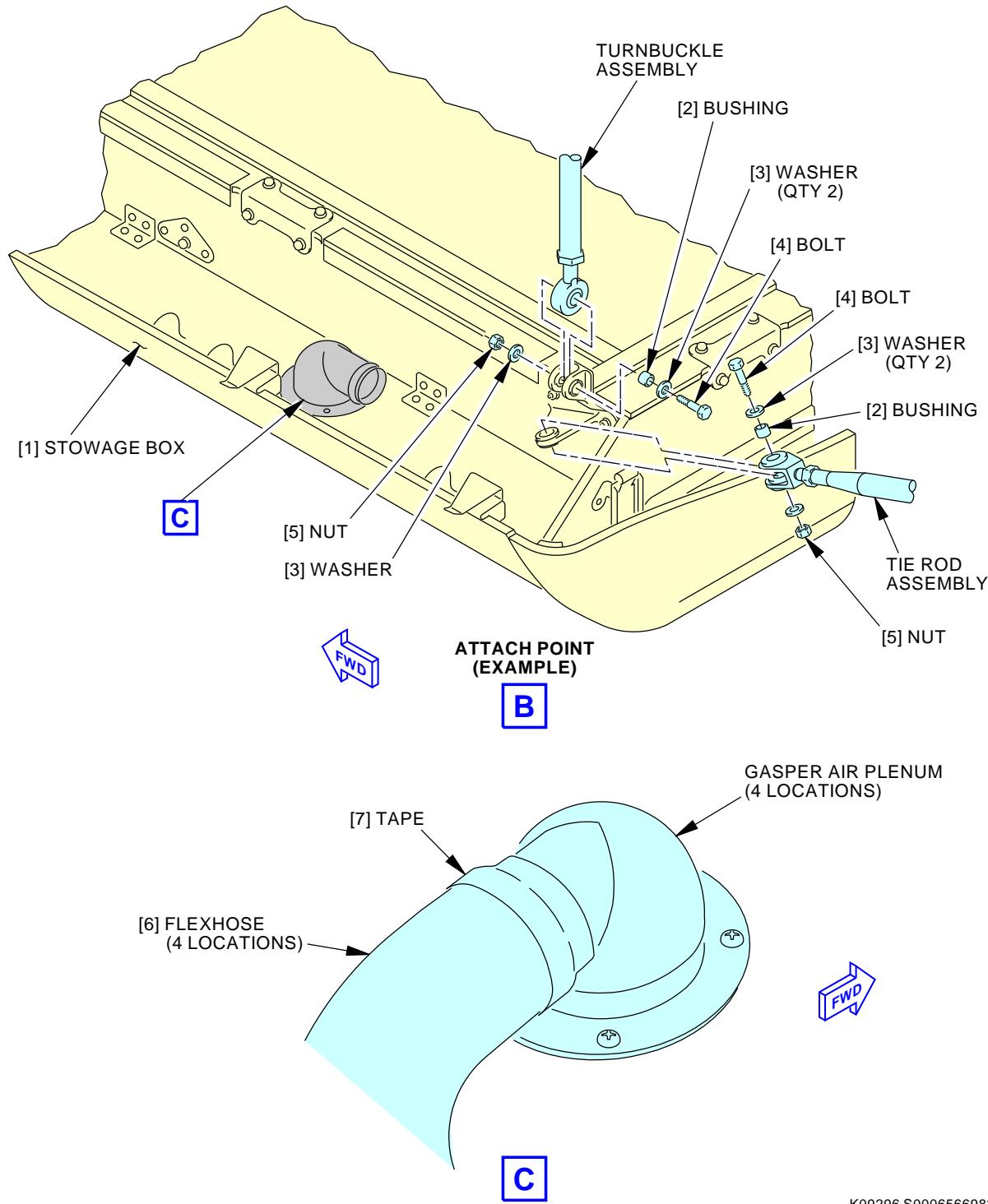
EFFECTIVITY
AKS ALL

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Center Overhead Stowage Box Installation
Figure 401/25-24-40-990-801 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-24-40-400-801

3. Center Overhead Stowage Box Installation

(Figure 401)

A. References

Reference	Title
25-21-45-400-803-001	Main Ceiling Panel - Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G50344	Tape - Nitto P-212HD (Formerly Permacel) Glass Cloth	

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Center Overhead Stowage Box Installation

SUBTASK 25-24-40-420-001

WARNING: BE CAREFUL WHEN YOU MOVE THE STOWAGE BOX. BECAUSE THE STOWAGE BOX WEIGHS APPROXIMATELY 45 POUNDS (20 KILOGRAMS), INJURIES TO PERSONS CAN OCCUR.

WARNING: ONE PERSON MUST HOLD THE STOWAGE BOX WHILE YOU INSTALL THE HARDWARE THAT SECURES THE STOWAGE BOX TO THE AIRPLANE. THE STOWAGE BOX CAN FALL AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) Put the stowage box [1] in its position.

SUBTASK 25-24-40-410-001

- (2) Put each of the tie rods and turnbuckles into the clevises on the stowage box [1].

SUBTASK 25-24-40-020-010

- (3) Install the bolt [4], washers [3], nut [5], and bushing [2] for the turnbuckle assemblies.

NOTE: Use the attachment hardware that you tagged when you removed the turnbuckle assemblies.

SUBTASK 25-24-40-020-011

- (4) Install the bolt [4], washers [3], nut [5], and bushing [2] for the tie rod assemblies.

NOTE: Use the attachment hardware that you tagged when you removed the tie rod assemblies.

AKS 001-017

SUBTASK 25-24-40-020-012

- (5) Connect the flex hoses [6] to the gasper air plenums on the stowage box [1].

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AKS 001-017 (Continued)

SUBTASK 25-24-40-020-013

- (6) Install new Nitto P-212HD tape, G50344 [7], on the flex hose to the gasper air plenum connections.

AKS ALL

E. Put the Airplane in Its Usual Condition

SUBTASK 25-24-40-420-002

- (1) Install the items removed from the center overhead stowage box [1] for this task.

SUBTASK 25-24-40-420-003

- (2) Close the center overhead stowage box door.

SUBTASK 25-24-40-020-014

- (3) Install the sculptured ceiling panels adjacent to the stowage box [1]. To install the ceiling panels, do this task: Main Ceiling Panel - Installation, TASK 25-21-45-400-803-001.

———— END OF TASK ————

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OUTBOARD STOWAGE CLOSET - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Outboard Stowage Closet Removal
 - (2) Outboard Stowage Closet Installation.

TASK 25-24-77-000-801

2. Outboard Stowage Closet Removal

NOTE: See Figure 401

NOTE: See Figure 402

A. References

Reference	Title
25-22-00-000-801	Passenger Seat - Removal (P/B 401)
25-24-10-000-803	Fixed Class Divider Header - Removal (P/B 401)
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)

B. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

C. Prepare for the Procedure

SUBTASK 25-24-77-010-001

- (1) If necessary, do this task: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001 or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001.

SUBTASK 25-24-77-010-002

- (2) If necessary, do this task: Fixed Class Divider Header - Removal, TASK 25-24-10-000-803.

SUBTASK 25-24-77-010-005

- (3) If necessary, do this task: Reference Not Currently Available

SUBTASK 25-24-77-010-003

- (4) If necessary, to get better access to the floor attachments, do this task: Passenger Seat - Removal, TASK 25-22-00-000-801.

SUBTASK 25-24-77-010-004

- (5) Remove the closeout seal from the top and sides of the closet.

D. Outboard Closet Removal

SUBTASK 25-24-77-020-001

- (1) Do the steps that follow to disconnect the top of the closet:

(a) For closets with top access panel:

- 1) Insert a standard tool and push to release the two quick release latches on the access panel.

(b) For closets without top access panel:

- 1) Open the top access door.

2) From inside the closet above:

- a) Remove the four screws of the closeout panel.

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- (c) If necessary disconnect the Electrical Connector [1].

SUBTASK 25-24-77-030-001

- (2) Do the applicable steps that follow to disconnect the floor attachments for the closet:
- Remove the seat track fitting Cover Plates [8].
 - On Seat Track Fittings [9] with Bolts [2], remove the Bolts [2], Washers [3], Washers (Fillers) [4], or Bushings [5] that attach the closet to the Seat Track Fittings [9].
 - Keep the Bolts [2], Washers [3], Washers (Fillers) [4], and Bushings [5] for the installation of the closet.
 - On Seat Track Fittings [9] with Nuts [14], remove the Nuts [14] and Washers [3] that attach the closet to the Seat Track Fittings [9].

SUBTASK 25-24-77-020-002

- (3) Remove the closet.
- If necessary, remove the Spacer [6] from above the Seat Track Fittings [9] and save for the installation of the closet.

SUBTASK 25-24-77-030-002

- (4) If necessary, do these steps that follow to remove the Seat Track Fittings [9]:
- Remove the tape and filler from the seat track.
 - Move the Seat Track Fitting [9] forward or aft approximately 0.5 in. (1.3 cm) to align it with the circular openings in the seat track.
 - Lift the Seat Track Fitting [9] out of the seat track.

————— END OF TASK ————

TASK 25-24-77-400-801

3. Outboard Stowage Closet Installation

NOTE: See Figure 401

NOTE: See Figure 402

A. References

Reference	Title
25-22-00-400-802	Passenger Seat - Installation (P/B 401)
25-24-10-400-803	Fixed Class Divider Header - Installation (P/B 401)
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

C. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

D. Outboard Closet Installation

SUBTASK 25-24-77-420-001

- (1) If necessary, do these steps to install the Seat Track Fittings [9]:
- Remove the old moisture barrier seal from the seat track.

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- (b) Apply compound, C00528 on the Seat Track Fitting [9].
- (c) Put the Seat Track Fitting [9] in the circular opening in the seat track.
- (d) Move the Seat Track Fitting [9] forward or aft 0.5 in. (1.3 cm) to lock it in the correct position for the installation.

SUBTASK 25-24-77-430-001

- (2) If necessary install the Spacer [6] and Washer (Filler) [4] above the Seat Track Fittings [9].

SUBTASK 25-24-77-820-001

- (3) Align the closet with the Seat Track Fittings [9].

SUBTASK 25-24-77-430-002

- (4) On Seat Track Fittings [9] with Bolts [2]:
 - (a) Install the Washers [3], Washers (Fillers) [4], or Bushings [5], and Bolts [2] to attach the closet to the Seat Track Fittings [9].
 - (b) Tighten all the Bolts [2].
 - (c) Torque all the Bolts [2] to 86 ± 4 in-lb (9.7 ± 0.5 N·m).

SUBTASK 25-24-77-400-003

- (5) On Seat Track Fittings [9] with Nuts [14]:
 - (a) Install the Washers [3] and Nuts [14] to attach the closet to the Seat Track Fittings [9].
 - (b) Tighten all the Nuts [14] to 200 ± 40 in-lb (22.6 ± 4.5 N·m)

SUBTASK 25-24-77-400-001

- (6) Do these steps to prevent corrosion
 - (a) Apply seat track filler in the seat track around the seat track fitting.
 - (b) Apply a new moisture barrier seal with a cutout for the seat track fitting.

SUBTASK 25-24-77-410-004

- (7) If the closet or partition has a tie rod, do these steps:
 - (a) If the Tie Rod [10] is not installed, connect the Tie Rod [10] to the overhead structure rail.
 - (b) Adjust the Tie Rod [10] end fitting, as required, to help install the Tie Rod [10].
NOTE: Do not adjust either end fitting past the witness hole.
 - (c) Remove the lockwire on either end of the Tie Rod [10] if more adjustment is necessary.
 - (d) Tighten the Tie Rod [10] jam nut when adjustments are complete.
 - (e) If necessary, install a lockwire to the ends of the Tie Rod [10].

SUBTASK 25-24-77-430-004

- (8) If necessary, connect the Electrical Connector [1].

SUBTASK 25-24-77-410-005

- (9) Close the tie rod access panel.

SUBTASK 25-24-77-430-003

- (10) If necessary, install the Cover Plates [8] to the bottom of the closet.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-77-390-001

- (1) Install the closeout seal to the top and sides of the closet.

SUBTASK 25-24-77-410-001

- (2) If necessary, do this task: Passenger Seat - Installation, TASK 25-22-00-400-802.

EFFECTIVITY
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SUBTASK 25-24-77-410-002

- (3) If necessary, do this task: Fixed Class Divider Header - Installation, TASK 25-24-10-400-803.

SUBTASK 25-24-77-410-003

- (4) If necessary, do this task: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or
Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001.

SUBTASK 25-24-77-410-007

- (5) If necessary, do this task: Reference Not Currently Available

———— END OF TASK ————

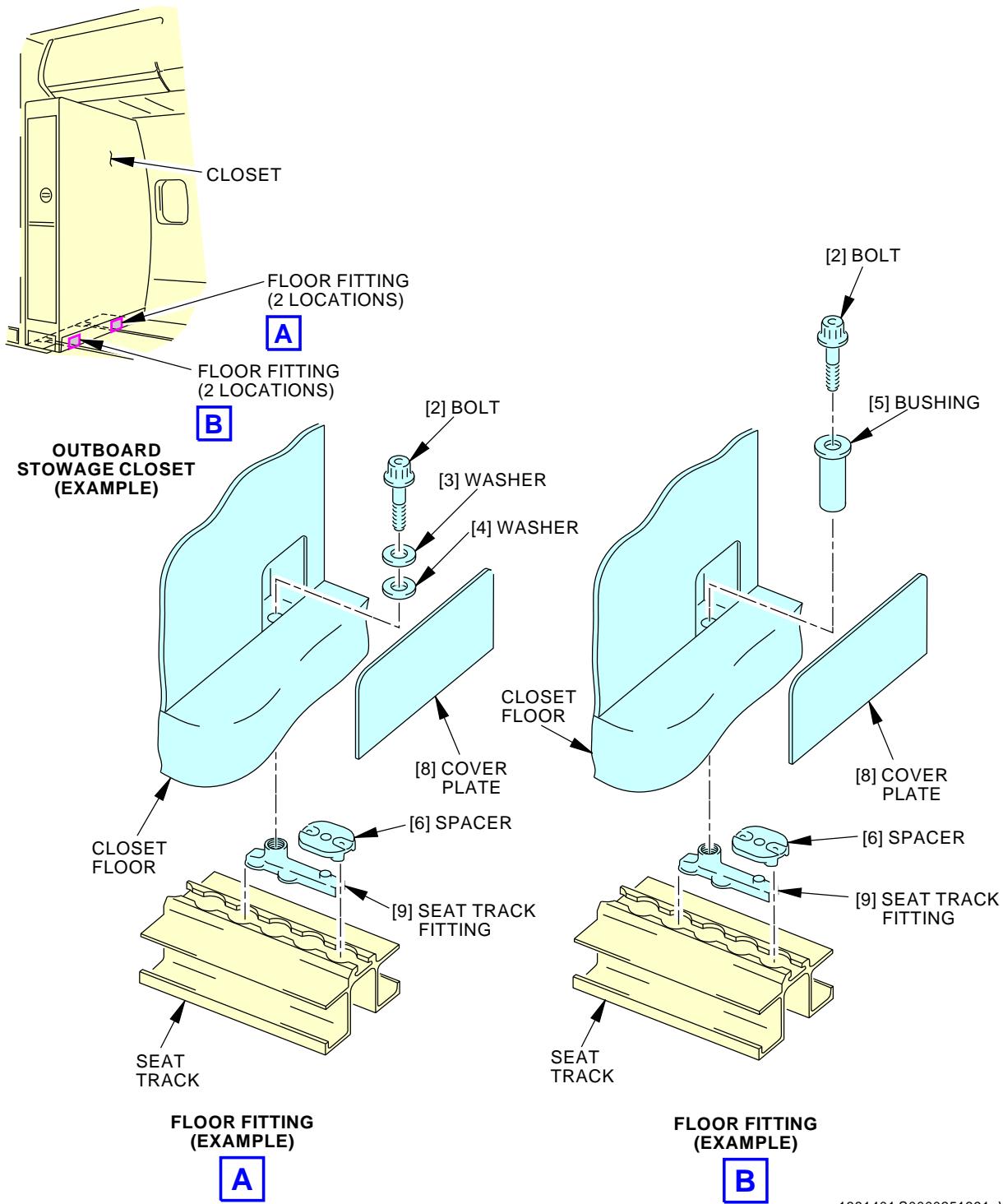
EFFECTIVITY
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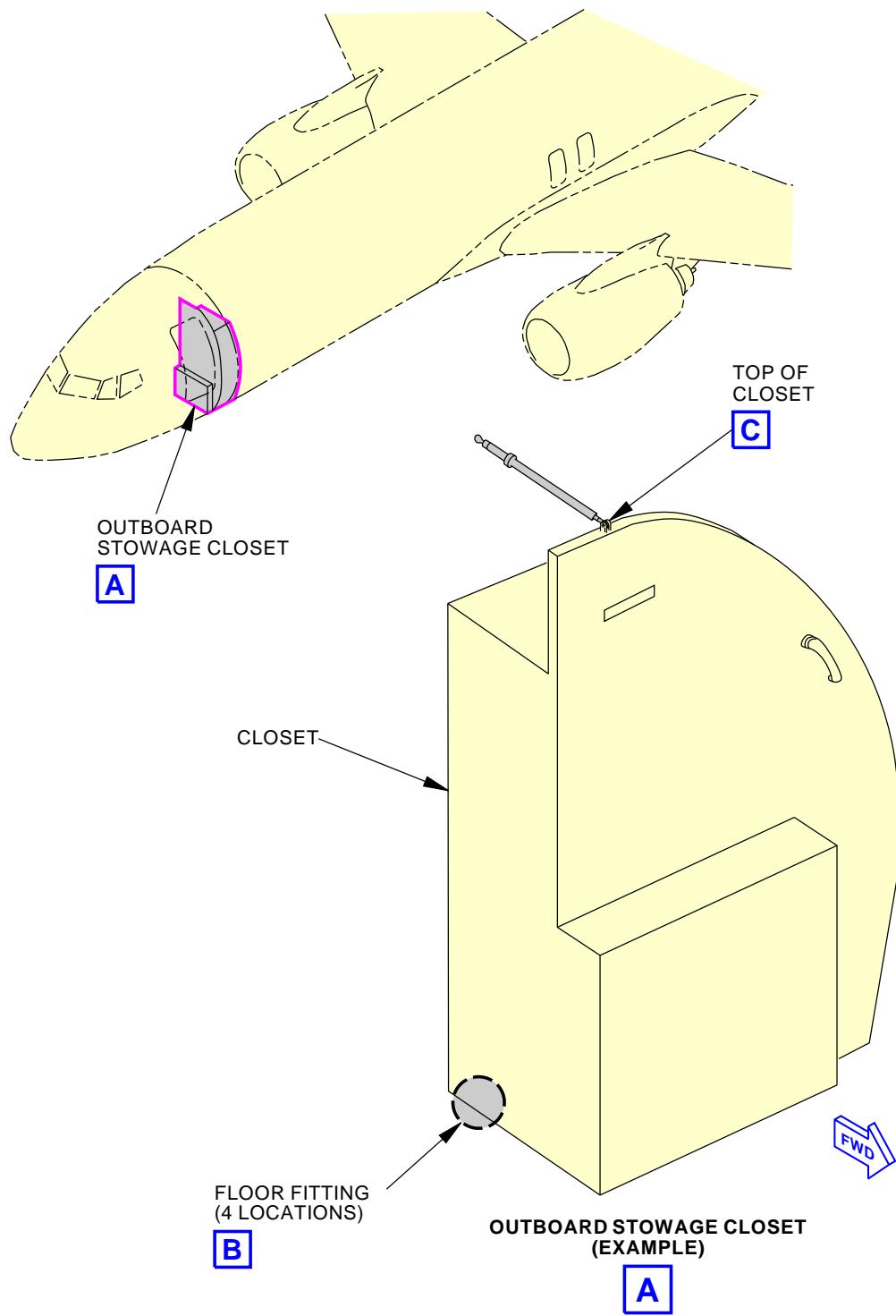
Outboard Stowage Closet Installation
Figure 401/25-24-77-990-802

EFFECTIVITY
 AKS 007, 008

25-24-77



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Outboard Stowage Closet Installation
Figure 402/25-24-77-990-803 (Sheet 1 of 3)

EFFECTIVITY
AKS 007, 008

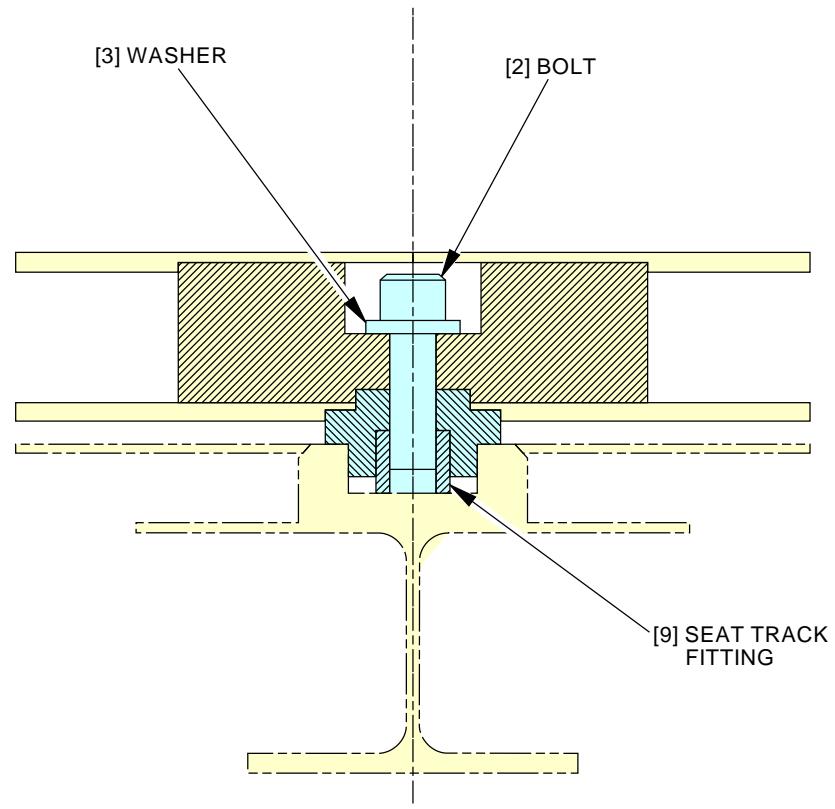
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FLOOR FITTING
(EXAMPLE)

B

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Outboard Stowage Closet Installation
Figure 402/25-24-77-990-803 (Sheet 2 of 3)

EFFECTIVITY
AKS 007, 008

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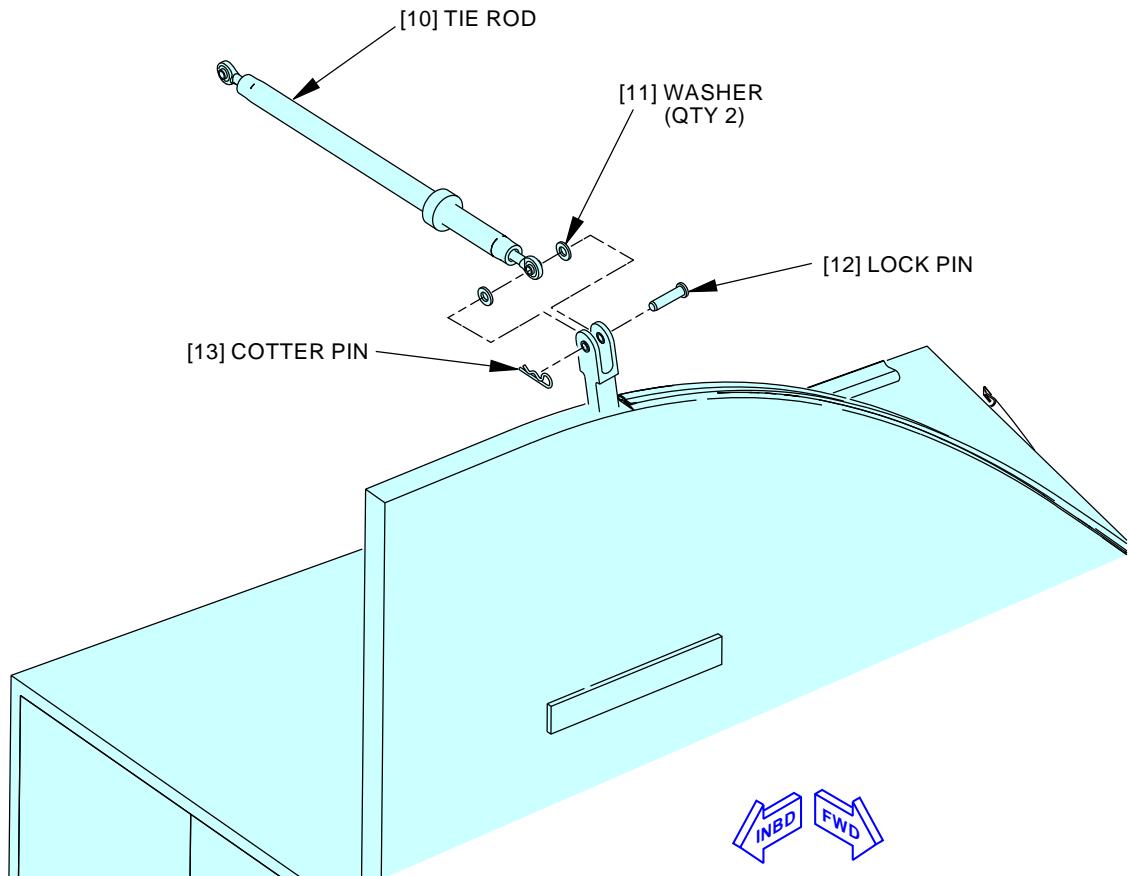
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Outboard Stowage Closet Installation
Figure 402/25-24-77-990-803 (Sheet 3 of 3)

EFFECTIVITY
AKS 007, 008

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

ATTENDANT'S PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
 - (1) Prepare for the Removal
 - (2) Removal of the attendant's panel with the LCD touch screen
 - (3) Installation of the attendant's panel with the LCD touch screen
 - (4) Replacement of the attendant panel flipguard assembly
 - (5) Return the Airplane to It's Usual Condition
- B. These tasks are applicable to the forward and the aft attendant's panels.
- C. When the attendant's panel is removed the emergency lighting will come on. This will drain the emergency lighting battery packs in approximately 10-15 minutes. These battery packs must be recharged before the airplane can be released for flight.

TASK 25-25-11-840-801

2. Prepare for the Removal

A. Preparation

SUBTASK 25-25-11-860-001

- (1) Do these steps to turn the emergency lights off if you do not have enough time to recharge the emergency lights battery pack before you dispatch the airplane.
 - (a) Make sure that these circuit breakers are closed:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT

- (b) Put the Emergency Lighting Control Switch located on the flight deck P5 overhead panel in the ARM position.
- (c) Make sure the Emergency Lighting System Control Switch located on the applicable attendant panel module is in the NORMAL position.

SUBTASK 25-25-11-860-002

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C00073	PASSENGER CABIN CREW CALL
D	19	C01423	VACUUM WASTE

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT
D	12	C01936	ATTENDANT PANELS

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F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	21	C00084	INTPH AND WARN

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C00140	WORK AND THSHD LTS
C	9	C00138	WATER QTY IND

These circuit breakers are inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027			
C	1	C01350	THRSHOLD LTS (PROV)
E	11	C00413	BRT ENTRY LTS (INOP)

————— END OF TASK ————

| AKS ALL

TASK 25-25-11-000-802

3. Attendant's Panel with LCD Touch Panel - Removal

Figure 401

A. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

B. Remove the Attendant's Panel.

SUBTASK 25-25-11-840-009

(1) Do this task: Prepare for the Removal, TASK 25-25-11-840-801.

SUBTASK 25-25-11-010-001

(2) Remove the two screws from the bottom of the panel shroud.

SUBTASK 25-25-11-020-008

(3) Pull the shroud from the attendant panel.

SUBTASK 25-25-11-020-009

(4) Remove the screws from the bottom of the attendant panel frame.

SUBTASK 25-25-11-010-002

(5) Loosen the two screws at the top of the attendant panel frame.

SUBTASK 25-25-11-020-010

(6) Lift the panel and pull forward to disconnect the electrical connector.

NOTE: Make sure to handle the panel with care. It is easily damaged.

————— END OF TASK ————

EFFECTIVITY
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TASK 25-25-11-400-802

4. Attendant's Panel with LCD Screen - Installation

Figure 401

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Install the Attendant's Panel

SUBTASK 25-25-11-410-001

- (1) Put the attendant panel in its' correct position.

NOTE: Make sure to handle the panel with care. It is easily damaged.

SUBTASK 25-25-11-420-004

- (2) Install the screws that attach the attendant panel.

(a) Make sure that the screw holes are aligned before installing the screws.

SUBTASK 25-25-11-420-005

- (3) Put the shroud in its position on the attendant panel.

SUBTASK 25-25-11-420-006

- (4) Install the screws.

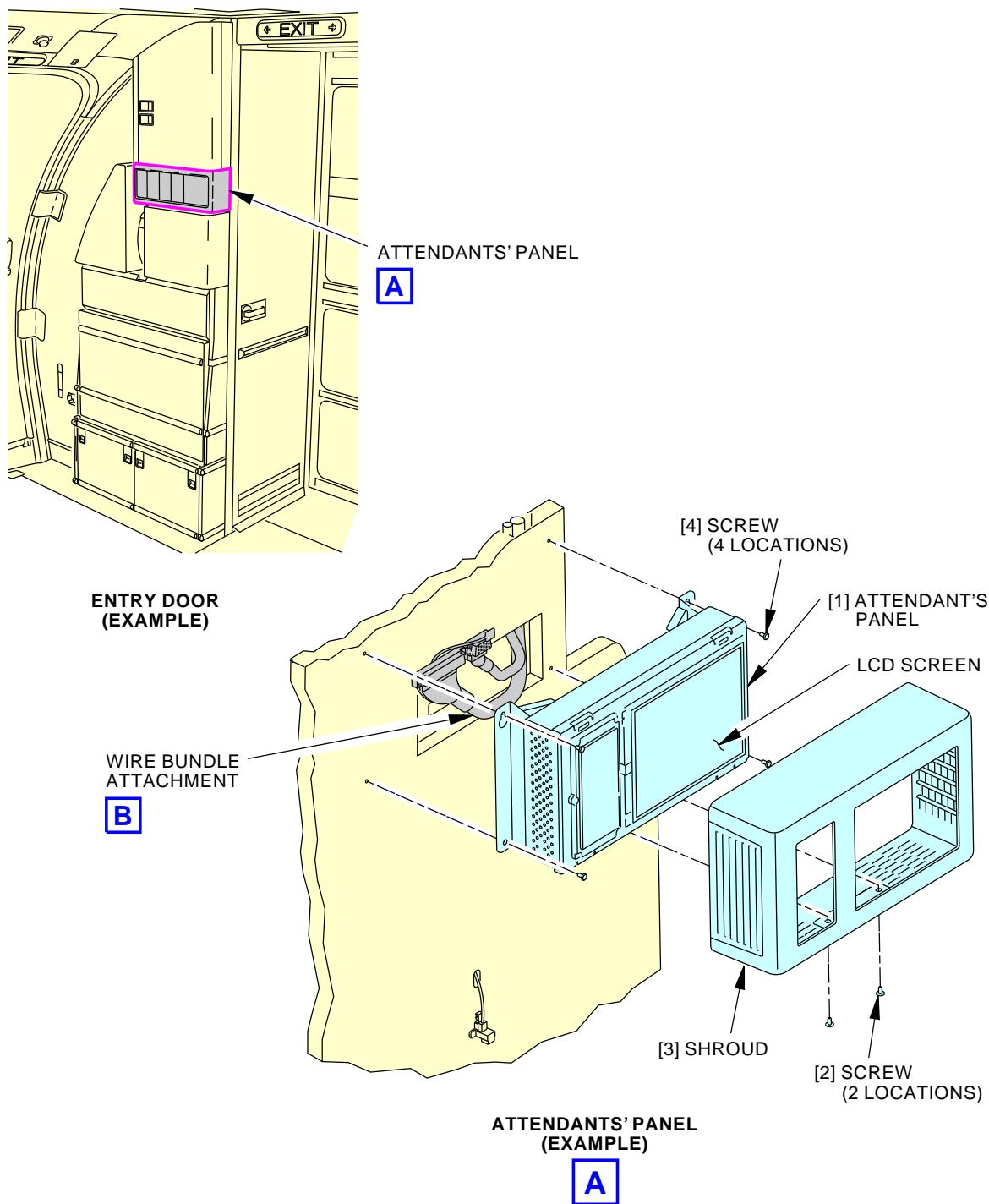
SUBTASK 25-25-11-840-008

- (5) Do this task: Return the Airplane to Its' Usual Condition, TASK 25-25-11-840-802.

———— END OF TASK ————



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Attendants' Panel Installation
Figure 401/25-25-11-990-804 (Sheet 1 of 2)

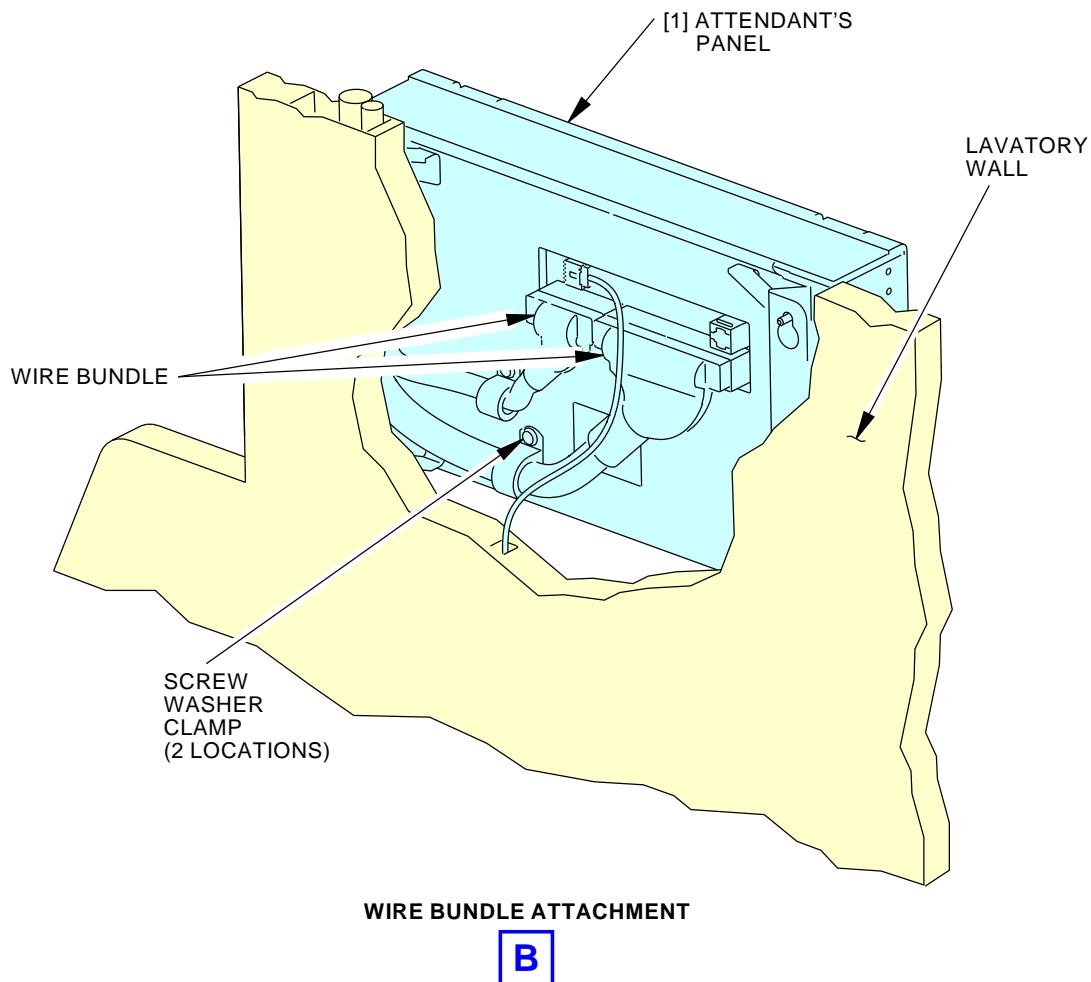
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Attendants' Panel Installation
Figure 401/25-25-11-990-804 (Sheet 2 of 2)

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TASK 25-25-11-400-803

5. Attendant Panel Flipguard Assembly Installation

(Figure 402)

A. General

- (1) This procedure provides the instructions to install the attendant panel flipguard assembly.

NOTE: This procedure starts with only the housing and the brackets for the flipguard screw on the panel. Bypass the steps that do not apply to the degree of assembly necessary.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-8305	Socket - Wrench
STD-3733	Pliers - Long Nosed

C. Consumable Materials

Reference	Description	Specification
A50082	Compound - Sealing, thread locking	MIL-S-46163 Type 1
B00130	Alcohol - Isopropyl	TT-I-735
C00047	Adhesive - Silicone RTV, 1 Part, Sealant Primer	MIL-A-46106
C00048	Primer - PR 1200 Prime Coat Adhesion Promoter	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G01659	Swab - Cotton Or Rayon, (Disposable)	
G02439	Brush - Nylon Bristle	
G50314	Tape - Masking	BAC5034-4 Type VII Class 2

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare for the Flipguard Assembly Installation

SUBTASK 25-25-11-010-003

- (1) Do this task: Attendant's Panel with LCD Touch Panel - Removal, TASK 25-25-11-000-802.



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F. Install the Flipguard Assembly

SUBTASK 25-25-11-420-007

WARNING: CLEANING SOLVENT IS COMBUSTIBLE AND VAPOR MAY BE TOXIC. AVOID PROLONGED BREATHING OF VAPOR AND PROLONGED OR REPEATED CONTACT WITH SKIN. AVOID CONTACT WITH EYES. CLEAN PARTS IN WELL-VENTILATED AREA AND USE APPROVED SAFETY EQUIPMENT.

CAUTION: OBSERVE PRECAUTIONS FOR HANDLING ELECTROSTATIC SENSITIVE DEVICES (ESD).

- (1) Do these tasks to install the flipguard damper [3]:
 - (a) Clean the area with alcohol, B00130 and a cotton wiper, G00034.
 - 1) Let it dry for 15 minutes.
 - (b) Apply a PR 1200 prime coat adhesion promoter, C00048 with a brush, G02439.
 - 1) Let it dry for 15 minutes..
 - 2) Wipe off the excess primer.
 - (c) Apply the adhesive, C00047 in the housing cavity.
 - (d) Install the flipguard damper [3] in the housing cavity over the adhesive and compress the flipguard damper [3] in place with a cotton swab, G01659.
 - 1) Wipe off the excess adhesive around the flipguard damper [3] with a clean cotton swab.
 - a) Let it dry for 1 hour at 131°F (55°C) or air dry for 24 hours.

SUBTASK 25-25-11-420-008

- (2) Do these tasks to prepare the flipguard:
 - (a) Insert one torsion spring [5] in the flipguard with a long-nosed pliers, STD-3733 (View A1, Figure 402).
 - (b) Hold the torsion spring [5] with your thumb and remove the long-nosed pliers, STD-3733.
 - (c) Adjust the torsion spring [5] into place with the long-nosed pliers, STD-3733 (View A1, Figure 402).
 - (d) Insert a pin halfway into the flipguard to seal the torsion spring [5] into place.
 - (e) Adjust the torsion spring [5] with the long-nosed pliers, STD-3733 (View A2, Figure 402).
 - (f) Insert the second torsion spring [5] into the flipguard.
 - (g) Insert a pin all the way into the flipguard to seal the second torsion spring [5] into place (View A3, Figure 402).

SUBTASK 25-25-11-420-009

- (3) Do these tasks to install the flipguard:
 - (a) Apply masking tape, G50314 on the housing to protect the surface of the housing.
 - (b) Position the flipguard assembly [4] on the housing (View A4, Figure 402).

NOTE: Torsion springs must line up with the housing holes.
 - (c) Adjust the torsion spring [5] into place with the long-nosed pliers, STD-3733.
 - (d) Insert the flipguard screw [1] into the housing and the flipguard assembly [4] (View A5, Figure 402).
 - (e) Adjust the torsion spring [5] with the long-nosed pliers, STD-3733.
 - 1) Use the screw [1] to push the pin out from the flipguard assembly [4].



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- (f) Use a brush, G02439 to apply thread lock compound, A50082 on the two outside threads of the flipguard screw [1].
- (g) Install the flipguard nut [2] on the flipguard screw [1].
 - 1) Use a 0.125 in. (3.2 mm) socket, SPL-8305 and tighten the nut to 1.8 in-lb (0.2 N·m).

NOTE: Use a second nut driver to prevent the screw from turning.

SUBTASK 25-25-11-210-001

- (4) Make sure that when you open and release the flipguard cover, it springs back to the closed position.

SUBTASK 25-25-11-420-010

- (5) Do this task: Attendant's Panel with LCD Screen - Installation, TASK 25-25-11-400-802.

———— END OF TASK ————

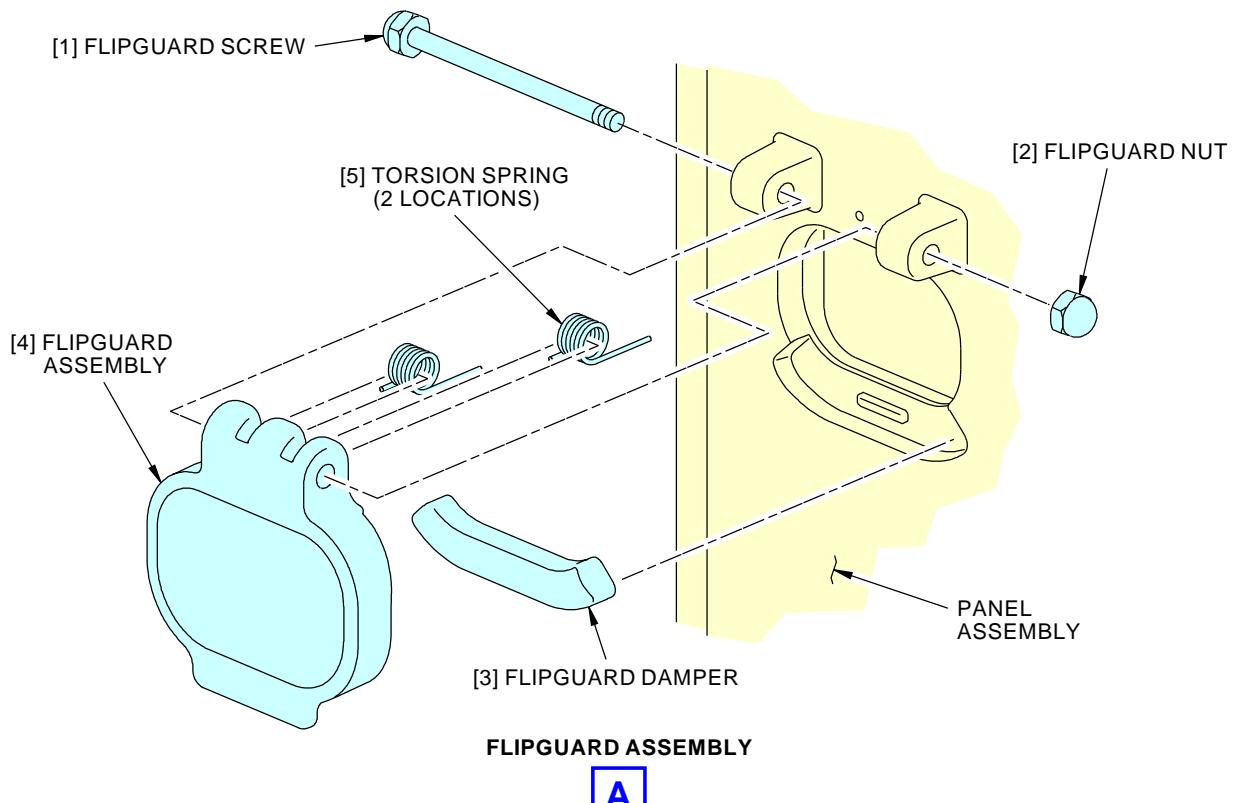
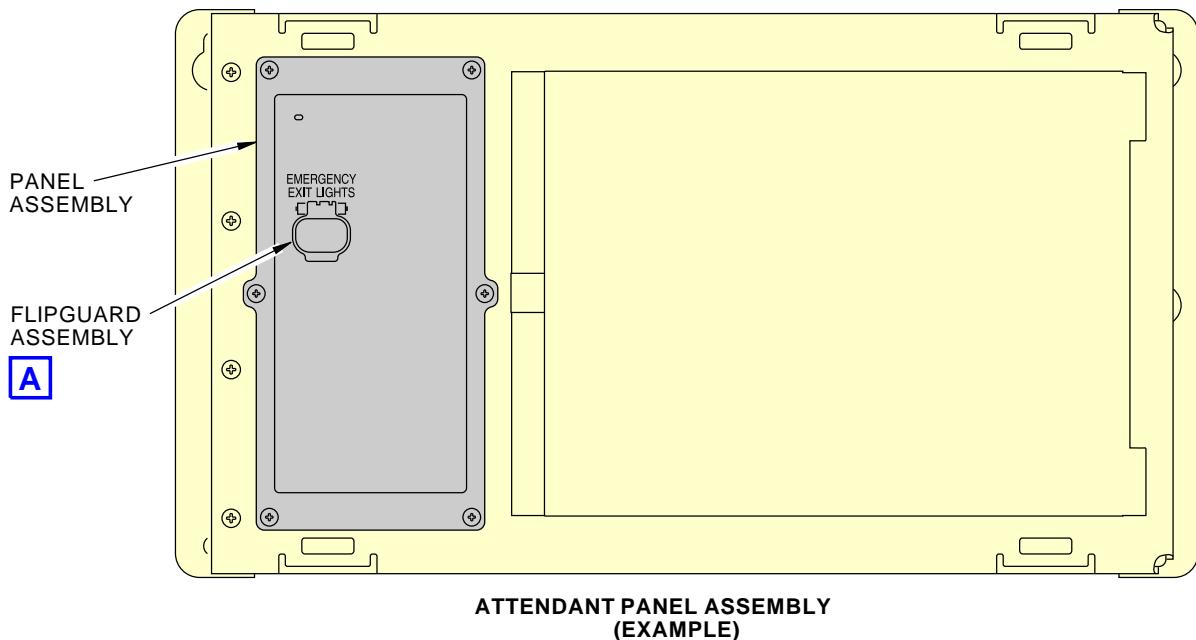
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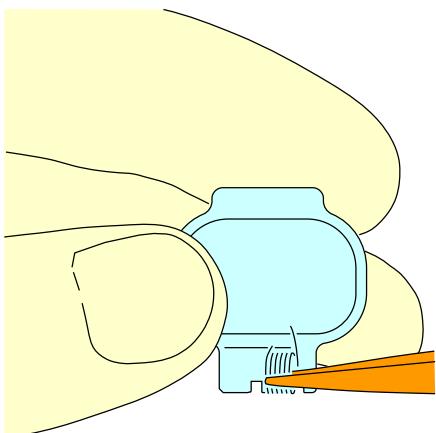
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**Flipguard Assembly Installation
Figure 402/25-25-11-990-805 (Sheet 1 of 2)**

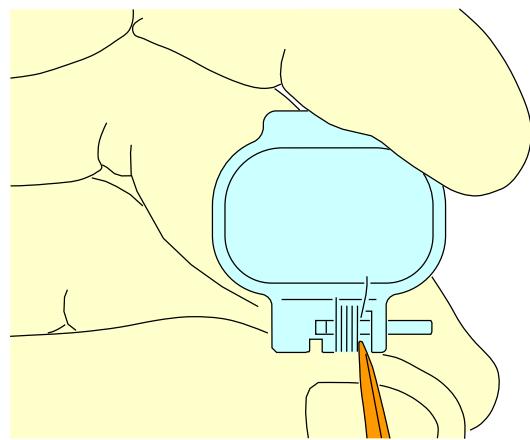
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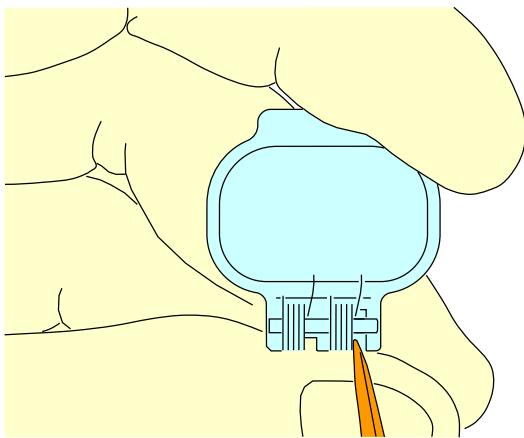
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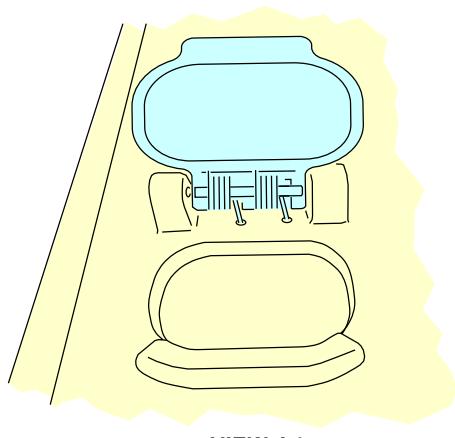
VIEW A1



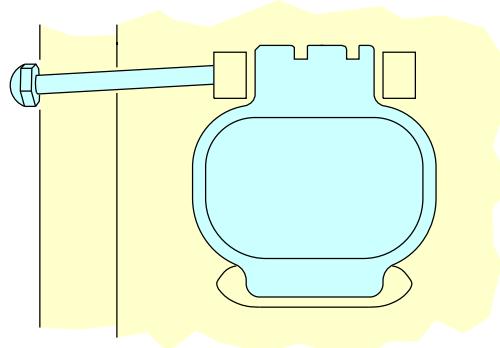
VIEW A2



VIEW A3



VIEW A4



VIEW A5

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Flipguard Assembly Installation
Figure 402/25-25-11-990-805 (Sheet 2 of 2)

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TASK 25-25-11-840-802

6. Return the Airplane to Its' Usual Condition

A. References

Reference	Title
23-42-03-470-801	Attendant Control Panel (ACP) Software Loading (P/B 201)
23-42-03-700-801	Attendant Control Panel (ACP) Configuration Check (P/B 201)
23-42-03-710-801	Attendant Control Panel - Operational Test (P/B 501)
33-20-00-710-804-001	Passenger Compartment Lights - Operational Test (P/B 501)
33-51-00 P/B 501	EMERGENCY LIGHTS - ADJUSTMENT/TEST
33-51-06-610-802	Power Supply - Charge the Battery Packs (P/B 201)

B. Procedure

SUBTASK 25-25-11-840-002

- (1) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	9	C00073	PASSENGER CABIN CREW CALL
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT
D	19	C01423	VACUUM WASTE

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT
D	12	C01936	ATTENDANT PANELS

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	21	C00084	INTPH AND WARN

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
C	3	C00140	WORK AND THSHD LTS
C	9	C00138	WATER QTY IND

These circuit breakers are inoperative and should remain open:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
AKS 001-025, 027			
C	1	C01350	THRSHOLD LTS (PROV)
E	11	C00413	BRT ENTRY LTS (INOP)

AKS ALL

SUBTASK 25-25-11-840-003

- (2) Return the emergency lights system back to its normal configuration.

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- (a) Do the applicable tasks in this procedure: EMERGENCY LIGHTS - ADJUSTMENT/TEST, PAGEBLOCK 33-51-00/501.
- (b) Charge the battery packs if it is necessary. Do this task: Power Supply - Charge the Battery Packs, TASK 33-51-06-610-802.

SUBTASK 25-25-11-710-004

- (3) Do the applicable test of the entry lights: Passenger Compartment Lights - Operational Test, TASK 33-20-00-710-804-001.

NOTE: Do only the applicable steps.

SUBTASK 25-25-11-470-002

- (4) Do this task if it is necessary: Attendant Control Panel (ACP) Configuration Check, TASK 23-42-03-700-801

SUBTASK 25-25-11-470-001

- (5) Do this task if it is necessary: Attendant Control Panel (ACP) Software Loading, TASK 23-42-03-470-801

SUBTASK 25-25-11-710-006

- (6) Do this task: Attendant Control Panel - Operational Test, TASK 23-42-03-710-801

———— END OF TASK ————

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CABIN ATTENDANTS' SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure contains the following tasks:
- (1) The removal of the attendants' seats.
 - (2) The installation of the attendants' seat.

TASK 25-25-12-000-801

2. Attendants' Seat Removal

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-12-020-001

- (1) Remove the headrest [4]. To remove it, pull on it. It is attached with hook and loop fasteners (Velcro).
 - (a) Remove the mounting bolts [5] that attach the inertia reel bracket of the seat belt to the wall.

SUBTASK 25-25-12-020-002

- (2) Open the storage compartment door below the seat and remove the mounting bolts [2].

SUBTASK 25-25-12-010-001

- (3) Do these steps to open the lower seat back:
 - (a) Open the seat pan a small distance.
 - (b) Open the fabric flap that is between the lower seat back and the upper seat back. To open it, pull it away from the upper seat back. It is attached with hook and loop fasteners (Velcro).
 - (c) Push the two latches on the lower seat back toward the center of the seat back.
 - (d) Pull the seat back out and down.

SUBTASK 25-25-12-020-003

- (4) Remove the mounting bolts [3] that are behind the lower seat back.

SUBTASK 25-25-12-020-004

- (5) Remove the seat.

SUBTASK 25-25-12-869-001

- (6) If installed, remove life vest located in the life vest container.

NOTE: N/A this step if seat is not being transported offsite. (This includes any mode of transportation)

SUBTASK 25-25-12-869-002

- (7) Route seat to shop if necessary.

———— END OF TASK ————

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TASK 25-25-12-400-801

3. Attendants' Seat Installation

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-12-420-001

- (1) Put the seat in its position.

SUBTASK 25-25-12-420-002

- (2) Open the storage compartment door below the seat and install the mounting bolts [2] and washers.

SUBTASK 25-25-12-010-002

- (3) Do these steps to open the lower seat back:

- (a) Open the seat pan a small distance.
- (b) Open the fabric flap that is between the lower seat back and the upper seat back. To open it, pull it away from the upper seat back. It is attached with hook and loop fasteners (Velcro).
- (c) Push the two latches on the lower seat back toward the center of the seat back.
- (d) Pull the seat back out and down.

SUBTASK 25-25-12-420-003

- (4) Install the mounting bolts [3] and washers that go behind the lower seat back.

SUBTASK 25-25-12-410-001

- (5) Close the lower seat back.

SUBTASK 25-25-12-420-004

- (6) Attach the inertia reel bracket of the seat belt to the wall with its bolts [5] and washers.

SUBTASK 25-25-12-420-005

- (7) Install the headrest. It is attached with hook and loop fasteners (Velcro).

SUBTASK 25-25-12-869-003

- (8) If required for overwater operation, install one each life vest in life vest container.

———— END OF TASK ————

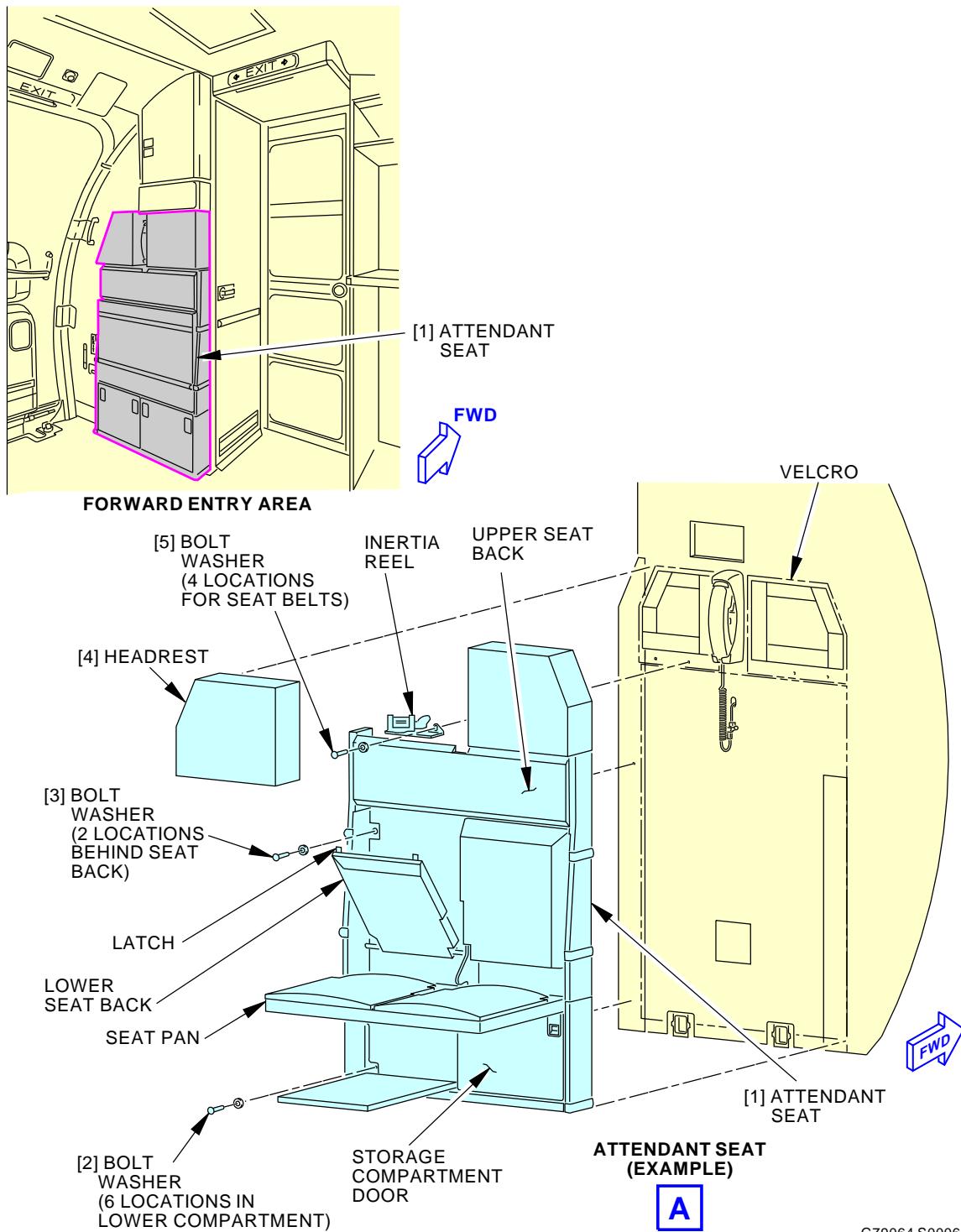
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Cabin Attendant's Seat Installation
Figure 401/25-25-12-990-803

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CABIN ATTENDANTS' SEAT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains the following tasks:
 - (1) An inspection of the attachment points for the attendants' seat and its seat belts.
 - (2) An operational check of the attendants' seat and its seat belts.

TASK 25-25-12-200-801

2. Attendants' Seat and Harness Attachment Inspection

Figure 601

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

200	Upper Half of Fuselage
-----	------------------------

B. Procedure

SUBTASK 25-25-12-210-001

- (1) Make sure the seat belts and the shoulder harness are not worn or damaged.

SUBTASK 25-25-12-210-002

- (2) Do these steps to examine the top mounting bolts [5] of the seat:
 - (a) Remove the headrest [4]. To remove it, pull on it. It is attached with hook and loop fasteners (Velcro).
 - (b) Make sure the mounting bolts [5] that attach the bracket for the inertia reels to the wall are not loose.
 - (c) Make sure the mounting bolts that attach the inertia reels of the shoulder harness to the bracket are not loose.
 - (d) Install the headrest.

SUBTASK 25-25-12-210-003

- (3) Do these steps to examine the middle mounting bolts of the seat:
 - (a) Do these steps to open the lower seat back:
 - 1) Open the seat pan a small distance.
 - 2) Open the fabric flap that is between the lower seat back and the upper seat back. To open it, pull it away from the upper seat back. It is attached with hook and loop fasteners (Velcro).
 - 3) Push the two latches on the lower seat back toward the center of the seat back.
 - 4) Pull the seat back out and down.
 - (b) Make sure the mounting bolts [3] that attach the seat to the wall are not loose.
 - (c) Close the lower seat back.

SUBTASK 25-25-12-210-004

- (4) Do these steps to examine the lower mounting bolts of the seat:
 - (a) Open the storage compartment door.
 - (b) Make sure the mounting bolts [2] that attach the seat to the wall are not loose.

EFFECTIVITY
AKS ALL

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- (c) Close the storage compartment door.

SUBTASK 25-25-12-210-005

- (5) Do these steps to examine the lower attachment points for the seat belts:
- Pull the seat cushion away from the attachment points for the seat belts.
 - Make sure the bolts are tight.

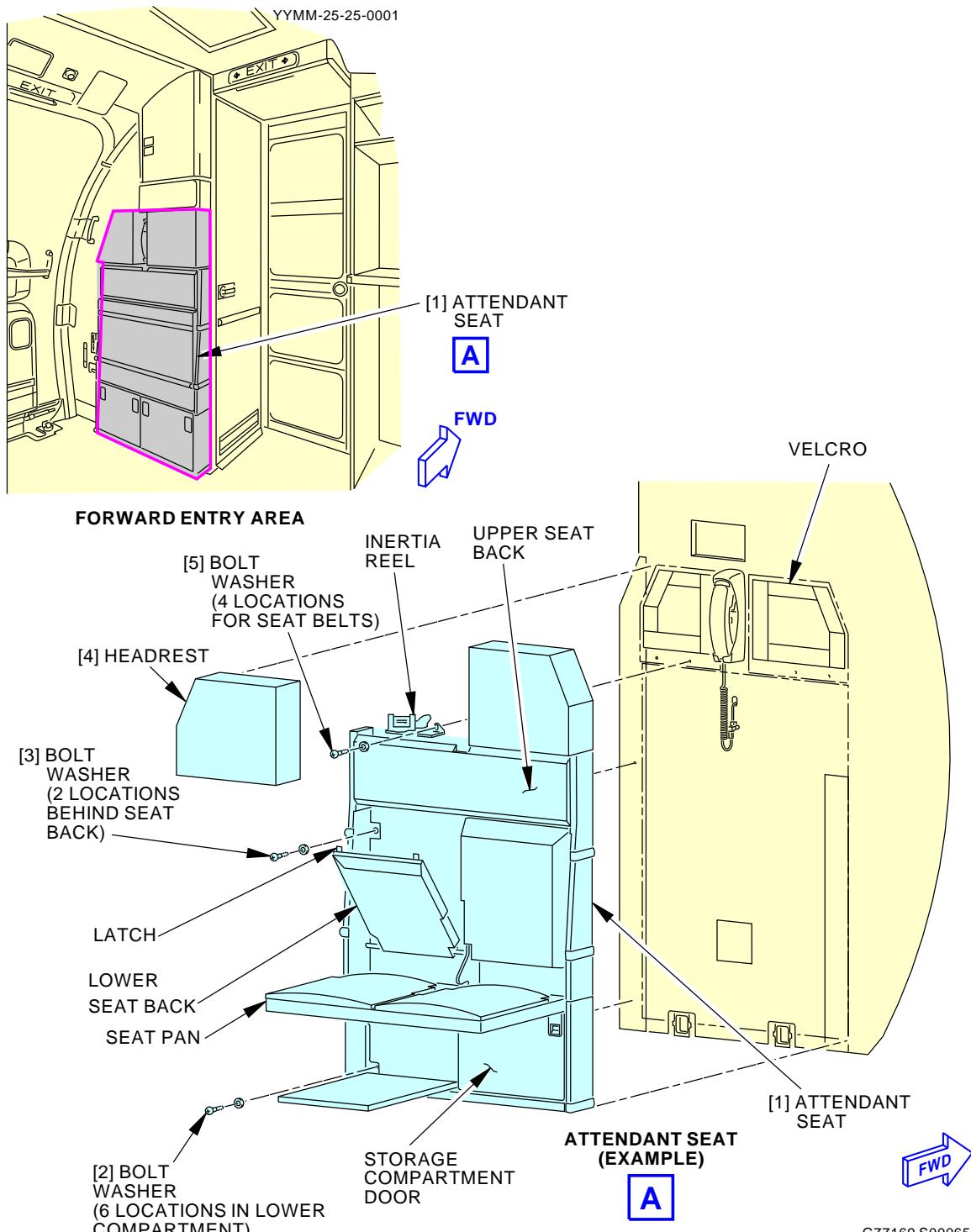
SUBTASK 25-25-12-200-001

- (6) Do these steps to inspect the pivot points of the seat pan:
- Open the seat pan.
 - Hold the seat pan near its back corner and shake the seat pan to make sure it is not loose.
 - Make sure the seat pan has no obvious cracks.

———— END OF TASK ———

EFFECTIVITY
AKS ALL

25-25-12



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Cabin Attendant's Seat Inspection/Check
Figure 601/25-25-12-990-804

EFFECTIVITY
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25-25-12



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TASK 25-25-12-710-801

3. Attendants' Seat Bottom Check

(Figure 601)

A. General

- (1) This task is an inspection of the attendants' seat bottom, referred to in this procedure as the seat pan.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-25-12-710-001

- (1) Push the seat pan fully down (open) and release it. Make sure the seat pan retracts to its fully up (closed) position without aid.

SUBTASK 25-25-12-210-006

- (2) Do these steps to examine the pivot points of the seat pan:
- Open the seat pan.
 - Hold the seat pan near its back corner and shake the seat pan to make sure it is not loose.
 - Make sure the seat pan has no obvious cracks.

———— END OF TASK ————

TASK 25-25-12-710-802

4. Inertia Reel, Attendants' Seat Harness, Operational Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-12-710-002

- (1) Do these steps to make sure the shoulder harnesses operate correctly:
- Pull the shoulder harness out approximately half way.
 - Pull suddenly on the shoulder harness.
 - Make sure the shoulder harness locks and does not extend the full length of the strap.
 - Release the shoulder harness.
 - Make sure the shoulder harness retracts.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-25-12

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CARPETS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) The removal of the carpet.
 - (2) The installation of the carpet.

TASK 25-27-15-000-801

2. Carpet Removal

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
B50003	Solvent - Cleaning - HFE 71DE	BAC5402
B50005	Solvent - Cleaning - Vertrel MCA	BAC5402
B50225	Solvent - Citra-Safe (Deodorized)	
B50226	Solvent - Citra-Safe	
G01288	Tape - Carpet	BMS5-133

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

NOTE: The carpets that are over an access panel in the floor are identified with a push stud fastener (a snap).

SUBTASK 25-27-15-020-001

- (1) Remove the track covers if it is applicable.

SUBTASK 25-27-15-020-002

- (2) Pull the carpet edges back from the carpet tape, G01288 on the cabin floor.

SUBTASK 25-27-15-020-003

- (3) Pull the carpet free from the carpet tape, G01288 and remove the carpet.

SUBTASK 25-27-15-020-004

- (4) Remove and discard the old carpet tape, G01288 from the floor.

SUBTASK 25-27-15-020-007

CAUTION: BE CAREFUL WHEN YOU REMOVE ADHESIVE FROM THE FLOOR PANEL SURFACES. DAMAGE TO THE FLOOR PANEL CAN OCCUR.

- (5) If adhesive stays on the floor, use a scraper to remove most of the adhesive.

SUBTASK 25-27-15-100-001

- (6) Remove the remaining adhesive and clean the floor panel surface with one of these solvents:



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WARNING: DO NOT GET ALCOHOL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. PUT ON A RESPIRATOR, GOGGLES, AND GLOVES. DO NOT BREATHE THE FUMES. KEEP ALCOHOL AWAY FROM SPARKS, FLAME, AND HEAT. MAKE SURE THAT THERE IS SUFFICIENT AIR FLOW IN THE WORK AREA. ALCOHOL IS POISONOUS AND FLAMMABLE. YOU CAN ABSORB POISONOUS MATERIALS FROM THE ALCOHOL THROUGH YOUR SKIN. IT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

(a) Isopropyl alcohol, B00130 (IPA) :

- 1) Make sure that the area where you will use this solvent has good air flow, and remove ignition sources.

NOTE: This solvent has a high flash point and is a lower risk. It can be safely used with the usual precautions with electrical power on the airplane.

(b) Vertrel MCA solvent, B50005 or HFE 71DE solvent, B50003

(c) Limonene solvent, B00634

(d) citra-safe solvent, B50225

(e) citra-safe solvent, B50226

NOTE: These solvents are not flammable.

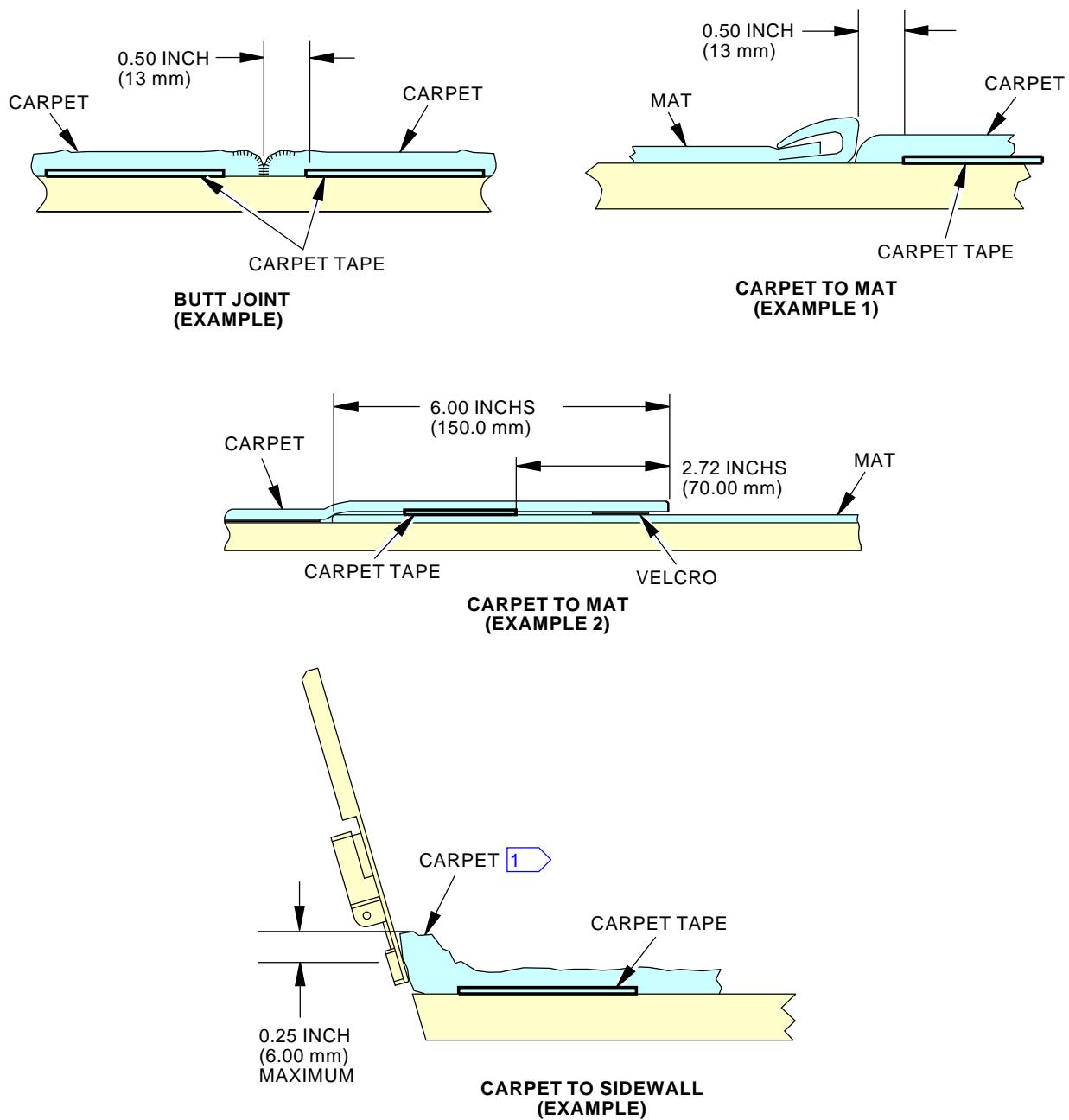
————— END OF TASK ————

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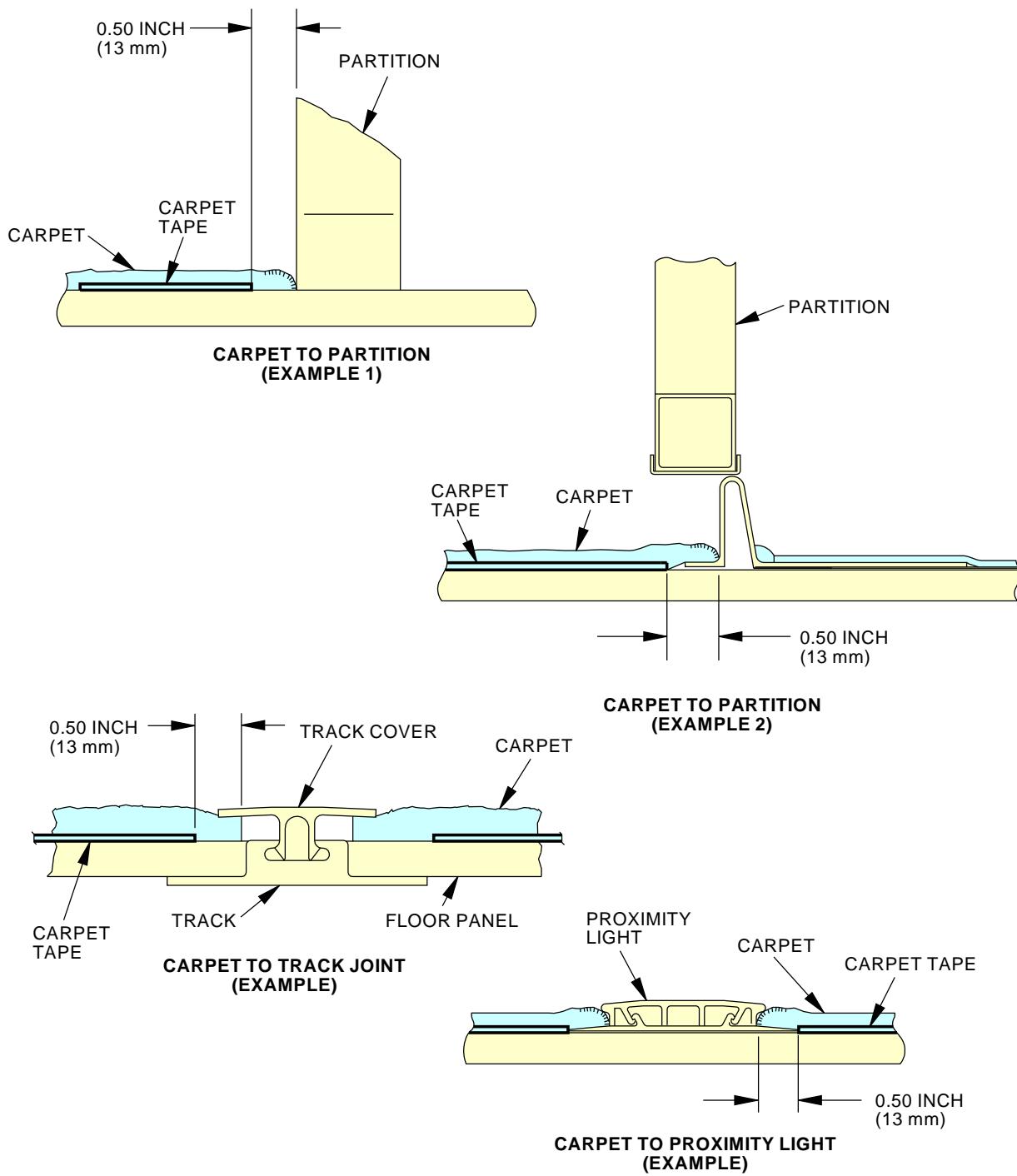
1 THIS CARPET MAY EXTEND UP THE SIDEWALL A MAXIMUM OF 0.25 INCH (6 mm). DO NOT PUT THE CARPET UNDER THE EDGE OF THE AIR GRILL.

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Carpet Installation
Figure 401/25-27-15-990-801 (Sheet 1 of 2)

EFFECTIVITY
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G66688 S0006567043_V3

Carpet Installation
Figure 401/25-27-15-990-801 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-27-15-400-801

3. Carpet - Installation

(Figure 401)

A. Tools/Equipment

Reference	Description
STD-6636	Vacuum Cleaner - wet and dry type

B. Consumable Materials

Reference	Description	Specification
G01288	Tape - Carpet	BMS5-133
G50036	Tape - Carpet, Double-sided, 5 oz/sq yd., Black on side 2. Differential Tack. Storage Life 36 Months.	BMS5-133 Type IV Class 1
G50069	Tape - Carpet, Double-backed, Adhesive - BMS5-133, Type IV, Class 1	BMS5-133 Type IV Class 1
G50155	Tape - Carpet, Double-sided, 16 oz/sq. yd., White. Storage Life 18 Months.	BMS5-133 Type II Class 1
G50156	Tape - Carpet, Double-sided, 16 oz/sq. yd., Black. Storage Life 18 Months.	BMS5-133 Type II Class 2
G50242	Fluid - Anti-Static, Nilodor Anti-Stat Static Relief (P/N C275-005)	

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-27-15-160-002

- (1) Make sure that the floor panels are clean.

SUBTASK 25-27-15-420-001

CAUTION: DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (2) Apply one of the optional tapes listed below around the edges of the carpet segments. Apply the tape approximately 0.5 in. (12.7 mm) from the edge of the carpet.
- (a) carpet tape, G01288.
 - (b) tape, G50036.
 - (c) carpet tape, G50069.
 - (d) tape, G50155.
 - (e) tape, G50156.

SUBTASK 25-27-15-420-002

- (3) Apply one of the above optional tapes down the middle along the length of the aisle carpet.

SUBTASK 25-27-15-420-003

- (4) Install the carpet in its position.

SUBTASK 25-27-15-160-003

- (5) Use a vacuum cleaner, STD-6636 to clean the carpet.

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SUBTASK 25-27-15-420-005

- (6) Apply the antistatic spray Nilodor Anti-Stat Fluid, G50242 to the carpet per the manufacturer's instructions as required.

SUBTASK 25-27-15-420-004

- (7) Install the seat track covers between the seats if applicable.

———— END OF TASK ——

EFFECTIVITY
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ENTRY AND SERVICE AREA FLOOR COVERING - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
 - (1) Entry and Service Area Floor Covering Removal,
 - (2) Entry and Service Area Floor Covering Installation.
- B. A standard and an alternate method is approved for use on all mat installations.

TASK 25-27-21-000-801

2. Entry and Service Area Floor Covering - Removal

(Figure 401)

A. References

Reference	Title
25-66-02-000-801	Floor-Mounted Escape Slide Bracket Removal (P/B 201)

B. Consumable Materials

Reference	Description	Specification
G00088	Fabric, General Purpose, Rigid, Fire Retarded, BMS8-2	
	Glass Fabric Reinforced Plastic Sheeting	
G02423	Tape - Moisture Barrier - 3 Feet Wide - 3M	
	8663	
G02500	Tape - Moisture Barrier - 4 inch Wide - 3M	
	8663DL	

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Remove the Floor Covering

SUBTASK 25-27-21-000-001

- (1) Entry Area Mat Removal (Standard Method):
 - (a) Remove the retainer plate from the edge of the mat.
 - (b) Remove or loosen the threshold if it is necessary to release the mats.

SUBTASK 25-27-21-000-002

- (2) Entry and Service Area Floor Covering Removal
 - (a) Release the mat from the edge retainers.
 - (b) Remove the sealant around the mat, if necessary.
 - (c) Release the mat from the tape that holds the mat to the waterseal.
NOTE: Be careful to prevent damage to the waterseal.
 - (d) Do the steps that follow to remove the waterseal if you replace the entire area:
 - 1) Pull the strips of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 from the floor.
 - 2) Remove fillet seal from the edges of the sidewall.

SUBTASK 25-27-21-000-003

- (3) Entry Area Mat Removal (Alternate Method):
 - (a) Remove the fasteners from the doorway retainer and the flight deck threshold.

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- (b) Remove the girt bar latch fittings. Do this task: Floor-Mounted Escape Slide Bracket Removal, TASK 25-66-02-000-801
- (c) Remove or loosen the doorway retainer and the flight deck threshold to release the mats.

CAUTION: DAMAGE CAN OCCUR TO THE WATERSEAL WHEN USING A SKIN WEDGE OR EQUIVALENT.

- 1) Remove the plastic aisle threshold, if necessary. Do this step:
 - a) Use a skin wedge or equivalent to remove the threshold from the double-back tape.

SUBTASK 25-27-21-000-004

- (4) Do these steps, when entry and service area floor covering with monuments is installed:
 - (a) Separate the edge of the mat from the tape.
 - (b) Remove the sealant around the mat, if necessary.
 - (c) Pull the mat upward from the tape and toward the monument wall.
NOTE: This area is where the mat will be trimmed.
 - (d) Put a protective strip fabric, G00088 or equivalent between the waterseal and the mat.
NOTE: The waterseal can be damaged if the fabric, G00088 or equivalent is not used to protect it.

CAUTION: WHEN CUTTING THE MAT DO NOT DAMAGE THE WATERSEAL.

- (e) Cut the mat adjacent to the monument walls.
NOTE: This is to start the mat removal.
- (f) Release the rest of the mat and pull from under the monument wall.

SUBTASK 25-27-21-000-005

- (5) To remove the waterseal if you replace the entire area, do the steps that follow:
 - (a) Pull the strips of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 from the floor.
 - (b) Remove the fillet seal from the edges of the sidewall, if necessary.

————— END OF TASK ————

TASK 25-27-21-400-801

3. Entry and Service Area Floor Covering - Installation

(Figure 401)

A. References

Reference	Title
25-66-02-400-801	Floor-Mounted Escape Slide Bracket Installation (P/B 201)
53-21-00-300-801	Repair the Polyurethane Waterseal (P/B 801)
53-21-11 P/B 801	WATER BARRIER - REPAIRS
SRM 51-20-01	Structural Repair Manual

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109

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(Continued)

Reference	Description	Specification
B01011	Solvent - Final Cleaning Of Composites Prior To Non-Structural Bonding (AMM 20-30-91/201) - Series 91	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G01288	Tape - Carpet	BMS5-133
G50179	Tape - Moisture Barrier, Adhesive One-side, Clear Polyurethane	BMS8-346 Type I

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Installation

SUBTASK 25-27-21-840-001

WARNING: DO NOT APPLY SOLVENTS BY AIR SPRAY AND DO NOT KEEP SOLVENTS IN OPEN CONTAINERS.

WARNING: SOLVENT MATERIALS USED IN CLEANING CONTAIN TOXIC INGREDIENTS. AVOID CONTACT OF THESE MATERIALS WITH SKIN OR EYES. USE WITH ADEQUATE VENTILATION OR RESPIRATOR MASKS. WEAR PROTECTIVE GLOVES WHEN USING SOLVENTS AND CLEANERS. CONSULT THE APPLICABLE HEALTH AND SAFETY REGULATIONS FOR FURTHER PRECAUTIONS.

- (1) Prepare the waterseal surface for the mat if the waterseal has not been removed and replaced.
 - (a) Examine the waterseal for cuts, tears abrasions or other signs of deterioration.
 - (b) Repair the waterseal if it is necessary.
 - 1) Do the applicable task in this procedure: WATER BARRIER - REPAIRS, PAGEBLOCK 53-21-11/801
 - 2) Do this task: Repair the Polyurethane Waterseal, TASK 53-21-00-300-801
 - (c) Clean the waterseal with an oil-free cotton wiper, G00034, moistened with Series 91 solvent, B01011, if it is necessary.
 - (d) Clean the sealant from the edge retainers.
 - 1) Do not let the solvent get on the waterseal or on the undisturbed sealant.

SUBTASK 25-27-21-840-002

- (2) Prepare the floor panels for the waterseal if the waterseal has been removed.
 - (a) Clean the floor panels:
 - 1) Apply Series 91 solvent, B01011 with a clean oil-free cotton wiper, G00034.
 - 2) Rub the surface to remove the soil.
 - 3) Use a clean cotton wiper, G00034, to remove the Series 91 solvent, B01011 before it evaporates.
 - (b) Protect the floor tracks from corrosion SRM 51-20-01.
 - (c) After you clean the floor panels do not get them dirty before you apply the waterseal.



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E. Install the Floor Covering

SUBTASK 25-27-21-420-001

- (1) Do these steps to install the waterseal if it is necessary:

CAUTION: DO NOT CUT TAPE AGAINST FLOOR PANELS, SEAT TRACKS, ATTACHMENT FITTINGS OR TAPE APPLIED ON THE FLOOR.

- (a) Apply moisture barrier tape, G50179 across the entire area perpendicular to the center line of the airplane.
NOTE: Make sure there is a minimum of a 1.0 in. (25.4 mm) overlap of each strip.
- (b) Push the tape down firmly in all areas.
- (c) Apply moisture barrier tape, G50179 across each overlap joint centered over the overlap.
- (d) Apply sealant, A00247 to the edges, cracks and small holes to make sure the waterseal and the adjacent structure has a complete seal.

SUBTASK 25-27-21-420-006

- (2) Entry Area Mat Installation (Standard Method)

- (a) Install the entry monuments as necessary.

NOTE: The galleys, lavatories and partitions that border the sides of the entry mat must be installed before the mat.

- (b) Cut the mat to the correct size.
- (c) Apply carpet tape, G01288, 6.0 in. (15.2 cm) wide, on the floor surface leaving no gaps. Keep the tape at least 0.25 in. (6.35 mm) and no more than 0.50 in. (12.70 mm) from the mat edges.

NOTE: Avoid running the tape over the raised areas and floor panel inserts. The direction of the tape is optional.

- (d) Apply adhesive, A00930, for faying surfaces on the trim as well as sealing all the cracks and small holes.

NOTE: adhesive, A00027 is optional to adhesive, A00930.

- (e) Put the mat in the correct location and push firmly on the tape.

- (f) Apply adhesive, A00930, at least 0.25 in. (6.35 mm) and no more than 0.35 in. (8.89 mm) wide, between the edge of the mat and the floor panel.

NOTE: adhesive, A00027 is optional to adhesive, A00930.

- (g) Put the edges in the edge retainers before the sealant starts to get hard.

SUBTASK 25-27-21-420-002

- (3) Entry Area Mat Installation (Alternate Method):

- (a) Do these steps to cut the mat to the correct size:

- 1) Precut a slit, centered between the monument walls, if necessary.

NOTE: Use the template or remove mat as a pattern to pre-cut the new mat.

NOTE: Cutting a slit in the mat prepares the mat for future removal.

- 2) Cut the mat to extend 0.15 in. (3.81 mm) to 0.35 in. (8.89 mm) past the galley walls.

NOTE: The mat will be located under the galley wall and the foam seals.

NOTE: Do not cut the mat around the galley partition fittings. The fittings will be installed on top of the mat.

- 3) Cut the mat to extend under the closet installation if a closet is installed.

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- 4) Cut the mat to fit around the forward fixed lavatory.

CAUTION: DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (b) Apply carpet tape, G01288, 6.0 in. (15.2 cm) wide, on the floor surface leaving no gaps. Keep the tape at least 0.25 in. (6.35 mm) and no more than 0.50 in. (12.70 mm) from the mat edges.

NOTE: Avoid running the tape over the raised areas and floor panel inserts. The direction of the tape is optional.

- (c) Apply adhesive, A00930, for faying surfaces on the slit edges of the mat running adjacent to the monuments.

NOTE: adhesive, A00027 is optional to adhesive, A00930.

- (d) Seal all the cracks and small holes, if necessary.

- (e) Put the mat in the correct location and push firmly on the tape.

- (f) Apply a 0.25 in. (6.35 mm) to 0.35 in. (8.89 mm) fillet seal between the mat and any monuments with adhesive, A00930.

NOTE: adhesive, A00027 is optional to adhesive, A00930.

- (g) Put the edges in the edge retainers before the sealant starts to get hard.

SUBTASK 25-27-21-420-003

- (4) Put the carpet in the edge retainers for the mats.

SUBTASK 25-27-21-420-004

- (5) Install or tighten the thresholds if it is necessary.

SUBTASK 25-27-21-420-005

- (6) Install the retainer plate on the edge of the mat and drain trough.

SUBTASK 25-27-21-390-001

- (7) Install the floor brackets for the escape slide adjacent to the entry and service doors if it is necessary. Do this task: Floor-Mounted Escape Slide Bracket Installation, TASK 25-66-02-400-801

SUBTASK 25-27-21-390-002

- (8) Seal the joints at the corners of the edge retainers and around the edges of the mat to make sure there is a water-tight surface.

SUBTASK 25-27-21-160-002

- (9) Remove the excess sealant.

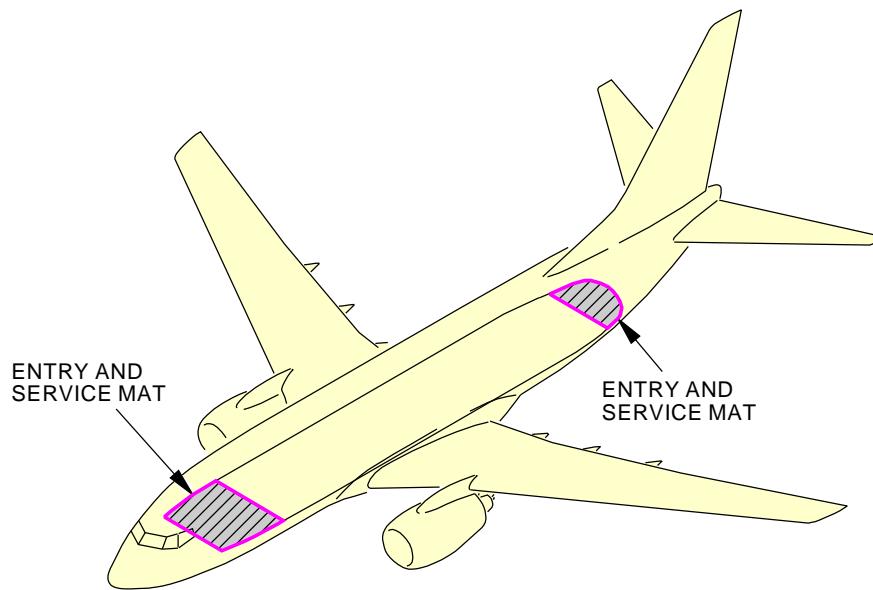
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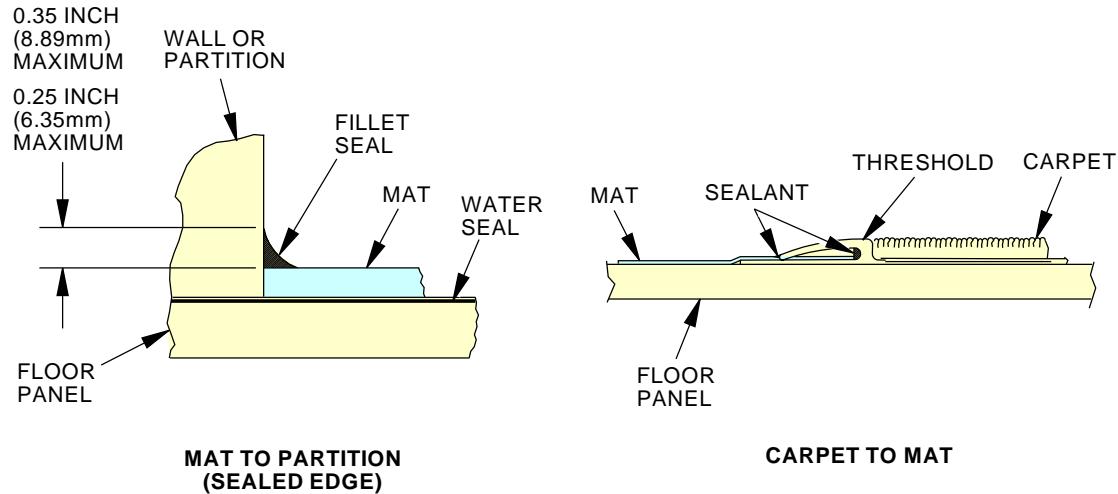
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ENTRY AND SERVICE AREA MAT



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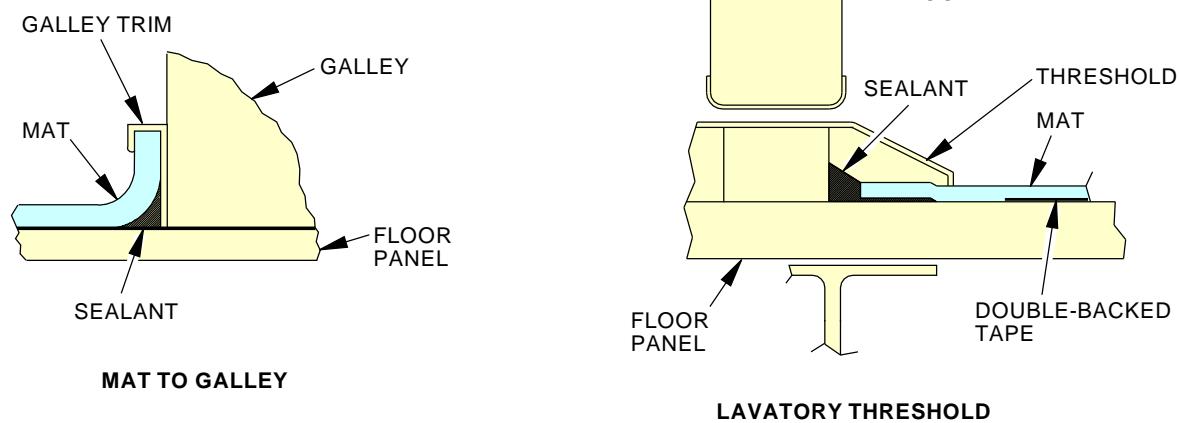
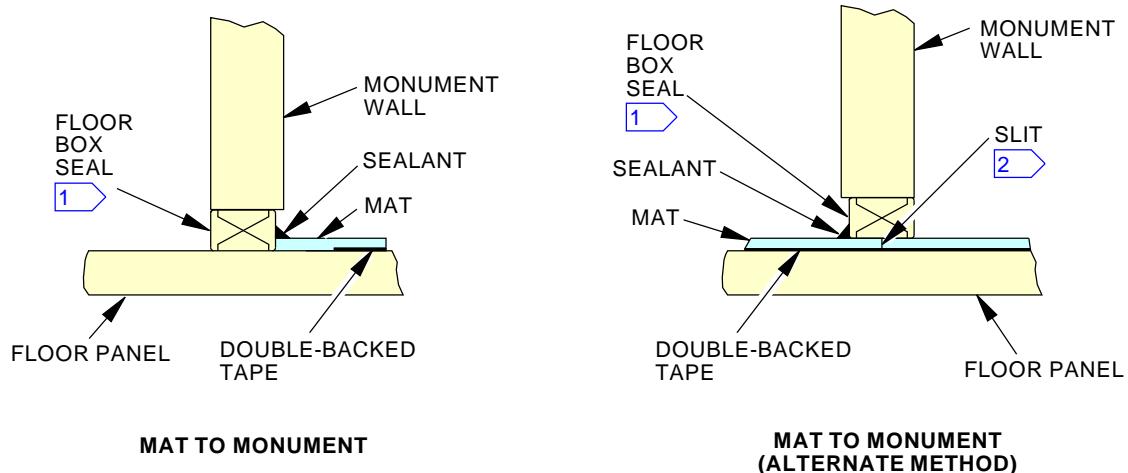
Entry and Service Area Mat Installation
Figure 401/25-27-21-990-801 (Sheet 1 of 3)

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1 SILICON FOAM, BMS 1-68

2 OPTIONAL METHOD, PRECUT A SLIT CENTERED BETWEEN MONUMENT WALLS

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Entry and Service Area Mat Installation
Figure 401/25-27-21-990-801 (Sheet 2 of 3)

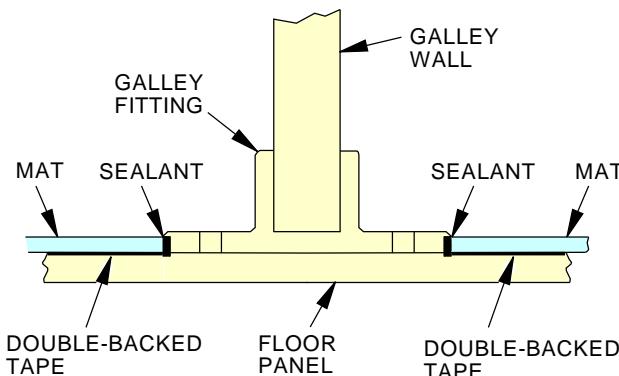
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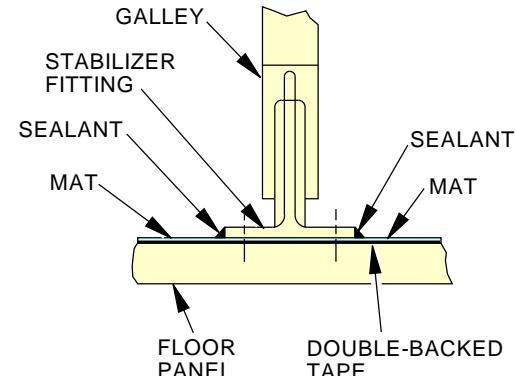
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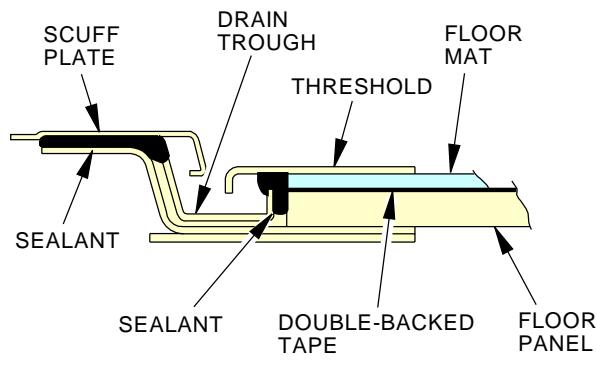
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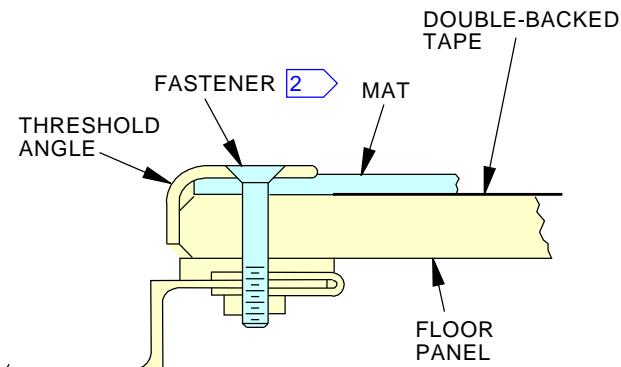
MAT TO GALLEY FITTING



MAT TO GALLEY FITTING
(ALTERNATE METHOD)



TROUGH TYPE DOOR MAT DRAIN



CONTROL CABIN THRESHOLD

INSTALL WITH SEALANT BMS 5-142 (BMS 5-95 OPTIONAL)

N57142 S0006567051_V4

Entry and Service Area Mat Installation
Figure 401/25-27-21-990-801 (Sheet 3 of 3)

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RACEWAYS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the raceway
 - (2) Installation of the raceway

TASK 25-27-31-000-804

2. Raceway - Removal

A. References

Reference	Title
25-21-46 P/B 401	SIDEWALL PANEL ASSEMBLY - REMOVAL/INSTALLATION
25-22-00-000-801	Passenger Seat - Removal (P/B 401)
25-27-15 P/B 401	CARPETS - REMOVAL/INSTALLATION

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Remove the Floor Mounted Proximity Lighting Raceway

SUBTASK 25-27-31-020-015

- (1) If it is necessary for access, do this task: Passenger Seat - Removal, TASK 25-22-00-000-801

SUBTASK 25-27-31-020-016

- (2) Remove the track covers [2].
 - (a) Disconnect the wires from the lights.
 - (b) Remove the tape and sleeving [5] from the wiring as necessary to release the wiring from the track.

SUBTASK 25-27-31-020-017

- (3) Pull the carpet away from each side of the track.

SUBTASK 25-27-31-020-018

- (4) Lift and remove the track [4] from the floor. It is attached with carpet tape.

NOTE: For installation, make a note of the location of the wiring and of the location of each light.

D. Remove the Seat Mounted Proximity Lighting Raceway

SUBTASK 25-27-31-020-019

- (1) Remove the straps that attach the proximity light cable on the seat leg. Disconnect the proximity light cable.

SUBTASK 25-27-31-020-020

- (2) Remove the passenger seats if it is necessary. Do this task: Passenger Seat - Removal, TASK 25-22-00-000-801

SUBTASK 25-27-31-020-021

- (3) Remove the track covers [2].

SUBTASK 25-27-31-020-022

- (4) Remove the carpet above the seat-to-sidewall raceways [4]. Do the applicable task in this procedure: PAGEBLOCK 25-27-15/401

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SUBTASK 25-27-31-020-023

- (5) To access the seat-to-sidewall disconnect, remove the applicable sidewall panel. Do the applicable task in this procedure: PAGEBLOCK 25-21-46/401.

SUBTASK 25-27-31-020-024

- (6) Disconnect the cables from the seat-to-sidewall connections.

SUBTASK 25-27-31-020-025

- (7) Remove the cables from the raceways [4].

SUBTASK 25-27-31-020-026

- (8) Lift and remove the raceways [4] from the floor panels.

NOTE: For installation, make a note of the location of the wire and of the location of each light.

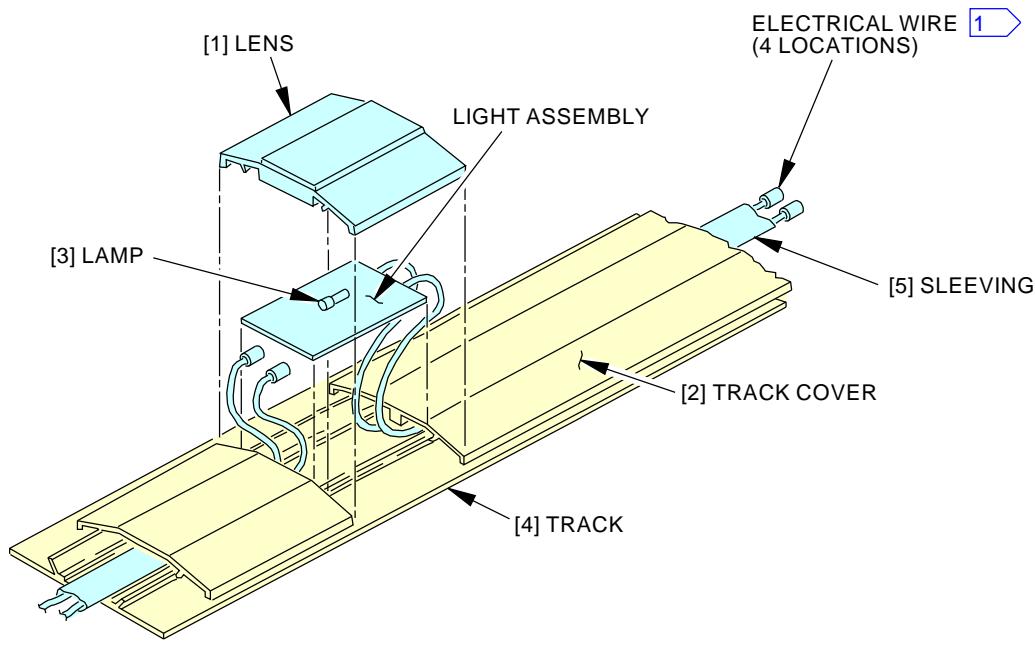
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FLOOR PROXIMITY LIGHT
(EXAMPLE)

[1] CAUTION: MAKE SURE THE WIRES ARE IN THE CENTER OF THE TRACK COVER. YOU CAN CAUSE DAMAGE TO THE WIRES IF THE WIRES ARE NOT IN THE CENTER OF THE TRACK COVER.

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Floor Proximity Raceway Installation
Figure 401/25-27-31-990-804 (Sheet 1 of 2)

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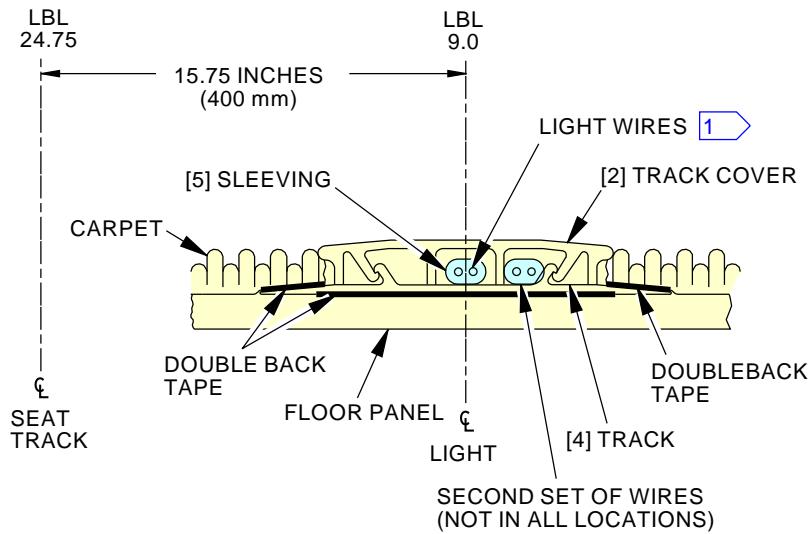
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FLOOR PROXIMITY LIGHTING RACEWAY
(EXAMPLE)

G19748 S0006567057_V2

Floor Proximity Raceway Installation
Figure 401/25-27-31-990-804 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-27-31



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TASK 25-27-31-400-804

3. Raceway - Installation

A. References

Reference	Title
25-21-46 P/B 401	SIDEWALL PANEL ASSEMBLY - REMOVAL/INSTALLATION
25-22-00-400-802	Passenger Seat - Installation (P/B 401)
25-27-15 P/B 401	CARPETS - REMOVAL/INSTALLATION
33-51-00-710-801	Emergency Lights - Operational Test (P/B 501)

B. Consumable Materials

Reference	Description	Specification
G01288	Tape - Carpet	BMS5-133
G02129	Tape - 223S (use until stock depleted)	
G50218	Strap - Plastic, Adjustable, Self-locking, 27.50 Inches (698.50MM) Long	BACS38K6

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Install the Floor Mounted Proximity Lighting Raceway

SUBTASK 25-27-31-420-033

- (1) If you are installing new track [4], then drill 1.25 in. (31.75 mm) holes in the track (the base part of the track only) for the wiring. Locate the holes to match where the wiring comes up through the floor.

SUBTASK 25-27-31-420-034

- (2) Install new carpet tape, G01288 on the floor panels for the seat-to-sidewall raceways [4] and along the seat tracks.

SUBTASK 25-27-31-420-035

- (3) Put the wiring through the holes in the raceway [4] and attach the track to the floor.

SUBTASK 25-27-31-420-036

- (4) Install the track [4] on the floor panel.
 - (a) At the expansion joint, STA 520, keep a 0.30 in. (7.62 mm) gap between the adjacent tracks [4].

SUBTASK 25-27-31-420-037

- (5) Install the light assemblies in the track [4].

SUBTASK 25-27-31-420-038

- (6) Install the sleeving [5] on the wires.

SUBTASK 25-27-31-420-039

- (7) Connect the wires to the lights.

SUBTASK 25-27-31-420-040

- (8) If necessary, use Nitto 223S Tape, G02129, to keep the wires in the center of the track cover [2].

SUBTASK 25-27-31-420-041

- (9) Put the carpet tape, G01288, on the flange of the track [4].

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SUBTASK 25-27-31-420-042

- (10) Install all the lenses [1] and the track covers [2].
 - (a) At the expansion joint, STA 520, keep a 0.30 in. (7.62 mm) gap between the adjacent track covers [2].

SUBTASK 25-27-31-420-043

- (11) Attach any wires that are not in the track to the floor with Nitto 223S Tape, G02129.

SUBTASK 25-27-31-420-044

- (12) Attach the carpet to each side of the track.

SUBTASK 25-27-31-420-045

- (13) Do this task: Emergency Lights - Operational Test, TASK 33-51-00-710-801.

NOTE: Do only the steps that are applicable to the floor proximity lights.

SUBTASK 25-27-31-420-046

- (14) Install the seats if they were removed. Do this task: Passenger Seat - Installation, TASK 25-22-00-400-802

E. Install the Seat Mounted Proximity Lighting Raceway

SUBTASK 25-27-31-420-047

- (1) Install new carpet tape, G01288[3] on the floor panels for the seat-to-sidewall raceways [4] and along the seat tracks.

SUBTASK 25-27-31-420-048

- (2) Install the raceways [4] on the floor panels.

SUBTASK 25-27-31-420-049

- (3) Install the proximity light cable in the raceways [4].

SUBTASK 25-27-31-420-050

- (4) Install the track covers [2].

SUBTASK 25-27-31-420-051

- (5) If you removed the seats, then install them. To install the seats, do this task: Passenger Seat - Installation, TASK 25-22-00-400-802.

SUBTASK 25-27-31-420-052

- (6) Connect the proximity light cable to the seat leg connection.

SUBTASK 25-27-31-420-053

- (7) Attach the proximity light cable to seat leg with the adjustable plastic strap, G50218 [1].

SUBTASK 25-27-31-420-054

- (8) Connect the proximity light cable to the sidewall connection.

SUBTASK 25-27-31-420-055

- (9) Install the carpet for the seat to sidewall raceways [4] if it was removed. Do the applicable task in this procedure: PAGEBLOCK 25-27-15/401

SUBTASK 25-27-31-420-056

- (10) Install the sidewall panels. Do the applicable task in this procedure: PAGEBLOCK 25-21-46/401

SUBTASK 25-27-31-710-007

- (11) Do this task: Emergency Lights - Operational Test, TASK 33-51-00-710-801.

NOTE: Do only the steps that are applicable to the seat mounted proximity lights.

— END OF TASK —

EFFECTIVITY
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Service Outlets - Maintenance Practices

1. General

- A. This procedure has these tasks:
- (1) Service outlets - deactivation.
 - (2) Service outlets - activation.

TASK 25-29-07-040-801

2. Service Outlets - Deactivation

A. General

- (1) This task will deactivate the power to the service outlets.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 260-8XPI Supplier: 88277 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

E. Prepare for the Removal

SUBTASK 25-29-07-020-007

- (1) Open this access door:

Number	Name/Location
117A	Electronic Equipment Access Door



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F. Procedure

WARNING: DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

SUBTASK 25-29-07-020-008

- (1) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	1	C00117	28V DC SERVICE OUTLETS

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	7	C00116	SERVICE OUTLETS
E	8	C00118	VAC OUTLET FWD
E	9	C00119	VAC OUTLET AFT

SUBTASK 25-29-07-410-002

- (2) Close this access door:

Number Name/Location

117A Electronic Equipment Access Door

G. Service Outlets - Tryout

NOTE: This tryout is to make sure that the power to the service outlets is in zero energy state.

SUBTASK 25-29-07-210-001

- (1) Use a digital/analog multimeter, COM-1793, to measure the voltage at the applicable service outlet.
 - (a) For the 115V AC service outlet, make sure that it has the correct voltage (0+/-1 VAC).
 - (b) For the 28V DC service outlet, make sure that it has the correct voltage (0+/-1 VDC).

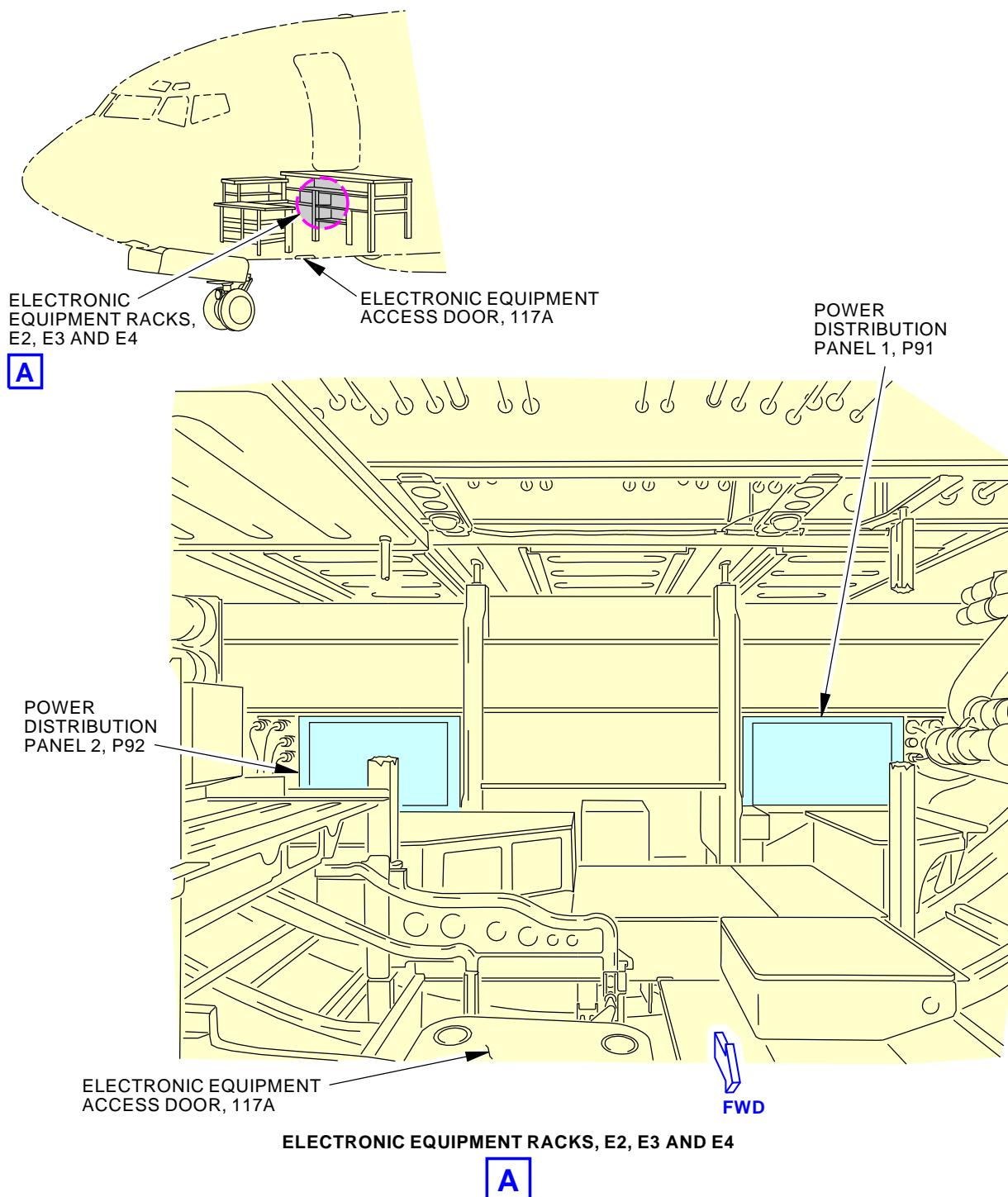
———— END OF TASK ————



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Electrical Control Panels P91, P92
Figure 201/25-29-07-990-802

EFFECTIVITY
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TASK 25-29-07-440-801

3. Service Outlets - Activation

(Figure 201)

A. General

- (1) This task will activate the power to the service outlets.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 260-8XPI Supplier: 88277 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

WARNING: DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

SUBTASK 25-29-07-420-007

- (1) Remove the safety tags and close these circuit breakers:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
F	1	C00117	28V DC SERVICE OUTLETS

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
E	7	C00116	SERVICE OUTLETS
E	8	C00118	VAC OUTLET FWD

EFFECTIVITY
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(Continued)

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	9	C00119	VAC OUTLET AFT

SUBTASK 25-29-07-210-002

- (2) Use a digital/analog multimeter, COM-1793, to measure the voltage at the applicable service outlet.
 - (a) For the 115V AC service outlet, make sure that it has the correct voltage (115 +5/-10 VAC).
 - (b) For the 28V DC service outlet, make sure that it has the correct voltage (28 +5/-5 VDC).

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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Service Outlets - Removal/Installation

1. General

- A. This procedure has these tasks:
 - (1) Service Outlet Removal
 - (2) Service Outlet Installation
- B. Vacuum cleaner outlets are located at the forward end of the forward and aft right hand side entry doors. Other service outlets are located on sidewall panels throughout the cabin. The removal and installation of these outlets is similar.

TASK 25-29-07-000-801

2. Service Outlet - Removal

A. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

B. Prepare for the Removal

SUBTASK 25-29-07-860-001

- (1) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	1	C00117	28V DC SERVICE OUTLETS

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	8	C00118	VAC OUTLET FWD
E	9	C00119	VAC OUTLET AFT

C. Remove the Service Outlet

SUBTASK 25-29-07-020-001

- (1) Remove the placard that covers the outlet housing.

SUBTASK 25-29-07-020-002

- (2) Remove the screws and spacers that attach the housing to the structure.

SUBTASK 25-29-07-020-003

- (3) Remove the housing.

SUBTASK 25-29-07-020-004

- (4) Remove the screws that attach the outlet to the structure.

SUBTASK 25-29-07-020-005

- (5) Pull the outlet away from the structure.

SUBTASK 25-29-07-020-006

- (6) Disconnect the outlet.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 25-29-07-400-801

3. Service Outlet - Installation

A. Location Zones

<u>Zone</u>	<u>Area</u>
-------------	-------------

200	Upper Half of Fuselage
-----	------------------------

B. Install the Service Outlet

SUBTASK 25-29-07-420-001

- (1) Put the outlet in its position.

SUBTASK 25-29-07-420-002

- (2) Connect the outlet.

SUBTASK 25-29-07-420-003

- (3) Install the screws that attach the outlet to the structure.

SUBTASK 25-29-07-420-004

- (4) Put the housing in its position.

SUBTASK 25-29-07-420-005

- (5) Install the screws and spacers that attach the housing to the structure.

SUBTASK 25-29-07-420-006

- (6) Install the placard over the housing.

C. Return the Airplane to its Usual Condition

SUBTASK 25-29-07-860-002

- (1) Remove the safety tags and close these circuit breakers:

F/O Electrical System Panel, P6-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	1	C00117	28V DC SERVICE OUTLETS

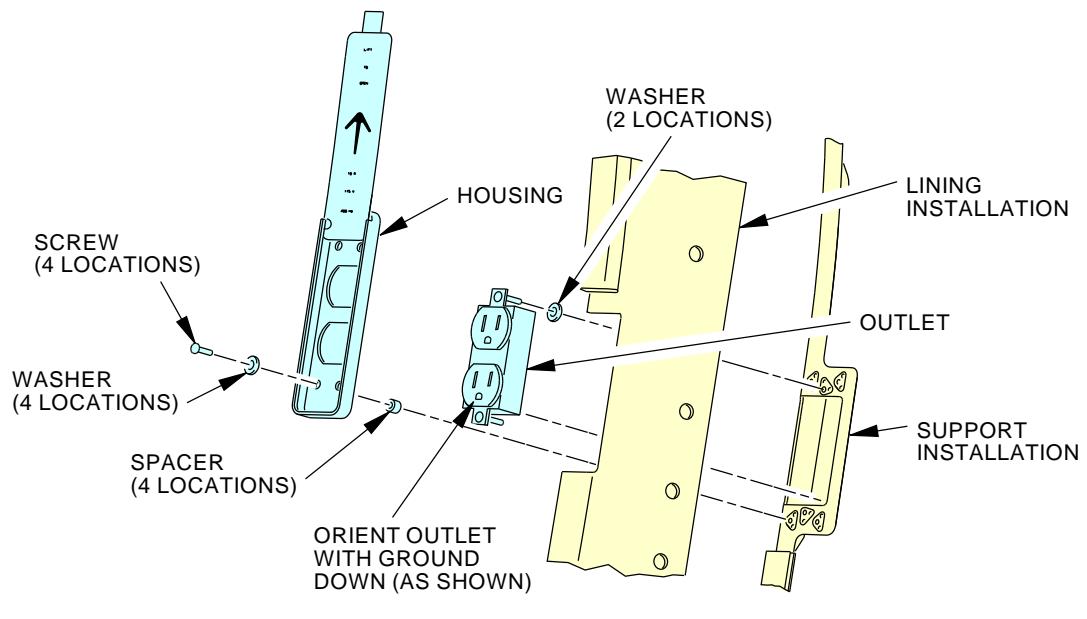
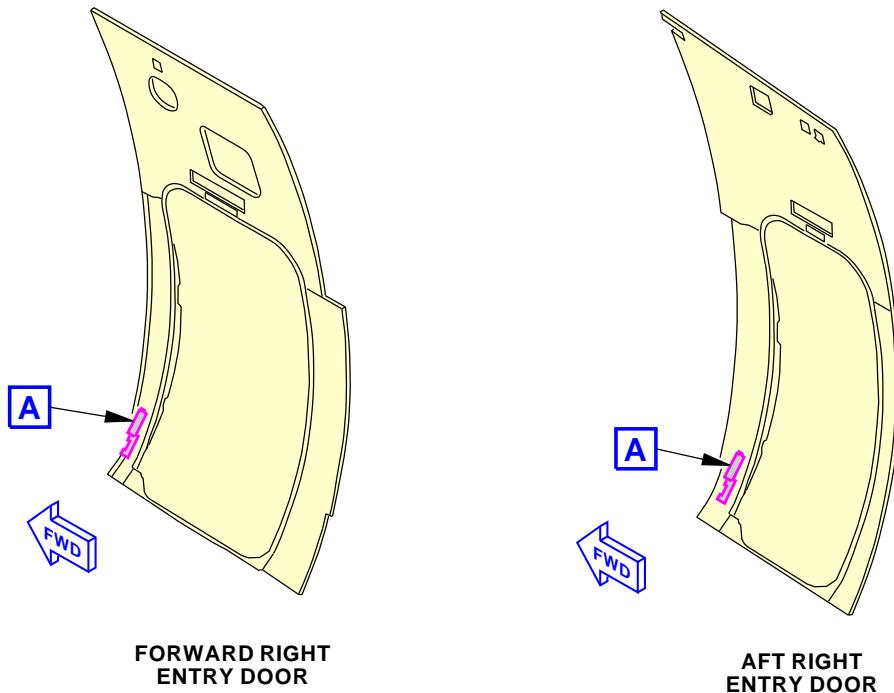
Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	8	C00118	VAC OUTLET FWD
E	9	C00119	VAC OUTLET AFT

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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Service Outlet Installation
Figure 401/25-29-07-990-801

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

GALLEY NO. 1 - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
 - (1) Galley No. 1 - deactivation.
 - (2) Galley No. 1 - activation.

TASK 25-31-11-040-801

2. Galley No. 1 - Deactivation

A. General

- (1) This task will deactivate the Galley Power Systems.

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-11-020-077

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

D. Galley Power Systems - Tryout

NOTE: This tryout is to make sure that the galley power systems are in a zero energy state.

SUBTASK 25-31-11-210-007

- (1) Make sure that the Power On indicator light on the galley is off.

SUBTASK 25-31-11-420-082

- (2) Turn the work light switch on the galley control panel to the BRT or DIM position.
 - (a) Make sure that the work light does not come on.

SUBTASK 25-31-11-020-078

- (3) Turn the work light switch on the galley control panel to the OFF position.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 25-31-11-440-801

3. Galley No. 1 - Activation

A. General

- (1) This task will activate the Galley Power Systems.

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-11-420-081

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

———— END OF TASK ————



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GALLEY NO. 1 - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Galley No. 1 Removal
 - (2) Galley No. 1 Installation

TASK 25-31-11-000-801

2. Galley No. 1 - Removal

(Figure 401)

A. General

- (1) Be careful during the removal of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-34-000-801	Forward Galley Door Doorway Header Panel - Removal (P/B 401)
25-21-35-020-801	Forward Galley Doorway Sidewall Lining Panel - Removal (P/B 401)
25-31-83-000-801	Forward Galley Header - Removal (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

D. Prepare for the Removal

SUBTASK 25-31-11-860-008

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

SUBTASK 25-31-11-020-012

- (2) Remove the light assembly for the floor proximity light if it is necessary. Do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802

SUBTASK 25-31-11-860-002

- (3) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801.



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AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-11-020-013

- (4) Remove the forward galley header if it is necessary. Do this task: Forward Galley Header - Removal, TASK 25-31-83-000-801

AKS ALL

SUBTASK 25-31-11-020-014

- (5) Remove the galley doorway header panel if it is necessary. Do this task: Forward Galley Door Doorway Header Panel - Removal, TASK 25-21-34-000-801.

SUBTASK 25-31-11-020-015

- (6) Do this task: Forward Galley Doorway Sidewall Lining Panel - Removal, TASK 25-21-35-020-801.

SUBTASK 25-31-11-020-001

- (7) Drain the water from the applicable galley equipment.

SUBTASK 25-31-11-020-022

- (8) Remove the carts and all of the other equipment from the galley.

E. Galley Removal

SUBTASK 25-31-11-020-016

- (1) Disconnect the electrical power at the connections in the ceiling above the galley.
(a) Get access through the access door in the forward lowered ceiling.
(b) Disconnect the electrical connectors [8].
(c) Disconnect the ground strap [4] from the ground stud [3] at the top of the galley.

SUBTASK 25-31-11-020-017

- (2) Disconnect the water supply at the connections in the ceiling above the galley.
(a) Get access through the access door in the forward lowered ceiling.
(b) Cut the plastic tie-straps [7] that attach the shroud [6] on the water connection [5].
(c) Disconnect the water supply connection [5] at the top of the galley.

SUBTASK 25-31-11-020-009

- (3) Through the applicable lower access panel, loosen the clamp, then disconnect the door flexible duct [13].

SUBTASK 25-31-11-020-010

- (4) If applicable, through the lower access panel, loosen the clamp, then disconnect the drain line [12].

SUBTASK 25-31-11-020-003

- (5) Remove the tie rod [1].
(a) Remove the quick-release pin [2] that attaches the tie rod [1] to the galley.

SUBTASK 25-31-11-020-004

- (6) Remove the coverplate on the floor hard points.

SUBTASK 25-31-11-020-005

- (7) Remove the sealant to get access to the fasteners, if it is necessary.

EFFECTIVITY
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SUBTASK 25-31-11-020-006

- (8) Remove the bolts [9], washers [10], and shims [11], at the four hard point locations.
NOTE: Keep the shims for the galley installation. Record the quantity of shims for a given location when you remove the shims.

SUBTASK 25-31-11-020-011

- (9) If applicable, remove the stabilizer [14].
(a) Remove the bolts [15] and washers [16], at the stabilizer [14].
(b) Remove the stabilizer [14].

SUBTASK 25-31-11-140-001

- (10) Remove fillet sealant from between galley mat and galley.

SUBTASK 25-31-11-020-008

- (11) Remove the galley.

———— END OF TASK ———

TASK 25-31-11-400-801

3. Galley No. 1 - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-34-400-801	Forward Galley Door Doorway Header Panel - Installation (P/B 401)
25-21-35-420-801	Forward Galley Doorway Sidewall Lining Panel - Installation (P/B 401)
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
25-31-83-400-801	Forward Galley Header - Installation (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

D. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right



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E. Galley Installation

SUBTASK 25-31-11-210-001

- (1) Do a check of the water barrier on the galley floor for damage. If necessary do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 25-31-11-100-001

- (2) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-11-350-001

- (3) Repair the galley mat if it is necessary.

SUBTASK 25-31-11-420-001

- (4) Move the galley inboard near its final position.

SUBTASK 25-31-11-420-006

- (5) Connect the galley ground strap [4] to the ground stud [3].
- (6) Do a resistance check of the static ground from the ground stud [3] on the galley to the airplane ground stud.
- (7) Make sure that the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-31-11-420-007

- (8) Connect the electrical connectors [8] in the ceiling above the galley.

SUBTASK 25-31-11-420-017

- (9) If exit light is installed, put the wires through the panel before the galley is in its final position.

SUBTASK 25-31-11-420-002

- (10) Put the galley into its final position.

SUBTASK 25-31-11-420-011

- (11) If applicable, install the stabilizer [14].
 - (a) Put the stabilizer [14] below the galley.
 - (b) Attach the stabilizer [14] with the bolts [15] and washers [16].
 - 1) Tighten the bolts [13] to 22.5 ± 2.5 in-lb (2.5 ± 0.3 N·m).
 - (c) Seal the stabilizer [14] with adhesive, A00027 or adhesive, A00027adhesive, A00930

SUBTASK 25-31-11-420-012

- (12) Connect the water supply.
 - (a) Connect the water supply connection [5] at the top of the galley.
 - (b) Install the shroud [6] on the connection [5] with plastic tie-straps [7].

SUBTASK 25-31-11-420-003

- (13) If necessary, loosely install the bolts [9], washers [10], and shims [11] at the four floor hard points.

NOTE: This will prevent galley movement while the floor seals are installed.

- (14) Install the floor seals (if required) and bond them with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-11-420-004

- (15) Install the bolts [9], washers [10], and shims [11] at the four floor hard points and with compound, C00528 to bolts.

NOTE: Install the shims as necessary. The shim installation may not be more than 3 shims per attachment fitting.

- (a) Torque the bolts [9] to 107.5 ± 17.5 in-lb (12.1 ± 2.0 N·m).

EFFECTIVITY
AKS ALL

25-31-11



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SUBTASK 25-31-11-420-005

- (16) Install the hard point coverplates and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-11-820-002

- (17) Attach the tie rod [1] to the attachment fitting on the top of the galley and on the fuselage and apply compound, C00528, to the bolt.

- (a) Adjust the tie rod [1] to the correct length.

1) Adjust only the end of the assembly without the lockwasher and the lockwire.

2) Make sure the that thread of the tie rod blocks the inspection hole in the body of the tie rod.

3) Tighten the jammnut.

- (b) Install the quick-release pin [2] at the galley end of the tie rod [1].

NOTE: Install the end of the tie rod [1] with the lockwasher and the lockwire at the fitting on the fuselage.

SUBTASK 25-31-11-420-013

- (18) If applicable, through the lower outboard access panel, connect the drain line [12] and tighten the clamp.

SUBTASK 25-31-11-420-008

- (19) Through the applicable lower outboard access panel, connect the door flexible duct [13] and tighten the clamp.

SUBTASK 25-31-11-420-014

- (20) Install the access covers and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-11-420-009

- (21) If applicable, install the light assembly for the floor proximity light (Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802).

SUBTASK 25-31-11-390-001

- (22) Apply a 0.25 in. (0.64 cm) - 0.35 in. (0.89 cm) fillet seal between the mat and galley with adhesive, A00027 or adhesive, A00930.

F. Put the Airplane in Its Usual Condition.

SUBTASK 25-31-11-410-001

- (1) Do this task: Forward Galley Door Doorway Header Panel - Installation, TASK 25-21-34-400-801

SUBTASK 25-31-11-410-002

- (2) Do this task: Forward Galley Doorway Sidewall Lining Panel - Installation, TASK 25-21-35-420-801

AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-11-410-003

- (3) If applicable, do this task: Forward Galley Header - Installation, TASK 25-31-83-400-801

AKS ALL

SUBTASK 25-31-11-420-019

- (4) Install the equipment that you removed from the galley.



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SUBTASK 25-31-11-860-006

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (5) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

SUBTASK 25-31-11-710-001

- (6) Make sure the electrical components in the galley operate correctly.

SUBTASK 25-31-11-710-004

- (7) If an exit light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-11-710-005

- (8) If a floor proximity light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-11-710-006

- (9) If a No Smoking Fasten Seat Belt sign is installed on the galley, make sure that it comes on.

SUBTASK 25-31-11-710-003

- (10) Do this task if it is necessary: Potable Water System - Leak Test, TASK 38-10-00-790-801

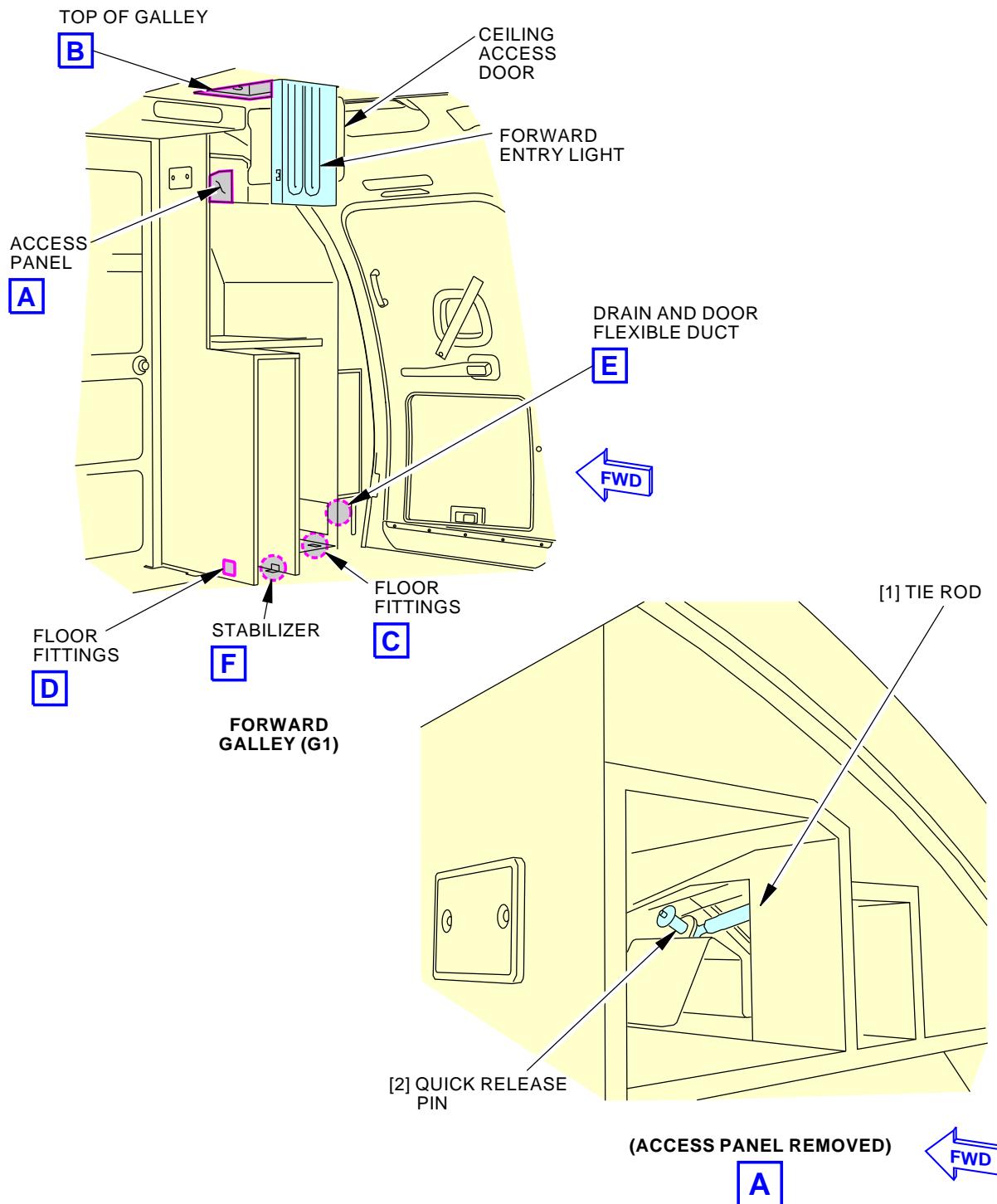
SUBTASK 25-31-11-670-001

- (11) Do this task if it is necessary: Potable Water System - Disinfectant, TASK 38-10-00-600-801

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-31-11

**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**


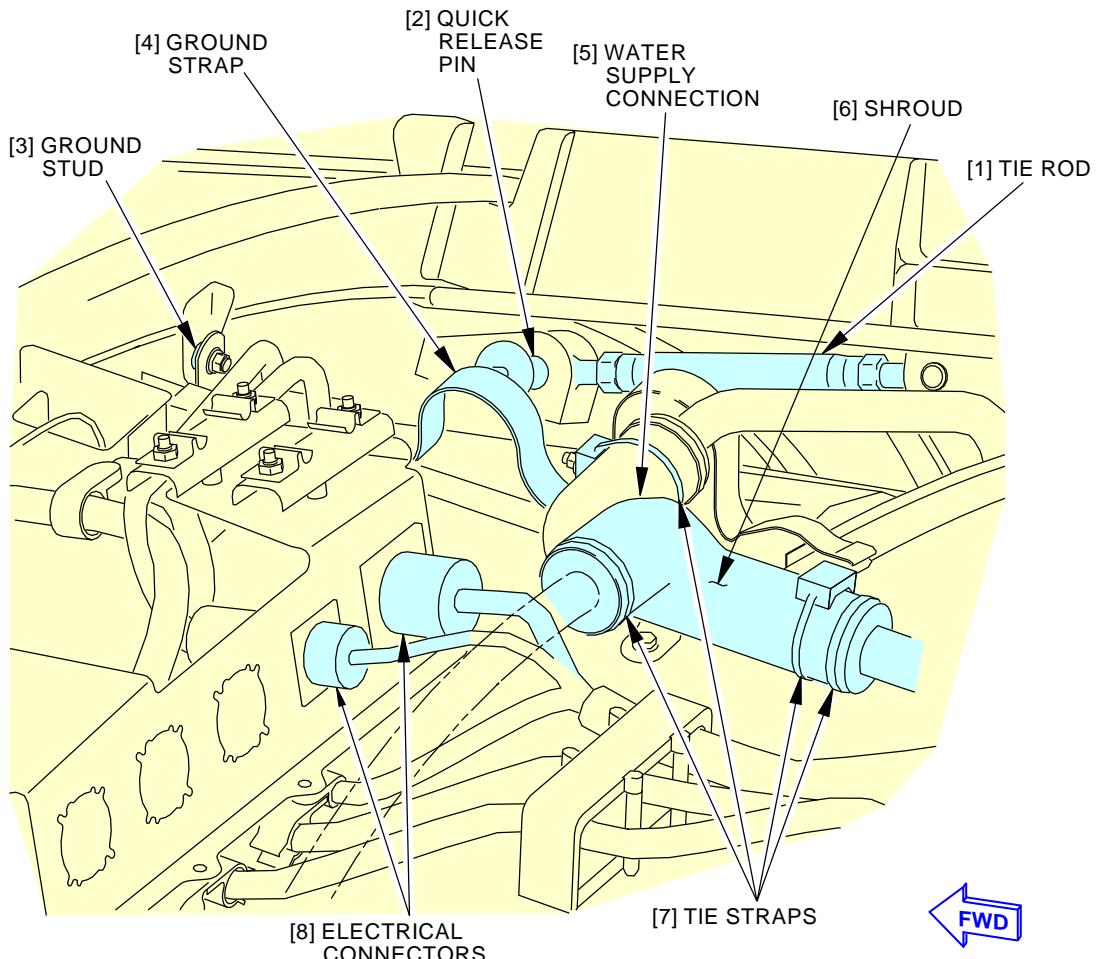
1305363 S0000225595_V3

Galley No. 1 Installation
Figure 401/25-31-11-990-801 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

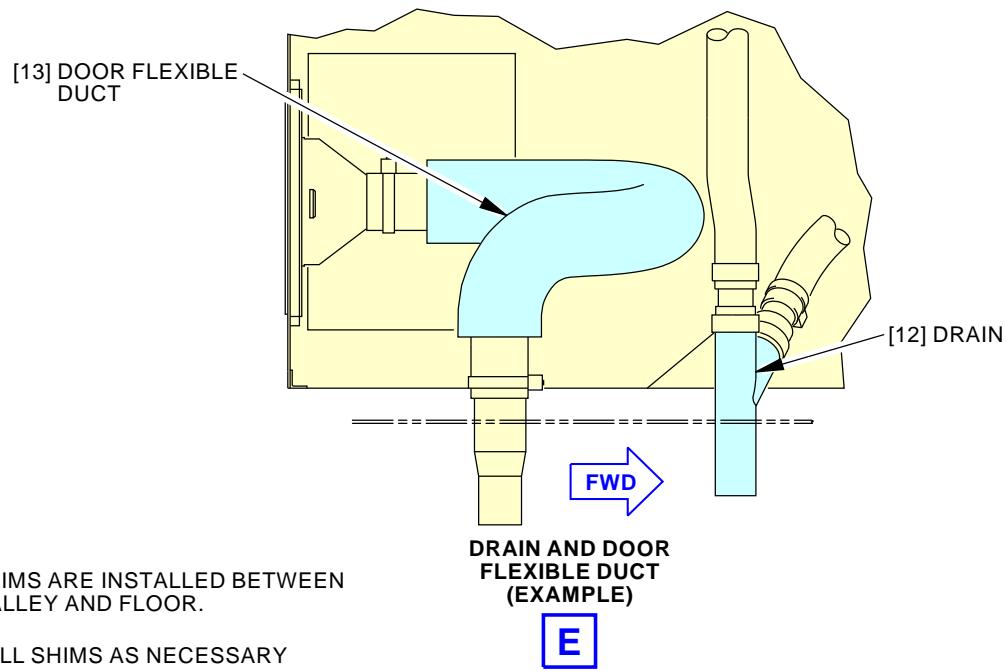
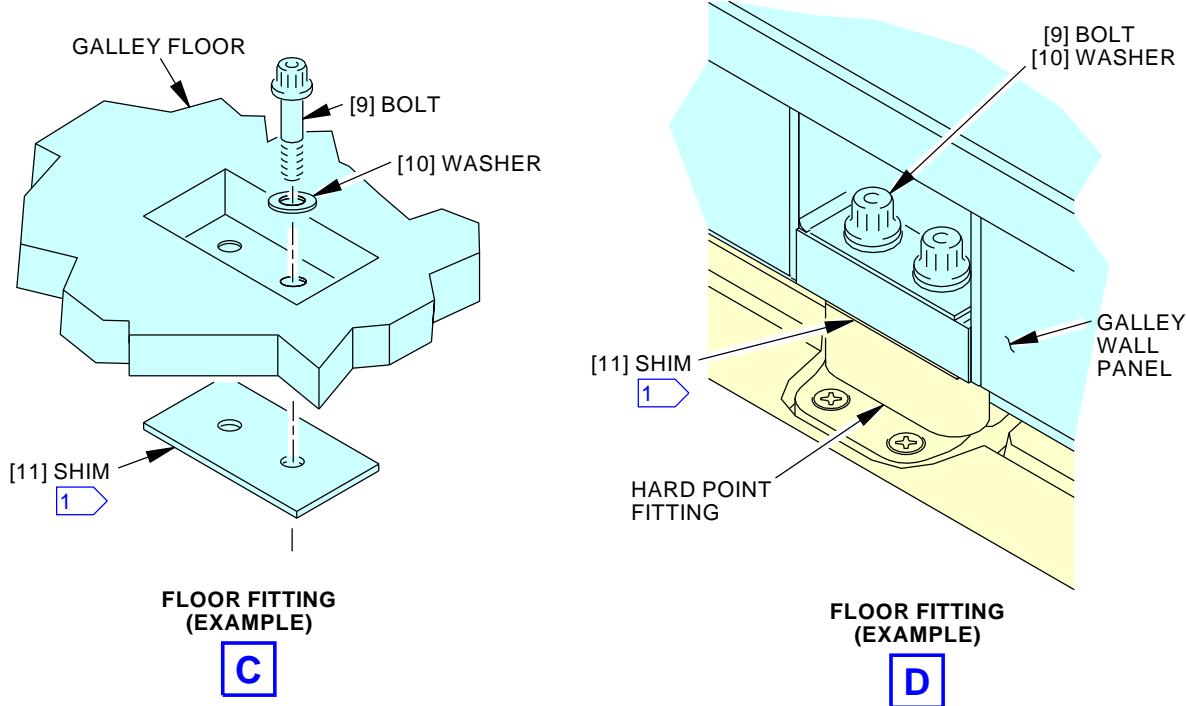
D633A101-AKS

25-31-11


**TOP OF GALLEY
(EXAMPLE)**
B

G03639 S0006567200_V3

Galley No. 1 Installation
Figure 401/25-31-11-990-801 (Sheet 2 of 4)
EFFECTIVITY
AKS ALL
25-31-11



N78704 S0006567203_V4

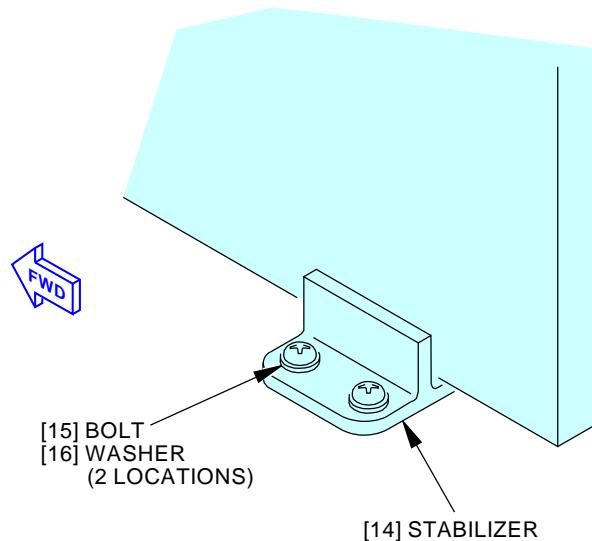
Galley No. 1 Installation
Figure 401/25-31-11-990-801 (Sheet 3 of 4)

EFFECTIVITY
 AKS ALL

D633A101-AKS

25-31-11

BOEING
737-600/700/800/900
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STABILIZER
(EXAMPLE)

F

H00290 S0006567204_V3

Galley No. 1 Installation
Figure 401/25-31-11-990-801 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

25-31-11



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GALLEY NO. 2 - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Galley No. 2 - deactivation.
 - (2) Galley No. 2 - activation.

TASK 25-31-21-040-801

2. Galley No. 2 - Deactivation

A. General

- (1) This task will deactivate the Galley Power Systems.

B. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-21-020-103

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

D. Galley Power Systems - Tryout

NOTE: This tryout is to make sure that the galley power systems are in a zero energy state.

SUBTASK 25-31-21-210-007

- (1) Make sure that the Power On indicator light on the galley is off.

SUBTASK 25-31-21-420-092

- (2) Turn the work light switch on the galley control panel to the BRT or DIM position.
 - (a) Make sure that the work light does not come on.

SUBTASK 25-31-21-020-104

- (3) Turn the work light switch on the galley control panel to the OFF position.

———— END OF TASK ————



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TASK 25-31-21-440-801

3. Galley No. 2 - Activation

A. General

- (1) This task will activate the Galley Power Systems.

B. Location Zones

<u>Zone</u>	<u>Area</u>
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-21-420-091

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

———— END OF TASK ————



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GALLEY NO. 2, 2A - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Galley No. 2 Removal
 - (2) Galley No. 2 Installation

| AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

- B. Galley No. 2 has an attached closet. This closet must be removed and installed with the galley.

AKS ALL

TASK 25-31-21-000-801

2. Galley No. 2 - Removal

(Figure 401)

A. General

- (1) Be careful during the removal of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-34-000-801	Forward Galley Door Doorway Header Panel - Removal (P/B 401)
25-21-35-020-801	Forward Galley Doorway Sidewall Lining Panel - Removal (P/B 401)
25-31-83-000-801	Forward Galley Header - Removal (P/B 401)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

D. Prepare for the Removal

SUBTASK 25-31-21-860-004

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

EFFECTIVITY
AKS ALL

25-31-21



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AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-010-001

- (2) Do this task: Forward Galley Header - Removal, TASK 25-31-83-000-801

AKS ALL

SUBTASK 25-31-21-010-002

- (3) Do this task: Forward Galley Door Doorway Header Panel - Removal, TASK 25-21-34-000-801

SUBTASK 25-31-21-010-003

- (4) Do this task: Forward Galley Doorway Sidewall Lining Panel - Removal, TASK 25-21-35-020-801

SUBTASK 25-31-21-020-001

- (5) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801

SUBTASK 25-31-21-020-002

- (6) Drain the water from the applicable galley equipment.

SUBTASK 25-31-21-010-005

- (7) Prepare the galley for the removal procedure.

- (a) Make sure power is removed from the galley equipment.
- (b) Remove the equipment from the galley before doing the procedure.
- (c) Remove the necessary access panels from the galley to complete the task.
- (d) Remove the necessary trim panels from the galley to complete the task.

E. Galley Removal

SUBTASK 25-31-21-020-013

- (1) Disconnect the water supply at the connection at the top of the galley.
 - (a) Get access through the applicable access panel in the top of the galley.
 - (b) Disconnect the water supply connection [4] above the top of the galley.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-020-004

- (2) Through the lower access panel, loosen the clamp [5], then disconnect the drain line [6].

AKS ALL

SUBTASK 25-31-21-020-005

- (3) Remove the tie rod [9].
 - (a) Remove the quick-release pin [10] that attaches the tie rod [9] to the galley lug fitting [11].

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-020-006

- (4) To remove the galley floor hard points, do these steps:
 - (a) Remove the coverplate on the floor hard points.
 - (b) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.
 - (c) Remove the bolts [12], washers [13], and shims [14] at the four hard point locations.

NOTE: Keep the shims for the galley installation. Record the quantity of shims for a given location when you remove the shims.

EFFECTIVITY
AKS ALL

25-31-21



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AIRCRAFT MAINTENANCE MANUAL

AKS 014, 019, 026, 028-999

SUBTASK 25-31-21-030-001

- (5) Remove the bolts [22] and washers [21] at the closet seat track fittings [23].

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-020-009

- (6) Do these steps to remove the stabilizer fitting [21]:

- Remove the bolts [15], washers [16], and nuts [17] at the bearing block [18].
- Remove the bearing block [18].
- Remove the bolts [19] and washers [20] at the stabilizer [21].
- Remove the stabilizer [21].

AKS ALL

SUBTASK 25-31-21-020-042

- (7) If necessary, move the galley out slightly for easier access to the electrical connectors [1] and ground stud [3].

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-020-011

- (8) Disconnect the electrical power at the connections above the galley.
- Disconnect the electrical connectors [1].

SUBTASK 25-31-21-020-012

- (9) Disconnect the ground strap [2] from the ground stud [3] at the top of the galley.

AKS ALL

SUBTASK 25-31-21-020-010

- (10) Lift up and remove the galley.

SUBTASK 25-31-21-030-002

- (11) If necessary, remove the seat track fittings at the seat track locations.

———— END OF TASK ————

TASK 25-31-21-400-801

3. Galley No. 2 - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-34-400-801	Forward Galley Door Doorway Header Panel - Installation (P/B 401)
25-21-35-420-801	Forward Galley Doorway Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
25-31-83-400-801	Forward Galley Header - Installation (P/B 401)

EFFECTIVITY
AKS ALL

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(Continued)

Reference	Title
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
51-21-92-600-801	Seat Track Filler Application (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

D. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

E. Galley Installation

SUBTASK 25-31-21-210-001

- (1) Do a check of the water barrier on the galley floor for damage. If necessary do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 25-31-21-100-001

- (2) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-21-350-001

- (3) Repair the galley mat if it is necessary.

SUBTASK 25-31-21-420-023

- (4) If necessary, install the seat track fittings at the seat track locations.
 - (a) Do this task: Seat Track Filler Application, TASK 51-21-92-600-801

SUBTASK 25-31-21-420-001

- (5) Move the galley inboard.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-420-007

- (6) Connect the galley ground strap [2] to the ground stud [3].
- (7) Do a resistance check of the static ground from the ground stud [3] on the galley to the airplane ground stud.
 - (a) Make sure the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-31-21-420-008

- (8) Connect the electrical connectors [1] in the ceiling above the galley.

AKS ALL

SUBTASK 25-31-21-820-001

- (9) Adjust the galley if it is necessary.

SUBTASK 25-31-21-420-002

- (10) Lift and put the galley into its correct position.

EFFECTIVITY
AKS ALL

25-31-21



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AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-420-027

- (11) If necessary, loosely install the bolts [12], washers [13], and shims [14] at the four hard points.
NOTE: This will prevent galley movement while the floor seals are installed.

AKS ALL

SUBTASK 25-31-21-420-003

- (12) Install the floor seals and bond them with adhesive, A00027 or adhesive, A00930.

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-420-026

- (13) Install the bolts [12], washers [13], and shims [14] at the floor hard points.
NOTE: Install the shims as necessary. The shim installation may not be more than 3 shims per attachment fitting.
(a) Apply compound, C00528 to the bolts.
(b) Torque the bolts [12] to 107.5 ± 17.5 in-lb (12.1 ± 2.0 N·m).

SUBTASK 25-31-21-420-005

- (14) Install the hard point coverplates and seal with adhesive, A00027 or adhesive, A00930.

AKS 014, 019, 026, 028-999

SUBTASK 25-31-21-420-024

- (15) Install the bolts [22] and washers [21] at the closet seat track fittings [23].

AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-420-006

- (16) Do these steps to install the stabilizer [21]:
(a) Put the stabilizer [21] below the galley.
(b) Install the bolts [19] and washers [20] at the stabilizer [21].
 1) Torque the bolts [19] to 22.5 ± 2.5 in-lb (2.5 ± 0.3 N·m).
(c) Install the bearing block [18] on the stabilizer [21].
(d) Install the bolts [15], washers [16], and nuts [17] at the bearing block [18].
(e) Seal the stabilizer with adhesive, A00930.

AKS ALL

SUBTASK 25-31-21-820-002

- (17) Do these steps to attach the tie rod [9] to the lug fitting [11] on the galley:
(a) Adjust the tie rod [9] to the correct length.
 1) Adjust only the end of the assembly without the lockwasher and the lockwire.
 2) Make sure that the thread of the tie rod blocks the inspection hole in the body of the tie rod.
 3) Tighten the jamnut.
(b) Install the quick-release pin [10] at the galley end of the tie rod [9].
NOTE: Install the end of the tie rod [9] with the lockwasher and the lockwire at the fitting on the fuselage.



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SUBTASK 25-31-21-420-009

- (18) If applicable, connect the water supply connection [4] at the top of the galley.

| AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-420-010

- (19) If applicable, through the lower outboard access panel, connect the drain line [6] and tighten the clamp [5].

AKS ALL

SUBTASK 25-31-21-420-011

- (20) If applicable, Install the access covers and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-21-390-001

- (21) Apply a fillet seal between the mat and galley wall with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-21-420-028

- (22) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801

F. Put the Airplane in Its Usual Condition.

SUBTASK 25-31-21-860-008

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

SUBTASK 25-31-21-410-014

- (2) Install the carts and all of the other equipment in the galley.

SUBTASK 25-31-21-410-015

- (3) Install the trim and access panels if they were removed.

| AKS 007, 008, 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-710-001

- (4) Make sure that the electrical components in the galley operate correctly.

AKS ALL

SUBTASK 25-31-21-710-003

- (5) If an exit light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-21-710-004

- (6) If a floor proximity light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-21-710-005

- (7) If a No Smoking/Fasten Seat Belt sign is installed on the galley, make sure that it comes on.

SUBTASK 25-31-21-710-002

- (8) Do this task if it is necessary: Potable Water System - Leak Test, TASK 38-10-00-790-801

EFFECTIVITY
AKS ALL

25-31-21



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SUBTASK 25-31-21-670-001

- (9) Do this task if it is necessary: Potable Water System - Disinfectant, TASK 38-10-00-600-801

SUBTASK 25-31-21-410-002

- (10) Do this task: Forward Galley Door Doorway Header Panel - Installation,
TASK 25-21-34-400-801

SUBTASK 25-31-21-410-003

- (11) Do this task: Forward Galley Doorway Sidewall Lining Panel - Installation,
TASK 25-21-35-420-801

AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-31-21-410-004

- (12) Do this task: Forward Galley Header - Installation, TASK 25-31-83-400-801

AKS ALL

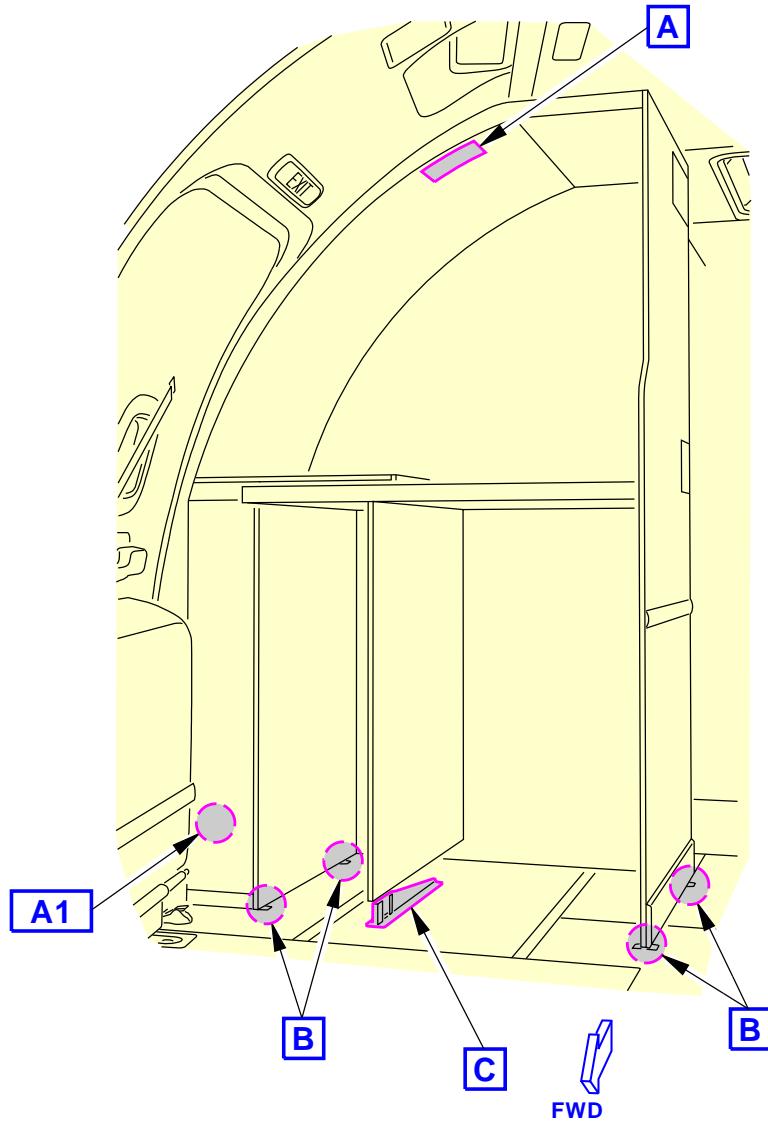
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EFFECTIVITY
AKS ALL

25-31-21



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



GALLEY NO. 2

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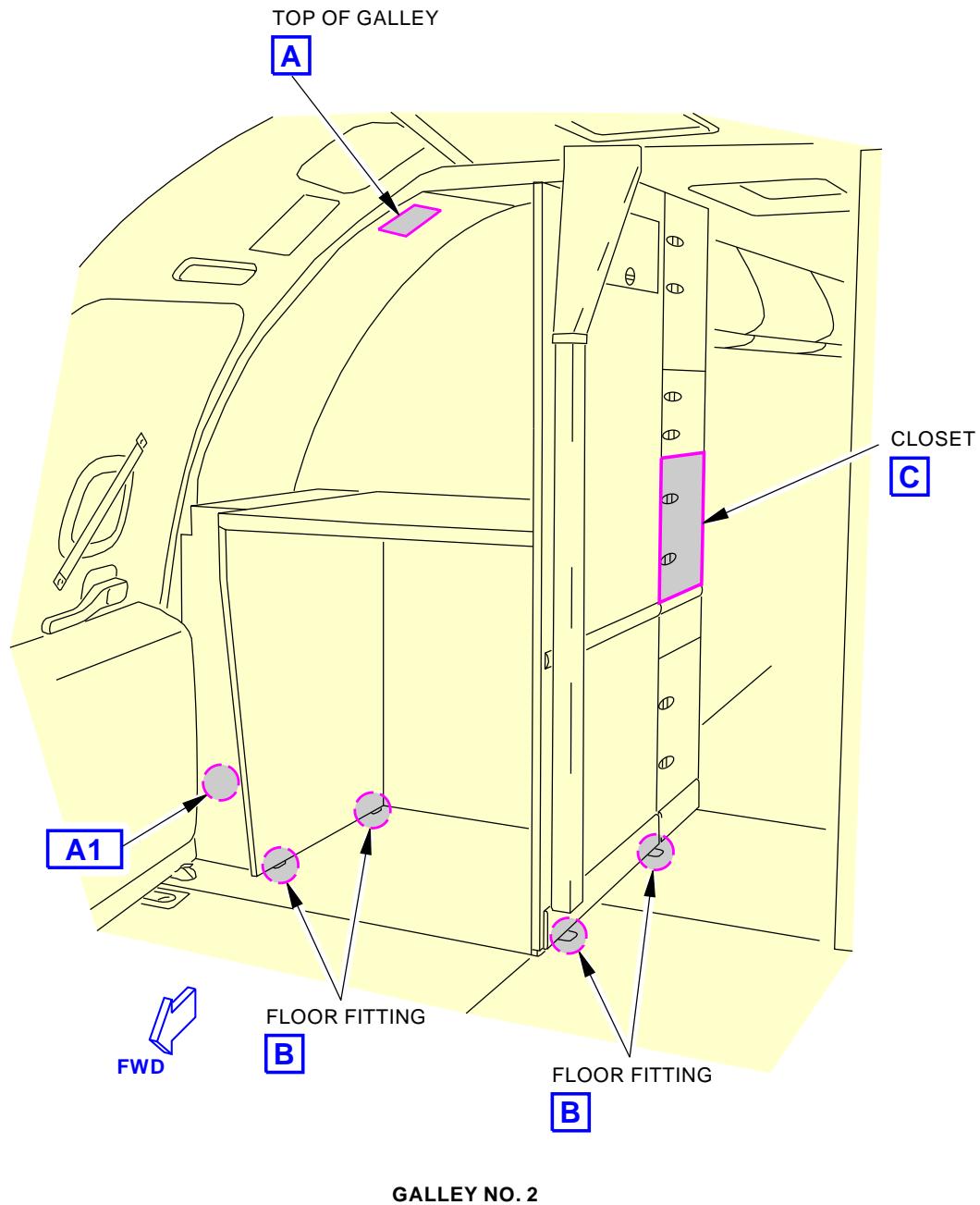
Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 1 of 6)

EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

25-31-21



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



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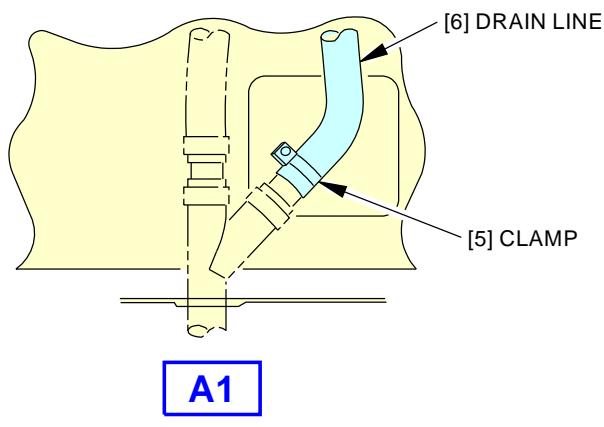
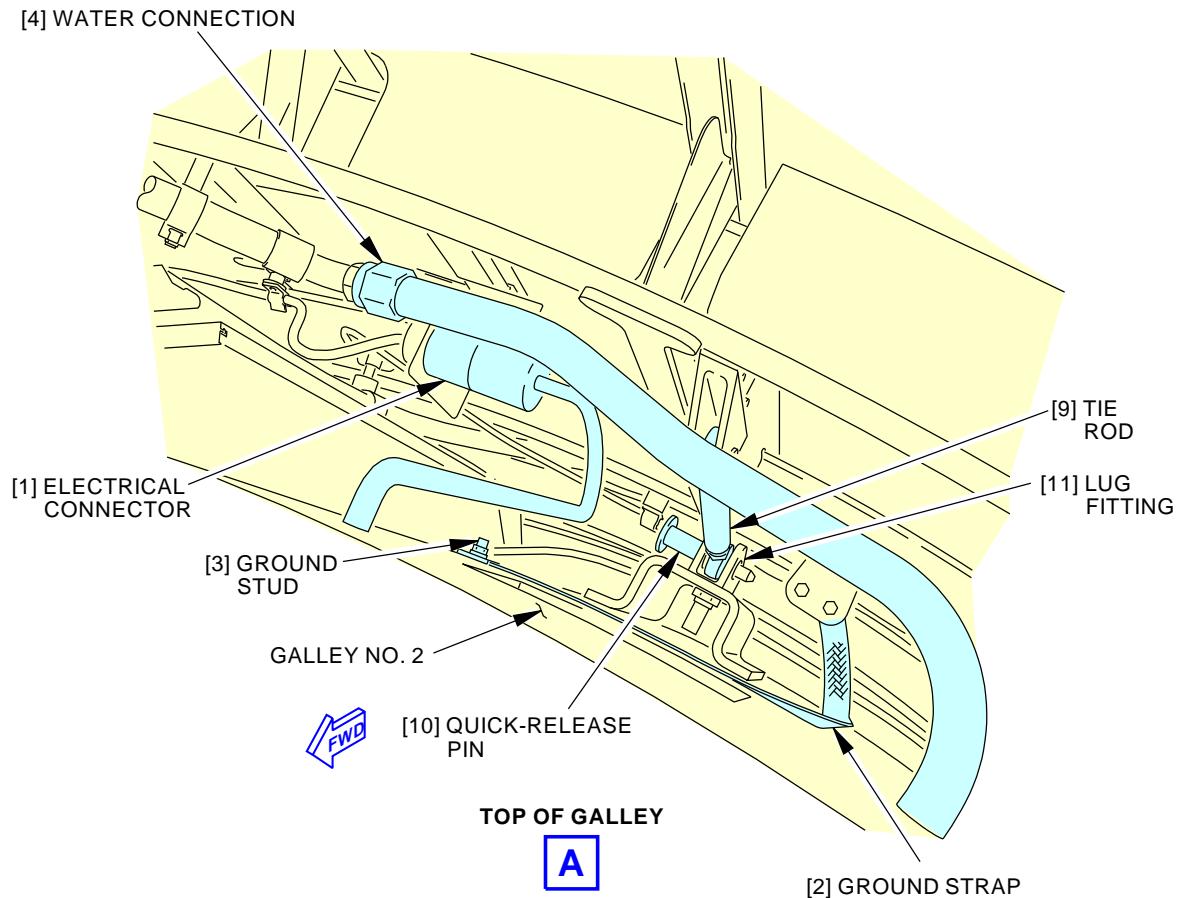
Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 2 of 6)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-21

D633A101-AKS

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H78612 S0006567220_V2

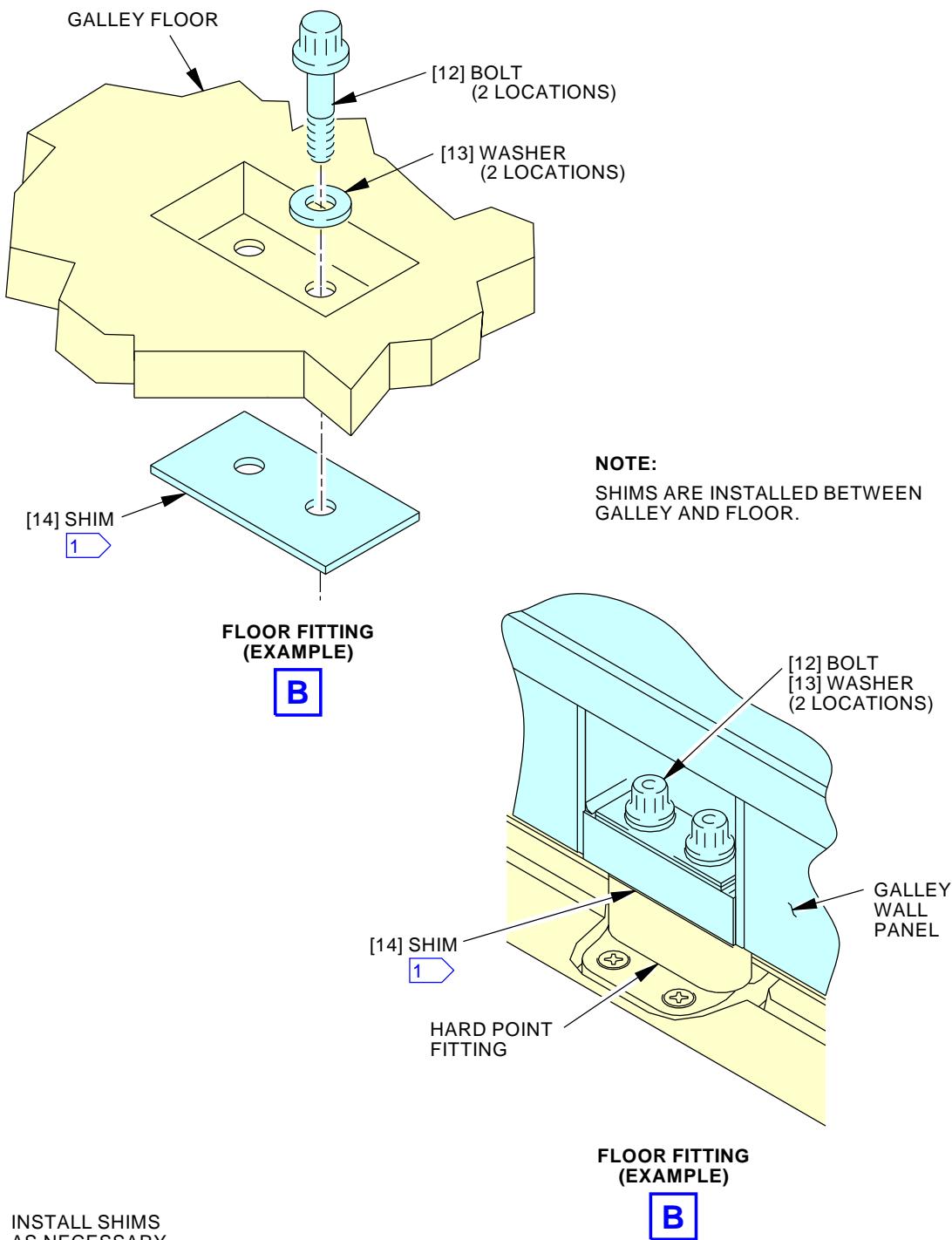
Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 3 of 6)

EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

25-31-21

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL



N90712 S0006567225_V2

Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 4 of 6)

EFFECTIVITY
AKS ALL

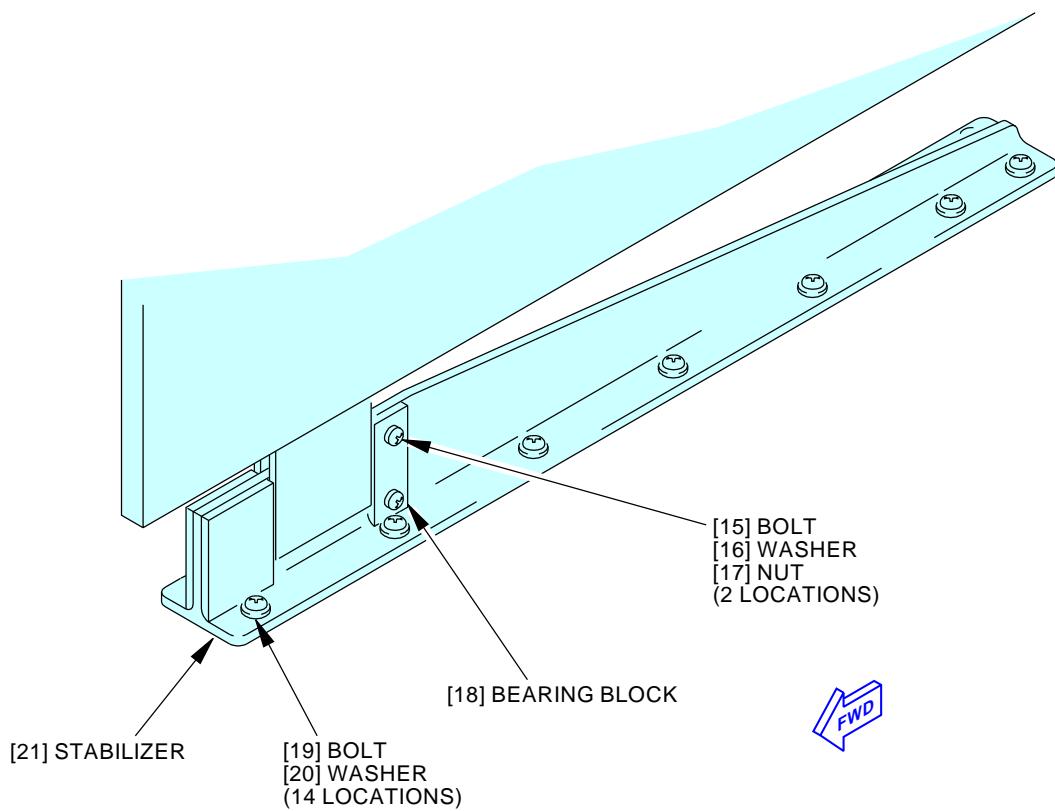
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25-31-21

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



H78697 S0006567227_V3

Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 5 of 6)

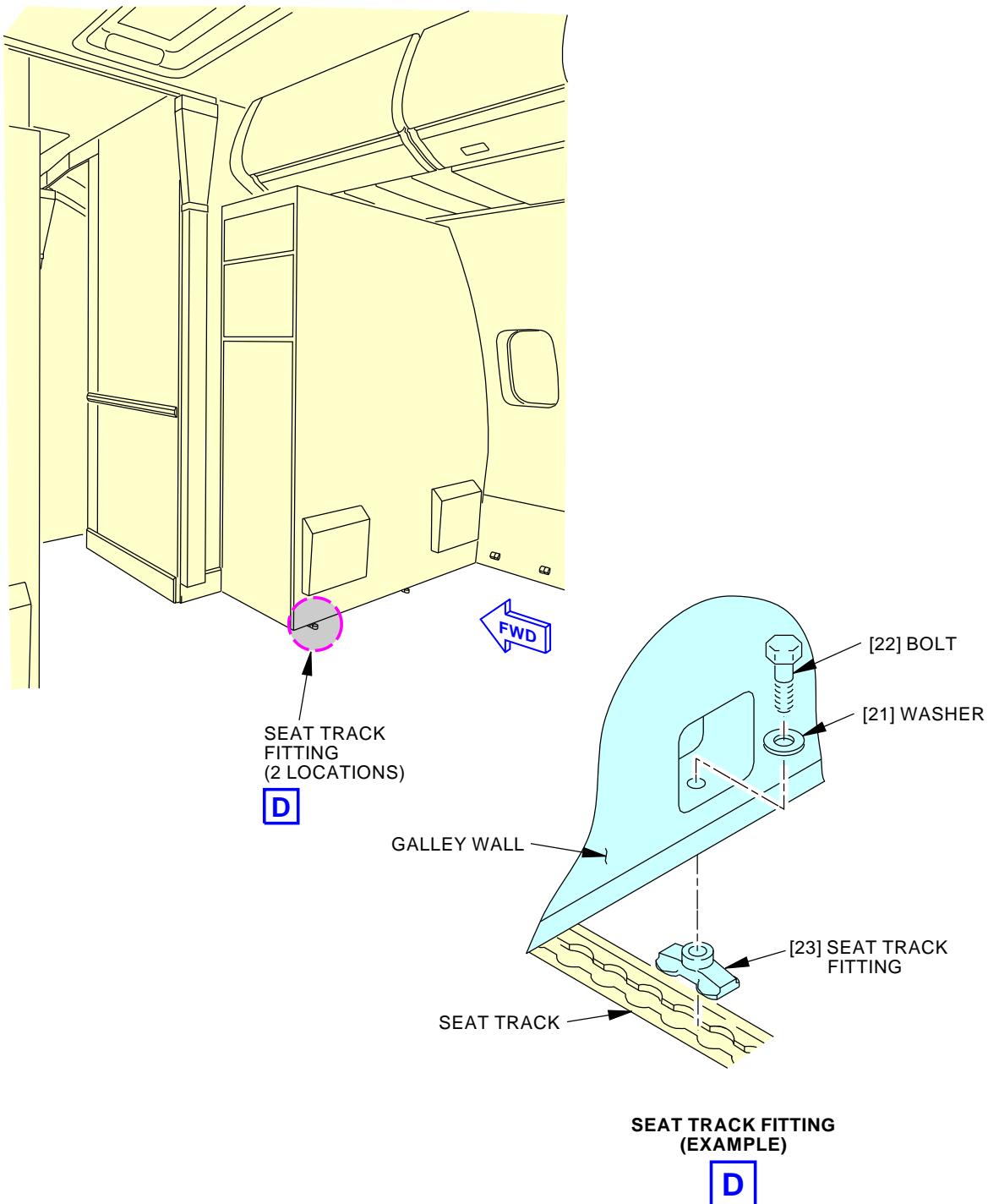
EFFECTIVITY
AKS 007, 008, 011, 012, 014, 019, 026, 028-999

25-31-21

D633A101-AKS

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1308003 S0000226195_V2

Galley No. 2 Installation
Figure 401/25-31-21-990-801 (Sheet 6 of 6)

EFFECTIVITY
AKS 014, 019, 026, 028-999

25-31-21



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL
GALLEY NO. 3 - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Galley No. 3 - deactivation.
 - (2) Galley No. 3 - activation.

TASK 25-31-31-040-801

2. Galley No. 3 - Deactivation

A. General

- (1) This task will deactivate the Galley Power Systems.

B. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-31-020-016

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

D. Galley Power Systems - Tryout

NOTE: This tryout is to make sure that the galley power systems are in a zero energy state.

SUBTASK 25-31-31-210-002

- (1) Make sure that the Power On indicator light on the galley is off.

SUBTASK 25-31-31-420-022

- (2) Turn the work light switch on the galley control panel to the BRT or DIM position.
 - (a) Make sure that the work light does not come on.

SUBTASK 25-31-31-020-017

- (3) Turn the work light switch on the galley control panel to the OFF position.

———— END OF TASK ————

TASK 25-31-31-440-801

3. Galley No. 3 - Activation

A. General

- (1) This task will activate the Galley Power Systems.

EFFECTIVITY

AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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AIRCRAFT MAINTENANCE MANUAL

B. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-31-420-021

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

———— END OF TASK ————

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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AIRCRAFT MAINTENANCE MANUAL
GALLEY NO. 3 - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Galley No. 3A Removal
 - (2) Galley No. 3A Installation

TASK 25-31-31-000-801

2. Galley No. 3 - Removal

NOTE: Figure 401

A. General

- (1) Be careful during the removal of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-24-000-801	Aft Door Doorway Header Panel - Removal (P/B 401)
25-21-25-020-801	Aft Entry and Service Doorways Sidewall Lining Panel - Removal (P/B 401)
25-21-71-000-801	Lowered Ceiling Removal (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)

C. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

D. Prepare for the Removal

SUBTASK 25-31-31-010-005

- (1) Do this task: Lowered Ceiling Removal, TASK 25-21-71-000-801

SUBTASK 25-31-31-010-006

- (2) Do this task: Aft Door Doorway Header Panel - Removal, TASK 25-21-24-000-801

SUBTASK 25-31-31-010-007

- (3) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Removal, TASK 25-21-25-020-801

SUBTASK 25-31-31-010-008

- (4) Do this task if it is necessary: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802

SUBTASK 25-31-31-010-009

- (5) Remove the equipment from the galley.

SUBTASK 25-31-31-010-010

- (6) Remove trim and access panels as required.

E. Galley Removal

SUBTASK 25-31-31-020-004

- (1) For galleys with power, do the following:

- (a) Disconnect the electrical connectors [1] above the galley.

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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AIRCRAFT MAINTENANCE MANUAL

- (b) If necessary, disconnect the ground strap [2] from the ground stud [3] at the top of the galley.

SUBTASK 25-31-31-020-008

- (2) If applicable, remove the tie rod [9].
(a) Remove the quick-release pin [10] that attaches the tie rod [9] to the galley lug fitting [11].

SUBTASK 25-31-31-000-004

- (3) Remove the floor fitting cover plates.

SUBTASK 25-31-31-000-005

- (4) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.

SUBTASK 25-31-31-000-006

- (5) For galleys with hard point fittings, remove the bolts [12], washers [13], and shims [14] at the hard point locations.

NOTE: Keep the shims for the galley installation. Record the quantity of shims for a given location when you remove the shims.

SUBTASK 25-31-31-000-007

- (6) If necessary, remove the stabilizer [43].
(a) Remove the bolts [41] and washers [42] at the stabilizer [43].
(b) Remove the stabilizer [43].

SUBTASK 25-31-31-030-001

- (7) For galleys with seat track fittings, remove the bolt [32] and washer [31] at the seat track locations.

SUBTASK 25-31-31-020-014

- (8) Remove the galley.

SUBTASK 25-31-31-030-002

- (9) If necessary, remove the seat track fittings [33].

————— END OF TASK ————

TASK 25-31-31-400-801

3. Galley No. 3 - Installation

NOTE: Figure 401

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-24-400-801	Aft Door Doorway Header Panel - Installation (P/B 401)
25-21-25-420-801	Aft Entry and Service Doorways Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
51-21-92-600-801	Seat Track Filler Application (P/B 201)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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AIRCRAFT MAINTENANCE MANUAL

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

D. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

E. Galley Installation

SUBTASK 25-31-31-160-001

- (1) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-31-350-002

- (2) Repair the galley mat if it is necessary.

SUBTASK 25-31-31-430-003

- (3) If necessary, install the seat track fittings [33].

SUBTASK 25-31-31-390-001

- (4) Do this task: Seat Track Filler Application, TASK 51-21-92-600-801.

SUBTASK 25-31-31-820-004

- (5) Move the galley inboard.

SUBTASK 25-31-31-820-005

- (6) Adjust the galley if it is necessary.

SUBTASK 25-31-31-390-002

- (7) Put the galley into its correct position.

SUBTASK 25-31-31-390-003

- (8) Install the floor seals and bond them with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-31-430-014

- (9) For galleys with seat track fittings, do the following:

- (a) Apply compound, C00528, to the bolts [32].

- (b) Install the bolts [32] and washers [31] at the seat track locations.

SUBTASK 25-31-31-430-004

- (10) For galleys with hardpoint fittings, do the following:

- (a) Apply the compound, compound, C00528, to the bolts [12].

- (b) Install the bolts [12], washers [13], and shims [14] at the hard point locations.

NOTE: Install the shims as necessary. The shim installation may not be more than 3 shims per attachment fitting.

- (c) Torque the bolts [12] to 107.5 ± 17.5 in-lb (12.1 ± 2.0 N·m).

SUBTASK 25-31-31-430-005

- (11) Install the floor fitting cover plates and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-31-430-006

- (12) If necessary, install the stabilizer [43] below the galley.

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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- (a) Put the stabilizer [43] below the galley.
- (b) Install the bolts [41] and washers [42] at the stabilizer [43].
- (c) Torque the bolts [41] to 22.5 ± 2.5 in-lb (2.54 ± 0.28 N·m).
- (d) Seal the stabilizer with adhesive, A00930.

SUBTASK 25-31-31-430-010

- (13) If applicable, attach the tie rod [9] to the lug fitting [11] on the galley.
 - (a) Adjust the tie rod [9] to the correct length.
 - 1) Adjust only the end of the assembly without the lockwasher and the lockwire.
 - 2) Make sure the thread of the tie rod blocks the inspection hole in the body of the tie rod.
 - 3) Tighten the jamnut.
 - (b) Install the quick-release pin [10] at the galley end of the tie rod [9].
- NOTE: Install the end of the tie rod [5] with the lockwasher and the lockwire at the fitting on the fuselage.

SUBTASK 25-31-31-430-012

- (14) For galleys with power, connect the electrical connectors [1] in the ceiling above the galley.

SUBTASK 25-31-31-430-011

- (15) If necessary, connect the galley ground strap [2] to the ground stud [3].
 - (a) Do a resistance check of the static ground from the ground stud [3] on the galley to the airplane ground stud.
 - (b) Make sure the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-31-31-430-013

- (16) Install the access covers and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-31-420-019

- (17) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

F. Put the Airplane in Its Usual Condition.

SUBTASK 25-31-31-410-005

- (1) Install the carts and all of the other galley equipment.

SUBTASK 25-31-31-410-012

- (2) Install the trim and access panels if they were removed.

SUBTASK 25-31-31-710-002

- (3) Make sure the electrical components in the galley operate correctly.

SUBTASK 25-31-31-410-006

- (4) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Installation, TASK 25-21-25-420-801.

SUBTASK 25-31-31-410-008

- (5) Do this task: Aft Door Doorway Header Panel - Installation, TASK 25-21-24-400-801.

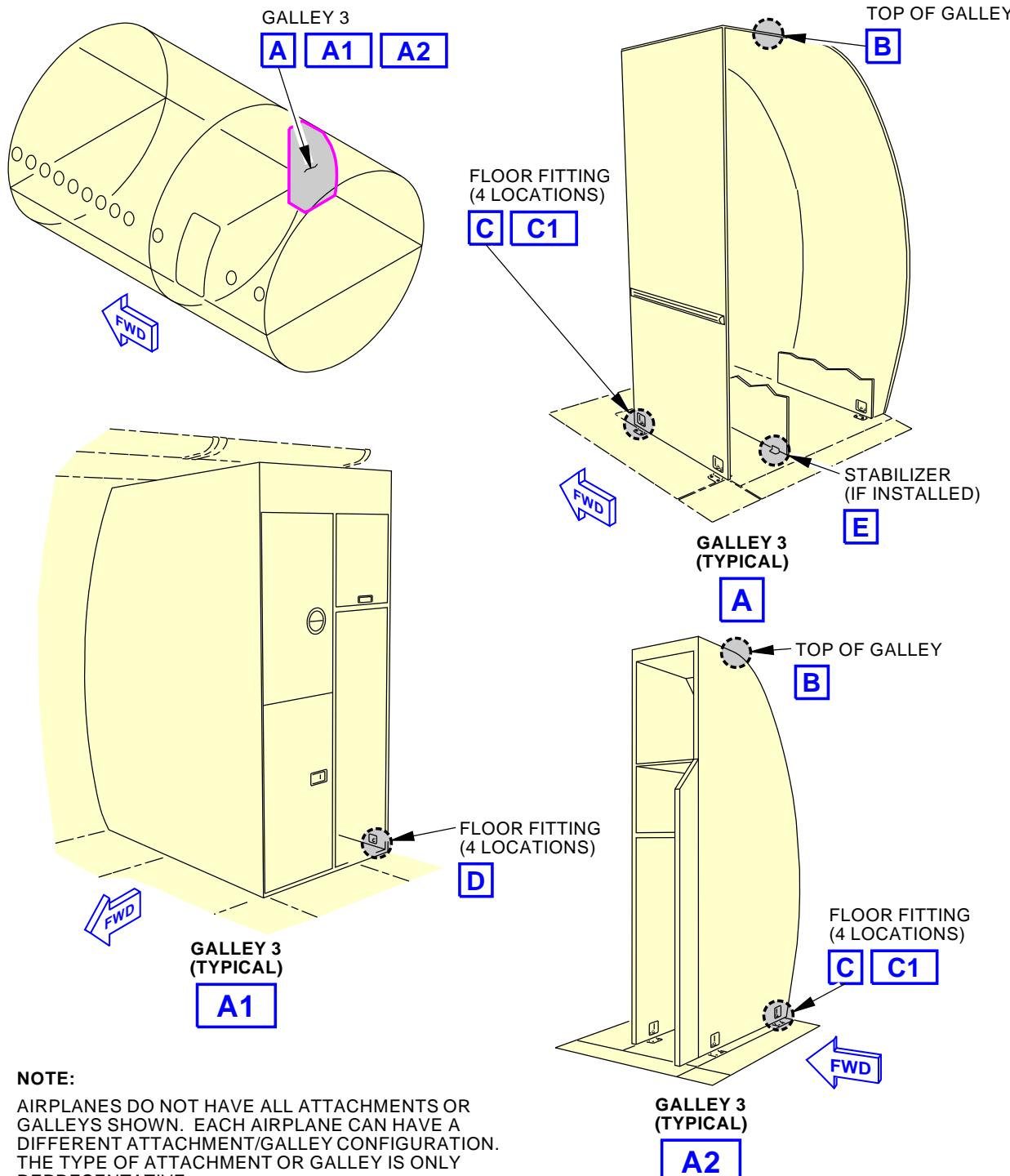
SUBTASK 25-31-31-410-011

- (6) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801.

— END OF TASK —

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31

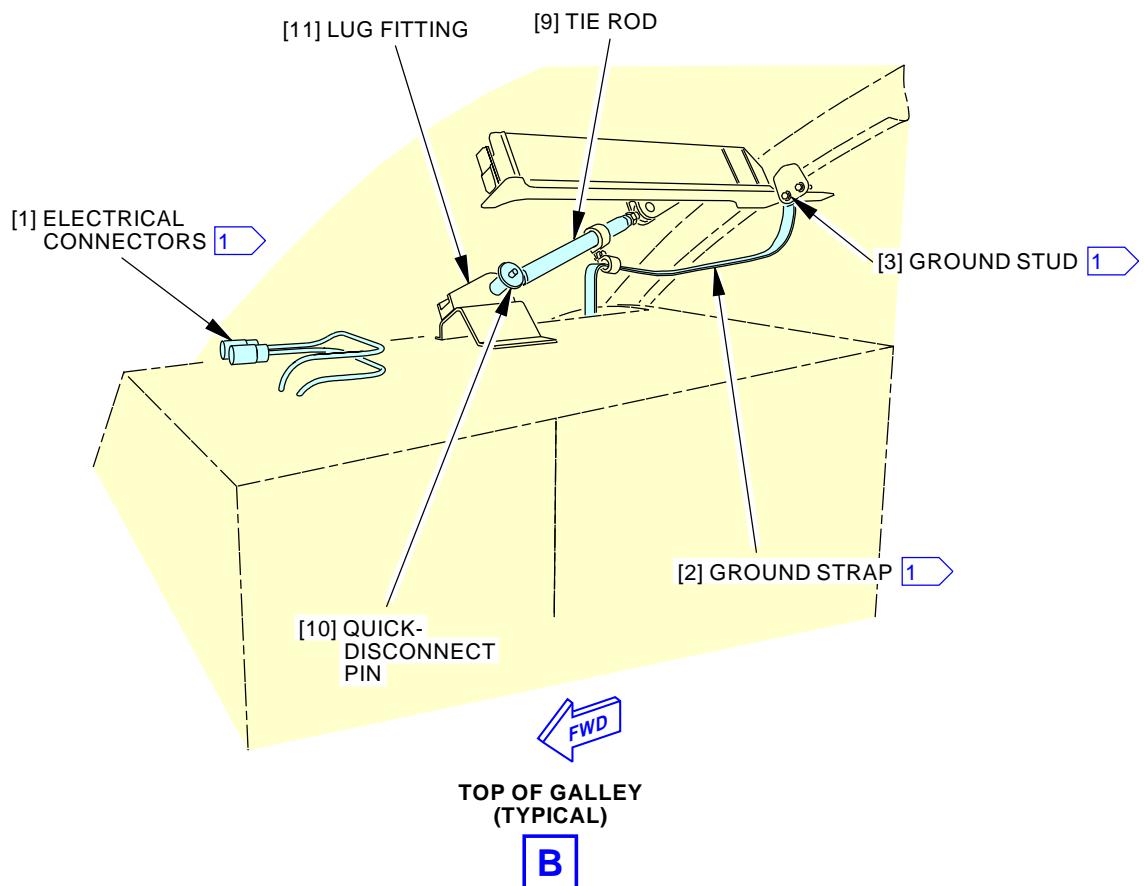


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Galley 3, 3A, 3B Installation
Figure 401/25-31-31-990-803 (Sheet 1 of 4)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



1 IF NECESSARY, DISCONNECT THE ELECTRICAL CONNECTORS, AND THE GROUND STUD AND STRAP.

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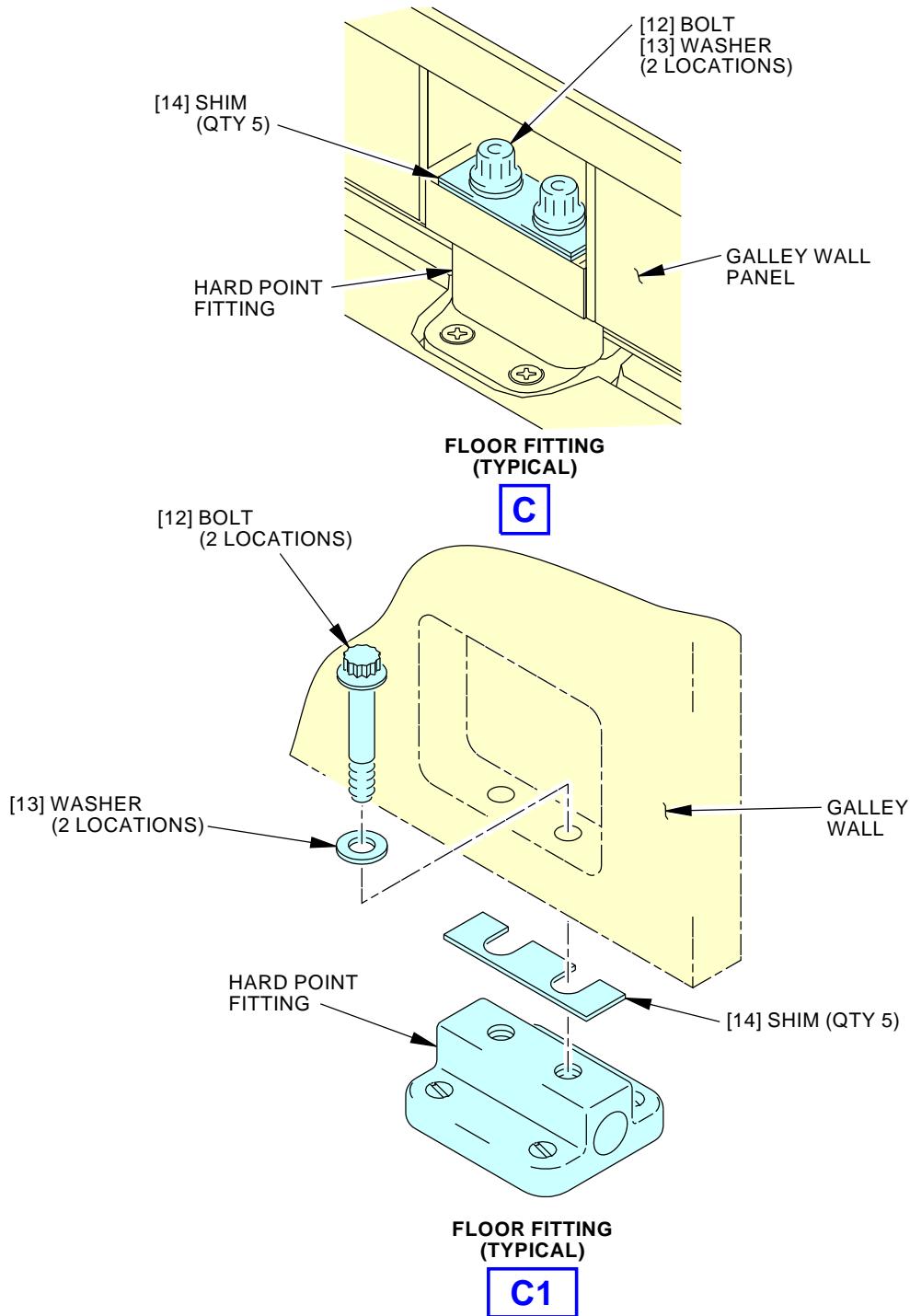
Galley 3, 3A, 3B Installation
Figure 401/25-31-31-990-803 (Sheet 2 of 4)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



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AIRCRAFT MAINTENANCE MANUAL

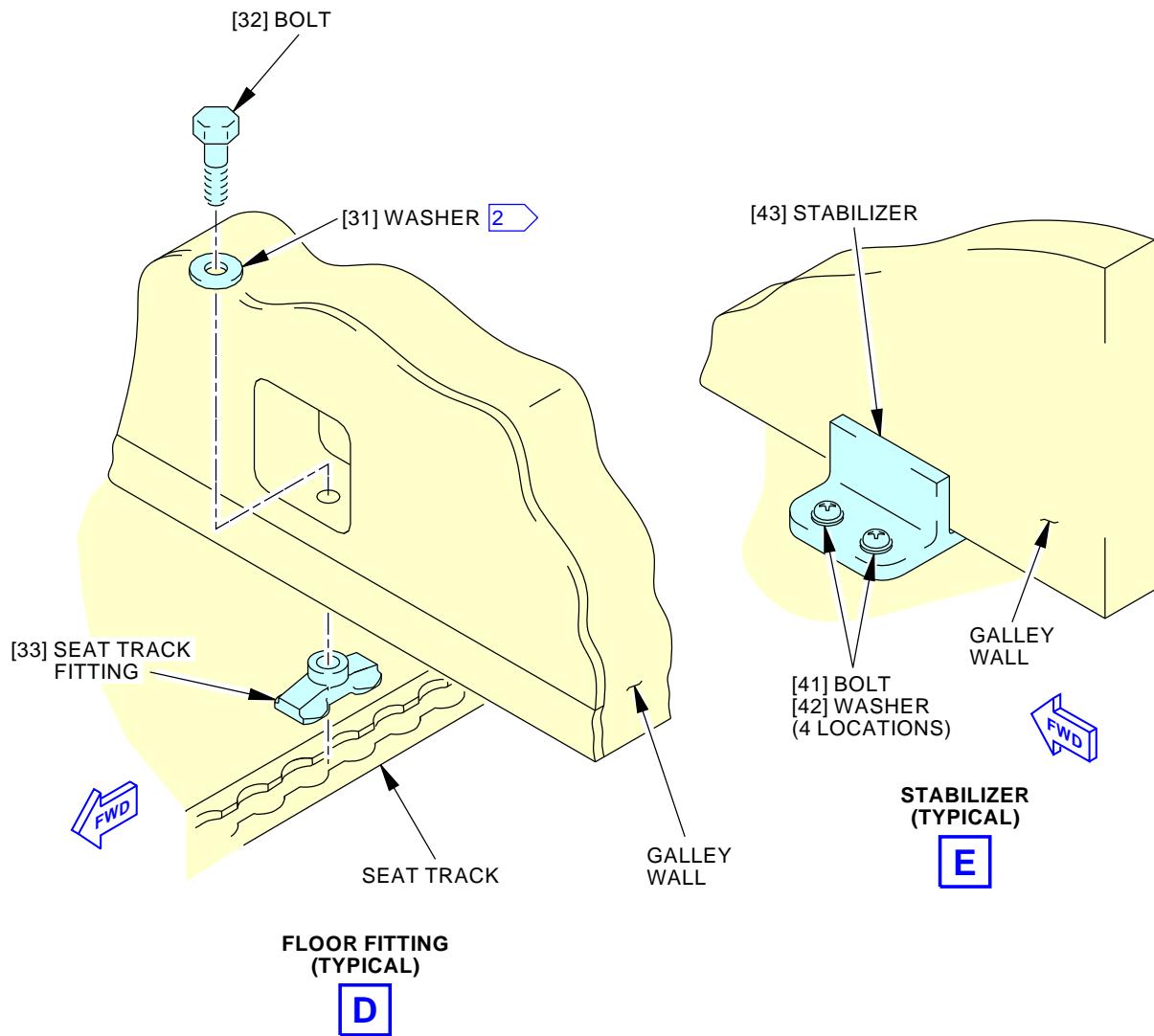


1568461 S0000291595_V2

Galley 3, 3A, 3B Installation
Figure 401/25-31-31-990-803 (Sheet 3 of 4)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



2 SOME FLOOR FITTING ATTACHMENTS WILL
CONTAIN A WASHER AT THIS LOCATION.

1568466 S0000291596_V2

Galley 3, 3A, 3B Installation
Figure 401/25-31-31-990-803 (Sheet 4 of 4)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-31



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL
GALLEY NO. 4 - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Galley No. 4 - deactivation.
 - (2) Galley No. 4 - activation.

TASK 25-31-41-040-801

2. Galley No. 4 - Deactivation

A. General

- (1) This task will deactivate the Galley Power Systems.

B. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-41-440-001

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

D. Galley Power Systems - Tryout

NOTE: This tryout is to make sure that the galley power systems are in a zero energy state.

SUBTASK 25-31-41-210-012

- (1) Make sure that the Power On indicator light on the galley is off.

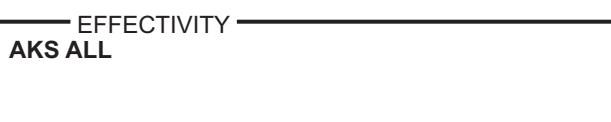
SUBTASK 25-31-41-420-201

- (2) Turn the work light on the galley control panel to the BRT or DIM position.
 - (a) Make sure that the work light does not come on.

SUBTASK 25-31-41-020-132

- (3) Turn the work light on the galley control panel to the OFF position.

———— END OF TASK ————



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TASK 25-31-41-440-801

3. Galley No. 4 - Activation

A. General

- (1) This task will activate the Galley Power Systems.

B. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

SUBTASK 25-31-41-420-203

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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GALLEY NO. 4 - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Galley No. 4 Removal
 - (2) Galley No. 4 Installation

TASK 25-31-41-000-801-005

2. Galley No. 4 - Removal

(Figure 401)

A. General

- (1) If removing Galley No. 4 from the airplane you must divide the galley.
- (2) Be careful during the removal of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-24-000-801	Aft Door Doorway Header Panel - Removal (P/B 401)
25-21-25-020-801	Aft Entry and Service Doorways Sidewall Lining Panel - Removal (P/B 401)
25-21-71-000-801	Lowered Ceiling Removal (P/B 401)
25-40-14-000-801	Lavatory D - Removal (P/B 401)
25-40-15-000-801	Lavatory E - Removal (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

D. Prepare for the Removal

SUBTASK 25-31-41-860-010-005

WARNING: DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

SUBTASK 25-31-41-010-003-005

- (2) Do this task: Lowered Ceiling Removal, TASK 25-21-71-000-801

SUBTASK 25-31-41-010-004-005

- (3) Do this task: Aft Door Doorway Header Panel - Removal, TASK 25-21-24-000-801



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SUBTASK 25-31-41-010-005-005

- (4) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Removal, TASK 25-21-25-020-801

SUBTASK 25-31-41-010-008-005

- (5) Do this task: Lavatory D - Removal, TASK 25-40-14-000-801

SUBTASK 25-31-41-010-009-005

- (6) Do this task: Lavatory E - Removal, TASK 25-40-15-000-801

SUBTASK 25-31-41-010-010-005

- (7) Remove the light assembly for the floor proximity light if it is necessary. Do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802

SUBTASK 25-31-41-860-012-005

- (8) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801

SUBTASK 25-31-41-020-001-005

- (9) Drain the water from the applicable galley equipment.

SUBTASK 25-31-41-010-011-005

- (10) Remove the carts and all of the other equipment from the galley.

SUBTASK 25-31-41-020-090

- (11) Remove the necessary trim panels from the galley.

SUBTASK 25-31-41-020-091

- (12) Remove the necessary access panels from the galley.

E. Galley Removal

SUBTASK 25-31-41-020-059-005

- (1) Do these steps to disconnect the galley water supply:
(a) Get access through the applicable access panel.
(b) If necessary, remove the insulation from around the galley water supply connection [4].
(c) Disconnect the water supply connection [4].

SUBTASK 25-31-41-020-055-005

- (2) Do these steps to disconnect the drain line:
(a) Through the applicable lower access panel, loosen the clamp [5], then disconnect the drain line [6].

SUBTASK 25-31-41-020-004-005

- (3) Disconnect the door flexible ducts [8].
(a) Through the applicable lower access panels, loosen the clamp [7], then disconnect the door flexible duct [8].

SUBTASK 25-31-41-020-005-005

- (4) Remove the four tie rods [9].
(a) Remove the quick-release pin [10] that attaches the tie rod [9] to the galley lug fitting [11].

SUBTASK 25-31-41-020-006-005

- (5) Remove the coverplates on the floor hard points.

SUBTASK 25-31-41-020-007-005

- (6) Remove the grease from the attachment fittings to get access to the fasteners, if it is necessary.

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SUBTASK 25-31-41-020-008-005

- (7) Remove the bolts [12], washers [13], and shims [14] at the four hard point locations.

NOTE: Keep the shims for the galley installation. Record the quantity of shims for a given location when you remove the shims.

SUBTASK 25-31-41-020-085-005

- (8) Do these steps to remove the stabilizer fitting(s) [21]:

- (a) Remove the bolts [15], washers [16], and nuts [17] at the bearing block [18].
- (b) Remove the bearing block [18].
- (c) Remove the bolts [19] and washers [20] at the stabilizer fitting(s) [21].
- (d) Remove the stabilizer fitting(s) [21].

SUBTASK 25-31-41-010-059

- (9) Remove fillet sealant from between galley mat and galley.

SUBTASK 25-31-41-020-011-005

- (10) If necessary, move the galley out slightly for easier access to the electrical connectors [1] and ground stud [3].
- (11) Disconnect the electrical power at the connections above the galley.
 - (a) Disconnect the electrical connectors [1].
 - (b) Disconnect the ground strap [2] from the ground stud [3] at the top of the galley.

SUBTASK 25-31-41-020-010-005

- (12) Remove the galley.

— END OF TASK —

TASK 25-31-41-400-801-005

3. Galley No. 4 - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
25-21-24-400-801	Aft Door Doorway Header Panel - Installation (P/B 401)
25-21-25-420-801	Aft Entry and Service Doorways Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
25-40-14-400-801	Lavatory D - Installation (P/B 401)
25-40-15-400-801	Lavatory E - Installation (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

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(Continued)

Reference	Description	Specification
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G50327	Tape - Advanced Insulation Blanket	BMS5-157 Type I Class 1 Grade B Composition MPVF
G51139	Foam - Flexible Polyvinylidene Fluoride	BMS8-371 Type 1A Class 1 Grade 2

D. Location Zones

Zone	Area
240	Subzone - Passenger Compartment - Body Station 663.75 to Body Station 1016.00

E. Galley Installation

SUBTASK 25-31-41-210-005-005

- (1) Do a check of the water barrier on the galley floor for damage. If necessary do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 25-31-41-100-001-005

- (2) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-41-350-001-005

- (3) Repair the galley mat if it is necessary.

SUBTASK 25-31-41-420-001-005

- (4) Move the galley inboard.

SUBTASK 25-31-41-820-001-005

- (5) Assemble the galley if it was divided.

SUBTASK 25-31-41-420-007-005

- (6) Connect the galley ground strap [2] to the ground stud [3].

- (a) Do a resistance check of the static ground from the ground stud [3] on the galley to the airplane ground stud.

- (b) Make sure the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-31-41-420-008-005

- (7) Connect the electrical connectors [1] in the ceiling above the galley.

SUBTASK 25-31-41-420-002-005

- (8) Put the galley into its correct position.

SUBTASK 25-31-41-420-125

- (9) If necessary, loosely install the bolts [12], washers [13], and shims [14] at the four hard points.

NOTE: This will prevent galley movement while the floor seals are installed.

SUBTASK 25-31-41-420-003-005

- (10) Install the floor seals and bond them with adhesive, A00027 or adhesive, A00930.





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SUBTASK 25-31-41-420-004-005

- (11) Install the bolts [12], washers [13], and shims [14] at the four floor hard points and apply compound, C00528 to bolts.

NOTE: Install the shims as necessary. The shim installation may not be more than 3 shims per attachment fitting.

SUBTASK 25-31-41-420-113-005

- (12) Tighten the bolts [12] to 107.5 ± 17.5 in-lb (12.1 ± 2.0 N·m) at the four hard point locations.

SUBTASK 25-31-41-420-005-005

- (13) Install the hard point coverplates and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-41-420-006-005

- (14) Do these steps to install the stabilizer fittings [21]:

- (a) Put the stabilizer fittings [21] below the galley.
- (b) Make sure that the bearing block [18] is not installed.
 - 1) Remove the bearing block [18], if it is necessary.
- (c) Install the stabilizer fitting [21] with the bolts [19] and washers [20].
- (d) Tighten the bolts [19] to 22.5 ± 2.5 in-lb (2.5 ± 0.3 N·m)
- (e) Install the bearing block [18] on the stabilizer fittings [21].
- (f) Install the bolts [15], washers [16], and nuts [17] at the bearing block [18].
- (g) Seal the stabilizers with adhesive, A00930.

SUBTASK 25-31-41-820-003-005

- (15) Attach the four tie rods [9] to the lug fittings [11] on the galley.

- (a) Adjust the tie rod [9] to the correct length.
 - 1) Adjust only the end of the assembly without the lockwasher and the lockwire.
 - 2) Make sure that the thread of the tie rod blocks the inspection hole in the body of the tie rod.
 - 3) Tighten the jamnut.
- (b) Install the quick-release pin [10] at the galley end of the tie rod [9].

NOTE: Install the end of the tie rod [9] with the lockwasher and the lockwire at the fitting on the fuselage.

SUBTASK 25-31-41-420-072-005

- (16) Connect the galley water supply connection [4].

SUBTASK 25-31-41-420-085-005

- (17) If the water supply line is insulated, do these steps to wrap insulation foam and insulation tape on the water supply line:

- (a) Apply insulation foam, G51139 (BMS8-371) around the water supply connection [4].
- (b) Start the insulation foam, G51139 (BMS8-371) overlap below the water supply connection [4].
- (c) Continue to wind the insulation foam, G51139 (BMS8-371) around the fitting with a $0.2 +0.3 / -0.0$ in. ($5.1 +7.6 / -0.0$ mm) overlap for each turn.



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- (d) Complete the insulation foam, G51139 (BMS8-371) wrap approximately 2.0 in. (50.8 mm) above the end of the fitting.

NOTE: In areas where the fitting is bent to 90.0 degrees, small clearances between the insulation foam and the fitting are permitted. You can apply insulation foam (BMS8-371) in pieces.

- (e) Do these steps to put insulation tape around the insulation foam on the water supply line:
- 1) Apply insulation tape, G50327 (BMS5-157) around the insulation foam, G51139 (BMS8-371).
 - 2) Start the insulation tape, G50327 (BMS5-157) overlap before the insulation foam, G51139 (BMS8-371) begins.
 - 3) Continue to wind the insulation tape, G50327 (BMS5-157) around the insulation foam, G51139 (BMS8-371) with a 0.2 +0.3 / -0.0 in. (5.1 +7.6 / -0.0 mm) overlap for each turn, and stop after the insulation foam, G51139 (BMS8-371) ends.
 - 4) Make sure the insulation tape, G50327 (BMS5-157) overlap seals over the ends of the insulation foam, G51139 (BMS8-371) fully.

NOTE: Make sure the insulation foam that is under the insulation tape does not show.

SUBTASK 25-31-41-420-029-005

- (18) Connect the water line [3] and tighten the clamp [6].

SUBTASK 25-31-41-420-117-005

- (19) Connect the door flexible duct [8] and tighten the clamp [7].

SUBTASK 25-31-41-420-012-005

- (20) Install the access covers and seal with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-41-420-013-005

- (21) If applicable, install the light assembly for the floor proximity light (Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802).

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-31-41-860-015-005

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

SUBTASK 25-31-41-410-001-005

- (2) Install the carts and all of the other galley equipment.

SUBTASK 25-31-41-420-123

- (3) Install any removed galley trim panels.

SUBTASK 25-31-41-420-124

- (4) Install any removed access panels.



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SUBTASK 25-31-41-710-001-005

- (5) Make sure that the electrical components in the galley operate correctly.

SUBTASK 25-31-41-710-018-005

- (6) If an exit light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-41-710-019-005

- (7) If a floor proximity light is installed on the galley, make sure that it comes on.

SUBTASK 25-31-41-710-020-005

- (8) If a No Smoking Fasten Seat Belt sign is installed on the galley, make sure that it comes on.

SUBTASK 25-31-41-710-002-005

- (9) Do this task if it is necessary: Potable Water System - Leak Test, TASK 38-10-00-790-801

SUBTASK 25-31-41-670-001-005

- (10) Do this task if it is necessary: Potable Water System - Disinfectant, TASK 38-10-00-600-801

SUBTASK 25-31-41-410-002-005

- (11) Do this task: Lavatory D - Installation, TASK 25-40-14-400-801

SUBTASK 25-31-41-410-003-005

- (12) Do this task: Lavatory E - Installation, TASK 25-40-15-400-801

SUBTASK 25-31-41-410-006-005

- (13) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Installation,
TASK 25-21-25-420-801

SUBTASK 25-31-41-410-007-005

- (14) Do this task: Aft Door Doorway Header Panel - Installation, TASK 25-21-24-400-801

SUBTASK 25-31-41-410-008-005

- (15) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801

———— END OF TASK ————

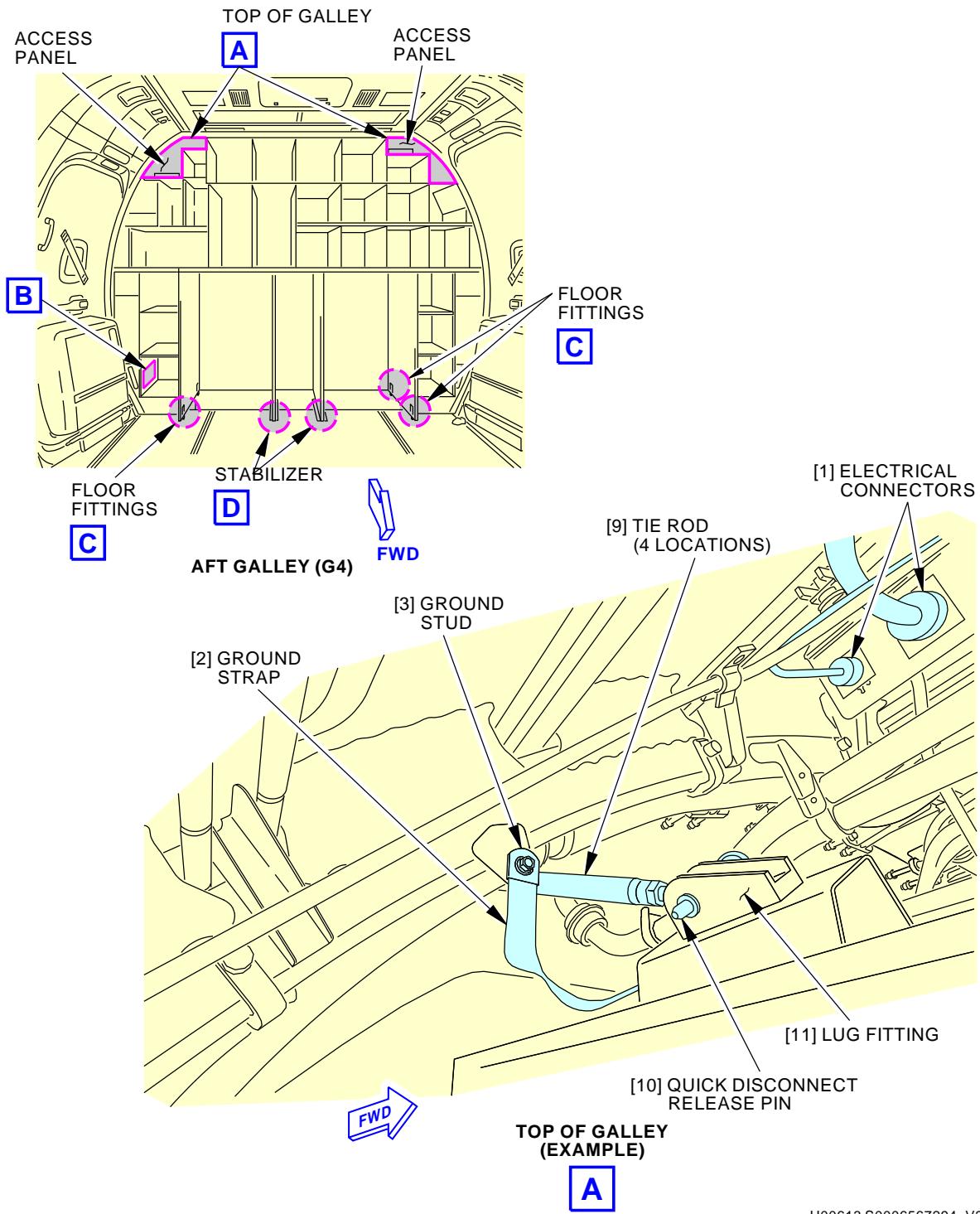


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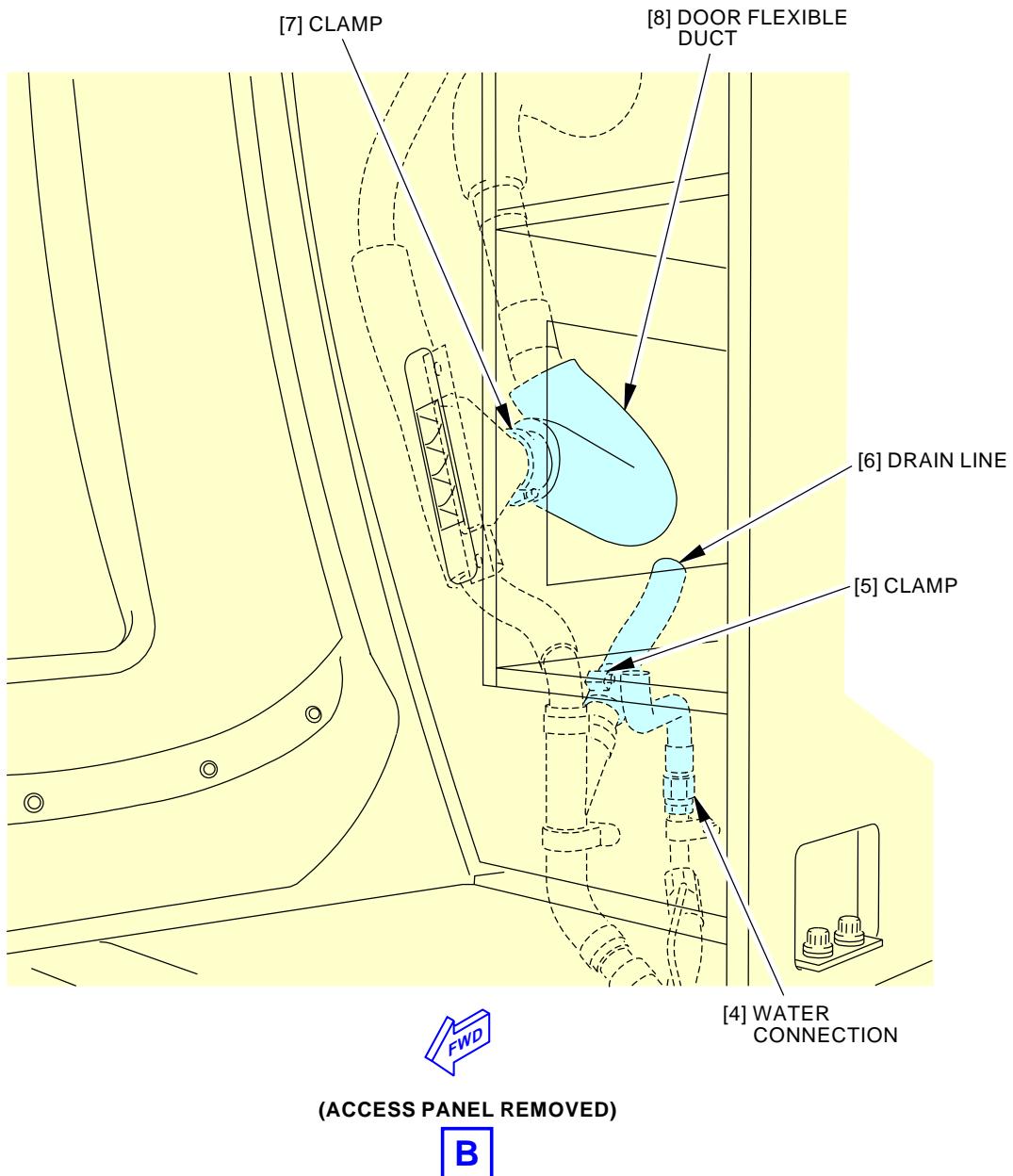
Galley No. 4 Installation
Figure 401/25-31-41-990-801-005 (Sheet 1 of 4)

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AKS ALL

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Galley No. 4 Installation
Figure 401/25-31-41-990-801-005 (Sheet 2 of 4)

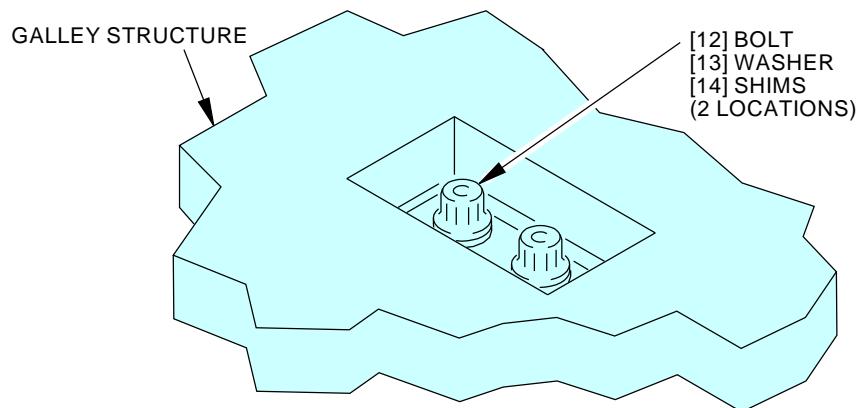
EFFECTIVITY
AKS ALL

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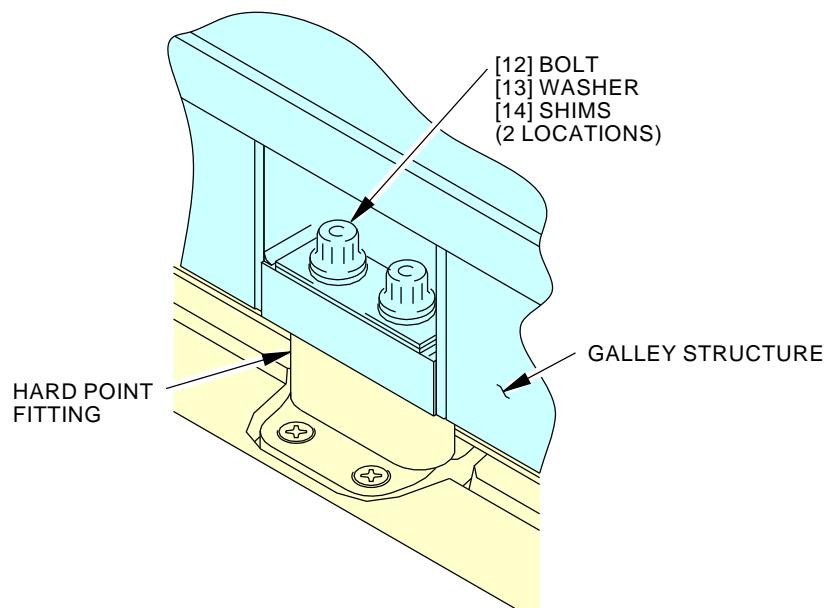


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FLOOR FITTING
(EXAMPLE)

C



FLOOR FITTING
(EXAMPLE)

C

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Galley No. 4 Installation
Figure 401/25-31-41-990-801-005 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

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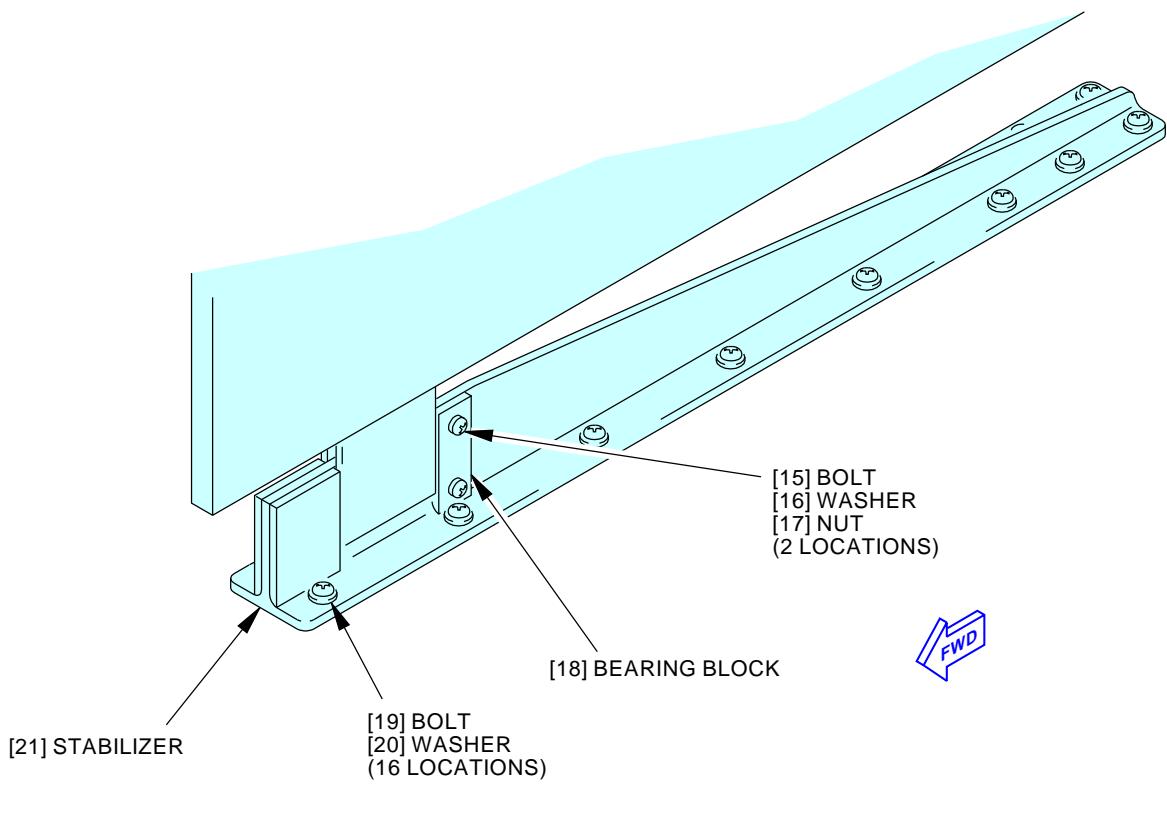
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STABILIZER
(EXAMPLE)



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Galley No. 4 Installation
Figure 401/25-31-41-990-801-005 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

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GALLEY NO. 6 - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Galley No. 6A Removal
 - (2) Galley No. 6A Installation

TASK 25-31-61-000-801

2. Galley No. 6 - Removal

(Figure 401)

A. General

- (1) Be careful during the removal of the galley to prevent damage to the galley mat.

B. References

Reference	Title
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)

C. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

D. Prepare for the Removal

SUBTASK 25-31-61-020-001

- (1) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

SUBTASK 25-31-61-010-003

- (2) Remove the carts and all of the other equipment in the galley.

SUBTASK 25-31-61-010-002

- (3) Remove the access and trim panels if it is necessary..

E. Galley Removal

SUBTASK 25-31-61-030-002

- (1) Remove the coverplates on the floor attachment points.

- (a) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.

- (b) Remove the bolt [23] and washer [24] at the seat track locations.

NOTE: Keep the shims for the galley installation. Record the quantity of shims for a given location when you remove the shims.

SUBTASK 25-31-61-020-008

- (2) Remove the galley.

SUBTASK 25-31-61-030-003

- (3) If necessary, remove the seat track fittings [11].

———— END OF TASK ————

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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TASK 25-31-61-400-801

3. Galley No. 6, 6A - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
51-21-92-600-801	Seat Track Filler Application (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III

D. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

E. Galley Installation

SUBTASK 25-31-61-110-001

- (1) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-61-350-001

- (2) Repair the galley mat if it is necessary.

SUBTASK 25-31-61-430-003

- (3) If necessary, install the seat track fittings [11] at the seat track locations.

SUBTASK 25-31-61-620-001

- (4) Do this task: Seat Track Filler Application, TASK 51-21-92-600-801

SUBTASK 25-31-61-420-001

- (5) Move the galley inboard.

SUBTASK 25-31-61-820-002

- (6) Adjust the galley if it is necessary.

SUBTASK 25-31-61-420-002

- (7) Put the galley into its correct position.

SUBTASK 25-31-61-420-003

- (8) Install the floor seals and bond them with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-61-430-002

- (9) Install the bolts [23] and washers [24] at the seat track locations.

- (10) Torque the bolts [23] to 150 ± 15 in-lb (16.9 ± 1.7 N·m).

- (11) Install the coverplates and seal with adhesive, A00027 or adhesive, A00930.

F. Put the Airplane in Its Usual Condition.

SUBTASK 25-31-61-410-002

- (1) Install the galley trim panels.

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-61



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SUBTASK 25-31-61-410-004

- (2) Install the carts and all of the other equipment in the galley.

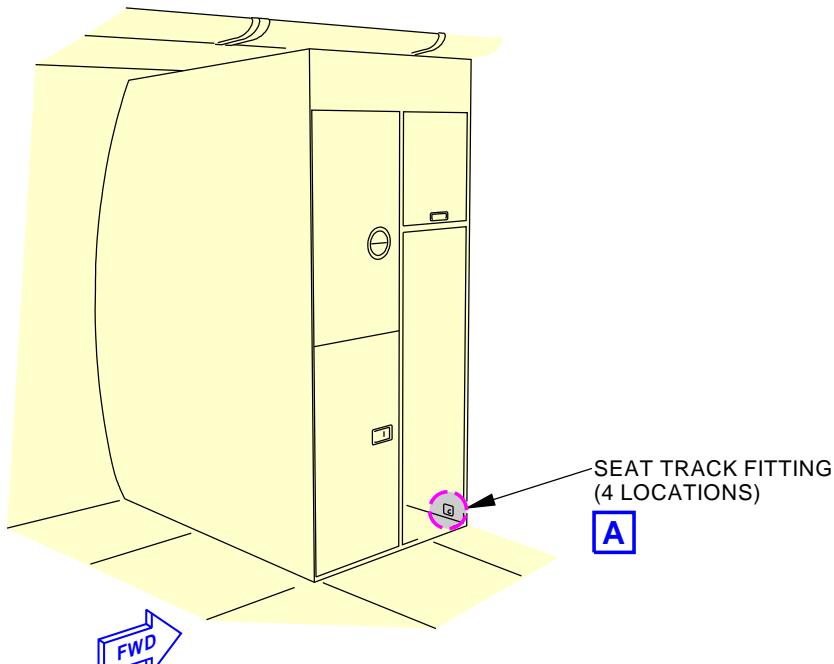
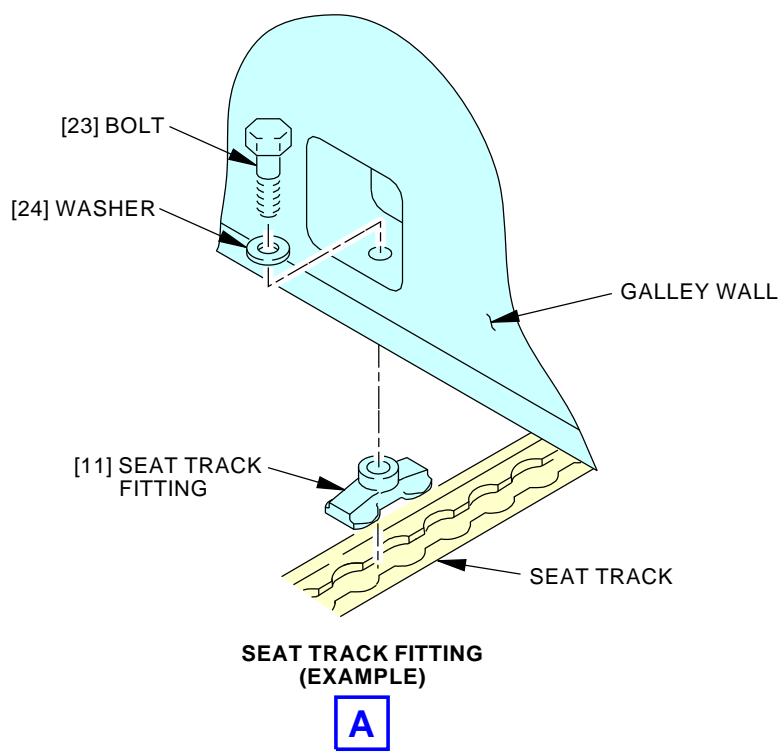
SUBTASK 25-31-61-420-011

- (3) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement,
TASK 33-51-14-960-802.

———— END OF TASK ——

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-61


GALLEY 6, 6A

**SEAT TRACK FITTING
(EXAMPLE)**
A

1305393 S0000225486_V2

Galley 6, 6A Installation
Figure 401/25-31-61-990-801

EFFECTIVITY
 AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-61



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GALLEY NO. 7 - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Galley No. 7 - deactivation.
 - (2) Galley No. 7 - activation.

TASK 25-31-71-040-801

2. Galley No. 7 - Deactivation

A. General

- (1) This task will deactivate the Galley Power Systems.

B. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-71-020-028

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

D. Galley Power Systems - Tryout

NOTE: This tryout is to make sure that the galley power systems are in a zero energy state.

SUBTASK 25-31-71-210-003

- (1) Make sure that the Power On indicator light on the galley is off.

SUBTASK 25-31-71-420-035

- (2) Turn the work light switch on the galley control panel to the BRT or DIM position.
 - (a) Make sure that the work light does not come on.

SUBTASK 25-31-71-020-029

- (3) Turn the work light switch on the galley control panel to the OFF position.

———— END OF TASK ————

TASK 25-31-71-440-801

3. Galley No. 7 - Activation

A. General

- (1) This task will activate the Galley Power Systems.



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B. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

C. Procedure

WARNING: BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-31-71-420-034

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
F	7	C00913	GALLEY BUS C
F	8	C00915	GALLEY BUS D

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

———— END OF TASK ————

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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GALLEY NO. 7 - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Galley No. 7 Removal
 - (2) Galley No. 7 Installation

TASK 25-31-71-000-801

2. Galley No. 7 - Removal

(Figure 401)

A. References

Reference	Title
25-21-30-020-801	Forward Entry Door Doorway Header Panel - Removal (P/B 401)
25-21-31-420-801	Forward Entry Doorway Sidewall Lining Panel - Removal (P/B 401)
25-24-31-000-801-001	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802-001	Overhead Stowage Bin Module - Removal (P/B 401)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)

B. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

C. Prepare for the Removal

SUBTASK 25-31-71-860-010

- (1) Open these circuit breakers and install safety tags:

Power Distribution Panel Number 2, P92

Row	Col	Number	Name
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

SUBTASK 25-31-71-010-002

- (2) Do this task: Forward Entry Door Doorway Header Panel - Removal, TASK 25-21-30-020-801

SUBTASK 25-31-71-010-003

- (3) Do this task: Forward Entry Doorway Sidewall Lining Panel - Removal,
TASK 25-21-31-420-801

SUBTASK 25-31-71-020-001

- (4) Do this task if it is necessary: Floor Proximity Light - Light Assembly Replacement,
TASK 33-51-14-960-802.

SUBTASK 25-31-71-020-026

- (5) Do this task if it is necessary: Overhead Stowage Bin - Removal, TASK 25-24-31-000-801-001
or Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802-001

SUBTASK 25-31-71-010-004

- (6) Remove all of the equipment from the galley.

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-71



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D. Galley Removal

SUBTASK 25-31-71-030-002

- (1) Remove the tie rod [7].
 - (a) Remove the nut [13], washer [14], bolt [8], and csk washer [9] from the tie rod [7] and the galley lug fitting [12].
 - (b) If necessary, attach this end of the tie rod [7] to the upper airplane structure to keep it out of the way.

SUBTASK 25-31-71-020-015

- (2) Do these steps to remove the galley from the seat track fittings:
 - (a) Remove the seat track fittings bolts [10] at the seat track locations.

SUBTASK 25-31-71-020-025

- (3) If necessary, move the galley out slightly for easier access to the electrical connectors [1].

SUBTASK 25-31-71-020-002

- (4) Disconnect the electrical power from the galley.
 - (a) Disconnect the electrical connectors [1].

SUBTASK 25-31-71-020-008

- (5) Remove the galley.

SUBTASK 25-31-71-020-014

- (6) If necessary, remove the seat track fitting [11] from the seat track locations.

————— END OF TASK ————

TASK 25-31-71-400-801

3. Galley No. 7 - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the galley to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley area.

B. References

Reference	Title
24-22-00-860-811	Supply Electrical Power (P/B 201)
25-21-30-420-801	Forward Entry Door Doorway Header Panel - Installation (P/B 401)
25-21-31-420-802	Forward Entry Doorway Sidewall Lining Panel - Installation (P/B 401)
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
33-51-00-710-801	Emergency Lights - Operational Test (P/B 501)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
51-21-92-600-801	Seat Track Filler Application (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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(Continued)

Reference	Description	Specification
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III

D. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

E. Galley Installation

SUBTASK 25-31-71-210-001

- (1) Do a check of the water barrier on the galley floor for damage. If necessary do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 25-31-71-160-001

- (2) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-31-71-350-002

- (3) Repair the galley mat if it is necessary.

SUBTASK 25-31-71-430-001

- (4) If necessary, install the seat track fitting [11] and floor fitting [12] at the seat track locations.

SUBTASK 25-31-71-620-002

- (5) Do this task: Seat Track Filler Application, TASK 51-21-92-600-801

SUBTASK 25-31-71-820-004

- (6) Move the galley inboard.

SUBTASK 25-31-71-430-007

- (7) Connect the electrical connectors [1] in the ceiling above the galley.

SUBTASK 25-31-71-820-005

- (8) Adjust the galley if it is necessary.

SUBTASK 25-31-71-820-006

- (9) Put the galley into its correct position.

SUBTASK 25-31-71-420-030

- (10) If necessary, loosely install the seat track fitting bolts [10] and washers [13] at the seat track locations.

NOTE: This will prevent galley movement while the floor seals are installed.

SUBTASK 25-31-71-390-001

- (11) Install the floor seals and bond them with adhesive, A00027 or adhesive, A00930.

SUBTASK 25-31-71-430-012

- (12) Do these steps to install the galley on the seat track fittings:

(a) Install the seat track fitting bolts [10] and washers [13] at the seat track locations.

- 1) Torque the seat track fitting bolts [10] to 155 ± 25 in-lb (17.5 ± 2.8 N·m).

SUBTASK 25-31-71-430-005

- (13) Do these steps to attach the tie rod [7] to the galley lug fitting [12] on the galley:

(a) If necessary, remove the end of the tie rod [7] from the upper airplane structure and put it in the galley lug fitting [12].

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-71



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- (b) Install the bolt [8] with the csk washer [9] through the galley lug fitting [12], tie rod [7], and the opposite galley lug fitting [12].
 - (c) Adjust the tie rod [7] to the correct length.
 - 1) Adjust only the end of the assembly without the lockwasher and the lockwire.
 - 2) Make sure that the thread of the tie rod blocks the inspection hole in the body of the tie rod.
 - 3) Tighten the jammnut.
 - (d) Install the washer [14] and nut [13] on the bolt [8].
- NOTE:** Install the end of the tie rod [7] with the lockwasher and the lockwire at the fitting on the fuselage.

SUBTASK 25-31-71-410-008

- (14) Install the access covers and seal with adhesive, A00027 or adhesive, A00930.

F. Put the Airplane in Its Usual Condition.

SUBTASK 25-31-71-865-001

WARNING: BE CAREFUL WHEN YOU ACCESS THE (ROW F) CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. IF POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER BEFORE YOU ACCESS THE CIRCUIT BREAKERS ON THE INSIDE OF THE P91 AND P92 PANELS. THE P91 AND P92 PANELS CONTAIN HIGH VOLTAGES AND CURRENTS THAT MAY CAUSE INJURIES TO PERSONS.

- (1) Remove the safety tags and close these circuit breakers:

Power Distribution Panel Number 2, P92

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	7	C00912	GALLEY BUS A
F	8	C00914	GALLEY BUS B

SUBTASK 25-31-71-430-010

- (2) Install the galley trim panels.

SUBTASK 25-31-71-861-001

- (3) If necessary, do this task: Supply Electrical Power, TASK 24-22-00-860-811

SUBTASK 25-31-71-710-002

- (4) Make sure the that electrical components in the galley operate correctly.

SUBTASK 25-31-71-710-005

- (5) Make sure that the electrical components in the galley operate correctly if applicable.

SUBTASK 25-31-71-960-001

- (6) Do this task if it is necessary: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802

SUBTASK 25-31-71-420-018

- (7) Do this task if it is necessary: Forward Entry Doorway Sidewall Lining Panel - Installation, TASK 25-21-31-420-802

SUBTASK 25-31-71-420-019

- (8) Do this task if it is necessary: Forward Entry Doorway Header Panel - Installation, TASK 25-21-30-420-801

SUBTASK 25-31-71-710-006

- (9) Do this task if it is necessary: Emergency Lights - Operational Test, TASK 33-51-00-710-801

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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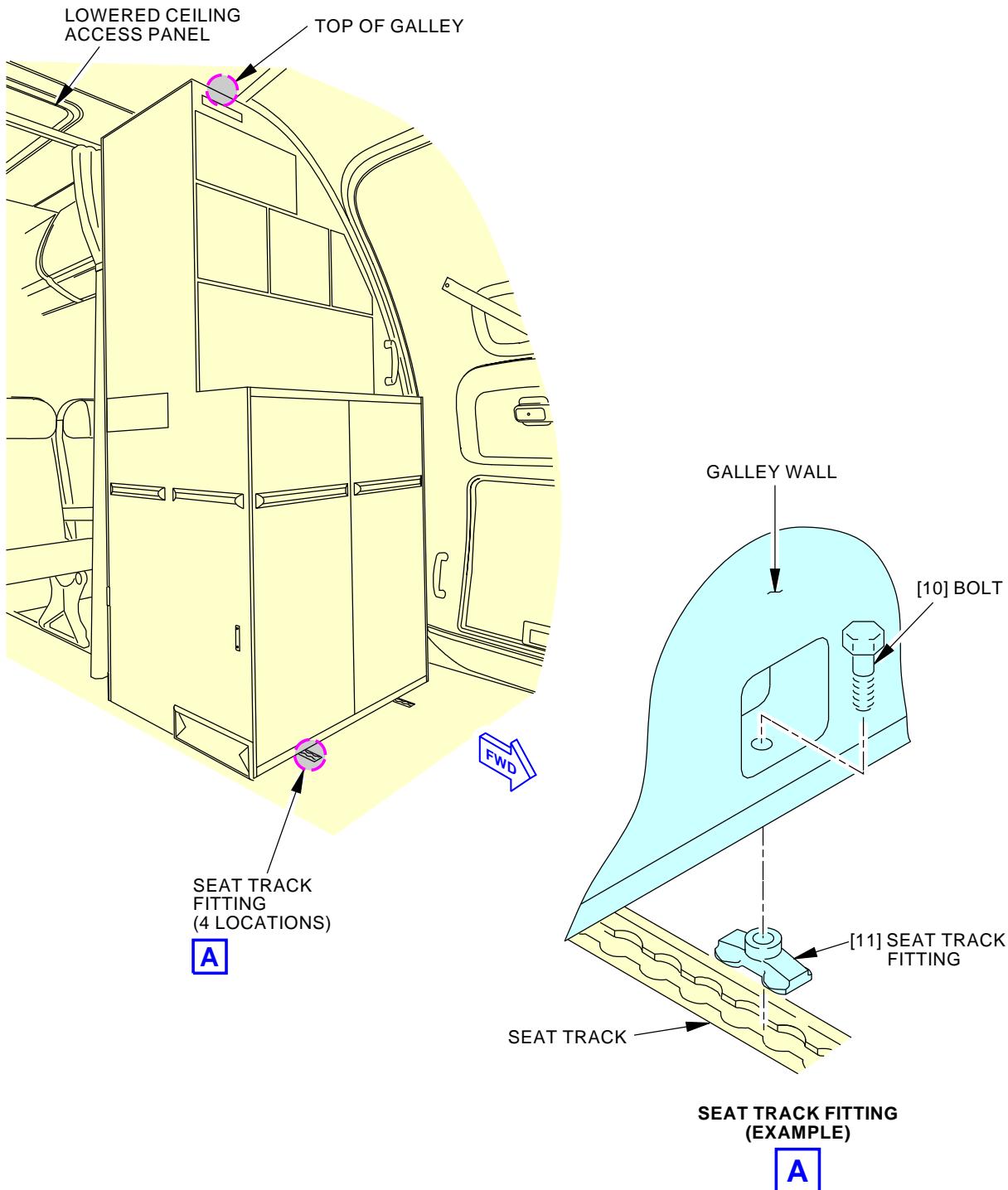
SUBTASK 25-31-71-420-032

- (10) Do this task if it is necessary: Overhead Stowage Bin - Installation,
TASK 25-24-31-400-803-001 or Overhead Stowage Bin Module - Installation,
TASK 25-24-31-400-804-001

———— END OF TASK ————

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-71



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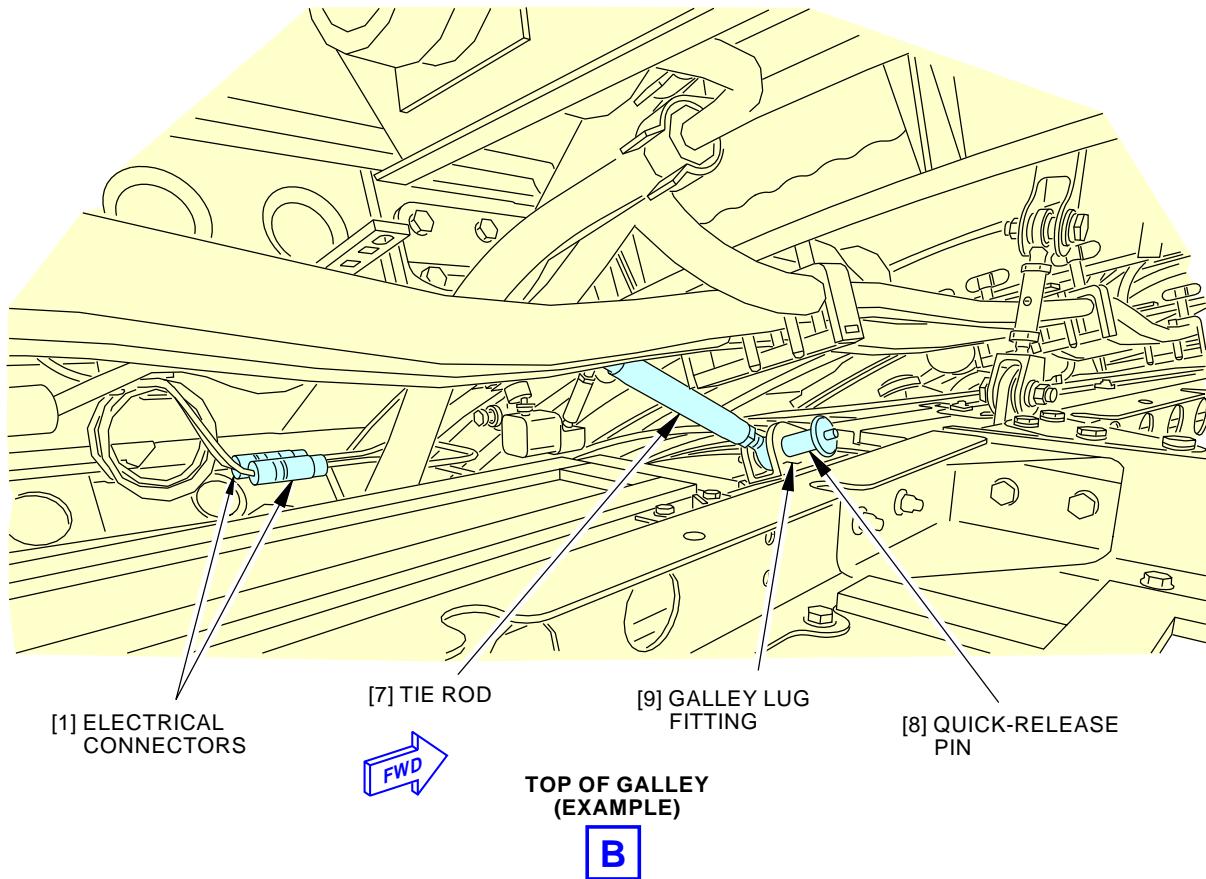
Galley 7 Installation
Figure 401/25-31-71-990-802 (Sheet 1 of 3)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-71



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AIRCRAFT MAINTENANCE MANUAL



H99143 S0006567348_V2

Galley 7 Installation
Figure 401/25-31-71-990-802 (Sheet 2 of 3)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

25-31-71

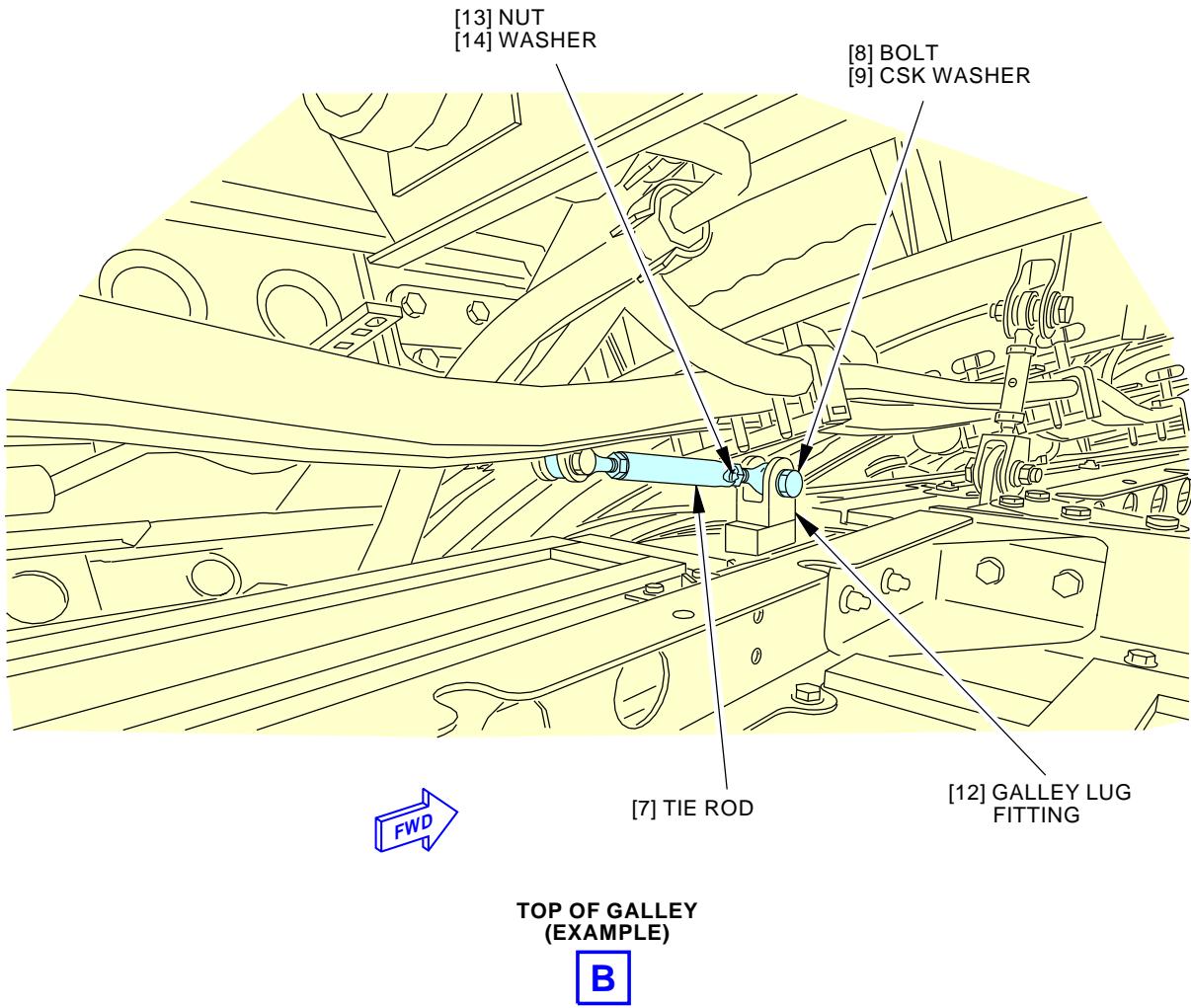
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Galley 7 Installation
Figure 401/25-31-71-990-802 (Sheet 3 of 3)

EFFECTIVITY
AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

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FORWARD GALLEY HEADER - REMOVAL/INSTALLATION

1. **General**

- A. This procedure contains these tasks:
 - (1) Forward Galley Header Removal
 - (2) Forward Galley Header Installation

TASK 25-31-83-000-801

2. **Forward Galley Header - Removal**

(Figure 401)

A. **References**

Reference	Title
25-21-71-000-805	Close Out Panel Removal, Forward Lowered Ceiling (P/B 401)

B. **Location Zones**

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. **Prepare for the Removal**

SUBTASK 25-31-83-010-001

- (1) Do this task: Close Out Panel Removal, Forward Lowered Ceiling, TASK 25-21-71-000-805

D. **Galley Header Removal**

SUBTASK 25-31-83-000-001

- (1) Remove the curtain [2] from the track on the header [1].

SUBTASK 25-31-83-020-002

- (2) Remove the screws [4] and [5], and the washers [3] at four locations on the header [1].

SUBTASK 25-31-83-020-003

- (3) Remove the header [1] from the galleys.

———— END OF TASK ————

TASK 25-31-83-400-801

3. **Forward Galley Header - Installation**

(Figure 401)

A. **References**

Reference	Title
25-21-71-400-805	Close Out Panel Installation, Forward Lowered Ceiling (P/B 401)

B. **Location Zones**

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. **Galley Header Installation**

SUBTASK 25-31-83-400-001

- (1) Install the header [1] between the galleys.

EFFECTIVITY
AKS 011, 012, 014, 019, 026, 028-999

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SUBTASK 25-31-83-420-002

- (2) Attach the header [1] with the screws [4] and [5], and the washers [3] at four locations.

SUBTASK 25-31-83-420-003

- (3) Install the curtain [2] on the track of the header [1].

D. Put the Airplane in Its Usual Condition

SUBTASK 25-31-83-410-001

- (1) Do this task: Close Out Panel Installation, Forward Lowered Ceiling, TASK 25-21-71-400-805.

———— END OF TASK ————

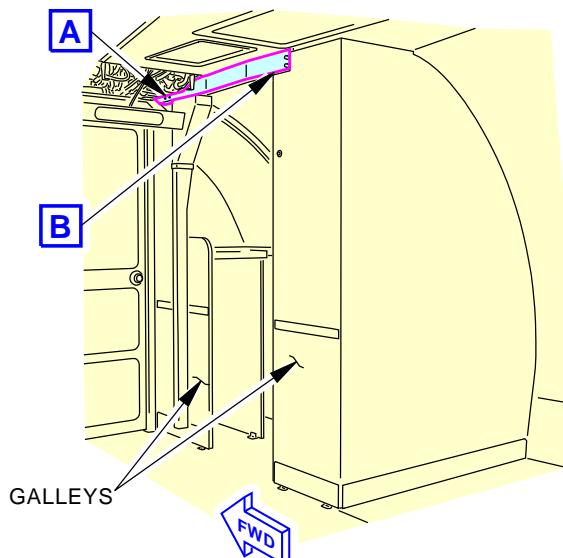
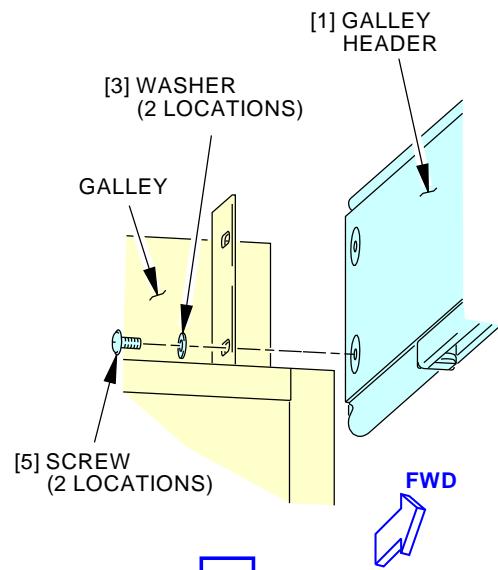
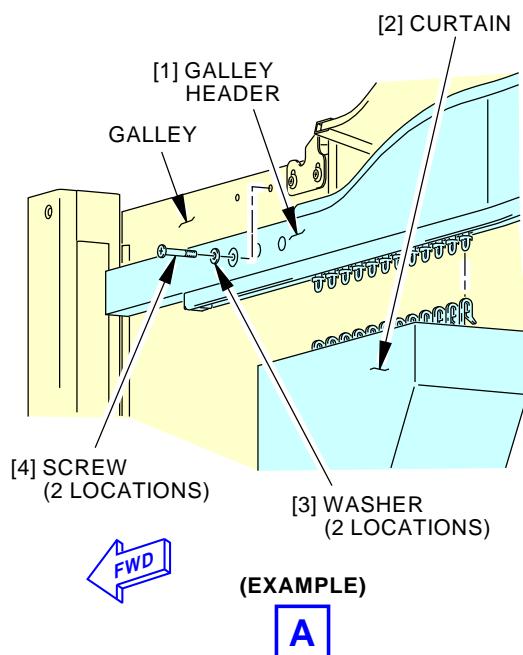
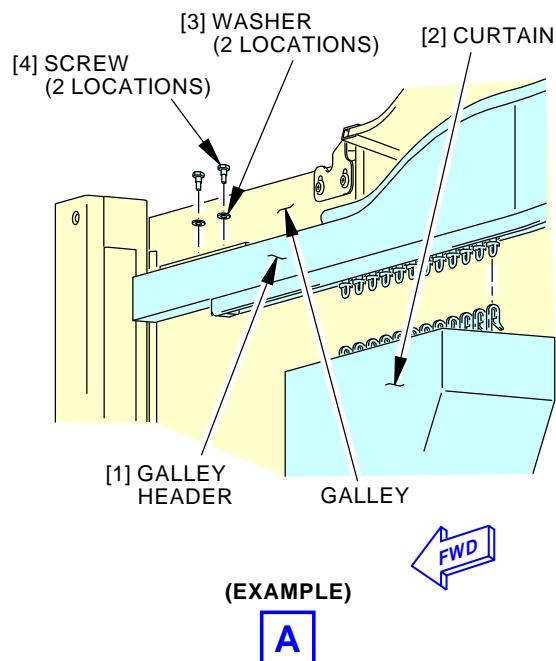
EFFECTIVITY
AKS 011, 012, 014, 019, 026, 028-999

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**FORWARD PASSENGER COMPARTMENT
(EXAMPLE)**

B

(EXAMPLE)
A

(EXAMPLE)
A

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Forward Galley Header Installation

Figure 401/25-31-83-990-801

EFFECTIVITY
 AKS 011, 012, 014, 019, 026, 028-999

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LAVATORIES - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Water heater power - deactivation.
 - (2) Water heater power - activation.
 - (3) Lavatory power - deactivation.
 - (4) Lavatory power - activation.

TASK 25-40-00-040-802

2. Water Heater Power - Deactivation

A. General

- (1) This task will deactivate the power to the water heaters for the lavatories.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

SUBTASK 25-40-00-020-001

- (1) Open the circuit breakers for the applicable lavatories and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
F	13	C00104	LAVATORY WATER HEATER A
F	14	C01073	LAVATORY WATER HEATER D
F	15	C01096	LAVATORY WATER HEATER E

D. Water Heater Power - Tryout

NOTE: This tryout is to make sure that the power to the water heaters is in zero energy state.

SUBTASK 25-40-00-410-001

- (1) Turn on the faucet.
(a) Make sure that there is no hot water.

———— END OF TASK ————

TASK 25-40-00-440-802

3. Water Heater Power - Activation

A. General

- (1) This task will activate the power to the water heaters for the lavatories.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
AKS ALL

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(Continued)

Zone	Area
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

SUBTASK 25-40-00-410-002

- (1) Remove the safety tags and close these circuit breakers for the applicable lavatories:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
F	13	C00104	LAVATORY WATER HEATER A
F	14	C01073	LAVATORY WATER HEATER D
F	15	C01096	LAVATORY WATER HEATER E

SUBTASK 25-40-00-420-003

- (2) Turn on the faucet.
 - (a) Make sure that there is hot water.

— END OF TASK —

TASK 25-40-00-040-803

4. Lavatory Power - Deactivation

A. General

- (1) This task will deactivate the power to the lavatories.

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

SUBTASK 25-40-00-020-003

- (1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT



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(Continued)

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	10	C00783	OXYGEN PASS LEFT
F	13	C00104	LAVATORY WATER HEATER A
F	14	C01073	LAVATORY WATER HEATER D
F	15	C01096	LAVATORY WATER HEATER E

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027	E	11	C00413 BRT ENTRY LTS (INOP)

AKS ALL

D. Lavatory Power - Tryout

NOTE: This tryout is to make sure that the power to the lavatories is in a zero energy state.

SUBTASK 25-40-00-210-006

- (1) Visually make sure that mirror lights in the lavatories are off.

SUBTASK 25-40-00-210-007

- (2) At the overhead panel, P5, or the aft attendant panel, set the emergency light switch to the on mode.
 - (a) Make sure the emergency dome lights in the lavatories do not come on.

SUBTASK 25-40-00-210-008

- (3) Do these steps to make sure that the power to the water heaters is off:
 - (a) Turn on the faucet.

EFFECTIVITY
AKS ALL

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AIRCRAFT MAINTENANCE MANUAL

- (b) Make sure that the water is not hot.

— END OF TASK —

TASK 25-40-00-440-803

5. Lavatory Power - Activation

A. General

- (1) This task will activate the power to the lavatories.

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Procedure

SUBTASK 25-40-00-420-002

- (1) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	10	C00783	OXYGEN PASS LEFT
F	13	C00104	LAVATORY WATER HEATER A
F	14	C01073	LAVATORY WATER HEATER D
F	15	C01096	LAVATORY WATER HEATER E

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O

EFFECTIVITY
AKS ALL

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(Continued)

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027			
E	11	C00413	BRT ENTRY LTS (INOP)

AKS ALL

SUBTASK 25-40-00-210-009

- (2) Visually make sure that the mirror lights in the lavatories are on.

SUBTASK 25-40-00-210-010

- (3) At the overhead panel, P5, or the aft attendant panel, set the emergency light switch to the on mode.
(a) Make sure the emergency dome lights in the lavatories come on.

SUBTASK 25-40-00-210-011

- (4) At the overhead panel, P5, or the aft attendant panel, set the emergency light switch to the off mode.

SUBTASK 25-40-00-210-011

- (5) Do these steps to make sure that the power to the water heaters is on:
(a) Turn on the faucet.
(b) Make sure that the water is hot.

———— END OF TASK ————

EFFECTIVITY	AKS ALL
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LAVATORY SEALANT - REMOVAL/INSTALLATION

1. General

- A. This procedure has this task.
 - (1) Lavatory Sealant Installation.

TASK 25-40-01-400-801

2. Lavatory Sealant Installation

(Figure 401)

A. References

Reference	Title
51-31-00-160-801	Prepare For Sealing (P/B 201)
51-31-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)
51-31-00-390-804	Fillet Seal Application (P/B 201)
51-31-00-390-805	Fastener Seal Application (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00635	Adhesive - RTV 108 Translucent Silicone Rubber RTV Paste, One-part	MIL-A-46106
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

C. Sealant Installation Procedure

SUBTASK 25-40-01-400-001

(1) FOR LAVATORIES WITH BI-FOLD DOORS;

Do these steps to apply sealant to the threshold area:

- (a) Remove the threshold [2] from the lavatory [1] if it is necessary.
- (b) Clean the areas that will be sealed (TASK 51-31-00-160-801).
- (c) Apply a bead of sealant [3] of RTV 108 adhesive, A00635 around the bi-fold door pivot hole [11] (TASK 51-31-00-390-801).
- (d) Install the threshold [2].
- (e) Remove the excess RTV 108 adhesive, A00635 from the bi-fold door pivot hole [11].
- (f) Apply a fillet seal [4] around the interior edges of the threshold [2] with RTV 108 adhesive, A00635 (TASK 51-31-00-390-804).
- (g) Install the bi-fold door [5]

SUBTASK 25-40-01-400-002

(2) FOR LAVATORIES WITHOUT BI-FOLD DOORS;

Do these steps to apply sealant to the threshold area:

- (a) Clean the areas that will be sealed. (TASK 51-31-00-160-801).
- (b) Install the threshold [2].

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- (c) Apply a fillet seal [4] around the interior edges of the threshold [2] with RTV 108 adhesive, A00635 (TASK 51-31-00-390-804).

SUBTASK 25-40-01-400-003

- (3) If not already done, do these steps to apply sealant to each floor fitting:
- (a) Apply sealant [9] to the bolts in the lavatory floor fittings with compound, C00528(TASK 51-31-00-390-805).
 - (b) Apply fay surface sealant [7] to the cover plate [6] with adhesive, A00027, adhesive, A00930 or RTV 108 adhesive, A00635 (TASK 51-31-00-390-801).
 - (c) Install the cover plate [6] on each lavatory fitting [8].

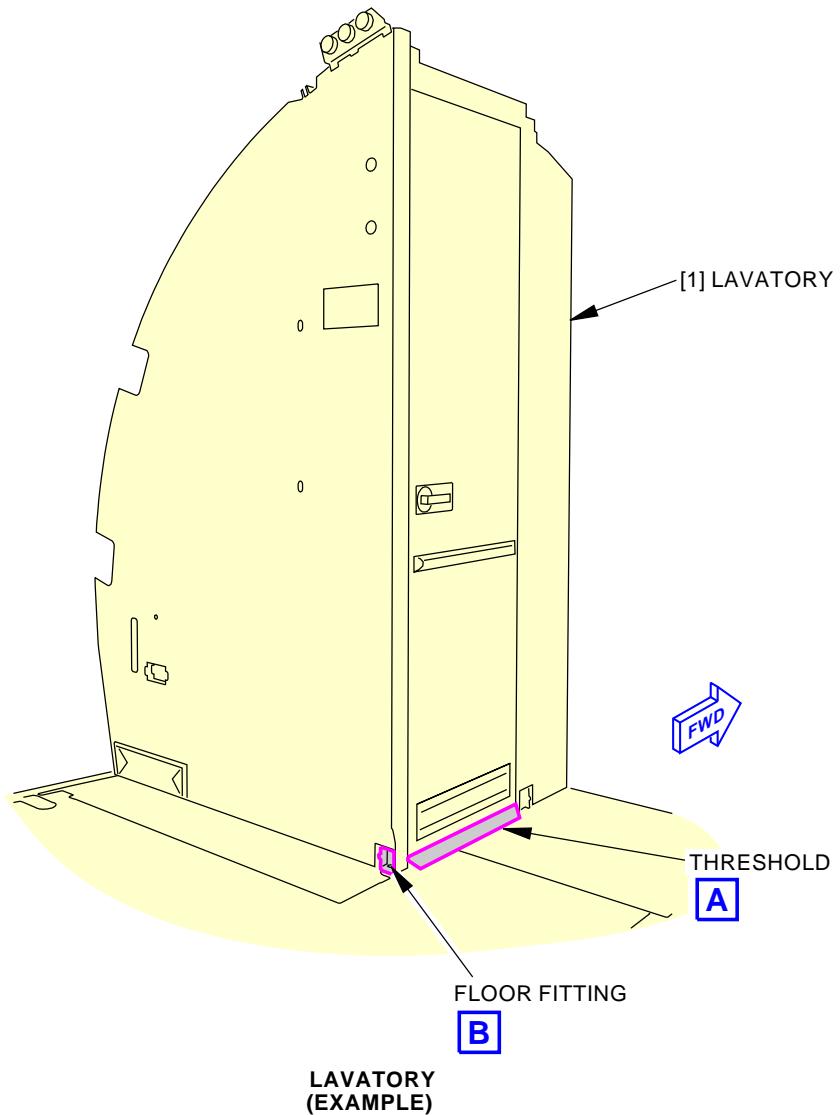
———— END OF TASK ————

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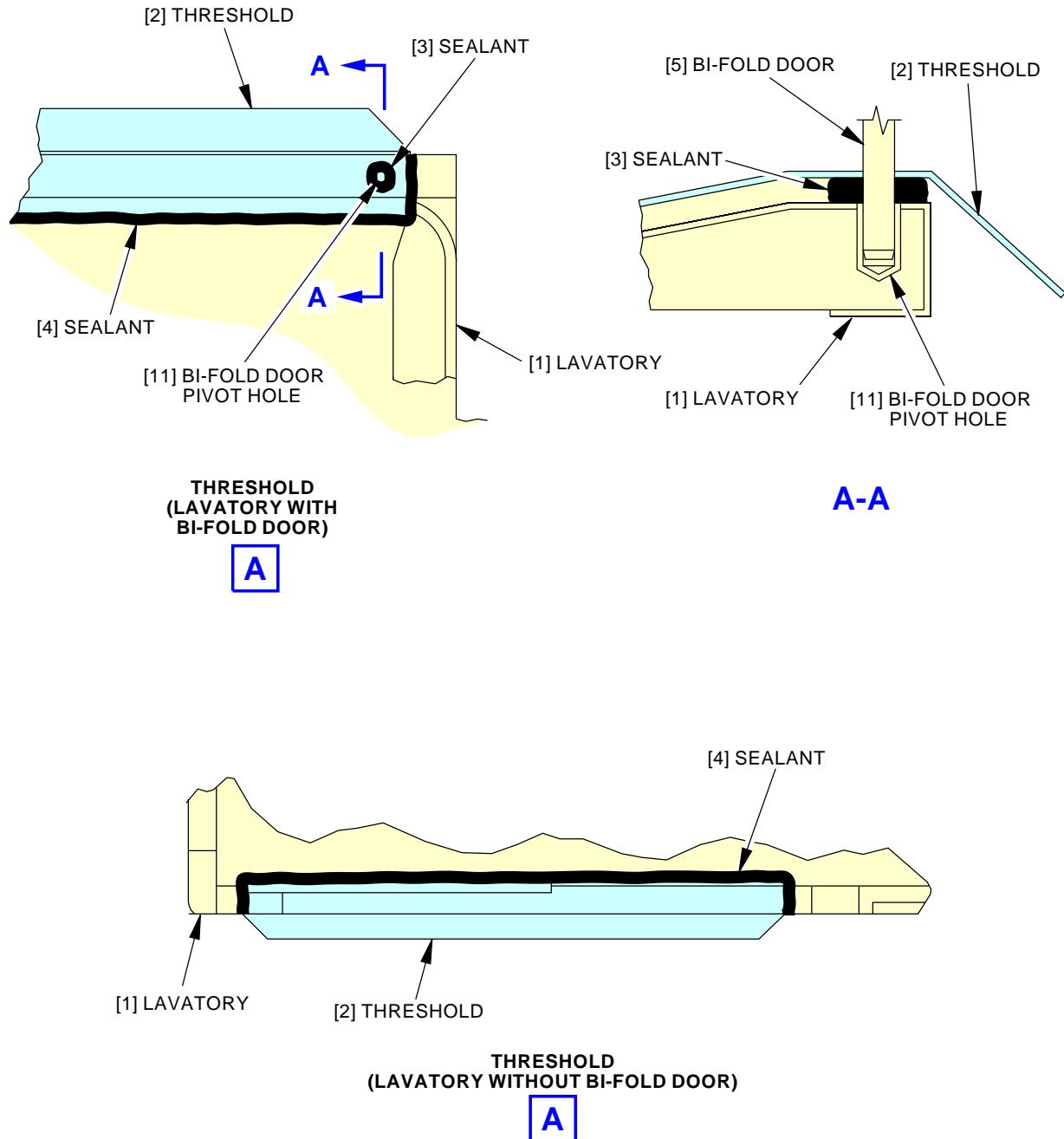


403152 S0000135745_V2

Lavatory Sealant Installation
Figure 401/25-40-01-990-801 (Sheet 1 of 3)

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403154 S0000135747_V3

Lavatory Sealant Installation
Figure 401/25-40-01-990-801 (Sheet 2 of 3)

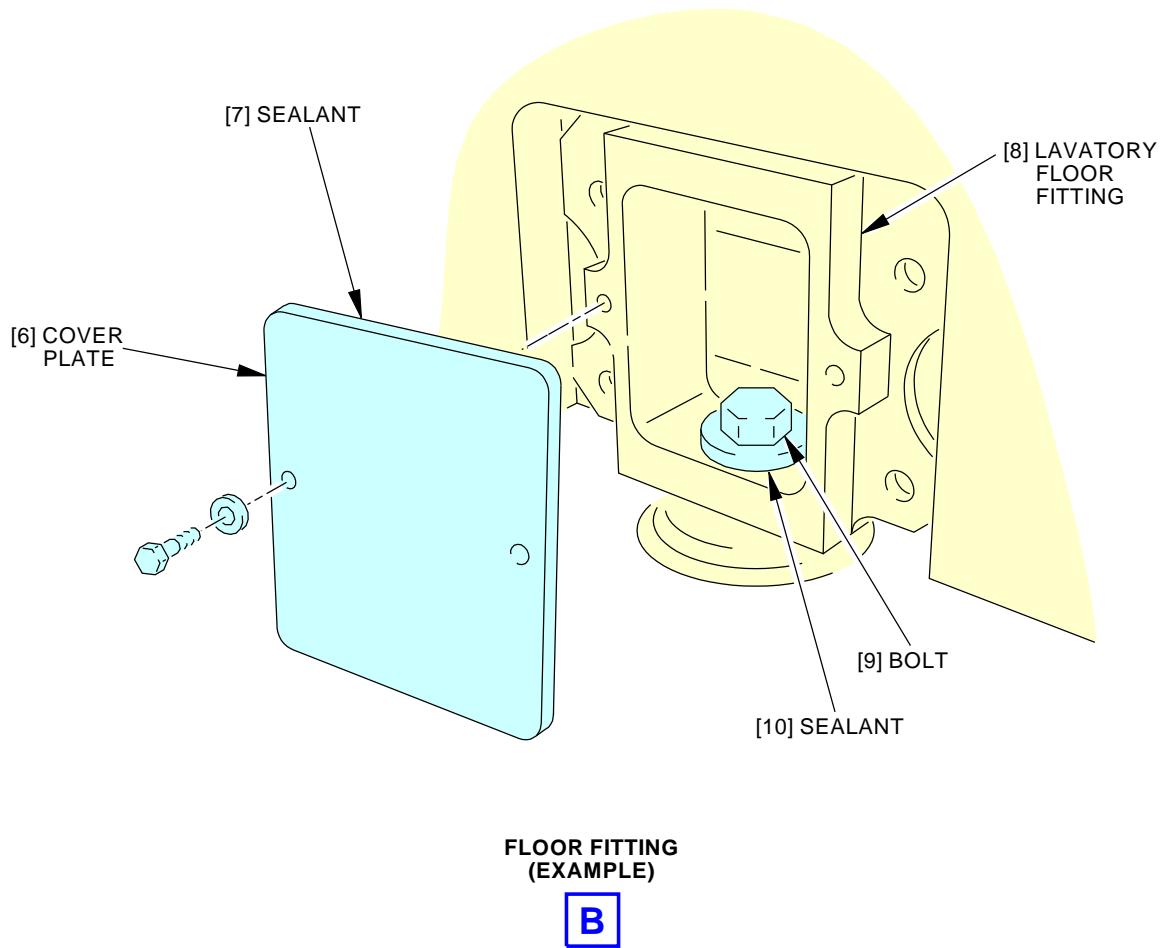
EFFECTIVITY
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403155 S0000135746_V2

Lavatory Sealant Installation
Figure 401/25-40-01-990-801 (Sheet 3 of 3)

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LAVATORY WASTE COMPARTMENT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has this task:
 - (1) An inspection of the lavatory waste compartment.

TASK 25-40-08-200-801

2. Lavatory Waste Compartment Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

| AKS 001-024

B. Waste Compartment Door Inspection Procedure

SUBTASK 25-40-08-210-003

- (1) Do these steps to make sure the door closes tightly:
 - (a) Pull the latch at the bottom of the door to open the door.
 - (b) Push around the edge of the door plate on the inner side of the door.
 - 1) Make sure the door plate moves quickly back to its initial position.

NOTE: There are springs behind the door plate. These springs compress when the door is closed.

 - (c) Do a visual check of the door plate on the inner side of the door for general condition.
 - (d) Close the door.
 - (e) Do these steps to make sure the latches are fully engaged:
 - 1) Push the door in the upper and lower latch area.
 - 2) Make sure the lower latch is parallel to the door.

NOTE: If you can easily see red on the lower latch, the latches are not fully engaged.

AKS 025-999

C. Waste Compartment Door Inspection Procedure

SUBTASK 25-40-08-210-004

- (1) Do these steps for lavatories with an inner waste compartment door and an outer waste compartment door to make sure the waste compartment doors close correctly:
 - (a) Open the outer waste compartment door.

NOTE: The latch is at the bottom of the door.
 - (b) Open the inner waste compartment door and release it.
 - 1) Make sure that the springs close the inner door without your help.
 - (c) Make sure the inner door is not bent or blocked such that it does not close fully. It must close tightly to make sure it can contain a fire.

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| AKS 025-999 (Continued)

- (d) Close the outer waste compartment door.
 - 1) Make sure the latch holds the outer door closed.

AKS ALL

D. Waste Compartment Flap Inspection Procedure

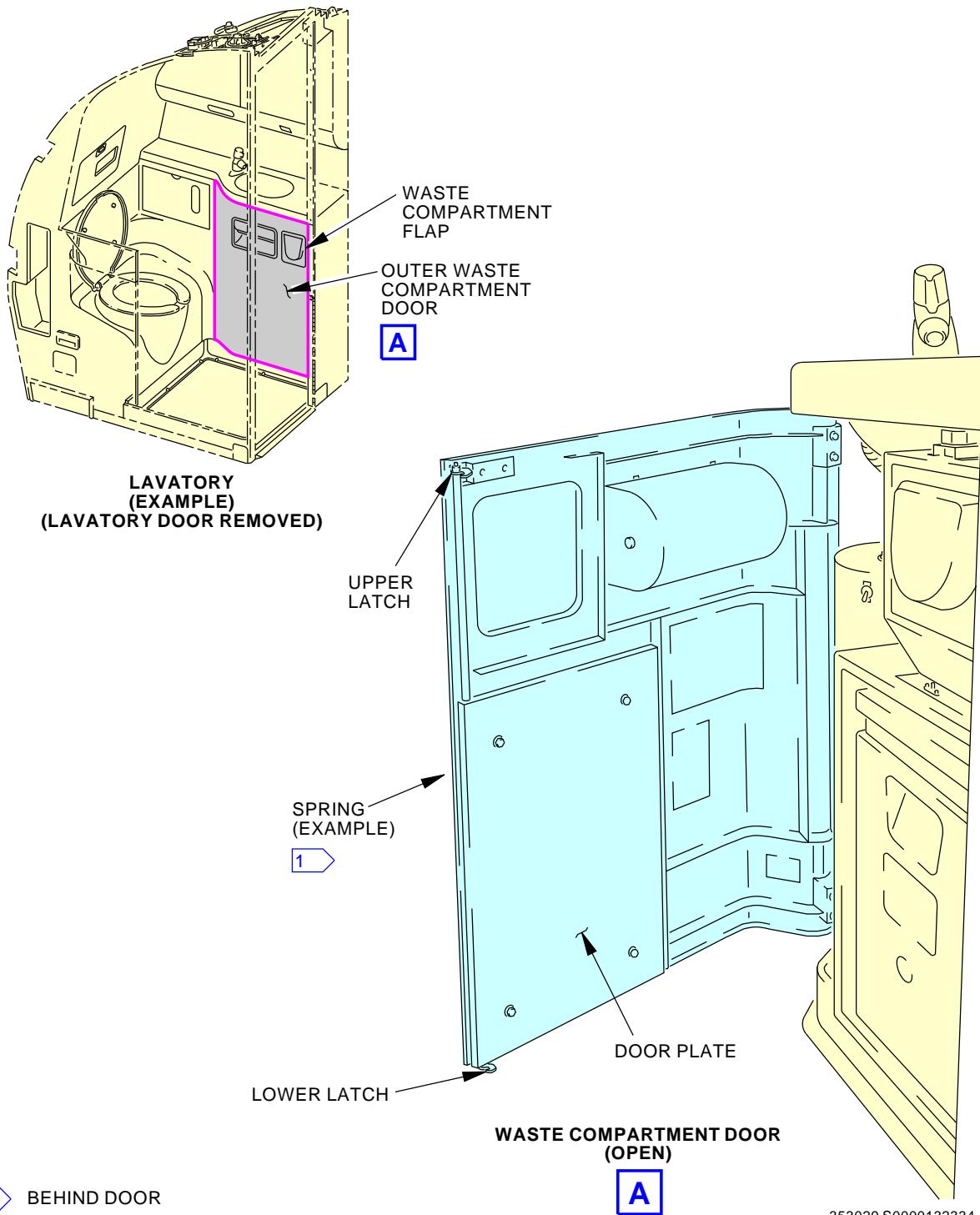
SUBTASK 25-40-08-210-002

- (1) Do these steps to make sure the waste compartment flap operates correctly:
 - (a) Push the waste compartment flap open.
 - (b) Release the waste compartment flap and make sure it closes fully.
 - (c) Make sure the waste compartment flap is not bent such that it does not close fully. It must close tightly to make sure it can contain a fire.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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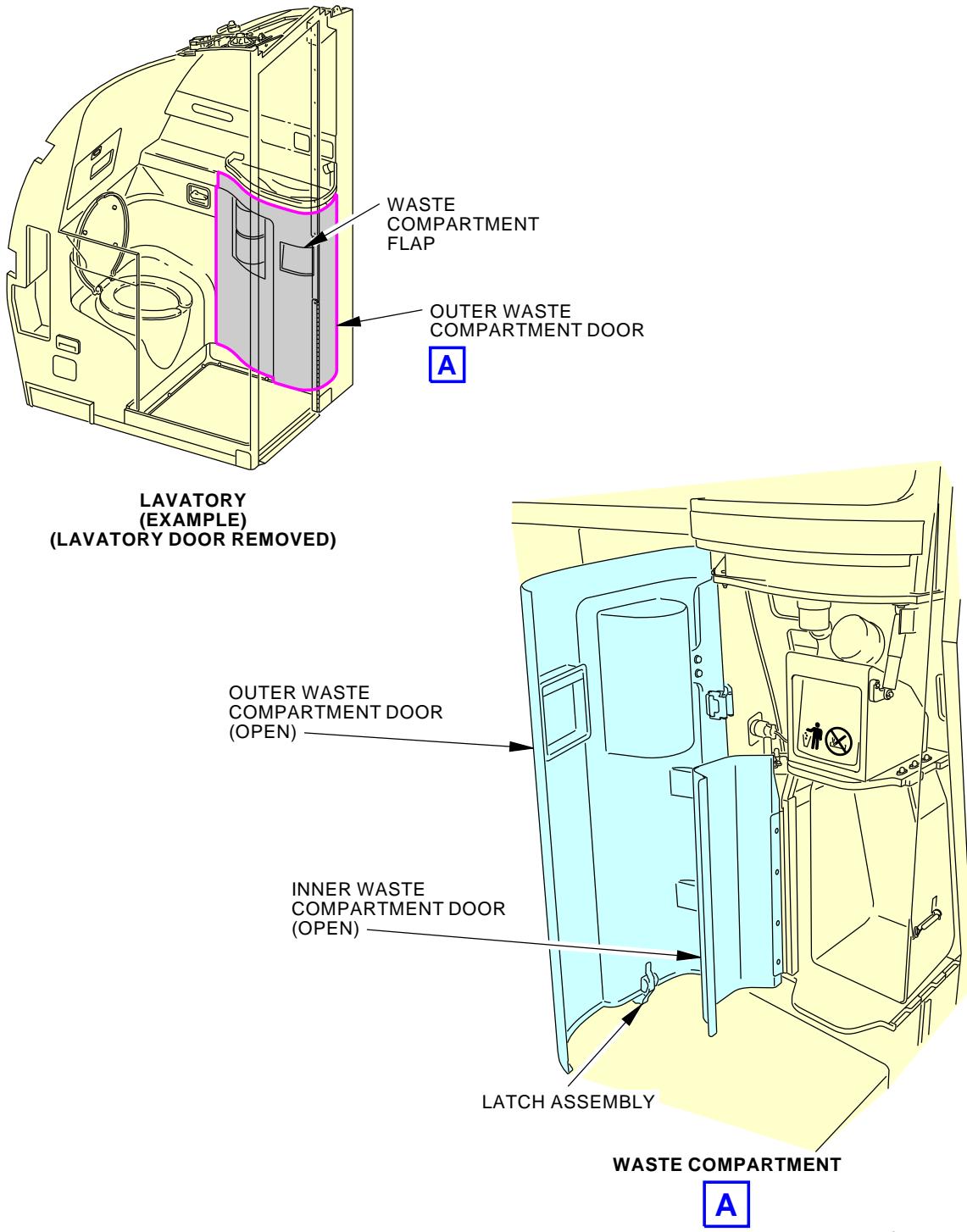
353029 S0000132334_V3

Lavatory Waste Compartment Inspection
Figure 601/25-40-08-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS 001-024

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D633A101-AKS



2339938 S0000533244_V2

**Lavatory Waste Compartment Inspection
Figure 601/25-40-08-990-801 (Sheet 2 of 2)**

 EFFECTIVITY
 AKS 025-999

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MODULAR LAVATORY A - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Lavatory A Removal.
 - (2) Lavatory A Installation.

TASK 25-40-11-000-801

2. **Lavatory A - Removal**

(Figure 401)

A. **General**

- (1) Be careful during the removal of the lavatory to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley and lavatory area.

B. **References**

Reference	Title
23-42-01-000-801	Attendant Handset Removal (P/B 401)
23-42-01-000-802	Attendant Handset Cord Removal (P/B 401)
23-42-01-000-803	Attendant Handset Cradle Removal (P/B 401)
25-11-02-000-802	Second Observer's Seat Removal (P/B 401)
25-11-21-000-801	Flight Compartment Forward Ceiling Panel Removal (P/B 201)
25-21-30-020-801	Forward Entry Door Doorway Header Panel - Removal (P/B 401)
25-21-31-420-801	Forward Entry Doorway Sidewall Lining Panel - Removal (P/B 401)
25-21-71-000-801	Lowered Ceiling Removal (P/B 401)
25-23-13-000-801	Attendant/Lavatory Service Unit - Removal (P/B 401)
25-24-15-000-807	Fixed Class Divider - Removal (P/B 401)
25-25-11-000-802	Attendant's Panel with LCD Touch Panel - Removal (P/B 401)
25-25-12-000-801	Attendants' Seat Removal (P/B 401)
25-31-71 P/B 401	GALLEY NO. 7 - REMOVAL/INSTALLATION
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-14-00-000-801	Left Dome Light - Removal (P/B 201)
38-32-00-040-801	Toilet Deactivation (P/B 201)
38-32-00-040-802	Toilet Deactivation (P/B 201)
38-32-01-000-801-001	Toilet Shroud Removal (P/B 401)
38-32-01-000-805-001	Vacuum Toilet Assembly Removal (P/B 401)
38-32-01-000-843-003	Toilet Shroud Removal (P/B 401)
38-32-01-000-844-003	Vacuum Toilet Assembly Removal (P/B 401)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)
52-51-01-000-801	Flight Compartment Door Removal (P/B 401)

C. **Location Zones**

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left



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D. Prepare for the Procedure

SUBTASK 25-40-11-040-001

- (1) Do this task: Toilet Deactivation, TASK 38-32-00-040-801 or Toilet Deactivation, TASK 38-32-00-040-802.

SUBTASK 25-40-11-860-001

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	10	C00783	OXYGEN PASS LEFT
F	13	C00104	LAVATORY WATER HEATER A

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027	E	11	C00413 BRT ENTRY LTS (INOP)
AKS ALL			

SUBTASK 25-40-11-010-002

- (3) Do this task: Attendant's Panel with LCD Touch Panel - Removal, TASK 25-25-11-000-802

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SUBTASK 25-40-11-010-003

- (4) If applicable, remove the attendants handset.
 - (a) Do this task: Attendant Handset Removal, TASK 23-42-01-000-801
 - (b) Do this task: Attendant Handset Cord Removal, TASK 23-42-01-000-802
 - (c) Do this task: Attendant Handset Cradle Removal, TASK 23-42-01-000-803

SUBTASK 25-40-11-010-004

- (5) Do this task: Attendants' Seat Removal, TASK 25-25-12-000-801

SUBTASK 25-40-11-010-005

- (6) Do this task: Flight Compartment Door Removal, TASK 52-51-01-000-801

SUBTASK 25-40-11-010-006

- (7) Do this task: Left Dome Light - Removal, TASK 33-14-00-000-801

SUBTASK 25-40-11-010-007

- (8) Do this task: Flight Compartment Forward Ceiling Panel Removal, TASK 25-11-21-000-801

SUBTASK 25-40-11-010-008

- (9) If applicable, do this task: Second Observer's Seat Removal, TASK 25-11-02-000-802

SUBTASK 25-40-11-010-009

- (10) If applicable, remove the fire axe from the flight compartment.

SUBTASK 25-40-11-010-010

- (11) Do this task: Attendant/Lavatory Service Unit - Removal, TASK 25-23-13-000-801

NOTE: The Lav Service Unit (Oxygen box) must be removed before the lavatory can be moved because of the overhead structural frame.

SUBTASK 25-40-11-010-011

- (12) Do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION, PAGEBLOCK 26-14-01/401

SUBTASK 25-40-11-010-012

- (13) Do this task: Lowered Ceiling Removal, TASK 25-21-71-000-801

SUBTASK 25-40-11-010-013

- (14) Do this task: Forward Entry Door Doorway Header Panel - Removal, TASK 25-21-30-020-801

SUBTASK 25-40-11-010-014

- (15) Do this task: Forward Entry Doorway Sidewall Lining Panel - Removal, TASK 25-21-31-420-801

AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

SUBTASK 25-40-11-010-015

- (16) If applicable, do this task: GALLEY NO. 7 - REMOVAL/INSTALLATION, PAGEBLOCK 25-31-71/401

AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-40-11-010-016

- (17) If applicable, do this task: Fixed Class Divider - Removal, TASK 25-24-15-000-807

AKS ALL

SUBTASK 25-40-11-870-001

- (18) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801

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SUBTASK 25-40-11-680-001

- (19) Drain the water from the applicable lavatory equipment.

SUBTASK 25-40-11-010-021

- (20) Do these steps to prepare the lavatory for the removal procedure:

- Remove the necessary trim panels from the lavatory to complete the task.
- Remove the necessary access panels from the lavatory to complete the task.
- Remove the necessary hose grommets from the lavatory to complete the task.

E. Procedure

SUBTASK 25-40-11-020-001

- (1) Disconnect the electrical connections [2] above the lavatory [1].

SUBTASK 25-40-11-030-001

- (2) Disconnect the ground connection from the lavatory [1].

- Remove the nut [3] and washer [4] from the ground stud [5] at the rear of the lavatory [1].
- Disconnect the ground strap [6] from the ground stud [5].

SUBTASK 25-40-11-020-002

- (3) Disconnect the gasper air supply at the connection at the rear of the lavatory [1].

- Get access through the applicable access panel in the rear of the lavatory [1].
- Disconnect the gasper air connection [7] at the rear of the lavatory [1].

SUBTASK 25-40-11-020-003

- (4) Disconnect the water supply at the connection at the rear of the lavatory [1].

- Get access through the applicable access panel in the rear of the lavatory [1].
- Disconnect the water supply connection [8] at the rear of the lavatory [1].

SUBTASK 25-40-11-020-004

- (5) Disconnect the drain line at the connection at the rear of the lavatory [1].

- Get access through the applicable access panel in the rear of the lavatory [1].
- Loosen the clamp [9], then disconnect the drain line [10].

SUBTASK 25-40-11-020-005

- (6) Disconnect the door flexible duct [11].

- Get access through the applicable access panel in the rear of the lavatory [1].
- Loosen the clamp [12] at the two ends of the door flexible duct.
- Remove the door flexible duct [11] from the lavatory [1].

AKS 001-024

SUBTASK 25-40-11-020-013

- (7) Disconnect the toilet from the airplane waste system tube through the applicable access panel.

AKS 025-999

SUBTASK 25-40-11-020-014

- (8) Do these steps to remove the waste line connection:

- If applicable, remove the boot [28] from the riser tube [26].
- Open the junction box access panel [21].

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AKS 025-999 (Continued)

- (c) Remove the sealant where the junction box access panel [21] attaches to the lavatory [1] and at the seam between the panels.
- (d) Disconnect the lanyard [22] from the clip on the junction box.
- (e) Disconnect the riser tube [26] from the waste tube [30].

NOTE: Make sure to keep the riser tube [26] for the installation of the lavatory.

AKS ALL

SUBTASK 25-40-11-010-020

- (9) If applicable, do these tasks:

- (a) Toilet Shroud Removal, TASK 38-32-01-000-801-001 or Toilet Shroud Removal, TASK 38-32-01-000-843-003
- (b) Vacuum Toilet Assembly Removal, TASK 38-32-01-000-805-001 or Vacuum Toilet Assembly Removal, TASK 38-32-01-000-844-003

NOTE: Removal of the toilet is optional.

NOTE: Time can be saved if the toilet stays in the lavatory.

SUBTASK 25-40-11-020-006

- (10) Remove the two tie rods [13] and [14].
 - (a) Remove the cotter pin [15], pin [16] and washer [17] at the two ends of the tie rods [13] and [14].
 - (b) Remove the two tie rods [13] and [14], from the lavatory [1] and the airplane structure.

SUBTASK 25-40-11-020-007

- (11) Remove the coverplate on the hard point fittings.

SUBTASK 25-40-11-020-008

- (12) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.

SUBTASK 25-40-11-020-009

- (13) Remove the bolt [18] and the washer [19] at the four hard point fittings.
- (14) If necessary, remove the shims [20] at the four hard point fittings.

SUBTASK 25-40-11-020-010

- (15) Remove the lavatory [1].

———— END OF TASK ———

TASK 25-40-11-400-801

3. Lavatory A - Installation

(Figure 401)

A. References

Reference	Title
23-31-00-740-801	Passenger Address System - Operational Test (P/B 501)
23-42-01-400-801	Attendant Handset Cradle Installation (P/B 401)
23-42-01-400-802	Attendant Handset Cord Installation (P/B 401)
23-42-01-400-803	Attendant Handset Installation (P/B 401)
23-42-01-700-801	Attendant Handset Installation Test (P/B 401)
25-11-02-400-802	Second Observer's Seat Installation (P/B 401)

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(Continued)

Reference	Title
25-11-21-400-801	Flight Compartment Forward Ceiling Panel Installation (P/B 201)
25-21-30-420-801	Forward Entry Door Doorway Header Panel - Installation (P/B 401)
25-21-31-420-802	Forward Entry Doorway Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
25-23-13-400-801	Attendant/Lavatory Service Unit - Installation (P/B 401)
25-24-15-400-806	Fixed Class Divider - Installation (P/B 401)
25-24-31-400-803-001	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-804-001	Overhead Stowage Bin Module - Installation (P/B 401)
25-25-11-400-802	Attendant's Panel with LCD Screen - Installation (P/B 401)
25-25-12-400-801	Attendants' Seat Installation (P/B 401)
25-31-71 P/B 401	GALLEY NO. 7 - REMOVAL/INSTALLATION
25-40-01-400-801	Lavatory Sealant Installation (P/B 401)
26-14-00-730-801	Lavatory Smoke Detection - Smoke Test (P/B 501)
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-14-00-400-801	Left Dome Light - Installation (P/B 201)
33-20-00-710-804-001	Passenger Compartment Lights - Operational Test (P/B 501)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
38-32-00-420-801	Toilet Activation (P/B 201)
38-32-00-440-801	Toilet Activation (P/B 201)
38-32-00-700-802	Toilet - Operational Test (P/B 501)
38-32-01-400-801-001	Toilet Shroud Installation (P/B 401)
38-32-01-400-805-001	Vacuum Toilet Assembly Installation (P/B 401)
38-32-01-400-843-003	Toilet Shroud Installation (P/B 401)
38-32-01-400-844-003	Vacuum Toilet Assembly Installation (P/B 401)
52-51-01-400-801	Flight Compartment Door Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

C. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

D. Lavatory Installation

SUBTASK 25-40-11-110-001

- (1) Clean the galley mat on the floor in the galley area with solvent, B00083.

NOTE: The galley mat is a cover on the floor panels in the galley and lavatory area.



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SUBTASK 25-40-11-350-001

- (2) Repair the galley mat if it is necessary.

AKS 025-999

SUBTASK 25-40-11-420-017

- (3) Make sure that the fire blanket is installed.
(4) Make sure that there is no damage to the fire blanket.

AKS ALL

SUBTASK 25-40-11-420-001

- (5) Move the lavatory [1] inboard.

SUBTASK 25-40-11-420-002

CAUTION: REMOVE AND INSTALL THE LAVATORY CAREFULLY. YOU CAN CAUSE DAMAGE TO THE GALLEY MAT.

- (6) Put the lavatory [1] on the hard point fittings until the lavatory floor is parallel with the airplane floor.

SUBTASK 25-40-11-420-003

- (7) If necessary, install the shims [20] at the forward hard points.
(a) The clearance between the top of the hard point fittings and the bottom of the lavatory fittings must come to 0.01 inches (0.254 mm).
(b) The shim maximum thickness must not be more than 0.10 inches (2.54 mm).
(c) Install shims [20] until the clearance comes to 0.01 inches (0.254 mm).

SUBTASK 25-40-11-420-004

- (8) Install the lavatory [1] fasteners.
(a) Apply compound, C00528 to the bolts [18] and washers [19].
(b) Install the bolt [18] and washer [19] at the four hard point fittings.
(c) Tighten the bolts [18] to 150 in-lb (17 N·m) and make sure that a layer of compound, C00528 seals the connection.

SUBTASK 25-40-11-400-002

- (9) Do this task: Lavatory Sealant Installation, TASK 25-40-01-400-801.
(a) During this task, install cover plates, threshold (if removed), and kickstrips (if applicable).

SUBTASK 25-40-11-820-002

- (10) Attach the two tie rods [13] and [14] to the fittings on the lavatory [1] and the airplane structure.
(a) Adjust the tie rods [13] and [14] to the correct length.
1) After the last tie rod adjustments are completed, make sure that the inspection holes at the two ends of the tie rods [13] and [14] are blocked and the threads are visible in the inspection holes.
2) Tighten the jambnuts with your fingers.
3) If the pin-to-pin length of the tie rod [14] is larger than 4 inches, install a second jambnut on the tie rod.
4) Make sure that the tie rods [13] and [14] are installed with the jambnut at the lower end.
(b) Install the pin [16] and washer [17] at the two ends of the tie rods [13] and [14].
(c) Lock the pin [16] and washer [17] at the two ends of the tie rod with the cotter pin [15].

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SUBTASK 25-40-11-390-001

- (11) Install a layer of adhesive, A00027 or adhesive, A00930 between the edge of the lavatory and the airplane floor.

SUBTASK 25-40-11-420-006

- (12) Connect the water supply at the connection at the rear of the lavatory [1].
(a) Get access through the applicable access panel in the rear of the lavatory [1].
(b) Connect the water supply connection [8] at the rear of the lavatory [1].

SUBTASK 25-40-11-420-007

- (13) Connect the drain line [10] at the connection at the rear of the lavatory [1].
(a) Through the applicable rear access panel, connect the drain line [10].
(b) Tighten the clamp [9] at the end of the drain line [10].

SUBTASK 25-40-11-420-008

- (14) Connect the gasper air supply at the connection at the rear of the lavatory [1].
(a) Get access through the applicable access panel in the rear of the lavatory [1].
(b) Connect the gasper air connection [7] at the rear of the lavatory [1].

SUBTASK 25-40-11-420-009

- (15) Connect the door flexible duct [11].
(a) Through the applicable rear access panel, connect the door flexible duct [11].
(b) Tighten the clamp [12] at the two ends of the door flexible duct [11].

SUBTASK 25-40-11-410-002

- (16) If applicable, do these tasks:
(a) Vacuum Toilet Assembly Installation, TASK 38-32-01-400-805-001 or Vacuum Toilet Assembly Installation, TASK 38-32-01-400-844-003
(b) Toilet Shroud Installation, TASK 38-32-01-400-801-001 or Toilet Shroud Installation, TASK 38-32-01-400-843-003

AKS 001-024

SUBTASK 25-40-11-420-018

- (17) Connect the toilet to the airplane waste system tube through the applicable access panel.

AKS 025-999

SUBTASK 25-40-11-420-016

CAUTION: MAKE SURE THAT AN O-RING WITHOUT DAMAGE IS INSTALLED ON THE WASTE LINE BEFORE YOU INSTALL THE RISER TUBE. A BAD OR MISSING O-RING CAN CAUSE FLUID LEAKAGE. THE FLUID CAN CAUSE CORROSION ON THE ADJACENT STRUCTURE.

- (18) Do these steps to connect the waste line connection:
(a) Open the junction box access panel [21].
(b) Make sure that the O-ring [29] is installed.
(c) Connect the riser tube [26] to the waste tube [30].
(d) Connect the lanyard [22] to the clip on the junction box.
(e) Fillet seal the junction box access panel [21] seam with adhesive, A00027 or equivalent.

EFFECTIVITY

AKS ALL

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AKS 025-999 (Continued)

- (f) Fillet seal the junction box access panel [21] with adhesive, A00027 or equivalent where it meets the lavatory.
- (g) If applicable, install the boot [28] to the riser tube [26].
- (h) Close the junction box access panel [21].

AKS ALL

SUBTASK 25-40-11-420-012

- (19) Connect the ground connection to the lavatory [1].
 - (a) Connect the ground strap [6] to the ground stud [5] on the back of the lavatory [1].
 - (b) Install the nut [3] and washer [4] on the ground stud [5].
 - (c) Do a resistance check of the static ground from the ground stud [5] on the lavatory [1] to the airplane ground stud.

AKS 001-024

- (d) Make sure the resistance is a maximum of 0.0025 Ohms.

AKS 025-999

- (e) Make sure the resistance is a maximum of 0.0013 Ohms.

AKS ALL

SUBTASK 25-40-11-420-011

- (20) Connect the electrical connectors [2] in the ceiling above the lavatory [1].

E. Put the Airplane in Its Usual Condition

SUBTASK 25-40-11-410-001

- (1) Do these steps to put the lavatory back to the serviceable condition:
 - (a) Replace the lavatory hose grommets removed before.
 - (b) Replace the lavatory access panels removed before.
 - (c) Replace the lavatory trim panels removed before.

SUBTASK 25-40-11-790-001

- (2) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801

SUBTASK 25-40-11-670-001

- (3) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801

AKS 011, 012, 014, 019, 026, 028-999

SUBTASK 25-40-11-410-004

- (4) If applicable, do this task: Fixed Class Divider - Installation, TASK 25-24-15-400-806

AKS 001-006, 009, 010, 013, 015-018, 020-025, 027

SUBTASK 25-40-11-410-007

- (5) If applicable, do this task: GALLEY NO. 7 - REMOVAL/INSTALLATION, PAGEBLOCK 25-31-71/401

AKS ALL

SUBTASK 25-40-11-410-008

- (6) Do this task: Forward Entry Doorway Sidewall Lining Panel - Installation, TASK 25-21-31-420-802

EFFECTIVITY	AKS ALL
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SUBTASK 25-40-11-410-009

- (7) Do this task: Forward Entry Door Doorway Header Panel - Installation,
TASK 25-21-30-420-801

SUBTASK 25-40-11-420-014

- (8) Do this task if necessary: Overhead Stowage Bin - Installation, TASK 25-24-31-400-803-001 or
Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-804-001

SUBTASK 25-40-11-410-010

- (9) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801

SUBTASK 25-40-11-410-011

- (10) Do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION,
PAGEBLOCK 26-14-01/401

SUBTASK 25-40-11-410-012

- (11) Do this task: Attendant/Lavatory Service Unit - Installation, TASK 25-23-13-400-801

SUBTASK 25-40-11-410-013

- (12) Do this task: Flight Compartment Door Installation, TASK 52-51-01-400-801

SUBTASK 25-40-11-410-014

- (13) Do this task: Left Dome Light - Installation, TASK 33-14-00-400-801

SUBTASK 25-40-11-410-015

- (14) Do this task: Flight Compartment Forward Ceiling Panel Installation, TASK 25-11-21-400-801

SUBTASK 25-40-11-410-016

- (15) If applicable, do this task: Second Observer's Seat Installation, TASK 25-11-02-400-802

SUBTASK 25-40-11-410-017

- (16) If applicable, install the fire axe in the flight compartment.

SUBTASK 25-40-11-410-018

- (17) Do this task: Attendants' Seat Installation, TASK 25-25-12-400-801

SUBTASK 25-40-11-410-019

- (18) If applicable, install the attendants handset.

- Do this task: Attendant Handset Cradle Installation, TASK 23-42-01-400-801
- Do this task: Attendant Handset Cord Installation, TASK 23-42-01-400-802
- Do this task: Attendant Handset Installation, TASK 23-42-01-400-803

SUBTASK 25-40-11-410-020

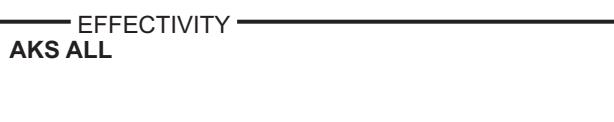
- (19) Do this task: Attendant's Panel with LCD Screen - Installation, TASK 25-25-11-400-802

SUBTASK 25-40-11-860-002

- (20) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C00250	PASS CABIN LIGHTING EMER CHGR FWD
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	10	C00783	OXYGEN PASS LEFT



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(Continued)

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	13	C00104	LAVATORY WATER HEATER A

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027	E	11	C00413 BRT ENTRY LTS (INOP)

AKS ALL

F. Post Installation Test

SUBTASK 25-40-11-440-001

- (1) Do this task: Toilet Activation, TASK 38-32-00-420-801 or Toilet Activation, TASK 38-32-00-440-801.

SUBTASK 25-40-11-710-001

- (2) Do this task: Lavatory Smoke Detection - Smoke Test, TASK 26-14-00-730-801

SUBTASK 25-40-11-710-005

- (3) If applicable, do this task: Attendant Handset Installation Test, TASK 23-42-01-700-801

SUBTASK 25-40-11-710-002

- (4) Do this task: Passenger Address System - Operational Test, TASK 23-31-00-740-801

SUBTASK 25-40-11-710-003

- (5) Do this task: Passenger Compartment Lights - Operational Test, TASK 33-20-00-710-804-001



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SUBTASK 25-40-11-710-004

- (6) Do this task: Toilet - Operational Test, TASK 38-32-00-700-802

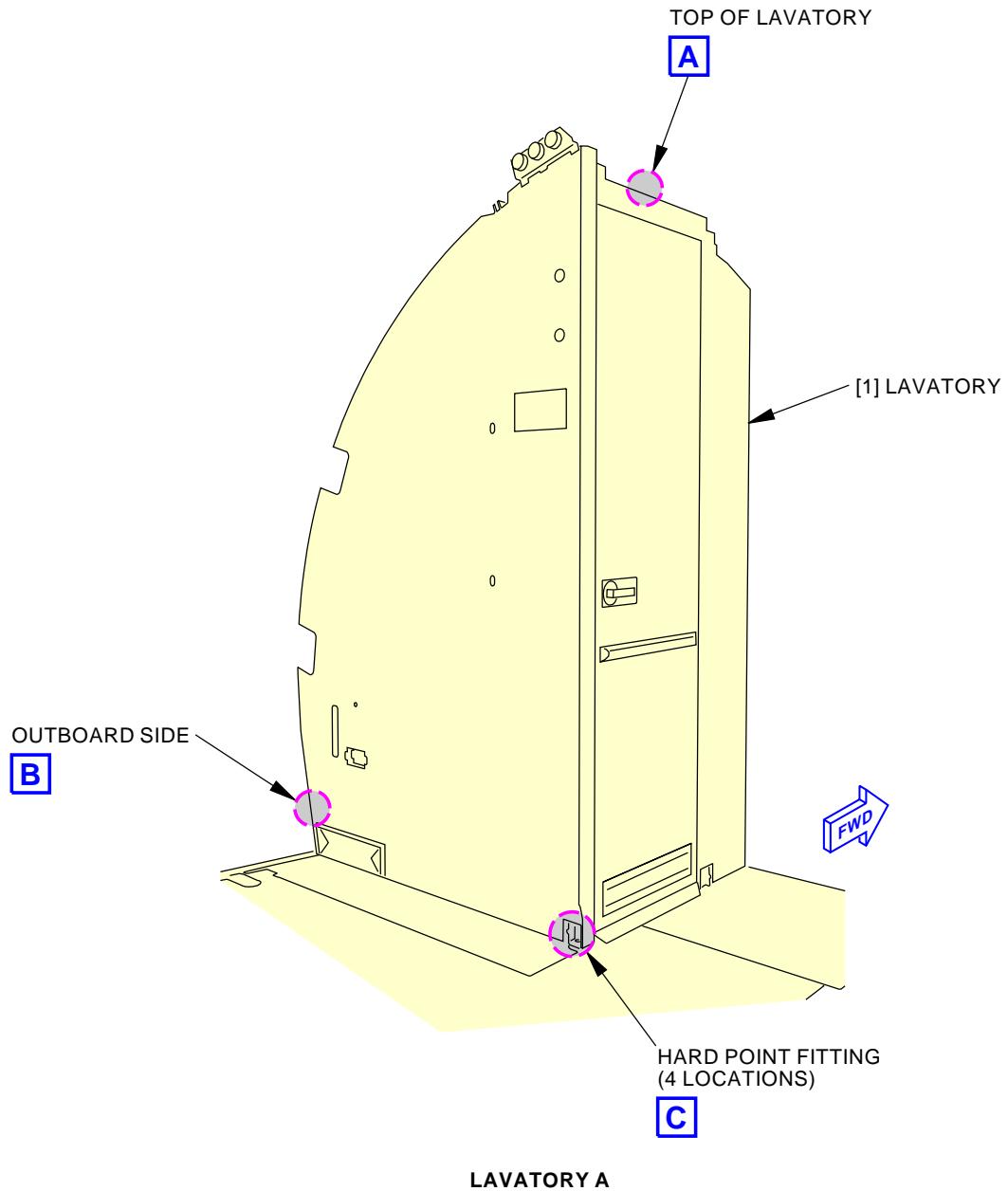
———— END OF TASK ——

EFFECTIVITY
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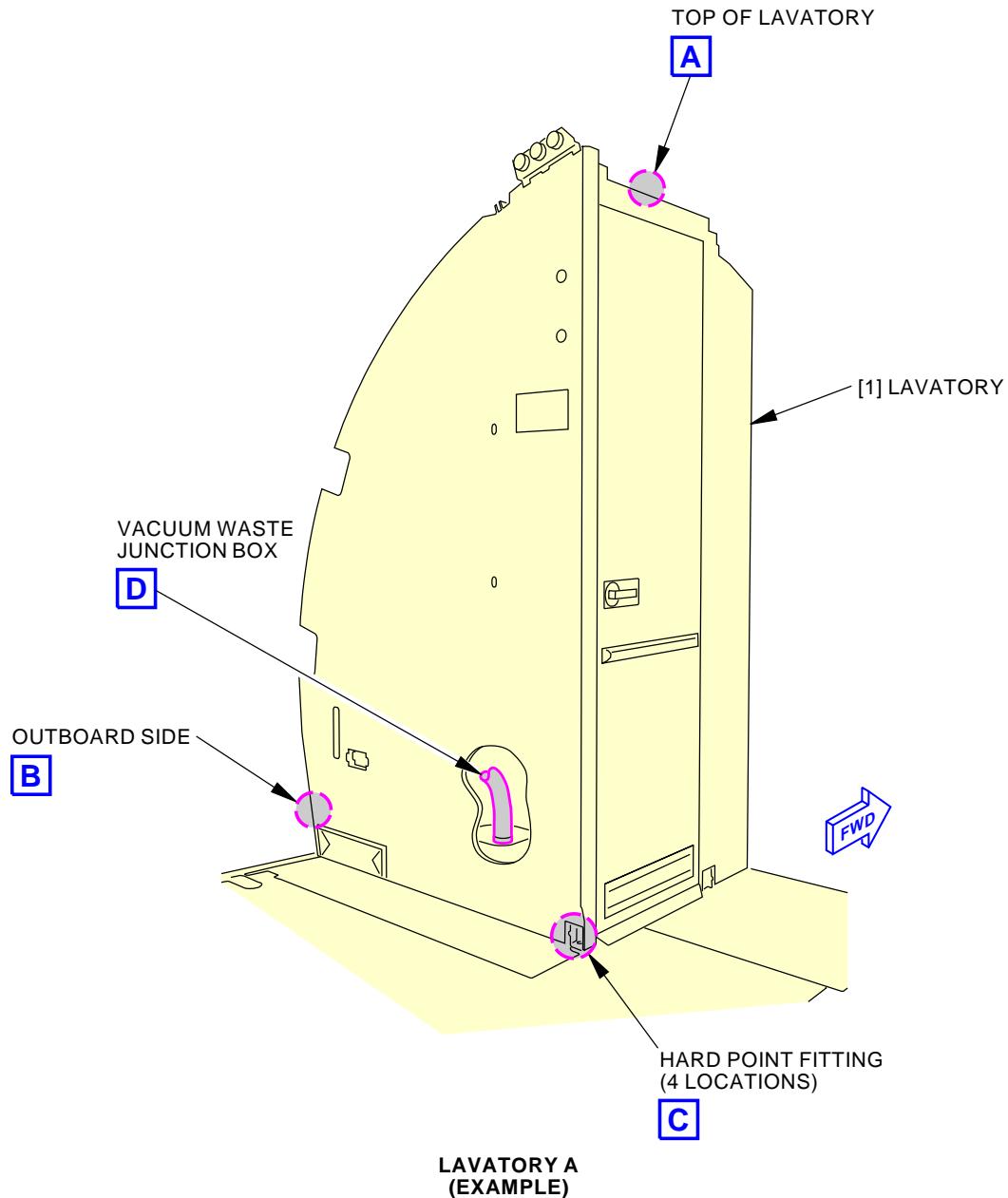
Lavatory A Installation
Figure 401/25-40-11-990-801 (Sheet 1 of 4)

EFFECTIVITY
AKS 001-024

25-40-11

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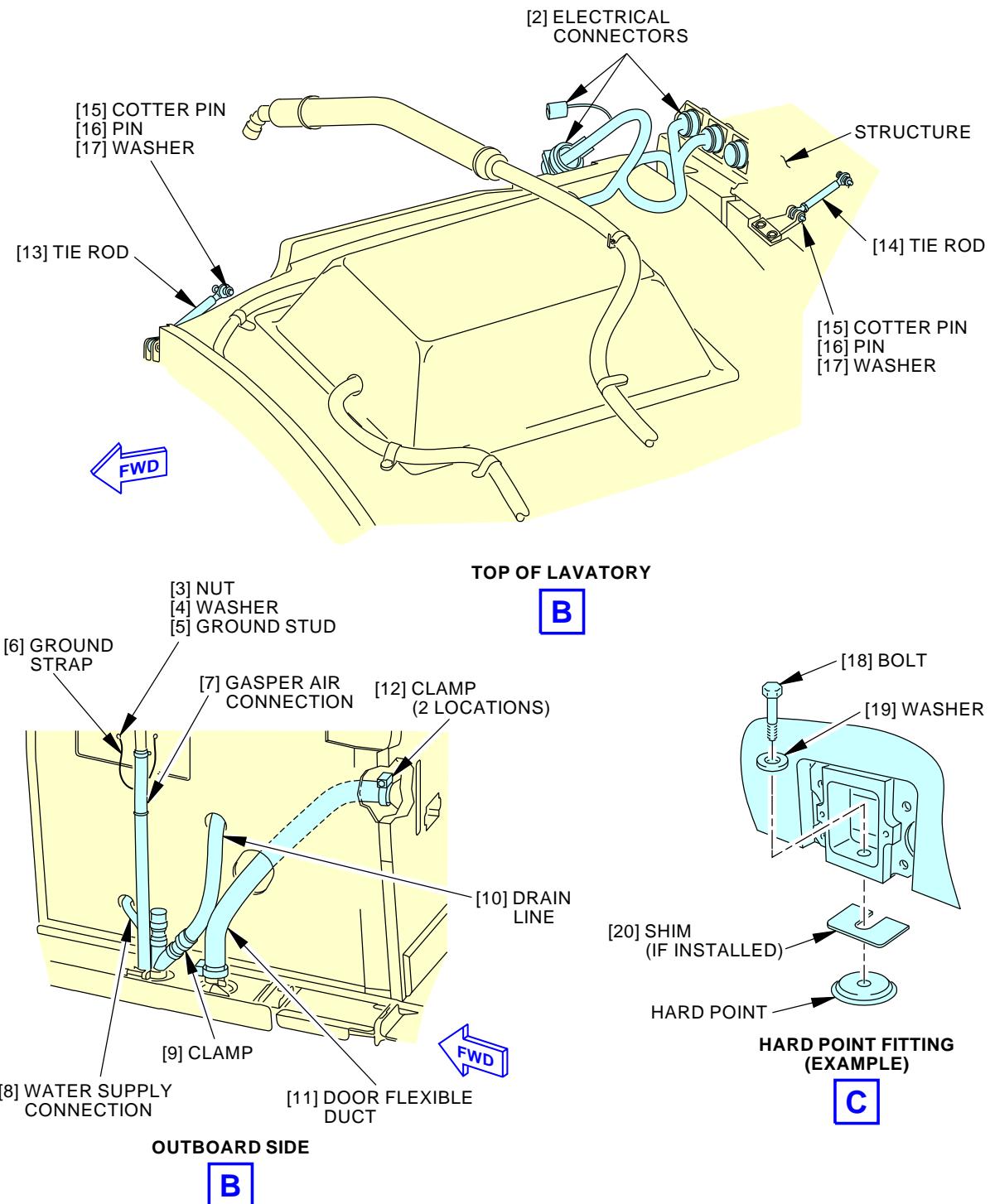
2243691 S0000502238_V2

Lavatory A Installation
Figure 401/25-40-11-990-801 (Sheet 2 of 4)

EFFECTIVITY
AKS 025-999**25-40-11**

D633A101-AKS

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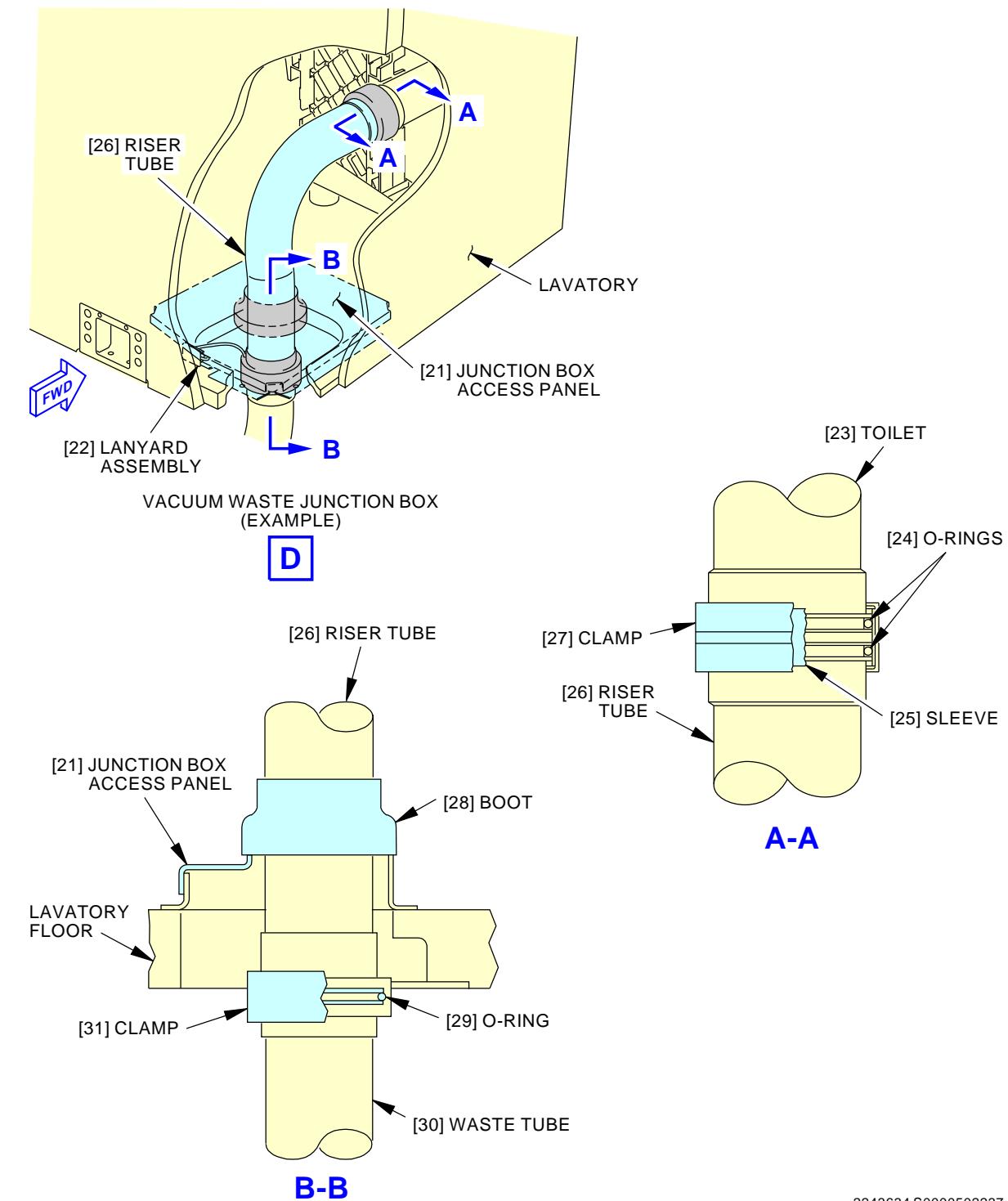


347862 S0000132152_V2

Lavatory A Installation
Figure 401/25-40-11-990-801 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

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Lavatory A Installation
Figure 401/25-40-11-990-801 (Sheet 4 of 4)

EFFECTIVITY
AKS 025-999

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D633A101-AKS



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MODULAR LAVATORY D - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Lavatory D Removal.
 - (2) Lavatory D Installation.

TASK 25-40-14-000-801

2. **Lavatory D - Removal**

(Figure 401)

A. **General**

- (1) Be careful during the removal of the lavatory to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley and lavatory area.

B. **References**

Reference	Title
23-42-01-000-801	Attendant Handset Removal (P/B 401)
23-42-01-000-802	Attendant Handset Cord Removal (P/B 401)
23-42-01-000-803	Attendant Handset Cradle Removal (P/B 401)
25-21-24-000-801	Aft Door Doorway Header Panel - Removal (P/B 401)
25-21-25-020-801	Aft Entry and Service Doorways Sidewall Lining Panel - Removal (P/B 401)
25-21-71-000-801	Lowered Ceiling Removal (P/B 401)
25-22-00-000-801	Passenger Seat - Removal (P/B 401)
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-32-00-040-801	Toilet Deactivation (P/B 201)
38-32-00-040-802	Toilet Deactivation (P/B 201)
38-32-01-000-801-001	Toilet Shroud Removal (P/B 401)
38-32-01-000-805-001	Vacuum Toilet Assembly Removal (P/B 401)
38-32-01-000-843-003	Toilet Shroud Removal (P/B 401)
38-32-01-000-844-003	Vacuum Toilet Assembly Removal (P/B 401)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)

C. **Location Zones**

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

D. **Prepare for the Removal**

SUBTASK 25-40-14-040-001

- (1) Do this task: Toilet Deactivation, TASK 38-32-00-040-801 or Toilet Deactivation, TASK 38-32-00-040-802.

SUBTASK 25-40-14-860-001

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT

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(Continued)

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	10	C00783	OXYGEN PASS LEFT
F	14	C01073	LAVATORY WATER HEATER D

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
			AKS 001-025, 027
E	11	C00413	BRT ENTRY LTS (INOP)

AKS ALL

SUBTASK 25-40-14-010-012

- (3) If applicable, remove the attendants handset.
 - (a) Do this task: Attendant Handset Removal, TASK 23-42-01-000-801.
 - (b) Do this task: Attendant Handset Cord Removal, TASK 23-42-01-000-802.
 - (c) Do this task: Attendant Handset Cradle Removal, TASK 23-42-01-000-803.

SUBTASK 25-40-14-010-002

- (4) It is not required to remove oxygen box to move lav D (only required for lav A).

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SUBTASK 25-40-14-010-003

- (5) If necessary, do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION, PAGEBLOCK 26-14-01/401.

SUBTASK 25-40-14-010-004

- (6) Do this task: Lowered Ceiling Removal, TASK 25-21-71-000-801.

SUBTASK 25-40-14-010-005

- (7) Do this task: Aft Door Doorway Header Panel - Removal, TASK 25-21-24-000-801.

SUBTASK 25-40-14-010-006

- (8) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Removal, TASK 25-21-25-020-801.

SUBTASK 25-40-14-010-007

- (9) If necessary, do this task: Passenger Seat - Removal, TASK 25-22-00-000-801, to remove the last row of seats.

SUBTASK 25-40-14-010-008

- (10) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

SUBTASK 25-40-14-870-001

- (11) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801.

SUBTASK 25-40-14-680-001

- (12) Drain the water from the applicable lavatory equipment.

SUBTASK 25-40-14-010-010

- (13) Do these steps to prepare the lavatory for the removal procedure.

- (a) If necessary, remove the step pad [2].
- (b) If necessary, remove the lavatory bi-fold door.
- (c) Remove the necessary trim panels from the lavatory to complete the task.
- (d) Remove the necessary access panels from the lavatory to complete the task.
- (e) Remove the necessary hose grommets from the lavatory to complete the task.

E. Lavatory Removal

SUBTASK 25-40-14-020-001

- (1) Disconnect the electrical and ground connections above the lavatory [1].

- (a) Disconnect the electrical connectors [17].

- 1) Install a jumper wire between pins 29 and 30 of the connector D11066 to turn off the emergency exit lights if it is necessary.

- (b) Remove the nuts [12] and washers [13] from the ground studs [14] at the top of the lavatory [1].

- (c) Disconnect the ground strap [19] from the ground studs [14] at the top of the lavatory [1].

SUBTASK 25-40-14-020-002

- (2) Disconnect the gasper air supply at the connection at the top of the lavatory [1].

- (a) Disconnect the gasper air connection [11] at the top of the lavatory [1].

SUBTASK 25-40-14-020-005

- (3) Remove the tie rod [18].

- (a) Remove the quick release pin [15] at the two ends of the tie rod [18].



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- (b) Remove the tie rod [18], from the lavatory [1] and the airplane structure.

AKS 001-024

SUBTASK 25-40-14-010-009

- (4) Disconnect the toilet from the airplane waste system tube through the applicable access panel.
(a) Install a protective cap on the waste system tube.

AKS 025-999

SUBTASK 25-40-14-020-012

- (5) Do these steps to remove the waste line connection:
(a) If applicable, remove the boot [38] from the riser tube [36].
(b) Open the junction box access panel [31].
(c) Remove the sealant where the junction box access panel [31] attaches to the lavatory [1] and at the seam between the panels.
(d) Disconnect the lanyard [32] from the clip on the junction box.
(e) Disconnect the riser tube [36] from the waste tube [40].

NOTE: Make sure to keep the riser tube [36] for the installation of the lavatory.

AKS ALL

SUBTASK 25-40-14-020-011

- (6) If applicable, do these tasks:
(a) Toilet Shroud Removal, TASK 38-32-01-000-801-001 or Toilet Shroud Removal, TASK 38-32-01-000-843-003.
(b) Vacuum Toilet Assembly Removal, TASK 38-32-01-000-805-001 or Vacuum Toilet Assembly Removal, TASK 38-32-01-000-844-003.

NOTE: Removal of the toilet is optional.

NOTE: Time can be saved if the toilet stays in the lavatory.

SUBTASK 25-40-14-020-003

- (7) Disconnect the water supply at the connection at the rear of the lavatory [1].
(a) Get access through the applicable access panel in the rear of the lavatory [1].
(b) Remove the insulation from around the water supply connection [22] at the rear of the lavatory.
(c) Disconnect the water supply connection [22] at the rear of the lavatory [1].

SUBTASK 25-40-14-020-004

- (8) Disconnect the drain line at the connection at the rear of the lavatory [1].
(a) Get access through the applicable access panel in the rear of the lavatory [1].
(b) Loosen the clamp [21], then disconnect the drain line [20].

SUBTASK 25-40-14-020-006

- (9) Remove the coverplate on the hard point fittings.

SUBTASK 25-40-14-020-007

- (10) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.

SUBTASK 25-40-14-020-008

- (11) Remove the bolts [23] and the washers [24] at the four hard point fittings.
(12) If necessary, remove the shims [25] at the four hard point fittings.

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SUBTASK 25-40-14-020-009

- (13) Remove the lavatory [1].

— END OF TASK —

TASK 25-40-14-400-801

3. Lavatory D - Installation

(Figure 401)

A. General

- (1) Be careful during the installation of the lavatory [1] to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley and lavatory area.

B. References

Reference	Title
23-31-00-740-801	Passenger Address System - Operational Test (P/B 501)
23-42-01-400-801	Attendant Handset Cradle Installation (P/B 401)
23-42-01-400-802	Attendant Handset Cord Installation (P/B 401)
23-42-01-400-803	Attendant Handset Installation (P/B 401)
23-42-01-700-801	Attendant Handset Installation Test (P/B 401)
25-21-24-400-801	Aft Door Doorway Header Panel - Installation (P/B 401)
25-21-25-420-801	Aft Entry and Service Doorways Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
25-22-00-400-802	Passenger Seat - Installation (P/B 401)
25-23-13-400-801	Attendant/Lavatory Service Unit - Installation (P/B 401)
25-40-01-400-801	Lavatory Sealant Installation (P/B 401)
26-14-00-730-801	Lavatory Smoke Detection - Smoke Test (P/B 501)
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-20-00-710-804-001	Passenger Compartment Lights - Operational Test (P/B 501)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
38-32-00-420-801	Toilet Activation (P/B 201)
38-32-00-440-801	Toilet Activation (P/B 201)
38-32-00-700-802	Toilet - Operational Test (P/B 501)
38-32-01-400-801-001	Toilet Shroud Installation (P/B 401)
38-32-01-400-805-001	Vacuum Toilet Assembly Installation (P/B 401)
38-32-01-400-843-003	Toilet Shroud Installation (P/B 401)
38-32-01-400-844-003	Vacuum Toilet Assembly Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III



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(Continued)

Reference	Description	Specification
G50327	Tape - Advanced Insulation Blanket	BMS5-157 Type I Class 1 Grade B Composition MPVF
G50408	Foam - Flexible Polyvinylidene Fluoride	BMS8-371

D. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

E. Lavatory Installation

SUBTASK 25-40-14-110-001

- (1) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-40-14-350-001

- (2) Repair the galley mat if it is necessary.

SUBTASK 25-40-14-420-001

- (3) Move the lavatory [1] inboard.

SUBTASK 25-40-14-420-002

- (4) Put the lavatory [1] on the hard point fittings until the lavatory floor is parallel with the airplane floor.

SUBTASK 25-40-14-420-003

- (5) If necessary, install the shims [25] at the outboard hard points.

- (a) The clearance between the top of the hard point fittings and the bottom of the lavatory fittings must come to 0.01 in. (0.25 mm).

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- (b) At the forward outboard hard point, the shim maximum thickness must not be more than 0.06 in. (1.52 mm).
 - (c) At the aft outboard hard point, the shim maximum thickness must not be more than 0.10 in. (2.54 mm).

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- (d) At the four hard point fittings, the shim maximum thickness must not be more than 0.06 in. (1.52 mm).

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- (e) Install shims [25] until the clearance comes to 0.01 in. (0.25 mm).

SUBTASK 25-40-14-420-004

- (6) Install the lavatory [1] fasteners.

- (a) Apply compound, C00528 to the bolts [23] and washers [24].

- (b) Loosely install the bolts [23] and washers [24] at the four hard point fittings.

SUBTASK 25-40-14-420-006

- (7) Connect the water supply at the connection at the rear of the lavatory [1].

- (a) Get access through the applicable access panel in the rear of the lavatory [1].

- (b) Connect the water supply connection [22] at the rear of the lavatory [1].



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SUBTASK 25-40-14-420-012

- (8) Do these steps to wrap insulation foam and insulation tape on the water supply line:
- Apply insulation foam, G50408 (BMS8-371) around the water supply connection [22].
 - Start the insulation foam, G50408 (BMS8-371) overlap below the water supply connection [22].
 - Continue to wind the insulation foam, G50408 (BMS8-371) around the fitting with a 0.2 +0.3 / -0.0 in. (5.1 +7.6 / -0.0 mm) overlap for each turn.
 - Complete the insulation foam, G50408 (BMS8-371) wrap approximately 2.0 in. (50.8 mm) above the end of the fitting.
- NOTE: In areas where the fitting is bent to 90.0 degrees, small clearances between the insulation foam and the fitting are permitted. You can apply insulation foam (BMS8-371) in pieces.
- (e) Do these steps to wrap insulation tape around the insulation foam on the water supply line:
- 1) Apply insulation tape, G50327 (BMS5-157) around the insulation foam, G50408 (BMS8-371).
 - 2) Start the insulation tape, G50327 (BMS5-157) overlap before the insulation foam, G50408 (BMS8-371) begins.
 - 3) Continue to wind the insulation tape, G50327 (BMS5-157) around the insulation foam, G50408 (BMS8-371) with a 0.2 +0.3 / -0.0 in. (5.1 +7.6 / -0.0 mm) overlap for each turn, and stop after the insulation foam, G50408 (BMS8-371) ends.
 - 4) Make sure the insulation tape, G50327 (BMS5-157) overlap seals over the ends of the insulation foam, G50408 (BMS8-371) fully.
- NOTE: Make sure the insulation foam that is under the insulation tape does not show.

SUBTASK 25-40-14-420-007

- (9) Connect the drain line [20] at the connection at the rear of the lavatory [1].
- Through the applicable rear access panel, connect the drain line [20].
 - Tighten the clamp [21] at the end of the drain line [20].

SUBTASK 25-40-14-820-002

- (10) Attach the tie rod [18] to the fittings on the lavatory [1] and the airplane structure.
- Adjust the tie rod [18] to the correct length.
 - After the last tie rod adjustments are completed, make sure that the inspection holes at the two ends of the tie rod [18] are blocked and threads are visible in the inspection holes.
 - Tighten the jammnuts [16] with your fingers.
 - Install the quick release pin [15] at the two ends of the tie rod [18].

SUBTASK 25-40-14-420-008

- (11) Connect the gasper air supply at the connection at the top of the lavatory [1].
- Connect the gasper air connection [11] at the top of the lavatory [1].

SUBTASK 25-40-14-420-009

- (12) Connect the ground strap [19] to the ground studs [14].



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- (a) Install the nuts [12] and washers [13] to the ground studs [14] at the top of the lavatory [1].
- (b) Do a resistance check of the static ground from the ground stud [14] on the lavatory [1] to the airplane ground stud.
- (c) Make sure that the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-40-14-420-010

- (13) Connect the electrical connectors [17] in the ceiling above the lavatory [1].
 - (a) Remove the jumper wire from pins 29 and 30 on connector D11066 if it was installed.

SUBTASK 25-40-14-420-015

- (14) Tighten the bolts [23] to 35 in-lb (4 N·m) and make sure that a layer of compound, C00528 seals the connection.

SUBTASK 25-40-14-400-002

- (15) Do this task: Lavatory Sealant Installation, TASK 25-40-01-400-801.
 - (a) During this task, install cover plates, threshold (if removed), and kickstrips (if applicable).

SUBTASK 25-40-14-390-001

- (16) Install a layer of adhesive, A00027 or adhesive, A00930 between the aft and inboard edges of the lavatory and the airplane floor.

SUBTASK 25-40-14-410-002

- (17) If applicable, do these tasks:
 - (a) Vacuum Toilet Assembly Installation, TASK 38-32-01-400-805-001 or Vacuum Toilet Assembly Installation, TASK 38-32-01-400-844-003.
 - (b) Toilet Shroud Installation, TASK 38-32-01-400-801-001 or Toilet Shroud Installation, TASK 38-32-01-400-843-003.

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SUBTASK 25-40-14-420-013

- (18) Connect the toilet to the airplane waste system tube through the applicable access panel.

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SUBTASK 25-40-14-420-014

CAUTION: MAKE SURE THAT AN O-RING WITHOUT DAMAGE IS INSTALLED ON THE WASTE LINE BEFORE YOU INSTALL THE RISER TUBE. A BAD OR MISSING O-RING CAN CAUSE FLUID LEAKAGE. THE FLUID CAN CAUSE CORROSION ON THE ADJACENT STRUCTURE.

- (19) Do these steps to connect the waste line connection:
 - (a) Open the junction box access panel [31].
 - (b) Make sure that the O-ring [39] is installed.
 - (c) Connect the riser tube [36] to the waste tube [40].
 - (d) Install the clamp [41] over the o-rings [39] and waste tube [40].
 - (e) Connect the riser tube [36] to the toilet [33].
 - 1) Install the o-ring [34], sleeve [35], and clamp [37] on the riser tube [36] and the toilet [33].
 - (f) Connect the lanyard [32] to the clip on the junction box.
 - (g) Fillet seal the junction box access panel [31] seam with adhesive, A00027 or equivalent.

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| AKS 025-999 (Continued)

- (h) Fillet seal the junction box access panel [31] with adhesive, A00027 or equivalent where it meets the lavatory.
- (i) If applicable, install the boot [38] to the riser tube [36].
- (j) Close the junction box access panel [31].

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F. Put the Airplane in Its Usual Condition.

SUBTASK 25-40-14-410-001

- (1) Put the lavatory back to the serviceable condition.
 - (a) Replace the lavatory hose grommets removed before.
 - (b) Replace the lavatory access panels removed before.
 - (c) Replace the lavatory trim panels removed before.
 - (d) If necessary, install the step pad [2].

SUBTASK 25-40-14-790-001

- (2) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-40-14-670-001

- (3) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-40-14-410-003

- (4) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

SUBTASK 25-40-14-010-011

- (5) If necessary, do this task: Passenger Seat - Installation, TASK 25-22-00-400-802, to install the last row of seats.

SUBTASK 25-40-14-410-004

- (6) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Installation, TASK 25-21-25-420-801.

SUBTASK 25-40-14-410-005

- (7) Do this task: Aft Door Doorway Header Panel - Installation, TASK 25-21-24-400-801.

SUBTASK 25-40-14-410-006

- (8) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801.

SUBTASK 25-40-14-410-007

- (9) If necessary, do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION, PAGEBLOCK 26-14-01/401.

SUBTASK 25-40-14-410-008

- (10) Do this task: Attendant/Lavatory Service Unit - Installation, TASK 25-23-13-400-801.

SUBTASK 25-40-14-410-010

- (11) If applicable, install the attendants handset.

- (a) Do this task: Attendant Handset Cradle Installation, TASK 23-42-01-400-801.
- (b) Do this task: Attendant Handset Cord Installation, TASK 23-42-01-400-802.
- (c) Do this task: Attendant Handset Installation, TASK 23-42-01-400-803.

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SUBTASK 25-40-14-860-002

- (12) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C01357	PASS CABIN LIGHTING EMER CHGR L AFT
B	10	C01358	PASS CABIN LIGHTING EMER CHGR R AFT
C	8	C01406	PASS CABIN SIGNS FASTEN SEAT BELT R
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
D	19	C01423	VACUUM WASTE
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	10	C00783	OXYGEN PASS LEFT
F	14	C01073	LAVATORY WATER HEATER D

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C01583	ENTERTAINMENT PA SYS BAT
D	4	C00082	COMMUNICATIONS PA AMPL BAT

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	21	C00560	INTERPHONE POWER F/O DC 2
C	22	C00561	INTERPHONE POWER F/O BAT
C	23	C00239	INTERPHONE POWER CAPT DC 2
C	24	C00240	INTERPHONE POWER CAPT BAT
D	21	C00084	INTPH AND WARN
D	22	C00086	AUDIO F/O
D	23	C00083	AUDIO CAPT
D	24	C00085	AUDIO OBS

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C00138	WATER QTY IND
C	11	C01388	VACUUM WASTE CONT

This circuit breaker is inoperative and should remain open:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
AKS 001-025, 027			
E	11	C00413	BRT ENTRY LTS (INOP)

AKS ALL

G. Post Installation Test

SUBTASK 25-40-14-440-001

- (1) Do this task: Toilet Activation, TASK 38-32-00-420-801 or Toilet Activation, TASK 38-32-00-440-801.

SUBTASK 25-40-14-710-001

- (2) Do this task: Lavatory Smoke Detection - Smoke Test, TASK 26-14-00-730-801.

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SUBTASK 25-40-14-710-005

- (3) If applicable, do this task: Attendant Handset Installation Test, TASK 23-42-01-700-801

SUBTASK 25-40-14-710-002

- (4) Do this task: Passenger Address System - Operational Test, TASK 23-31-00-740-801.

SUBTASK 25-40-14-710-003

- (5) Do this task: Passenger Compartment Lights - Operational Test, TASK 33-20-00-710-804-001.

SUBTASK 25-40-14-710-004

- (6) Do this task: Toilet - Operational Test, TASK 38-32-00-700-802.

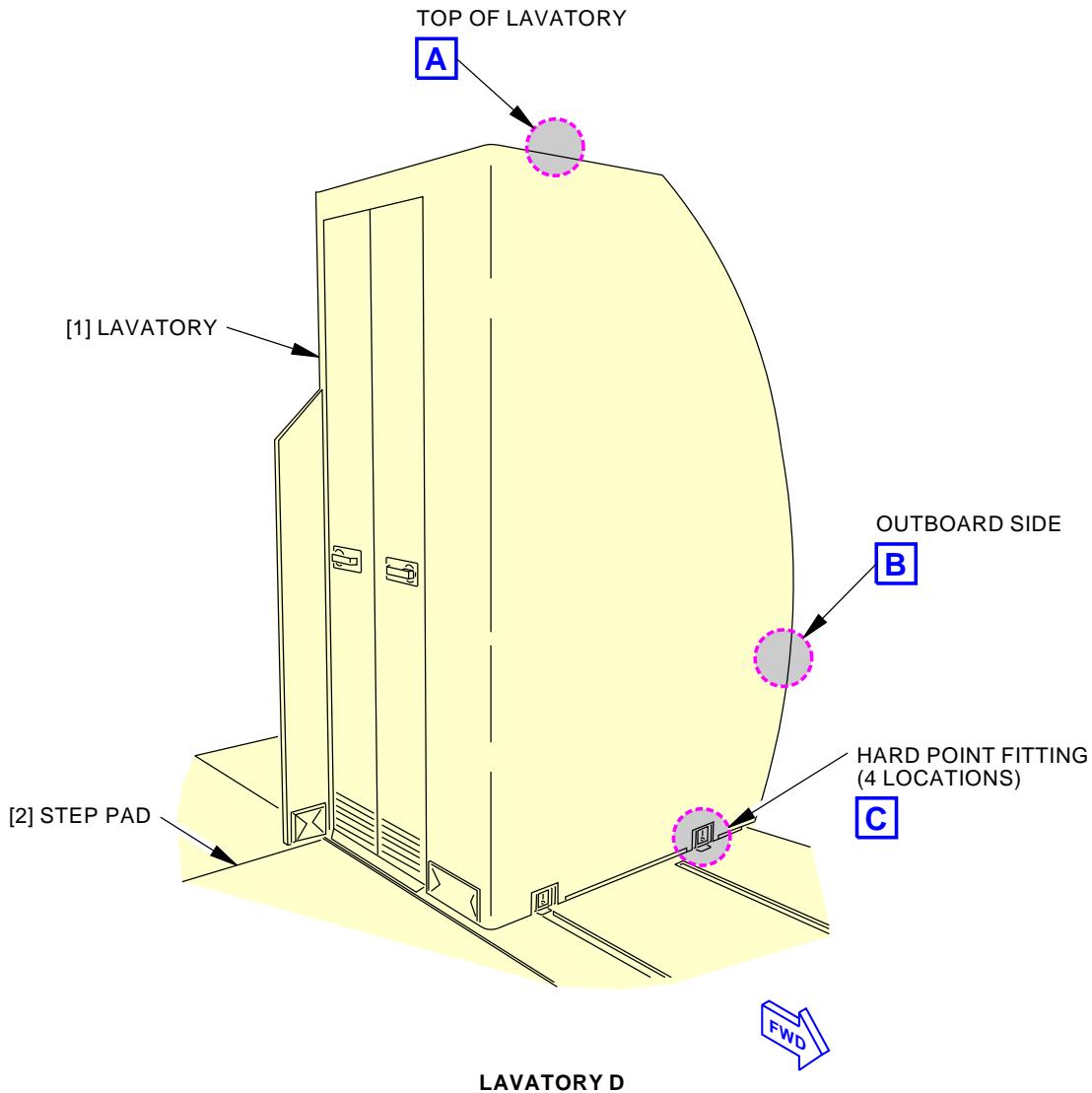
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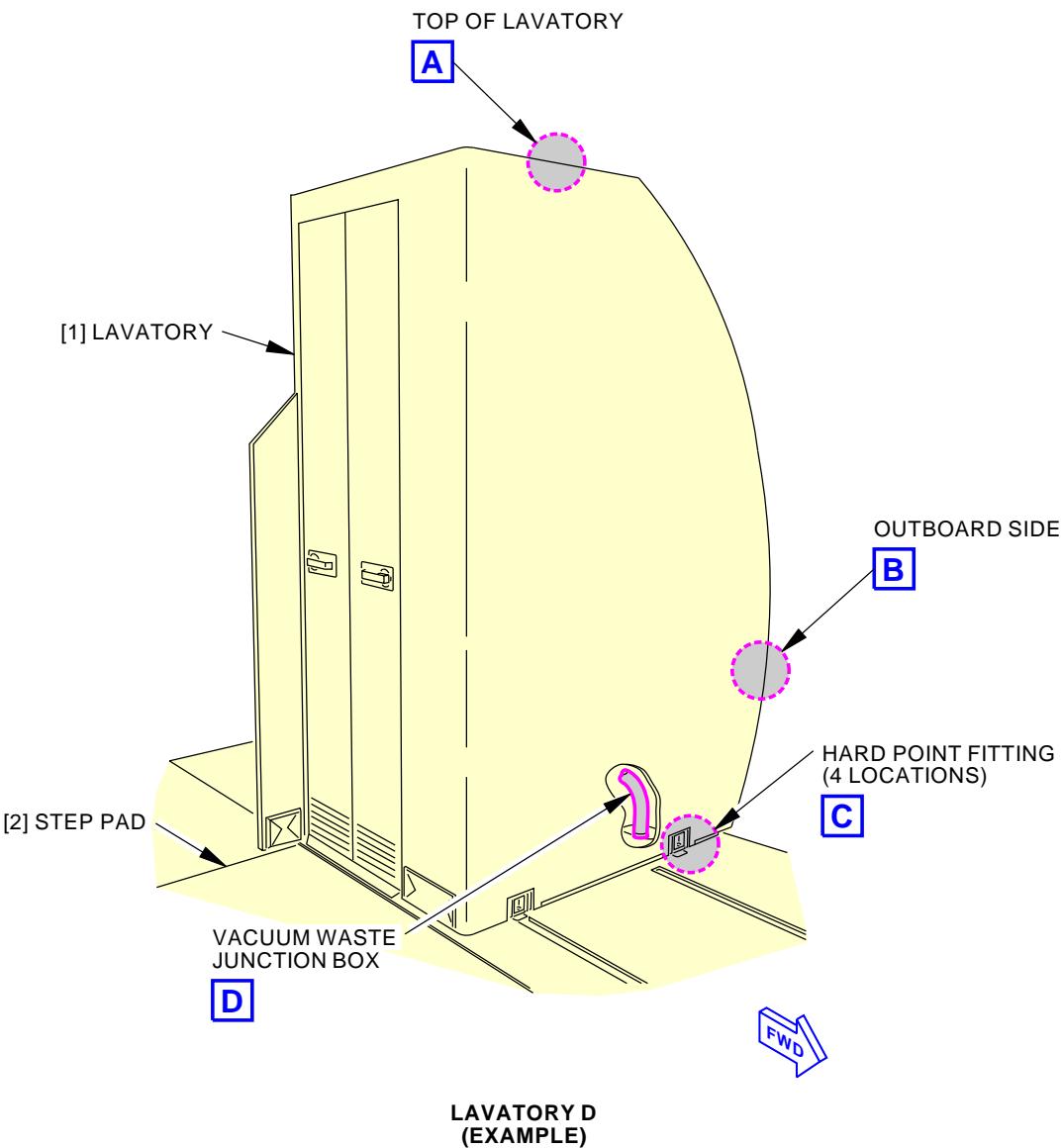
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Lavatory D Installation
Figure 401/25-40-14-990-801 (Sheet 1 of 4)

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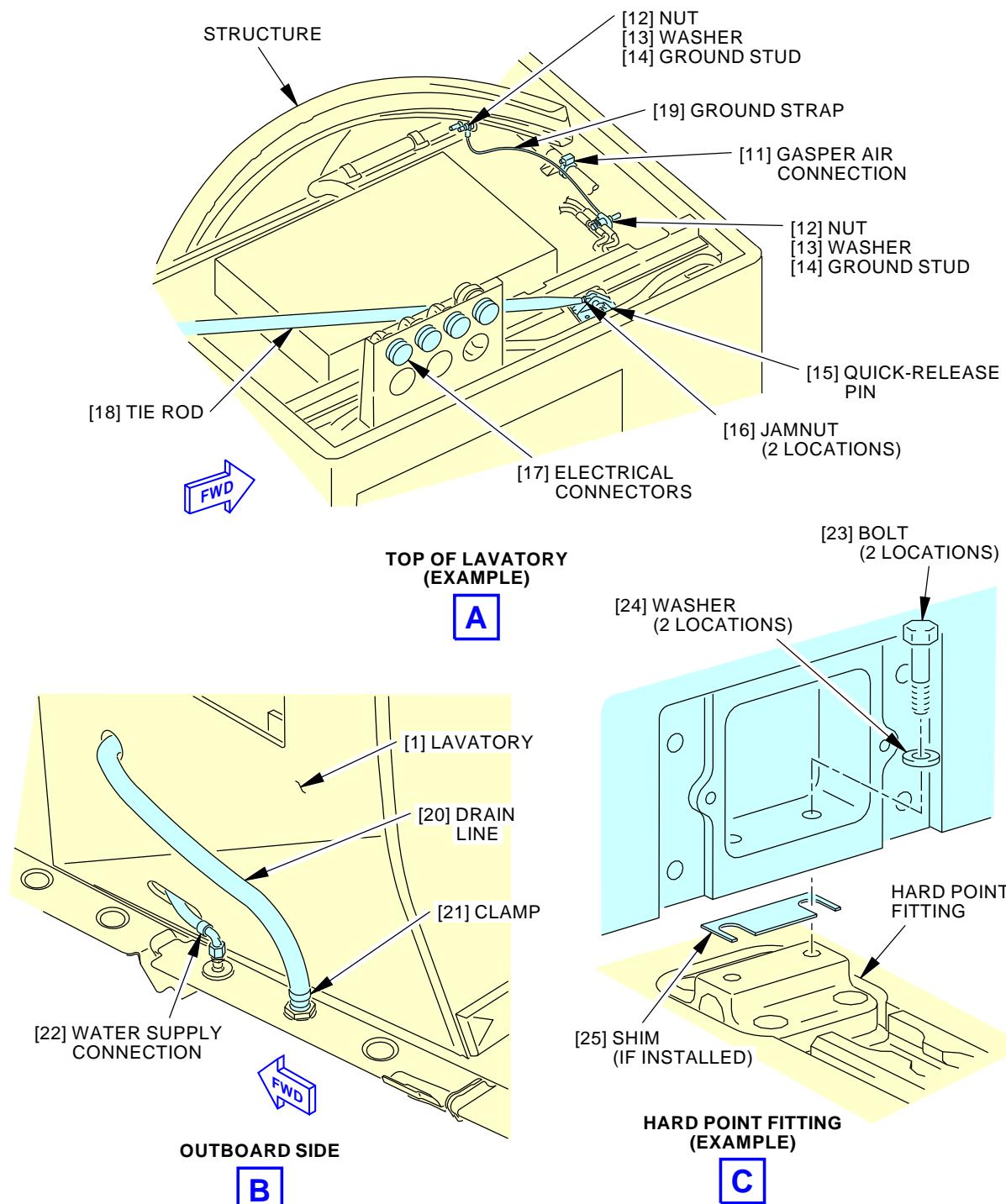


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Lavatory D Installation
Figure 401/25-40-14-990-801 (Sheet 2 of 4)

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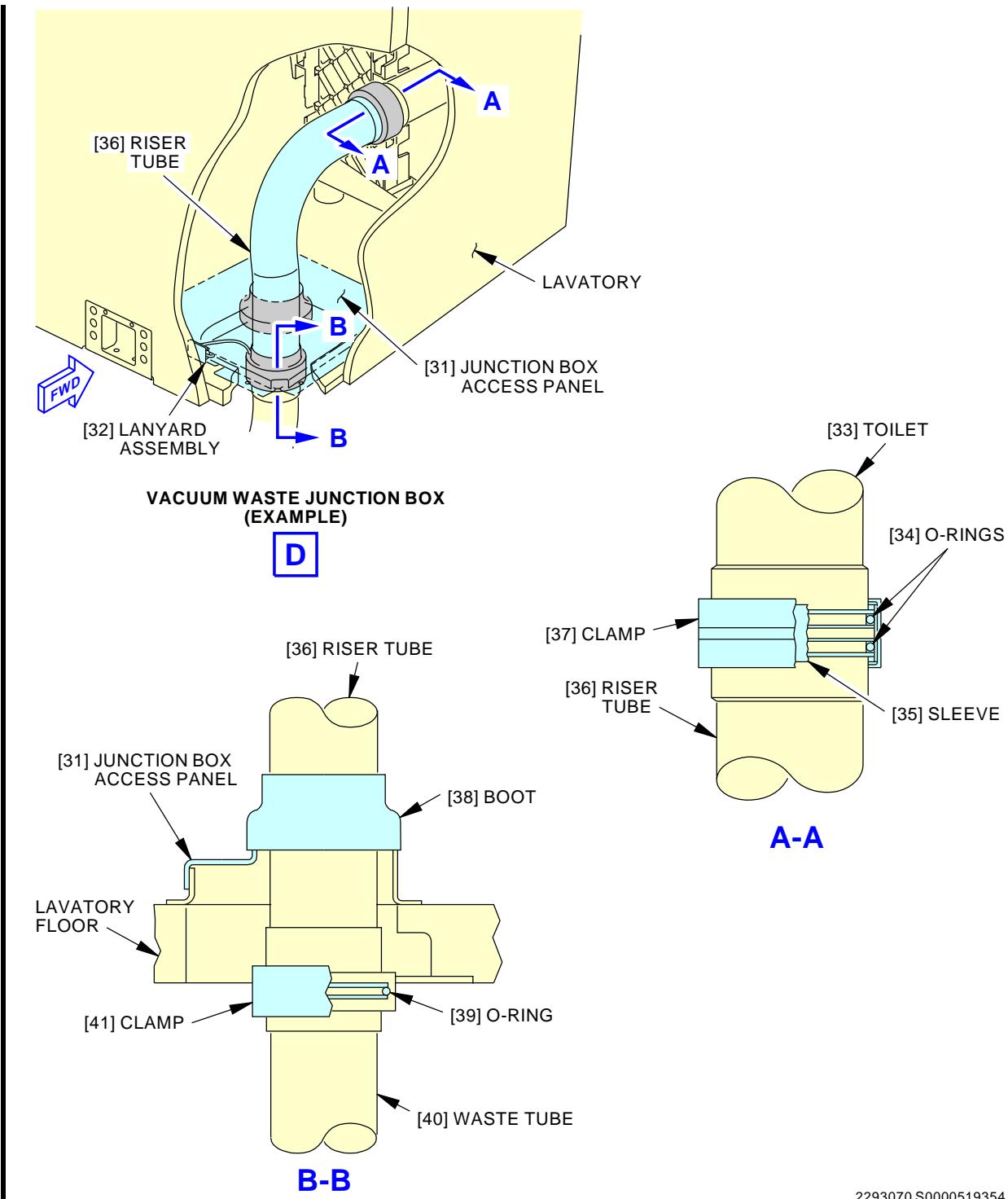


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Lavatory D Installation
Figure 401/25-40-14-990-801 (Sheet 3 of 4)

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Lavatory D Installation
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MODULAR LAVATORY E - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Lavatory E removal.
 - (2) Lavatory E installation.

TASK 25-40-15-000-801

2. Lavatory E - Removal

(Figure 401)

A. General

- (1) Be careful during the removal of the lavatory to prevent damage to the galley mat. The galley mat is a cover on the floor panels in the galley and lavatory area.

B. References

Reference	Title
23-42-01-000-801	Attendant Handset Removal (P/B 401)
23-42-01-000-802	Attendant Handset Cord Removal (P/B 401)
23-42-01-000-803	Attendant Handset Cradle Removal (P/B 401)
25-21-24-000-801	Aft Door Doorway Header Panel - Removal (P/B 401)
25-21-25-020-801	Aft Entry and Service Doorways Sidewall Lining Panel - Removal (P/B 401)
25-21-71-000-801	Lowered Ceiling Removal (P/B 401)
25-22-00-000-801	Passenger Seat - Removal (P/B 401)
25-25-12-000-801	Attendants' Seat Removal (P/B 401)
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-32-00-040-801	Toilet Deactivation (P/B 201)
38-32-00-040-802	Toilet Deactivation (P/B 201)
38-32-01-000-801-001	Toilet Shroud Removal (P/B 401)
38-32-01-000-805-001	Vacuum Toilet Assembly Removal (P/B 401)
38-32-01-000-843-003	Toilet Shroud Removal (P/B 401)
38-32-01-000-844-003	Vacuum Toilet Assembly Removal (P/B 401)
38-42-00-800-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

D. Prepare for the Removal

SUBTASK 25-40-15-040-001

- (1) Do this task: Toilet Deactivation, TASK 38-32-00-040-801 or Toilet Deactivation, TASK 38-32-00-040-802.



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SUBTASK 25-40-15-860-001

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	15	C01096	LAVATORY WATER HEATER E

SUBTASK 25-40-15-010-012

- (3) If applicable, remove the attendants handset.
- (a) Do this task: Attendant Handset Removal, TASK 23-42-01-000-801.
 - (b) Do this task: Attendant Handset Cord Removal, TASK 23-42-01-000-802.
 - (c) Do this task: Attendant Handset Cradle Removal, TASK 23-42-01-000-803.

SUBTASK 25-40-15-010-002

- (4) It is not required to remove the oxygen box to move lav E (only required for lav A).

SUBTASK 25-40-15-010-003

- (5) Do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION, PAGEBLOCK 26-14-01/401.

SUBTASK 25-40-15-010-004

- (6) Do this task: Lowered Ceiling Removal, TASK 25-21-71-000-801.

SUBTASK 25-40-15-010-005

- (7) Do this task: Aft Door Doorway Header Panel - Removal, TASK 25-21-24-000-801.

SUBTASK 25-40-15-010-006

- (8) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Removal, TASK 25-21-25-020-801.

SUBTASK 25-40-15-010-007

- (9) If necessary, do this task: Passenger Seat - Removal, TASK 25-22-00-000-801 to remove the last row of seats.

SUBTASK 25-40-15-010-013

- (10) If it is necessary, do this task: Attendants' Seat Removal, TASK 25-25-12-000-801

SUBTASK 25-40-15-010-008

- (11) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

SUBTASK 25-40-15-870-001

- (12) Do this task: Potable Water System - Deactivation, TASK 38-42-00-800-801.

SUBTASK 25-40-15-680-001

- (13) Drain the water from the applicable lavatory equipment.

SUBTASK 25-40-15-010-010

- (14) Remove the necessary trim panels from the lavatory to complete the task.
- (15) Remove the necessary access panels from the lavatory to complete the task.
- (16) Remove the necessary hose grommets from the lavatory to complete the task.



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E. Lavatory Removal

SUBTASK 25-40-15-020-001

- (1) Disconnect the electrical and ground connections above the lavatory [1].
 - (a) Disconnect the electrical connectors [2].
 - (b) Remove the nut [3] and washer [4] from the ground stud [5] at the top of the lavatory [1].
 - (c) Disconnect the ground strap [6] from the ground stud [5] at the top of the lavatory [1].

SUBTASK 25-40-15-020-002

- (2) Disconnect the gasper air supply at the connection at the top of the lavatory [1].
 - (a) Disconnect the gasper air connection [7] at the top of the lavatory [1].

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SUBTASK 25-40-15-010-009

- (3) Disconnect the toilet from the airplane waste system tube through the applicable access panel.

AKS 025-999

SUBTASK 25-40-15-020-012

- (4) Do these steps to remove the waste line connection:
 - (a) If applicable, remove the boot [28] from the riser tube [26].
 - (b) Open the junction box access panel [21].
 - (c) Remove the sealant where the junction box access panel [21] attaches to the lavatory [1] and at the seam between the panels.
 - (d) Disconnect the lanyard [22] from the clip on the junction box.
 - (e) Disconnect the riser tube [26] from the waste tube [30].

NOTE: Make sure to keep the riser tube [26] for the installation of the lavatory.

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SUBTASK 25-40-15-020-011

- (5) If applicable, do these tasks:
 - (a) Toilet Shroud Removal, TASK 38-32-01-000-801-001 or Toilet Shroud Removal, TASK 38-32-01-000-843-003.
 - (b) Vacuum Toilet Assembly Removal, TASK 38-32-01-000-805-001 or Vacuum Toilet Assembly Removal, TASK 38-32-01-000-844-003.

NOTE: Removal of the toilet is optional.

NOTE: Time can be saved if the toilet stays in the lavatory.

SUBTASK 25-40-15-020-003

- (6) Disconnect the water supply at the connection at the rear of the lavatory [1].
 - (a) Get access through the applicable access panel in the rear of the lavatory [1].
 - (b) Remove the insulation from around the water supply connection [8] at the rear of the lavatory.
 - (c) Disconnect the water supply connection [8] at the rear of the lavatory [1].

SUBTASK 25-40-15-020-004

- (7) Disconnect the drain line at the connection at the rear of the lavatory [1].
 - (a) Get access through the applicable access panel in the rear of the lavatory [1].
 - (b) Loosen the clamp [9], then disconnect the drain line [10].

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SUBTASK 25-40-15-020-005

- (8) Remove the tie rod [13].
 - (a) Remove the quick release pin [20] at the two ends of the tie rod [13].
 - (b) Remove the tie rod [13], from the lavatory [1] and the airplane structure.

SUBTASK 25-40-15-020-006

- (9) Remove the cover plate on the hard point fittings.

SUBTASK 25-40-15-020-007

- (10) Remove the grease from the attachment fitting to get access to the fasteners, if it is necessary.

SUBTASK 25-40-15-020-008

- (11) Remove the bolts [17] and the washers [18] at the four hard point fittings.

- (12) If necessary, remove the shims [19] at the four hard point fittings.

SUBTASK 25-40-15-020-009

- (13) Remove the lavatory [1].

————— END OF TASK ————

TASK 25-40-15-400-801

3. Lavatory E - Installation

(Figure 401)

A. References

Reference	Title
23-31-00-740-801	Passenger Address System - Operational Test (P/B 501)
23-42-01-400-801	Attendant Handset Cradle Installation (P/B 401)
23-42-01-400-802	Attendant Handset Cord Installation (P/B 401)
23-42-01-400-803	Attendant Handset Installation (P/B 401)
23-42-01-700-801	Attendant Handset Installation Test (P/B 401)
25-21-24-400-801	Aft Door Doorway Header Panel - Installation (P/B 401)
25-21-25-420-801	Aft Entry and Service Doorways Sidewall Lining Panel - Installation (P/B 401)
25-21-71-400-801	Lowered Ceiling Installation (P/B 401)
25-22-00-400-802	Passenger Seat - Installation (P/B 401)
25-23-13-400-801	Attendant/Lavatory Service Unit - Installation (P/B 401)
25-25-12-400-801	Attendants' Seat Installation (P/B 401)
25-40-01-400-801	Lavatory Sealant Installation (P/B 401)
26-14-00-730-801	Lavatory Smoke Detection - Smoke Test (P/B 501)
26-14-01 P/B 401	LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION
33-20-00-710-804-001	Passenger Compartment Lights - Operational Test (P/B 501)
33-51-14-960-802	Floor Proximity Light - Light Assembly Replacement (P/B 201)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
38-32-00-420-801	Toilet Activation (P/B 201)
38-32-00-440-801	Toilet Activation (P/B 201)
38-32-00-700-802	Toilet - Operational Test (P/B 501)
38-32-01-400-801-001	Toilet Shroud Installation (P/B 401)
38-32-01-400-805-001	Vacuum Toilet Assembly Installation (P/B 401)

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Reference

Title

38-32-01-400-843-003	Toilet Shroud Installation (P/B 401)
38-32-01-400-844-003	Vacuum Toilet Assembly Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G50327	Tape - Advanced Insulation Blanket	BMS5-157 Type I Class 1 Grade B Composition MPVF
G50408	Foam - Flexible Polyvinylidene Fluoride	BMS8-371

C. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

D. Lavatory Installation

SUBTASK 25-40-15-110-001

- (1) Clean the galley mat on the floor in the galley area with solvent, B00083.

SUBTASK 25-40-15-350-001

- (2) Repair the galley mat if it is necessary.

NOTE: The galley mat is a cover on the floor panels in the galley and lavatory area.

SUBTASK 25-40-15-420-001

- (3) Move the lavatory [1] inboard.

SUBTASK 25-40-15-420-002

CAUTION: REMOVE AND INSTALL THE LAVATORY CAREFULLY. YOU CAN CAUSE DAMAGE TO THE GALLEY MAT.

- (4) Put the lavatory [1] on the hard point fittings until the lavatory floor is parallel with the airplane floor.

SUBTASK 25-40-15-420-003

- (5) If necessary, install the shims [19] at the outboard hard points.

- (a) The clearance between the top of the hard point fittings and the bottom of the lavatory fittings must come to 0.01 inches (.254 mm).

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- (b) At the forward outboard hard point, the shim maximum thickness must not be more than 0.06 in. (1.52 mm).
 - (c) At the aft outboard hard point, the shim maximum thickness must not be more than 0.10 in. (2.54 mm).

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- (d) At the four hard point fittings, the shim maximum thickness must not be more than 0.06 in. (1.52 mm).

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- (e) Install shims [19] until the clearance comes to 0.01 in. (0.25 mm).

SUBTASK 25-40-15-420-004

- (6) Install the lavatory [1] fasteners.

- (a) Apply compound, C00528 to the bolts [17] and washers [18].
- (b) Install the bolts [17] and washers [18] at the four hard point fittings.
- (c) Tighten the bolts [17] to 35 in-lb (4 N·m), make sure that a layer of compound, C00528 seals the connection.

SUBTASK 25-40-15-400-002

- (7) Do this task: Lavatory Sealant Installation, TASK 25-40-01-400-801.

- (a) During this task, install cover plates, threshold (if removed), and kickstrips (if applicable).

SUBTASK 25-40-15-820-002

- (8) Attach the tie rod [13] to the fittings on the lavatory [1] and the airplane structure.

- (a) Adjust the tie rod [13] to the correct length.

- 1) After the last tie rod adjustments are completed, make sure that the inspection holes at the two ends of the tie rod [13] are blocked and the threads are visible in the inspection holes.

- 2) Tighten the jammnuts with your fingers.

- (b) Install the quick release pin [20] at the two ends of the tie rod [13].

SUBTASK 25-40-15-390-001

- (9) Install a layer of adhesive, A00027 or adhesive, A00930 between the aft and inboard edges of the lavatory and the airplane floor.

SUBTASK 25-40-15-420-006

- (10) Connect the water supply at the connection at the rear of the lavatory [1].

- (a) Get access through the applicable access panel in the rear of the lavatory [1].
- (b) Connect the water supply connection [8] at the rear of the lavatory [1].

SUBTASK 25-40-15-420-012

- (11) Do these steps to wrap insulation foam and insulation tape on the water supply line:

- (a) Apply insulation foam, G50408 (BMS8-371) around the water supply connection [8].
- (b) Start the insulation foam, G50408 (BMS8-371) overlap below the water supply connection [8].
- (c) Continue to wind the insulation foam, G50408 (BMS8-371) around the fitting with a 0.2 +0.3 / -0.0 in. (5.1 +7.6 / -0.0 mm) overlap for each turn.
- (d) Complete the insulation foam, G50408 (BMS8-371) wrap approximately 2.0 in. (50.8 mm) above the end of the fitting.

NOTE: In areas where the fitting is bent to 90.0 degrees, small clearances between the insulation foam and the fitting are permitted. You can apply insulation foam (BMS8-371) in pieces.

- (e) Do these steps to wrap insulation tape around the insulation foam on the water supply line:

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- 1) Apply insulation tape, G50327 (BMS5-157) around the insulation foam, G50408 (BMS8-371).
- 2) Start the insulation tape, G50327 (BMS5-157) overlap before the insulation foam, G50408 (BMS8-371) begins.
- 3) Continue to wind the insulation tape, G50327 (BMS5-157) around the insulation foam, G50408 (BMS8-371) with a 0.2 +0.3 / -0.0 in. (5.1 +7.6 / -0.0 mm) overlap for each turn, and stop after the insulation foam, G50408 (BMS8-371) ends.
- 4) Make sure the insulation tape, G50327 (BMS5-157) overlap seals over the ends of the insulation foam, G50408 (BMS8-371) fully.

NOTE: Make sure the insulation foam that is under the insulation tape does not show.

SUBTASK 25-40-15-420-007

- (12) Connect the drain line [10] at the connection at the rear of the lavatory [1].
 - (a) Through the applicable rear access panel, connect the drain line [10].
 - (b) Tighten the clamp [9] at the end of the drain line [10].

SUBTASK 25-40-15-410-002

- (13) If applicable, do these tasks:
 - (a) Vacuum Toilet Assembly Installation, TASK 38-32-01-400-805-001 or Vacuum Toilet Assembly Installation, TASK 38-32-01-400-844-003.
 - (b) Toilet Shroud Installation, TASK 38-32-01-400-801-001 or Toilet Shroud Installation, TASK 38-32-01-400-843-003.

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SUBTASK 25-40-15-420-013

- (14) Connect the toilet to the airplane waste system tube through the applicable access panel.

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SUBTASK 25-40-15-420-014

CAUTION: MAKE SURE THAT AN O-RING WITHOUT DAMAGE IS INSTALLED ON THE WASTE LINE BEFORE YOU INSTALL THE RISER TUBE. A BAD OR MISSING O-RING CAN CAUSE FLUID LEAKAGE. THE FLUID CAN CAUSE CORROSION ON THE ADJACENT STRUCTURE.

- (15) Do these steps to connect the waste line connection:
 - (a) Open the junction box access panel [21].
 - (b) Make sure that the O-ring [29] is installed.
 - (c) Connect the riser tube [26] to the waste tube [30].
 - (d) Connect the lanyard [22] to the clip on the junction box.
 - (e) Fillet seal the junction box access panel [21] seam with adhesive, A00027 or equivalent.
 - (f) Fillet seal the junction box access panel [21] with adhesive, A00027 or equivalent where it meets the lavatory.
 - (g) If applicable, install the boot [28] to the riser tube [26].



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| AKS 025-999 (Continued)

- (h) Close the junction box access panel [21].

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SUBTASK 25-40-15-420-008

- (16) Connect the gasper air supply at the connection at the top of the lavatory [1].
(a) Connect the gasper air connection [7] at the top of the lavatory [1].

SUBTASK 25-40-15-420-009

- (17) Connect the ground strap [6] to the ground stud [5].
(a) Install the nut [3] and washer [4] to the ground stud [5] at the top of the lavatory [1].
(b) Do a resistance check of the static ground from the ground stud [5] on the lavatory [1] to the airplane ground stud.
(c) Make sure that the resistance is a maximum of 0.0025 Ohms.

SUBTASK 25-40-15-420-010

- (18) Connect the electrical connectors [2] in the ceiling above the lavatory [1].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-40-15-410-001

- (1) Replace the lavatory hose grommets removed before.
(2) Replace the lavatory access panels removed before.
(3) Replace the lavatory trim panels removed before.

SUBTASK 25-40-15-410-003

- (4) If applicable, do this task: Floor Proximity Light - Light Assembly Replacement, TASK 33-51-14-960-802.

SUBTASK 25-40-15-410-011

- (5) If it is necessary, do this task: Attendants' Seat Installation, TASK 25-25-12-400-801

SUBTASK 25-40-15-010-011

- (6) If necessary, do this task: Passenger Seat - Installation, TASK 25-22-00-400-802 to install the last row of seats.

SUBTASK 25-40-15-410-004

- (7) Do this task: Aft Entry and Service Doorways Sidewall Lining Panel - Installation, TASK 25-21-25-420-801.

SUBTASK 25-40-15-410-006

- (8) Do this task:Aft Door Doorway Header Panel - Installation, TASK 25-21-24-400-801.

SUBTASK 25-40-15-410-008

- (9) Do this task: Lowered Ceiling Installation, TASK 25-21-71-400-801.

SUBTASK 25-40-15-410-007

- (10) Do this task: LAVATORY SMOKE DETECTOR - REMOVAL/INSTALLATION, PAGEBLOCK 26-14-01/401.

SUBTASK 25-40-15-410-009

- (11) Do this task: Attendant/Lavatory Service Unit - Installation, TASK 25-23-13-400-801.

SUBTASK 25-40-15-410-010

- (12) If applicable, install the attendants handset.

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- (a) Do this task: Attendant Handset Cradle Installation, TASK 23-42-01-400-801.
- (b) Do this task: Attendant Handset Cord Installation, TASK 23-42-01-400-802.
- (c) Do this task: Attendant Handset Installation, TASK 23-42-01-400-803.

SUBTASK 25-40-15-860-002

- (13) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	10	C01217	PASS CAB SIGNS LAV OCC SIGN
E	12	C01125	LAVATORY SMOKE
E	14	C01648	LAVATORY MIRROR LIGHT
F	15	C01096	LAVATORY WATER HEATER E

F. Lavatory Post-Installation Test

SUBTASK 25-40-15-790-001

- (1) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-40-15-670-001

- (2) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-40-15-440-001

- (3) Do this task: Toilet Activation, TASK 38-32-00-420-801 or Toilet Activation, TASK 38-32-00-440-801.

SUBTASK 25-40-15-710-001

- (4) Do this task: Lavatory Smoke Detection - Smoke Test, TASK 26-14-00-730-801.

SUBTASK 25-40-15-710-005

- (5) If applicable, do this task: Attendant Handset Installation Test, TASK 23-42-01-700-801

SUBTASK 25-40-15-710-002

- (6) Do this task: Passenger Address System - Operational Test, TASK 23-31-00-740-801.

SUBTASK 25-40-15-710-003

- (7) Do this task: Passenger Compartment Lights - Operational Test, TASK 33-20-00-710-804-001.

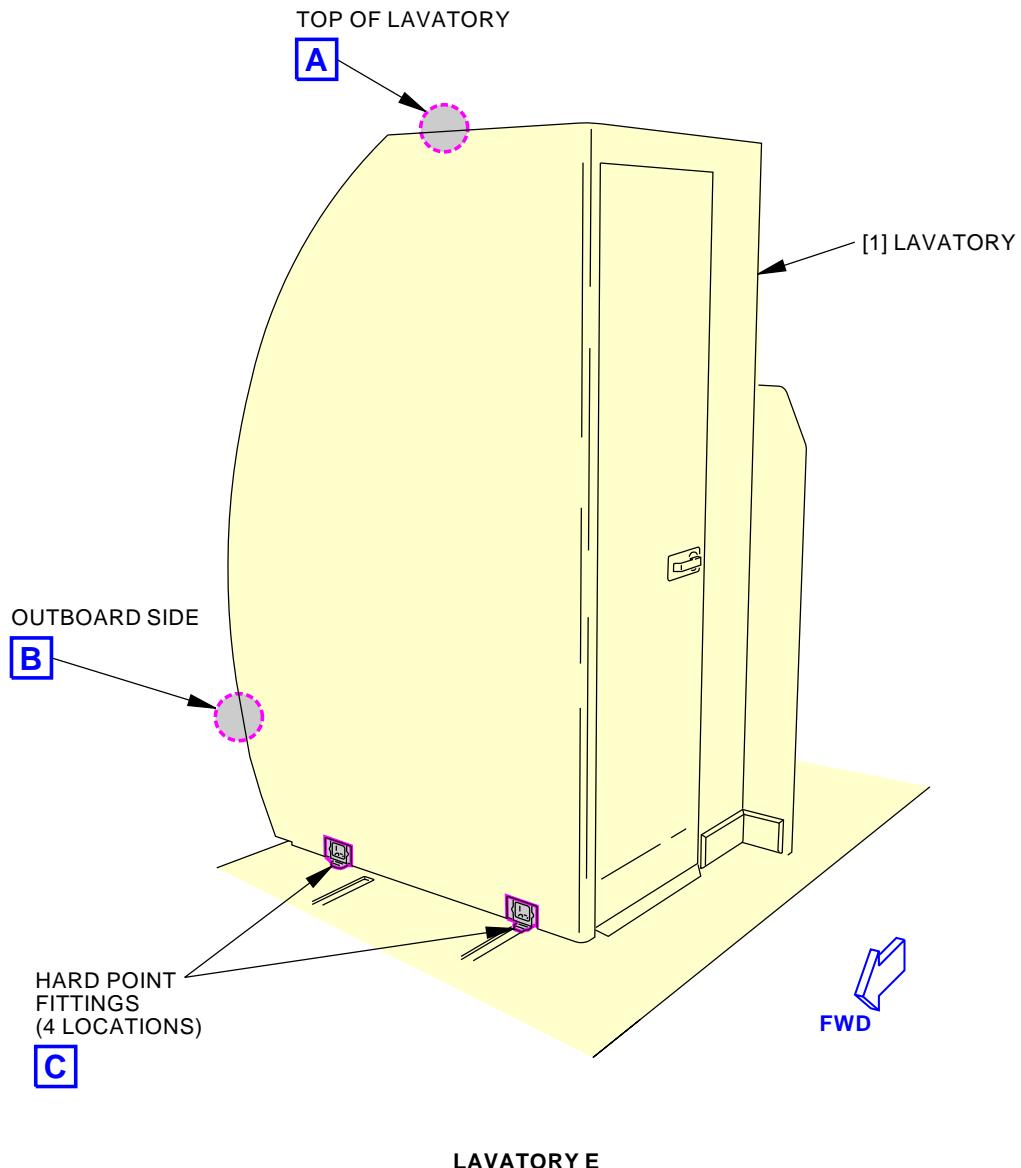
SUBTASK 25-40-15-710-004

- (8) Do this task: Toilet - Operational Test, TASK 38-32-00-700-802.

———— END OF TASK ————



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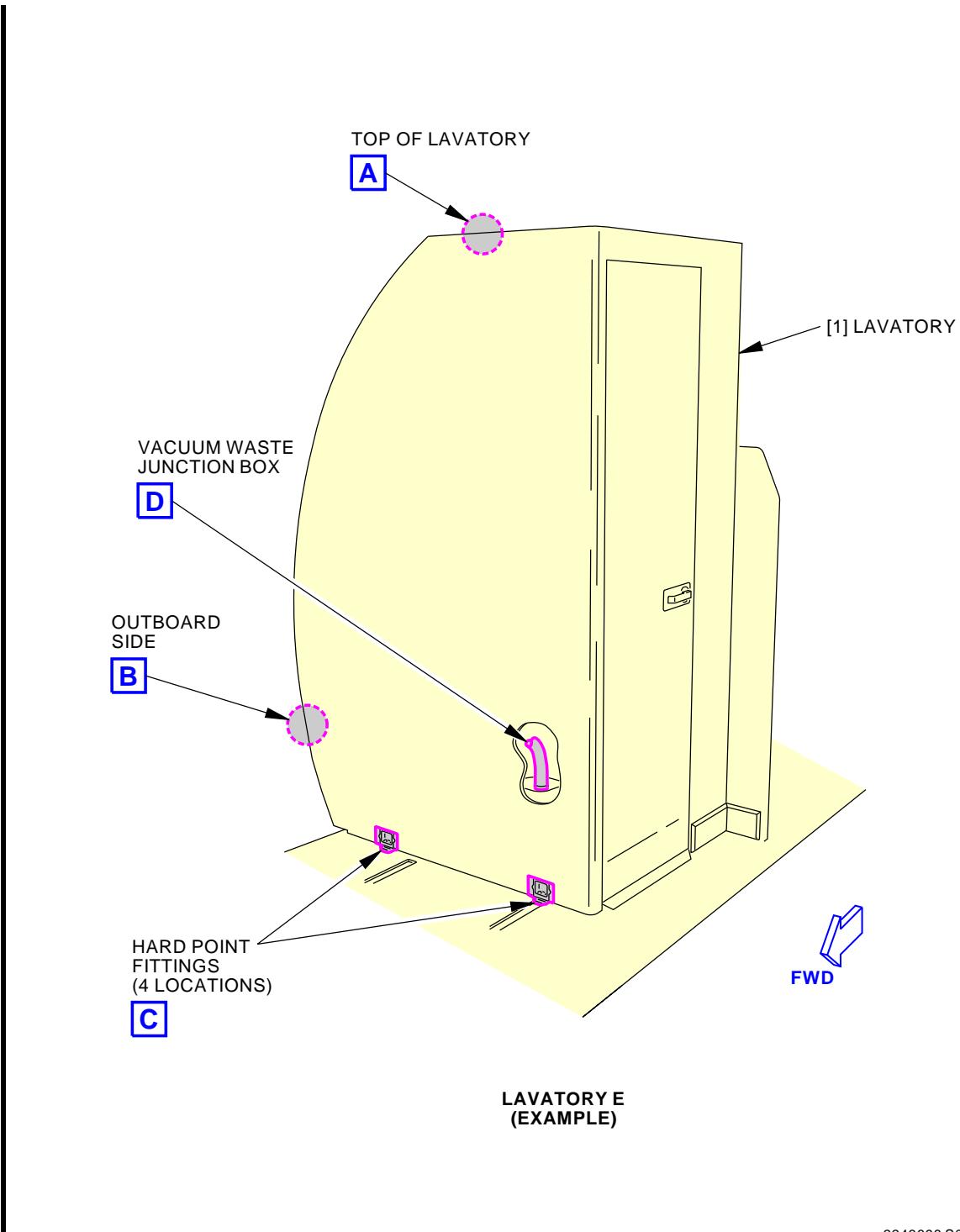
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Lavatory E Installation
Figure 401/25-40-15-990-801 (Sheet 1 of 4)

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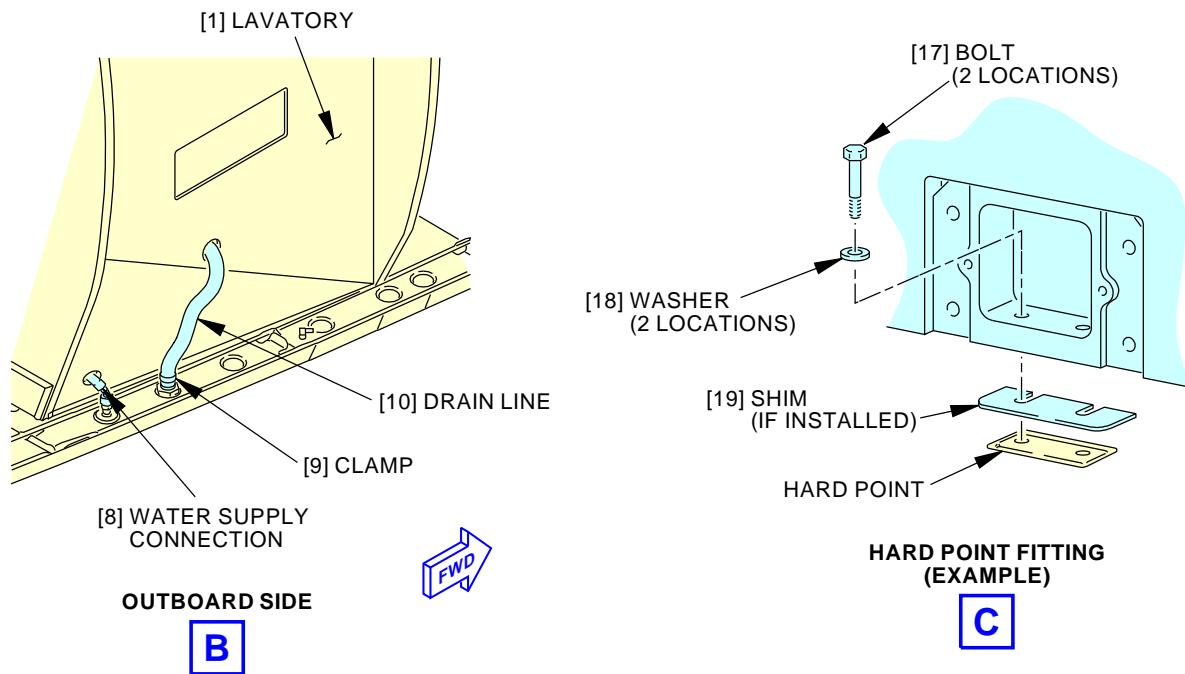
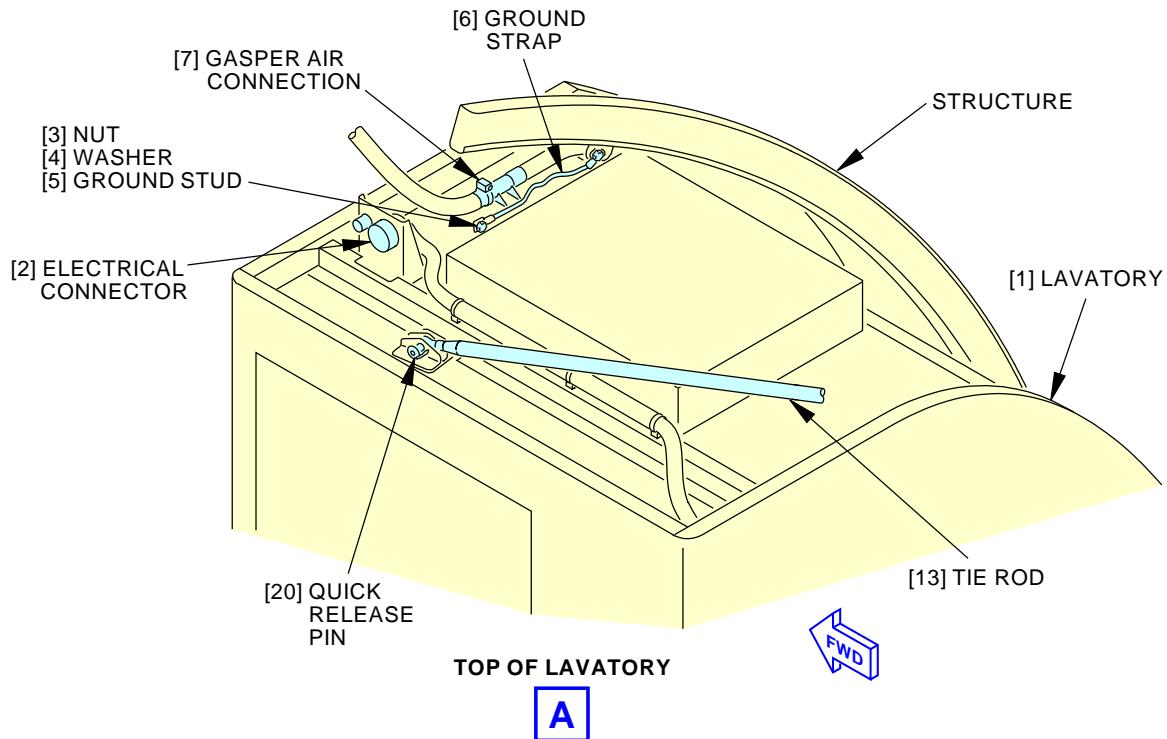


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Lavatory E Installation
Figure 401/25-40-15-990-801 (Sheet 2 of 4)

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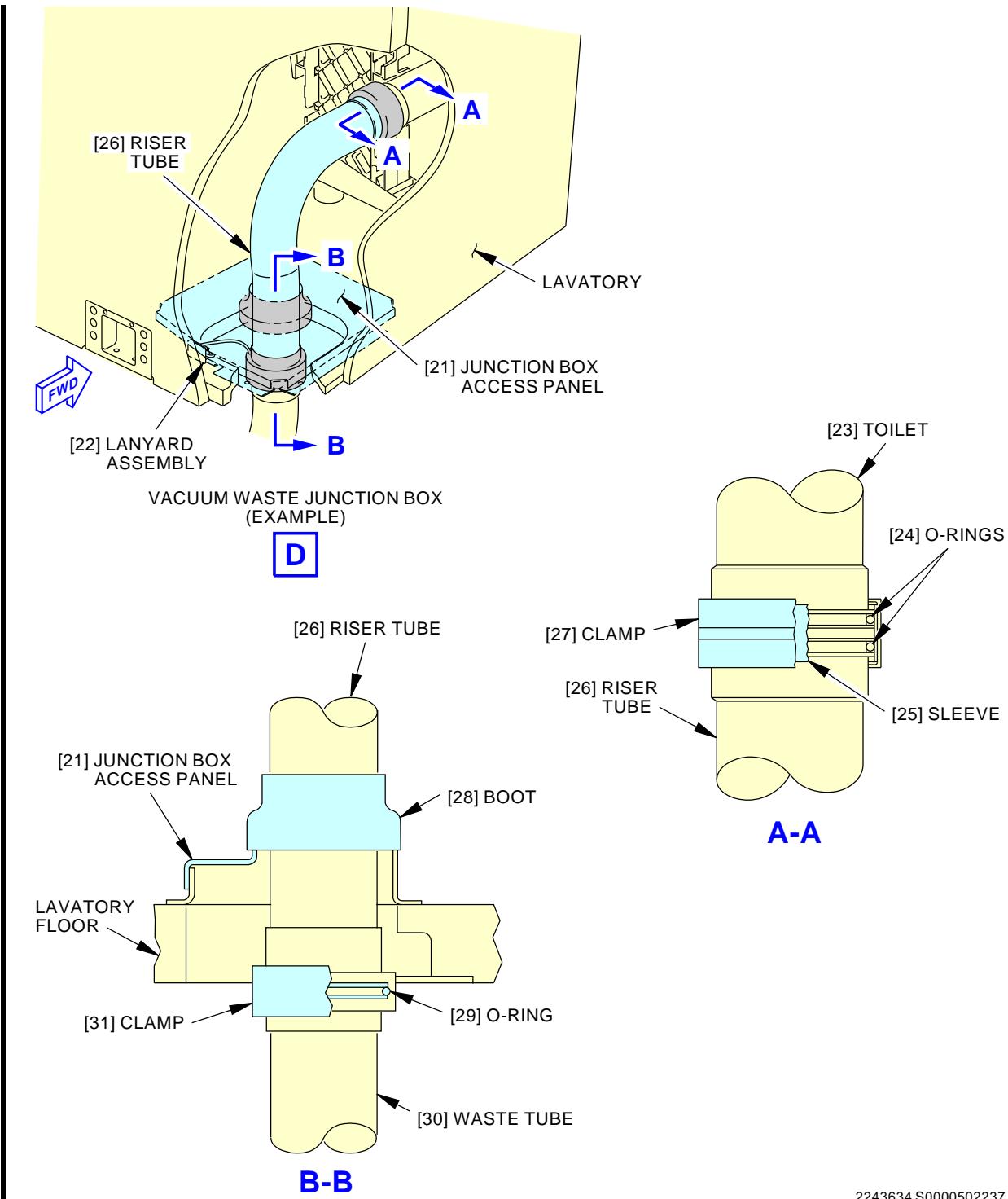


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Lavatory E Installation
Figure 401/25-40-15-990-801 (Sheet 3 of 4)

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Lavatory E Installation
Figure 401/25-40-15-990-801 (Sheet 4 of 4)

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CARGO COMPARTMENT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks for the forward and aft cargo compartments:
 - (1) Cargo Compartment Liner Inspection
 - (2) Cargo Compartment Blowout Panel Inspection
 - (3) Cargo Restraint Inspection for the restraints at the cargo doors
 - (4) Cargo Compartment Tiedown Fitting Inspection.

TASK 25-52-00-200-803

2. Cargo Compartment Liner Inspection

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task inspects all the liners in the forward and aft cargo compartments.
- (2) It is important that all of the fasteners, seams, and punctures are sealed correctly to keep the amount of oxygen in the compartment to a minimum.

B. References

Reference	Title
21-32-05 P/B 401	CARGO COMPARTMENT BLOWOUT PANELS - REMOVAL/INSTALLATION
25-00-00-300-801	Crushed-Core and Sandwich Panel Repair (P/B 801)
25-52-01-300-802	Permanent Repair for Molded Liners, Shrouds, and Liners with Complex Curves (P/B 801)
25-52-01-300-806	Neoprene Coated Cargo Liner Repair (P/B 801)
25-52-01-300-807	Silicone Impregnated Liner Repair (P/B 801)
25-52-01-300-808	Permanent Repair for the Contour of the Ceiling Shroud (P/B 801)
25-52-01-340-801	Permanent Repair for Flat or Slightly Curved Liners (P/B 801)
25-52-01-350-801	Loose or Damaged Tape Repair (P/B 801)
25-52-06-000-801	Cargo Compartment Sidewall Lining - Removal (P/B 401)
25-52-06-400-801	Cargo Compartment Sidewall Lining - Installation (P/B 401)
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)
25-52-16-000-801	Forward Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)
25-52-16-400-801	Forward Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)
25-52-17-000-801	Forward Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)
25-52-17-400-801	Forward Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)

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Reference	Title
25-52-18-400-801	Aft Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)
25-52-19-000-801	Aft Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)
25-52-19-400-801	Aft Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. Procedure

SUBTASK 25-52-00-210-001

- (1) Make sure that there is no loose or damaged tape at the joints for the ceiling liner, sidewall liner or bulkhead liner. If there is loose or damaged tape, do this task: Loose or Damaged Tape Repair, TASK 25-52-01-350-801.

SUBTASK 25-52-00-211-001

- (2) Make sure that the ceiling linings, sidewall linings, bulkhead linings and panels, blowout panels and floor panels do not have any cuts, tears, cracks, or holes.
 - (a) If there are cuts, tears, cracks or holes found on the blowout panel, replace the blowout panel (PAGEBLOCK 21-32-05/401).

SUBTASK 25-52-00-200-002

- (3) These are the maximum damage limits for the repair of the non-honeycomb linings. These damage limits apply to all the non-honeycomb linings (the ceiling panels and shrouds, the sidewall linings, and the forward bulkhead in the aft cargo compartment) EXCEPT for cracks along the contour of the ceiling shroud in the forward cargo compartment. The cracks length limits may be longer than 35 in. (88.9 cm) and are at least 2 in. (5.1 cm) away from other damage and from the panel edge on all sides, do this task: Permanent Repair for the Contour of the Ceiling Shroud, TASK 25-52-01-300-808.
 - (a) Make sure that cuts that are 36 in. (91 cm) long or less.
 - (b) Make sure that L-shaped tears are 9 in. (23 cm) long or less on either side.
 - (c) Make sure that holes are 1.5 in. (3.8 cm) in diameter or smaller.

SUBTASK 25-52-00-200-003

- (4) If the damage is less than or equal to the limits, do the applicable task to repair the lining:
 - (a) Permanent Repair for Flat or Slightly Curved Liners, TASK 25-52-01-340-801
 - (b) Permanent Repair for Molded Liners, Shrouds, and Liners with Complex Curves, TASK 25-52-01-300-802
 - (c) Neoprene Coated Cargo Liner Repair, TASK 25-52-01-300-806
 - (d) Silicone Impregnated Liner Repair, TASK 25-52-01-300-807

SUBTASK 25-52-00-200-004

- (5) If the damage is greater than the limits, you cannot repair the lining. You must replace the lining. Do the applicable tasks:

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- (a) Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801 and Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801
- (b) Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801 and Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801
- (c) Forward Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-16-000-801 and Forward Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-16-400-801
- (d) Forward Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-17-000-801 and Forward Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-17-400-801
- (e) Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801 and Aft Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-18-400-801
- (f) Aft Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-19-000-801 and Aft Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-19-400-801

SUBTASK 25-52-00-300-001

- (6) These are the maximum damage limits to repair the contour of the ceiling shroud in the forward cargo compartment. These damage limits only apply to cracks or cuts along the bend of the shroud. For damage to the flat parts of the shroud, use the damage limits and repair instructions for non-honeycomb linings.
 - (a) Make sure that cracks are at least 2 in. (5 cm) away from other damage and from the panel edge on all sides.

SUBTASK 25-52-00-300-002

- (7) If the damage to the contour of the ceiling shroud in the forward cargo compartment is less than or equal to the limits, do this task to repair the lining:
 - (a) Permanent Repair for the Contour of the Ceiling Shroud, TASK 25-52-01-300-808

SUBTASK 25-52-00-960-003

- (8) If the damage is greater than the limits, you cannot repair the lining. You must replace the lining. Do these tasks:
 - (a) Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801 and Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801

SUBTASK 25-52-00-200-005

- (9) These are the maximum damage limits for the repair of the nomex honeycomb panels.
 - (a) For panels with core damage, there must be at least 0.5 in. (1.3 cm) of undamaged core around the damaged area.

SUBTASK 25-52-00-300-003

- (10) If the damage is less than or equal to the limits, do this task to repair the lining:
 - (a) Crushed-Core and Sandwich Panel Repair, TASK 25-00-00-300-801

SUBTASK 25-52-00-960-004

- (11) If the damage is greater than the limits, you cannot repair the lining. You must replace the lining.

———— END OF TASK ————



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TASK 25-52-00-200-805

3. Cargo Compartment Blowout Panel Inspection

A. References

Reference	Title
21-32-05 P/B 401	CARGO COMPARTMENT BLOWOUT PANELS - REMOVAL/INSTALLATION

B. Location Zones

Zone	Area
100	Lower Half of Fuselage

C. Blowout Panel Inspection

SUBTASK 25-52-00-210-006

- (1) Make sure the blowout panel is fully engaged between the retaining ring and the rectangular seal.
 - (a) Do these steps to put the blowout panel in the correct position if it is not fully engaged:
 - 1) Remove the screws and washers that attach the grill to the frame.
 - 2) Remove the grill.
 - 3) Loosen the applicable bolts that attach the retaining ring to the frame in the area where the blowout panel came out.
 - 4) Make sure the blowout panel is not torn, punctured, or creased.
 - a) Replace the blowout panel if it is necessary.
 - 5) Put the blowout panel in the position between the retaining ring and the rectangular seal.
 - 6) Tighten the bolts that attach the retaining ring to the frame.
 - 7) Install the screws and washers to attach the grill to the frame.

SUBTASK 25-52-00-210-007

- (2) Make sure the grill is firmly attached and is aft of the blowout panel.

SUBTASK 25-52-00-960-002

- (3) Replace the blowout panel if it is necessary. Do the applicable task in this procedure: CARGO COMPARTMENT BLOWOUT PANELS - REMOVAL/INSTALLATION, PAGEBLOCK 21-32-05/401

———— END OF TASK ————

TASK 25-52-00-210-801

4. Cargo Restraint (Doorway) - Visual Inspection

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

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B. Procedure

SUBTASK 25-52-00-210-005

- (1) Visually examine the cargo restraint at the forward and aft cargo door. Examine the items that follow:
 - (a) Make sure the straps are not worn or frayed.
 - (b) Make sure that each strap attaches to an anchor point.

———— END OF TASK ————

TASK 25-52-00-200-804

5. Cargo Compartment Tiedown Fitting Inspection

Figure 602

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Procedure

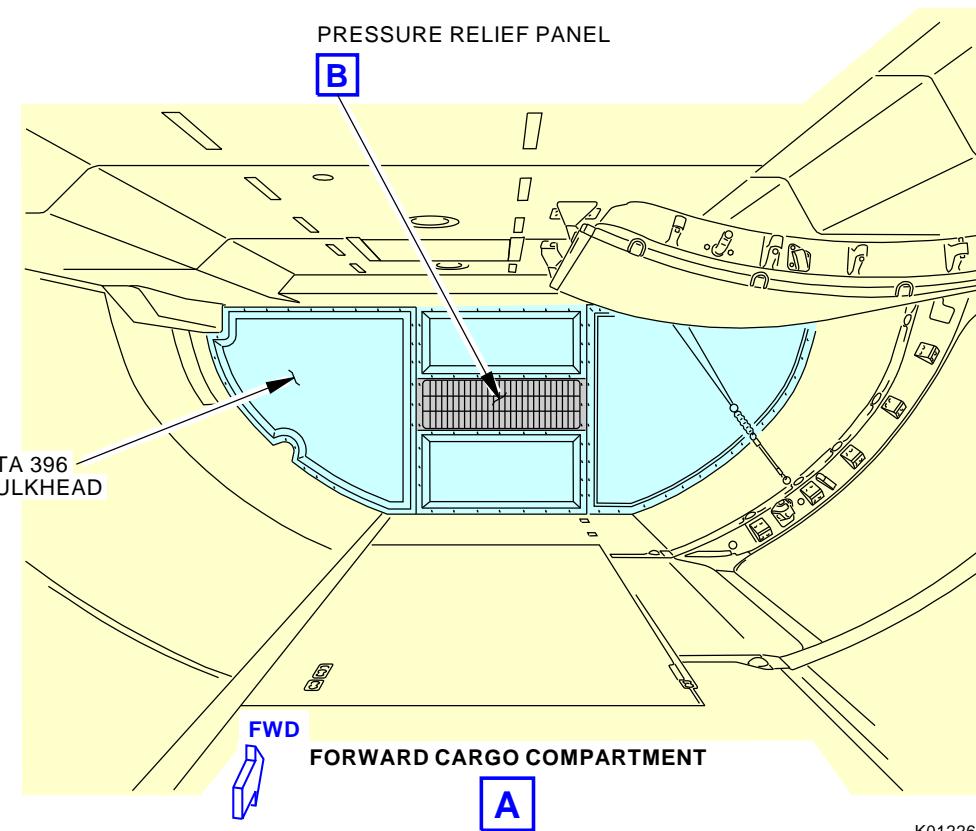
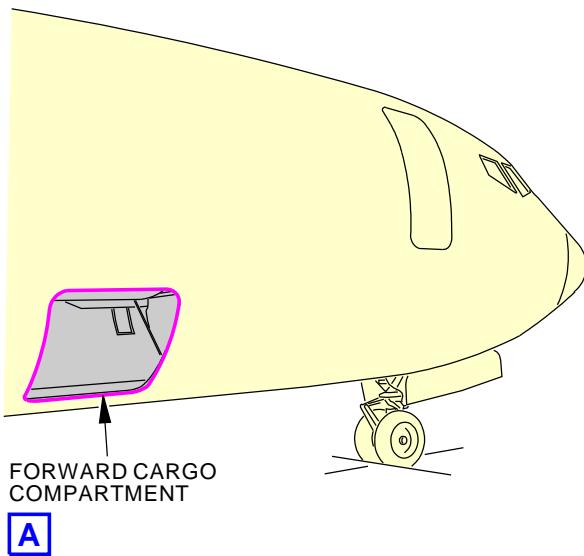
SUBTASK 25-52-00-210-004

- (1) Do a visual check of the tiedown fittings in the forward and aft cargo compartments.
 - (a) Make sure the tiedown fittings in the forward and aft cargo compartments are installed correctly.
 - (b) Make sure the tiedown fittings are not worn.
 - (c) Make sure the tiedown fittings can hold the nets or straps and provide sufficient restraint.

———— END OF TASK ————

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Forward Cargo Compartment Sta 396 Bulkhead Inspection
Figure 601/25-52-00-990-801 (Sheet 1 of 2)

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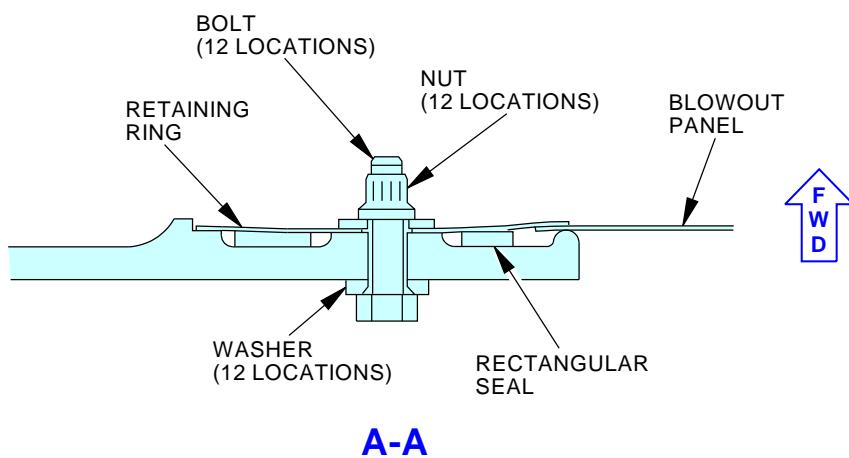
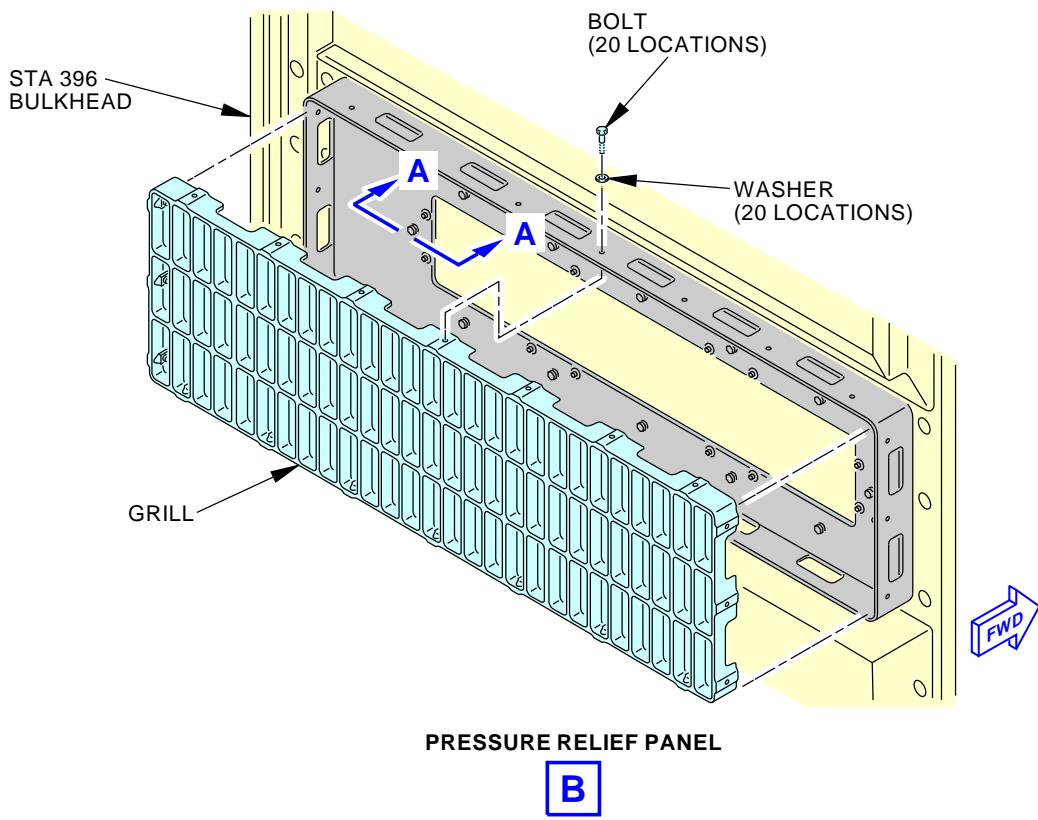
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Forward Cargo Compartment Sta 396 Bulkhead Inspection
Figure 601/25-52-00-990-801 (Sheet 2 of 2)

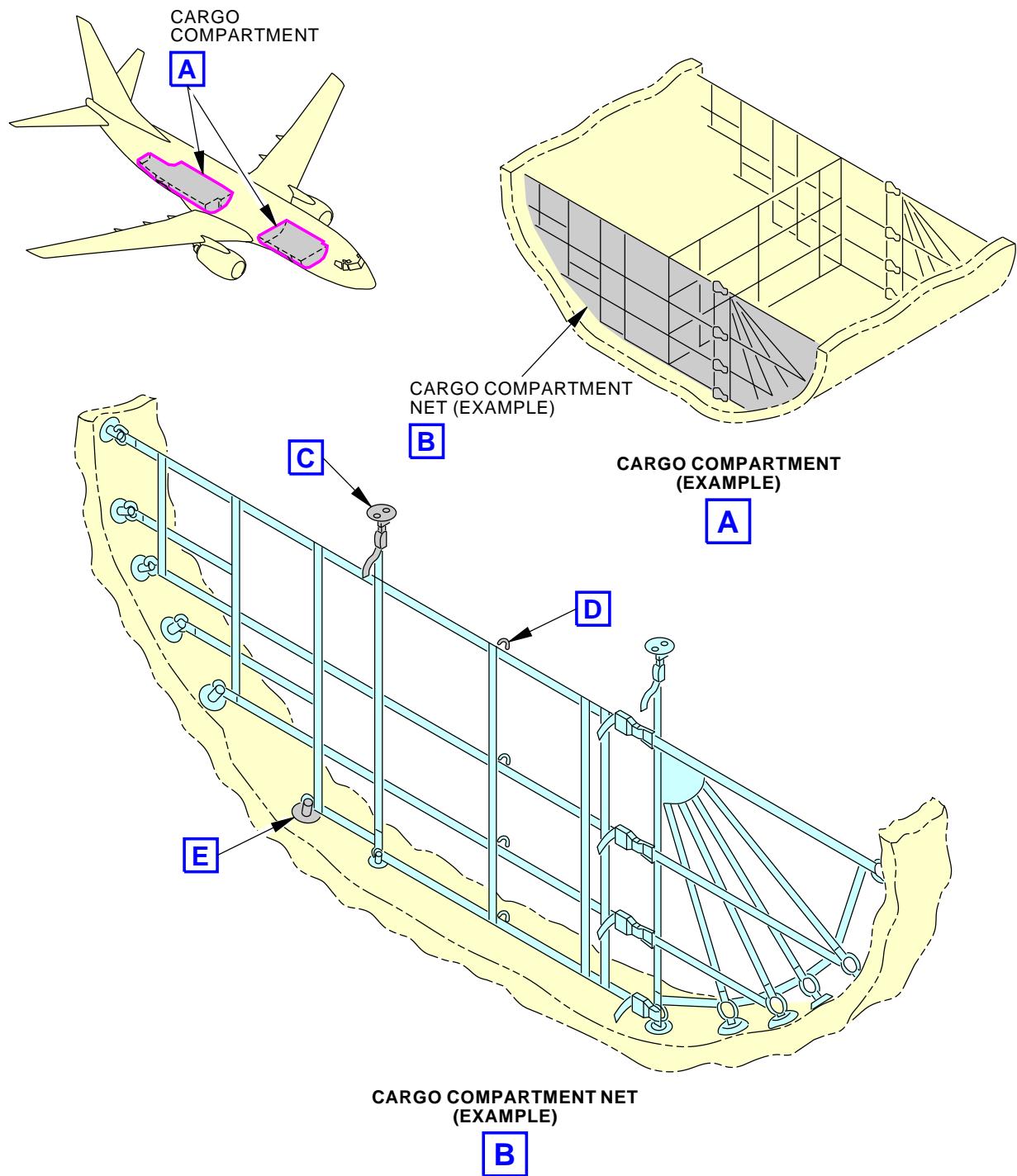
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Tiedown Fitting Inspection
Figure 602/25-52-00-990-803 (Sheet 1 of 2)

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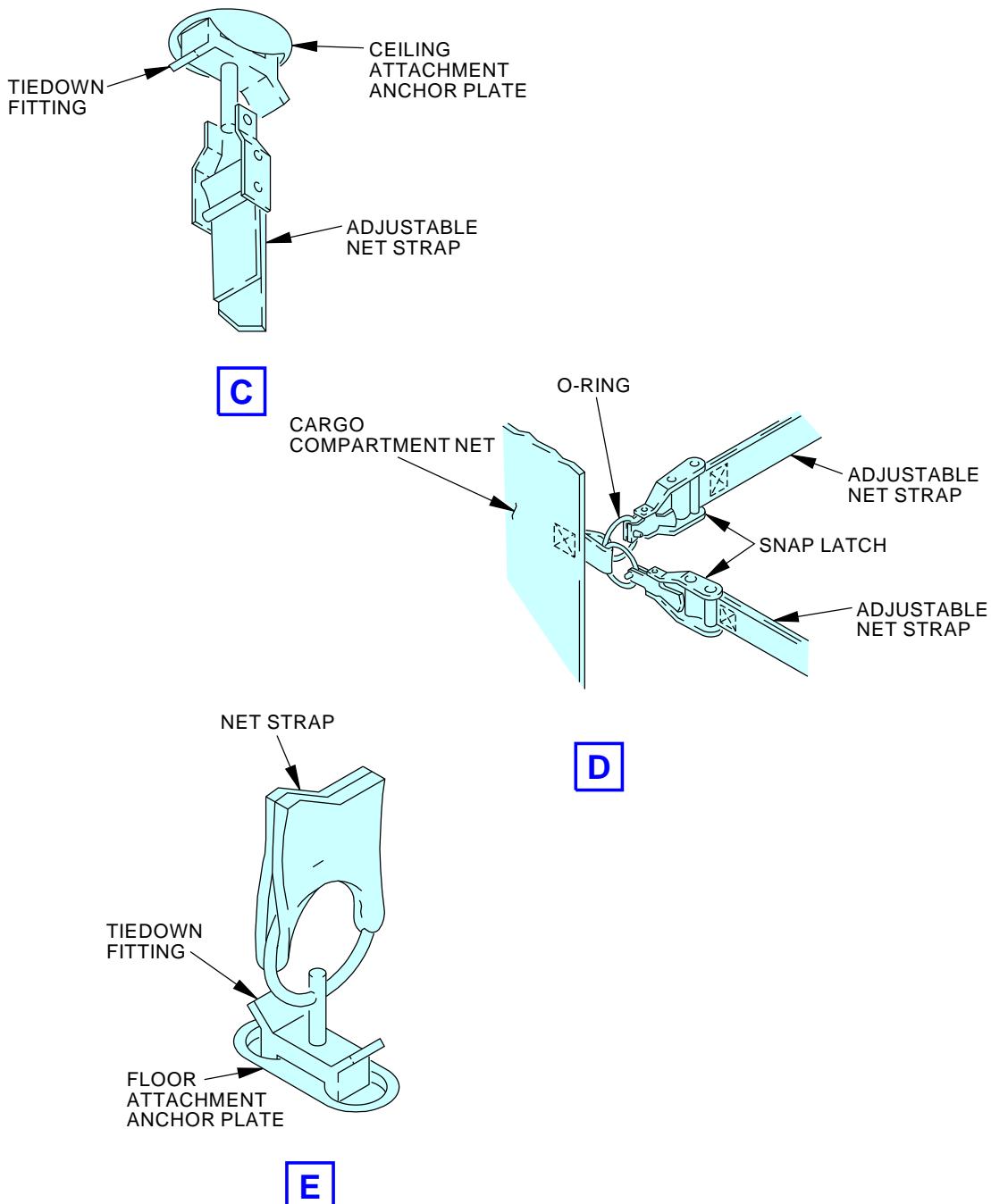
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Tiedown Fitting Inspection
Figure 602/25-52-00-990-803 (Sheet 2 of 2)

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CARGO COMPARTMENT - CLEANING/PAINTING

1. General

- A. This procedure contains the following task:
- (1) Cargo Compartment Cleaning.

TASK 25-52-00-100-801

2. Cargo Compartment Cleaning

A. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
24-22-00-860-811	Supply Electrical Power (P/B 201)
24-22-00-860-812	Remove Electrical Power (P/B 201)
51-21-91-620-802	Application of Corrosion Inhibiting Compound (P/B 701)

B. Tools/Equipment

Reference	Description
STD-1068	Vacuum - High Capacity

C. Consumable Materials

Reference	Description	Specification
B00003	Cleaner - Emulsion Alkaline - GMC 528B	
B00005	Cleaner - Alkaline - Cee Bee 280	
B00008	Cleaner - Alkaline - Oakite 204	
B00012	Cleaner - Alkaline - Turco Jet Clean C	
B00013	Cleaner - Alkaline - Dubois C-1102	
B00014	Cleaner - Zip-Chem Products Calla 301 Heavy Duty Cleaner	
B00015	Cleaner - Heavy Duty, Multipurpose - Calla 301A	BAC5744, AMS 1526-A, AMS 1550-A
B00016	Cleaner - Alkaline - TEC Formula No. 1	
B00017	Cleaner - Alkaline - Pace B-82 (Formerly Pacific B-82)	BMS11-12
B00325	Cleaner - Alkaline - Turco Jet Clean E	
B00335	Cleaner - Alkaline - TEC 86-2	
B00402	Cleaner - Aerospace Equipment	MIL-PRF-87937
B00432	Solvent - Alkaline - Cee Bee A-410B	
B00433	Solvent - Alkaline - Hydrex 09	
B00434	Solvent - Alkaline - Metaclean AC	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00252	Film - Polyethylene Film And Sheeting	ASTM D2103 (Supersedes L-P-512)
G00253	Material - Barrier Materials, Greaseproofed, Waterproof, Flexible, Heat-Sealable	MIL-PRF-121 (Supersedes MIL-B-121)
G00258	Paper - Moisture Resistant, Laminated - Angier 30	

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(Continued)

Reference	Description	Specification
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G50412	Paper - Litmus (Used to find the acidity or alkalinity of a liquid solution)	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

E. Procedure

SUBTASK 25-52-00-100-001

- (1) Use these standard tools and equipment.
 - (a) high capacity vacuum, STD-1068 (wet and dry)
 - (b) Drum - 30 or 55 gallon capacity, mounted on casters
 - (c) Hose Assembly - 6 foot length, 1 1/2-inch ID; with a swivel connection to the pump - Graco Model 206-266 siphon tube
 - (d) Hose - 50 foot length, 3/8-inch ID, 2250 PSI working pressure with 3/8-inch pipe fitting at each end - Graco Model 207-831
 - (e) Portable Airless Pump - Graco bulldog Model 207-463; Hydraclean Pressure with 7 gpm output, 1200 psi working pressure, 10:1 ratio pump on pneumatic cart Model 208-156, with regulator assembly 206-199; Graco Incorporated, 60-11th Ave NE, Minneapolis MN 53440

SUBTASK 25-52-00-110-001

- (2) Use one of these alkaline emulsion solvents:
 - (a) Calla 301 cleaner, B00014
 - (b) Cee Bee A-410B solvent, B00432
 - (c) Cee Bee 280 cleaner, B00005
 - (d) Dubois C-1102 cleaner, B00013
 - (e) GMC 528B cleaner, B00003
 - (f) Hydrex 09 solvent, B00433
 - (g) Metaclean AC solvent, B00434
 - (h) Oakite 204 cleaner, B00008
 - (i) Pace B-82 cleaner, B00017
 - (j) TEC Formula No. 1 cleaner, B00016
 - (k) TEC 86-2 cleaner, B00335
 - (l) Turco Jet Clean C cleaner, B00012
 - (m) Turco Jet Clean E cleaner, B00325

NOTE: The following cleaners are optional to GMC 528B cleaner, B00003: cleaner, B00402, Cee Bee 280 cleaner, B00005, Oakite 204 cleaner, B00008 and Calla 301A cleaner, B00015.

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F. Prepare to Clean

SUBTASK 25-52-00-860-001

- (1) Do this task: Remove Electrical Power, TASK 24-22-00-860-812.

SUBTASK 25-52-00-910-001

- (2) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 25-52-00-020-001

CAUTION: REMOVE ALL COMPONENTS THAT ARE NOT RESISTANT TO DAMAGE FROM THE SOLVENTS OR WATER. DAMAGE TO SOME COMPONENTS CAN OCCUR IF THEY GET WET WITH THE SOLVENTS OR WATER.

- (3) Remove all of the blankets and components that are not resistant to damage from solvents and water.

SUBTASK 25-52-00-950-001

CAUTION: APPLY THE MASKING TAPE AND PAPER TO ALL AREAS THAT YOU WILL NOT CLEAN. YOU MUST OBEY THE MANUFACTURER'S INSTRUCTIONS. THESE CLEANERS HAVE HIGH CONCENTRATION LEVELS AND CAN CAUSE DAMAGE TO THE PAINT OR CAN CAUSE CORROSION OF THE METAL SURFACES.

- (4) Use masking Scotch Flatback Masking Tape 250, G00270 with one of these protective materials to cover the areas that you will not clean:

NOTE: This includes protection of all the lubricated or waxed surfaces and the latches and fittings.

- (a) polyethylene film, G00252,
- (b) barrier material, G00253, or
- (c) Angier 30 paper, G00258

G. Clean the cargo compartment

SUBTASK 25-52-00-160-001

- (1) Remove the dirt, fluids, and the other loose material with a vacuum cleaner as necessary.

SUBTASK 25-52-00-110-002

WARNING: DO NOT GET THESE SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATH THE FUMES. PUT ON PROTECTIVE SPLASH GOGGLES AND GLOVES. KEEP THESE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. THESE SOLVENTS CAN BE POISONOUS OR FLAMMABLE WHICH CAN CAUSE INJURY OR DAMAGE.

CAUTION: DO NOT USE SOLVENTS THAT ARE NOT SHOWN IN THE CONSUMABLE MATERIALS. YOU CAN CAUSE DAMAGE TO THE EQUIPMENT IF YOU USE OTHER SOLVENTS.

- (2) Apply the solution of alkaline cleaner and water to the compartment with an airless pump.

NOTE: Let the solution soak for 5 minutes, but do not let it dry. Apply more solution as necessary to keep the surfaces wet.

SUBTASK 25-52-00-160-002

- (3) Remove the solution and the materials loosened by the solution with the vacuum cleaner.

SUBTASK 25-52-00-160-003

- (4) Do steps (2) and (3) again until the compartment is clean, as necessary.

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SUBTASK 25-52-00-170-001

- (5) Flush the compartment with clean water.
 - (a) Use pressure to apply the water.

SUBTASK 25-52-00-160-004

- (6) Remove the water with the vacuum cleaner as necessary.

SUBTASK 25-52-00-750-001

- (7) Do this PH check for the compartment as follows with litmus paper, G50412:
 - (a) Do a pH check of the clean water.
 - (b) Do a pH check of the water which remains caught in the compartment
NOTE: Do this check in more than one area.
 - (c) Compare the PH check of the clean water with the pH of the water still caught in the compartment.
 - (d) Make sure the pH in step (b) is not more than 1 pH unit of the pH in step (a).
NOTE: If not, flush the compartment again with clean water.

SUBTASK 25-52-00-160-005

- (8) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-52-00-620-001

- (9) Do this task: Application of Corrosion Inhibiting Compound, TASK 51-21-91-620-802.

H. Put the Airplane in its Usual Condition

SUBTASK 25-52-00-950-002

- (1) Remove all of the masking tape and paper.

SUBTASK 25-52-00-410-001

- (2) Install the equipment you removed.

SUBTASK 25-52-00-910-002

- (3) Remove the static ground.

SUBTASK 25-52-00-860-002

- (4) If it is necessary, do this task: Supply Electrical Power, TASK 24-22-00-860-811.

———— END OF TASK ————



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CARGO COMPARTMENT LINING - REPAIRS

1. General

- A. This procedure contains these tasks:
- (1) Loose or Damaged Tape Repair
 - (2) Permanent Repair for Flat or Slightly Curved Liners
 - (3) Permanent Repair for Molded Liners, Shrouds, and Liners with Complex Curves
 - (4) Permanent Repair for the Contour of the Ceiling Shroud
 - (5) Repair for Neoprene Coated Cargo Liners
 - (6) Repair for Silicone Impregnated Liners

TASK 25-52-01-350-801

2. Loose or Damaged Tape Repair

A. General

- (1) It is not necessary to remove the liners from the airplane for this repair.

B. Consumable Materials

Reference	Description	Specification
A50426	Tape - Cargo Lining, 2 inches wide	BMS5-146 Type 1 Class 1 Grade A
B00090	Solvent - Inhibited Trichloroethane 1,1,1	MIL-T-81533
B00093	Solvent - Tetrachloroethylene (Perchloroethylene)	ASTM D4081
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. Procedure

SUBTASK 25-52-01-020-003

- (1) Remove or discard all loose or damaged tape.

SUBTASK 25-52-01-160-004

- (2) Clean the damaged area with a clean cotton wiper, G00034, that is moist with solvent, B00093, or solvent, B00090.

SUBTASK 25-52-01-160-005

- (3) Dry the area with a clean dry cotton wiper, G00034, before the solvent dries.

SUBTASK 25-52-01-160-006

- (4) Clean the area again fully to remove the dirt, oil, paint, and other unwanted materials.

NOTE: A clean surface is necessary for a good bond.

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SUBTASK 25-52-01-420-003

WARNING: DO NOT PUT TAPE ON THE SMOKE DETECTOR TUBES OR THE FIRE EXTINGUISHER OUTLET TUBES. THE SMOKE DETECTOR AND THE FIRE EXTINGUISHER SYSTEM WILL NOT SENSE A FIRE IF THERE IS TAPE ON THE TUBE OR OUTLETS. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (5) Apply Tape, A50426.

NOTE: Do not use the old tape again. If you use the tape again, it will not have a satisfactory bond.

- Make sure the tape is within shelf life limits for optimum tape adhesion.
- Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.

———— END OF TASK ————

TASK 25-52-01-340-801

3. Permanent Repair for Flat or Slightly Curved Liners

(Figure 801)

A. General

- (1) There are four alternatives for permanent repairs. It is only necessary to use one of the four alternatives.

B. References

Reference	Title
25-52-06-000-801	Cargo Compartment Sidewall Lining - Removal (P/B 401)
25-52-06-400-801	Cargo Compartment Sidewall Lining - Installation (P/B 401)
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A00016	Adhesive - Pressure Sensitive Film For Interior Non-Structural Bonding	BMS5-91
A01016	Adhesive - Epoxy Resin, High Temperature - Thermion EP65HT-1	
A50022	Patch - Cargo Liner, Self-Adhesive Speed Patch - AF844, AF848, or AF888 (based on size)	
A50426	Tape - Cargo Lining, 2 inches wide	BMS5-146 Type 1 Class 1 Grade A
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
B00102	Abrasive - Aluminum Oxide Coated Cloth	

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Reference	Description	Specification
B00137	Abrasive - Garnet Coated Paper	
G00088	Fabric, General Purpose, Rigid, Fire Retarded, BMS8-2	
	Glass Fabric Reinforced Plastic Sheeting	
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223
G02393	Patch - Fiberglass, Heat-Resistant - Thermion 9290	
G50418	Patch - Cargo Liner, Self-Adhesive Speed Patch - Gillpatch III 6306 System Kit	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

E. Prepare for the Repair

SUBTASK 25-52-01-000-001

- (1) If it is necessary to remove the liner for repair, do the applicable task:
 - (a) Do this task: Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801.
 - (b) Do this task: Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801.
 - (c) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801.

SUBTASK 25-52-01-210-008

- (2) These are the maximum damage limits for the repair of the non-honeycomb linings. These damage limits apply to all the non-honeycomb linings (the ceiling panels and shrouds, the sidewall linings, and the forward bulkhead in the aft cargo compartment) EXCEPT for cracks along the contour of the ceiling shroud in the forward cargo compartment. The cracks length limits may be longer than 35 in. (88.9 cm) and are at least 2 in. (5.1 cm) away from other damage and from the panel edge on all sides, do this task: Permanent Repair for the Contour of the Ceiling Shroud, TASK 25-52-01-300-808.
 - (a) Make sure that cuts that are 36 in. (91 cm) long or less.
 - (b) Make sure that L-shaped tears are 9 in. (23 cm) long or less on either side.
 - (c) Make sure that holes are 1.5 in. (3.8 cm) in diameter or smaller.



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F. Alternative 1 - Repair the Cargo Liners With Screws and a Bonded Patch

SUBTASK 25-52-01-340-018

- (1) Make a patch from the applicable material, sheet, G02163, or fabric, G00088. The sheet, G02163 or fabric, G00088 must be the same thickness as the liner where the repair is necessary.

NOTE: Cargo areas contain sheet, G02163 and fabric, G00088. They are interchangeable.

The only difference is the fabric, G00088 is heavier and more durable. Both have the same fire retardant value.

NOTE: The patch must make a 2-inches (51 mm) overlap on the area that is not damaged.

For example, the patch dimension that is necessary for a 1.5-inches (38 mm) diameter hole would be 5.5-inches (140 mm) diameter.

SUBTASK 25-52-01-120-004

- (2) Rub the back of the patch with abrasive cloth, B00102 (80 grit).

SUBTASK 25-52-01-120-005

- (3) Use abrasive cloth, B00102 (80 grit), to remove all signs of the Tedlar on the area of the liner to be contacted by the patch.

NOTE: Tedlar is the protective white layer that is on the front of the liner.

SUBTASK 25-52-01-160-007

- (4) Clean all the surfaces with alcohol, B00065, or solvent, B00083, to remove the loose particles.

SUBTASK 25-52-01-340-019

- (5) Apply adhesive, A00016 or equivalent, to the back of the patch.

SUBTASK 25-52-01-340-020

- (6) Put the patch over the center of the damaged area.

SUBTASK 25-52-01-340-021

- (7) Apply pressure to the patch to make sure there is a good bond.

SUBTASK 25-52-01-340-022

- (8) Attach the patch permanently with steel sheet metal screws. Install the screws approximately 1.25 inches (31.75 mm) apart and 0.60 inch (15.24 mm) from the edge of the patch.

NOTE: Put the screws in positions where they do not touch the structure that is behind the panel.

SUBTASK 25-52-01-340-023

- (9) Apply Tape, A50426, on the heads of the screws to keep them installed through the fiberglass liner and patch.

(a) Make sure the tape is within shelf life limits for optimum tape adhesion.

(b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.

G. Alternative 2 - Thermion Repair System

SUBTASK 25-52-01-340-024

- (1) Get the correct Thermion 9290 patch, G02393, for the shape of the damage.

NOTE: The patch must make a 2-inches (51 mm) overlap on the area that is not damaged.

For example, the patch dimension that is necessary for a 1.5-inches (38 mm) diameter hole would be 5.5-inches (140 mm) diameter.

SUBTASK 25-52-01-120-006

- (2) Rub the back of the patch with abrasive cloth, B00102 (80 grit), to remove the gloss.

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- (a) Be careful to not rub the impregnated scrim area.

SUBTASK 25-52-01-120-007

- (3) Use abrasive, B00137 (80 grit), to remove all signs of the Tedlar on the area of the liner to be contacted by the patch.

NOTE: Tedlar is the protective white layer that is on the front of the liner.

SUBTASK 25-52-01-160-008

- (4) Clean all the surfaces with alcohol, B00065, or solvent, B00083, to remove the loose particles.

SUBTASK 25-52-01-340-025

- (5) Apply Thermion EP65HT-1 adhesive, A01016, to the back of the patch and to the liner.

SUBTASK 25-52-01-340-026

- (6) Put the patch over the center of the damaged area.

SUBTASK 25-52-01-340-027

- (7) Apply pressure to the patch until the excess adhesive comes out from the edges.

SUBTASK 25-52-01-340-028

- (8) Put Tape, A50426, around the edges of the patch.

NOTE: The tape will hold the patch while the adhesive dries (approximately 30 minutes). Also, the tape will protect the edges of the patch when the airplane is in service.

- (a) Make sure the tape is within shelf life limits for optimum tape adhesion.

- (b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.

H. Alternative 3 - Akro Fireguard System

SUBTASK 25-52-01-340-029

- (1) Get the correct Akro Fireguard repair kit, Akro Fireguard patch, A50022 for the shape of the damage.

NOTE: The patch must make a 2-inches (51 mm) overlap on the area that is not damaged.

For example, the patch dimension that is necessary for a 1.5-inches (38 mm) diameter hole would be 5.5-inches (140 mm) diameter.

NOTE: For edge damage, the patch must extend to the edge of the liner or be put below the adjacent metal structure.

SUBTASK 25-52-01-340-030

- (2) Use the Akro installation instructions (in the kit) to attach the patch over the center of the damage.

I. Alternative 4 - Gillpatch III System

SUBTASK 25-52-01-340-062

- (1) Get the Gillpatch III System patch, G50418, each kit has complete instructions to identify the repairable sizes and apply the patch.

- (a) The patch, G50418 must extend 2 inches beyond all sides of a tear or puncture.

NOTE: The patch must make a 2-inches (51 mm) overlap on the area that is not damaged. For example, the patch dimension that is necessary for a 1.5-inches (38 mm) diameter hole would be 5.5-inches (140 mm) diameter.

SUBTASK 25-52-01-160-015

- (2) Use a lint-free clean, dry cloth and alcohol, B00065, or solvent, B00083 or equivalent, to remove any oil, grease, dirt or stain from the damaged area to be patched.

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SUBTASK 25-52-01-210-001

- (3) Make sure the area is clean and dry before you apply the patch, G50418.
 - (a) Wipe off any film residue that remains on the liner surface.

SUBTASK 25-52-01-210-002

- (4) If there are any Tedlar surface, note that it is not necessary to remove them, as the patch, G50418 can be applied directly to Tedlar.

SUBTASK 25-52-01-340-063

- (5) When you are ready to apply the patch, G50418, peel the protective backing from the pressure sensitive adhesive on the back of the patch, G50418.

NOTE: Handle the patch very carefully as the adhesive will adhere aggressively to any surface that comes in contact with it.

SUBTASK 25-52-01-390-001

- (6) Center the adhesive side of the patch, G50418 over the damaged area.

SUBTASK 25-52-01-390-002

- (7) Use your hand to rub with circular even pressure over the entire surface of the patch, G50418 which also includes the exposed edges.

SUBTASK 25-52-01-210-003

- (8) Make sure the patch, G50418 completely adheres to the cargo liner it covers.
 - (a) The patch, G50418 must be firmly stuck in place and extends 2 inches beyond all sides of the tear or puncture.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-01-000-002

- (1) If it is necessary to install the liner after the repair, do the applicable task:
 - (a) Do this task: Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801.
 - (b) Do this task: Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801.
 - (c) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-18-400-801.

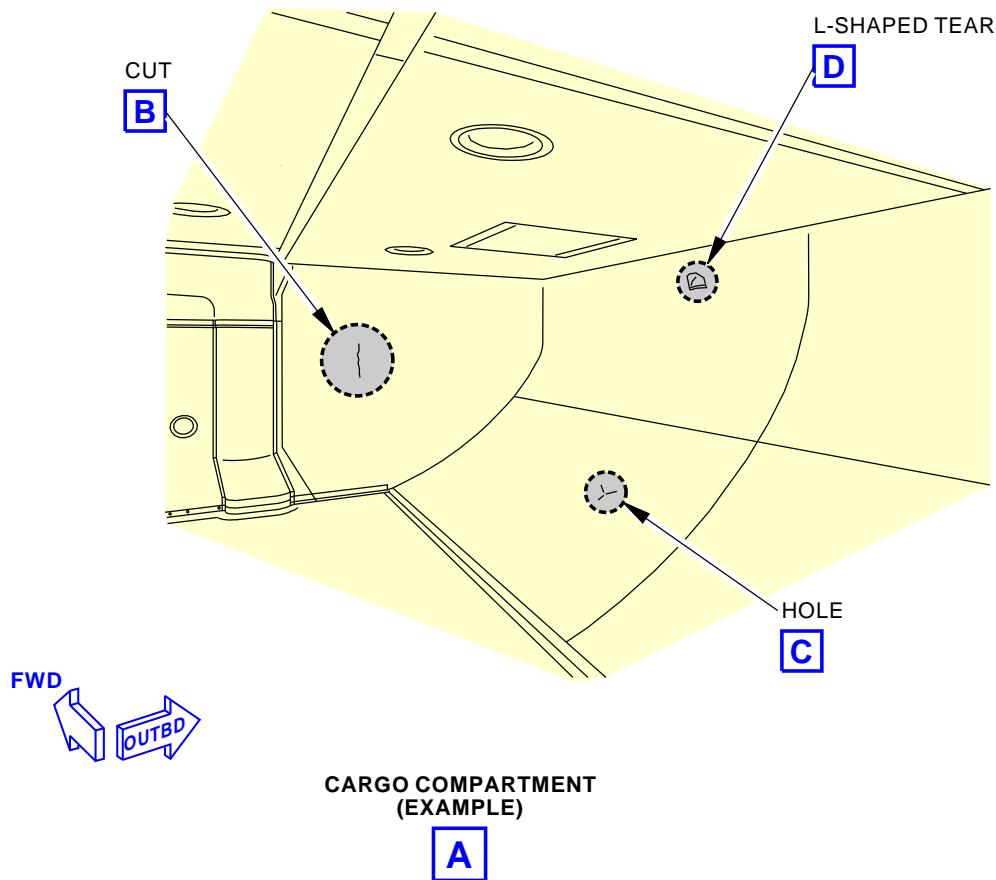
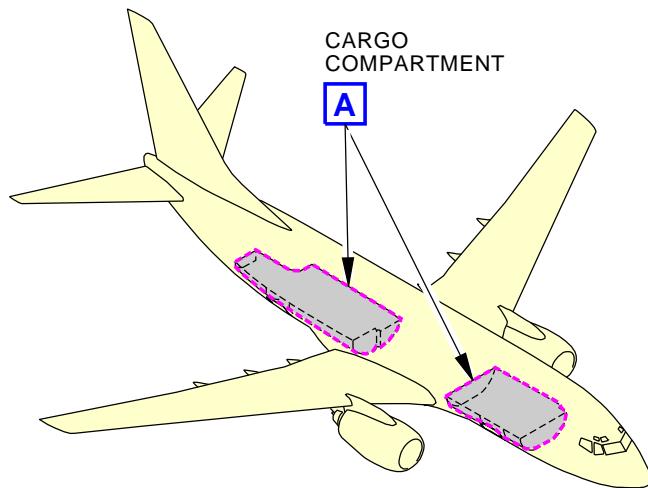
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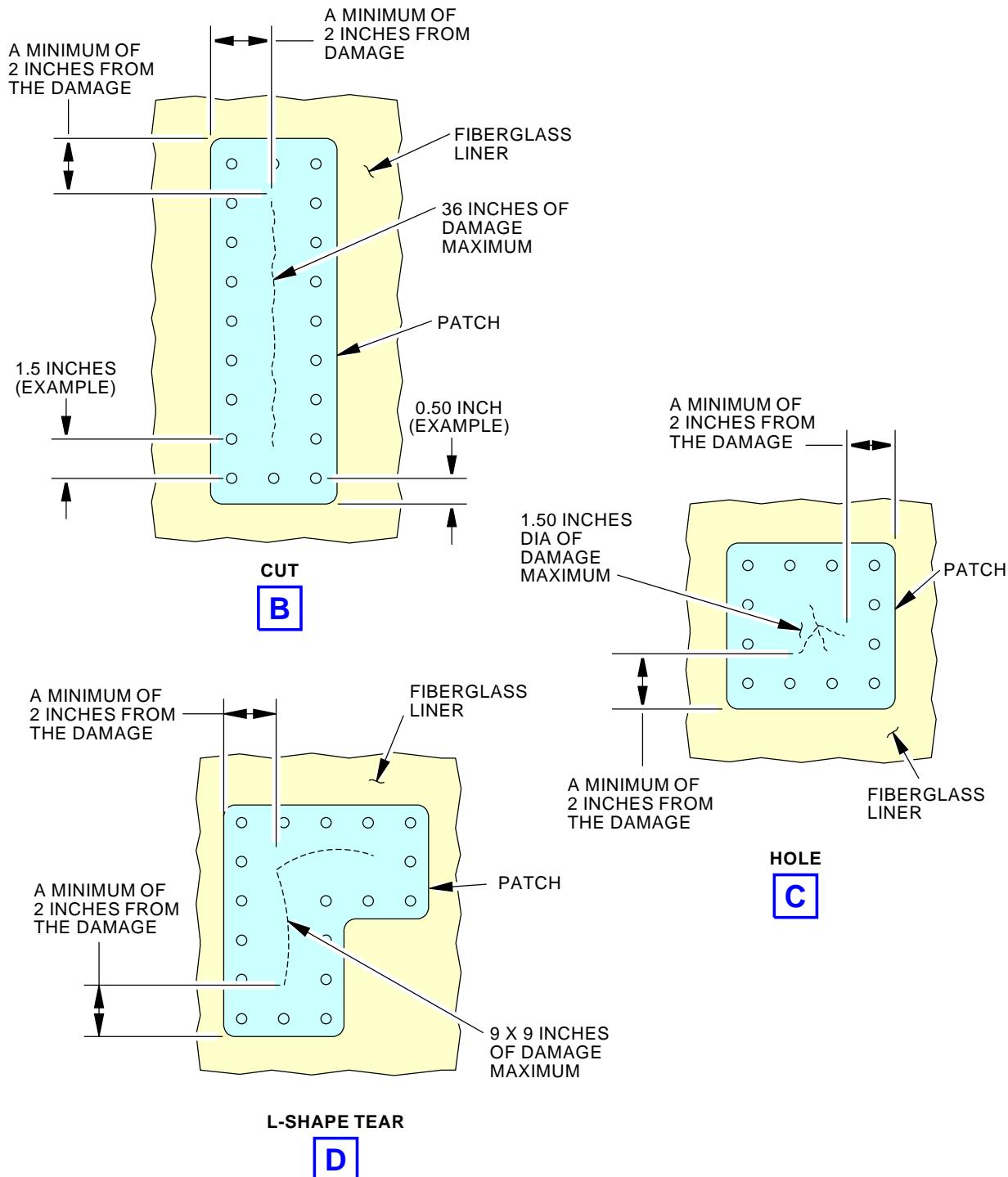
Fiberglass Liner Repair
Figure 801/25-52-01-990-801 (Sheet 1 of 2)

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Fiberglass Liner Repair
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TASK 25-52-01-300-802

4. Permanent Repair for Molded Liners, Shrouds, and Liners with Complex Curves

A. General

- (1) This task gives instructions to repair the non-honeycomb linings in the cargo compartments. This task is applicable to the ceiling panels and shrouds, the sidewall linings, and the forward bulkhead in the aft cargo compartment.

B. References

Reference	Title
25-52-06-000-801	Cargo Compartment Sidewall Lining - Removal (P/B 401)
25-52-06-400-801	Cargo Compartment Sidewall Lining - Installation (P/B 401)
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)
SRM 51-70-06	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00137	Abrasive - Garnet Coated Paper	
G00316	Fabric - Woven Glass Reinforcements For Laminating Plastics	BMS9-3
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)

D. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

E. Prepare for the Repair

SUBTASK 25-52-01-010-001

- (1) To remove the liner for repair, do the applicable task:
- Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801
 - Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801
 - Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801

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SUBTASK 25-52-01-300-004

- (2) These are the maximum damage limits for the repair of the non-honeycomb linings. These damage limits apply to all the non-honeycomb linings (the ceiling panels and shrouds, the sidewall linings, and the forward bulkhead in the aft cargo compartment) EXCEPT for cracks along the contour of the ceiling shroud in the forward cargo compartment. The cracks length limits may be longer than 35 in. (88.9 cm) and are at least 2 in. (5.1 cm) away from other damage and from the panel edge on all sides, do this task: Permanent Repair for the Contour of the Ceiling Shroud, TASK 25-52-01-300-808.
- (a) Make sure that cuts that are 36 in. (91 cm) long or less.
 - (b) Make sure that L-shaped tears are 9 in. (23 cm) long or less on either side.
 - (c) Make sure that holes are 1.5 in. (3.8 cm) in diameter or smaller.

SUBTASK 25-52-01-960-001

- (3) If the damage is greater than the limits, you cannot repair the lining. You must replace the lining.

SUBTASK 25-52-01-120-008

- (4) Use abrasive, B00137 (80 grit), to lightly sand the area of the liner to be contacted by the patch.

NOTE: Tedlar is the protective white layer that is on the front of the liner.

SUBTASK 25-52-01-120-009

- (5) Lightly rub the damaged area on the back side of the panel with abrasive cloth, B00102 (80 grit).

SUBTASK 25-52-01-160-009

- (6) Clean the damaged area with alcohol, B00065 or solvent, B00083.

F. Cargo Lining Repair

SUBTASK 25-52-01-300-005

- (1) Do this structural repair on the fiberglass side of the panel (SRM 51-70-06).

SUBTASK 25-52-01-300-006

- (2) Mix the resin, G50400, per the manufacturer's instructions.

SUBTASK 25-52-01-300-007

- (3) Apply a layer of the mixed resin to the side of the damaged panel that shows in the cargo compartment.

SUBTASK 25-52-01-300-008

- (4) Apply a layer of fiberglass fabric, G00316 (Type H), fabric on the layer of adhesive resin.

NOTE: The fiberglass fabric should make a minimum of a 2 in. (51 mm) overlap on the area that is not damaged. For example, the fiberglass fabric dimension that is necessary for a 1.5 in. (38.1 mm) diameter hole would be 5.5 in. (139.7 mm) in diameter.

SUBTASK 25-52-01-300-009

- (5) Apply one more layer of the adhesive.

SUBTASK 25-52-01-300-010

- (6) Allow the adhesive to cure for a minimum of 24 hours at 77°F (25°C), or for a minimum of 1-hour at 150°F (66°C).

NOTE: Allow a 10 degree tolerance in either direction for each.

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G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-01-840-002

- (1) To install the liner after repair, do the applicable task:
 - (a) Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801
 - (b) Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801
 - (c) Aft Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-18-400-801

———— END OF TASK ————

TASK 25-52-01-300-808

5. Permanent Repair for the Contour of the Ceiling Shroud

Figure 802

A. General

- (1) This task gives instructions to repair the contour of the ceiling shroud in the forward cargo compartment. This task only applies to cracks or cuts along the bend of the shroud. It does not apply to damage to the flat part of the shrouds.

B. References

Reference	Title
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III
G02312	Fabric, Phenolic Preimpregnated Glass	BMS8-226
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G51187	Sheet - Stainless Steel, 15-5PH CRES Sheet	Commercially Available
G51188	Sheet - Stainless Steel, 17-4PH CRES Sheet	Commercially Available
G51189	Sheet - Stainless Steel, 300 Series CRES Sheet	Commercially Available

D. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

E. Prepare for the Repair

SUBTASK 25-52-01-000-003

- (1) Do this task: Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801.

SUBTASK 25-52-01-200-001

- (2) These are the maximum damage limits to repair the contour of the ceiling shroud in the forward cargo compartment. These damage limits only apply to cracks or cuts along the bend of the shroud. For damage to the flat parts of the shroud, use the damage limits and repair instructions for non-honeycomb linings.

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- (a) Make sure that cracks are at least 2 in. (5 cm) away from other damage and from the panel edge on all sides.

F. Repair the Contour with a Steel Patch

SUBTASK 25-52-01-000-004

- (1) Remove the damaged areas.

SUBTASK 25-52-01-300-011

- (2) Fabricate a repair patch from CRES sheet 0.050 in. (0.13 cm) thick manufactured from stainless steel sheet, G51187, stainless steel sheet, G51188, or stainless steel sheet, G51189.

SUBTASK 25-52-01-300-012

- (3) Use adhesive, A01076 to bond the stainless steel sheet, G51189 patch to the ceiling shroud.

NOTE: : An optional method to bond the patch is to use seal, G02186 tape to install the patch to the ceiling shroud.

SUBTASK 25-52-01-300-013

- (4) Attach the patch permanently with screws. Use BACS12FA3K* screws, NAS1149D0363J washers and BACN10JC3CD nuts or equivalent.

(a) Fastener spacing in the forward-aft direction is 4.0 in. (101.6 mm) typical.

(b) Install two rows of fasteners past the end of the damage.

SUBTASK 25-52-01-300-014

- (5) Drill holes for the bolts around the edge of the patch. Drill the holes with a maximum of 4.0 in. (101.6 mm) of separation, and approximately 0.5 in. (12.7 mm) from the edges of the stainless steel patch. Make sure that the holes go through the patch and the original panel.

SUBTASK 25-52-01-200-002

- (6) Make sure that there is sufficient clearance between the screws and the adjacent structure and systems behind the panel.

SUBTASK 25-52-01-420-008

- (7) Install the screws, nuts and washers.

SUBTASK 25-52-01-410-003

- (8) Apply Nitto P-629 tape, G50428, over the fasteners and the joint edge to keep them installed through the patch.

(a) Make sure the tape is within shelf life limits for optimum tape adhesion.

(b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.

G. Repair the Contour with a Preformed Patch

SUBTASK 25-52-01-300-003

- (1) Make a patch from the applicable material fabric, G02312. The patch can be made from 4 plies of the fabric, G02312 material.

SUBTASK 25-52-01-340-002

- (2) Do these steps to fabricate or laminate the preformed patch:

(a) Make sure that the radius of the preformed patch matches the panel radius.

(b) Build a laminate equal in thickness to the number of plies removed.

(c) Taper sand this laminate to fit the plies removed from the panel.

(d) If you need to splice prepreg plies, overlap splices are preferred.

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- 1) Make sure that overlap widths are between 0.13 in. (3.30 mm) and 1.25 in. (31.75 mm) wide.
 - 2) Make sure that lap splices in adjacent plies are staggered.
- (e) You can use butt splices for laminates or panels that have four or more plies on each side.
- 1) Make sure that overlaps are not more than 0.01 in. (0.25 mm).
 - 2) Make sure that the maximum gap between prepreg edges are not more than 0.02 in. (0.51 mm).
 - 3) Make sure that butt splices on adjacent plies are staggered.

SUBTASK 25-52-01-350-001

- (3) Use adhesive, A01076 to bond the fabric, G02312 patch to the ceiling shroud.

NOTE: An optional method to bond the patch is to use seal, G02186 tape to install the patch to the ceiling shroud.

SUBTASK 25-52-01-420-001

- (4) Install the fasteners as necessary.
- (a) Fastener spacing in the forward-aft direction is 4.0 in. (101.6 mm) typical.
 - (b) Install two rows of fasteners past the end of the damage.

SUBTASK 25-52-01-350-002

- (5) Apply Nitto P-629 tape, G50428, over the fasteners and the joint edge to keep them installed through the patch.
- (a) Make sure that the tape is within shelf life limits for optimum tape adhesion.
 - (b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-01-840-001

- (1) Do this task: Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801.

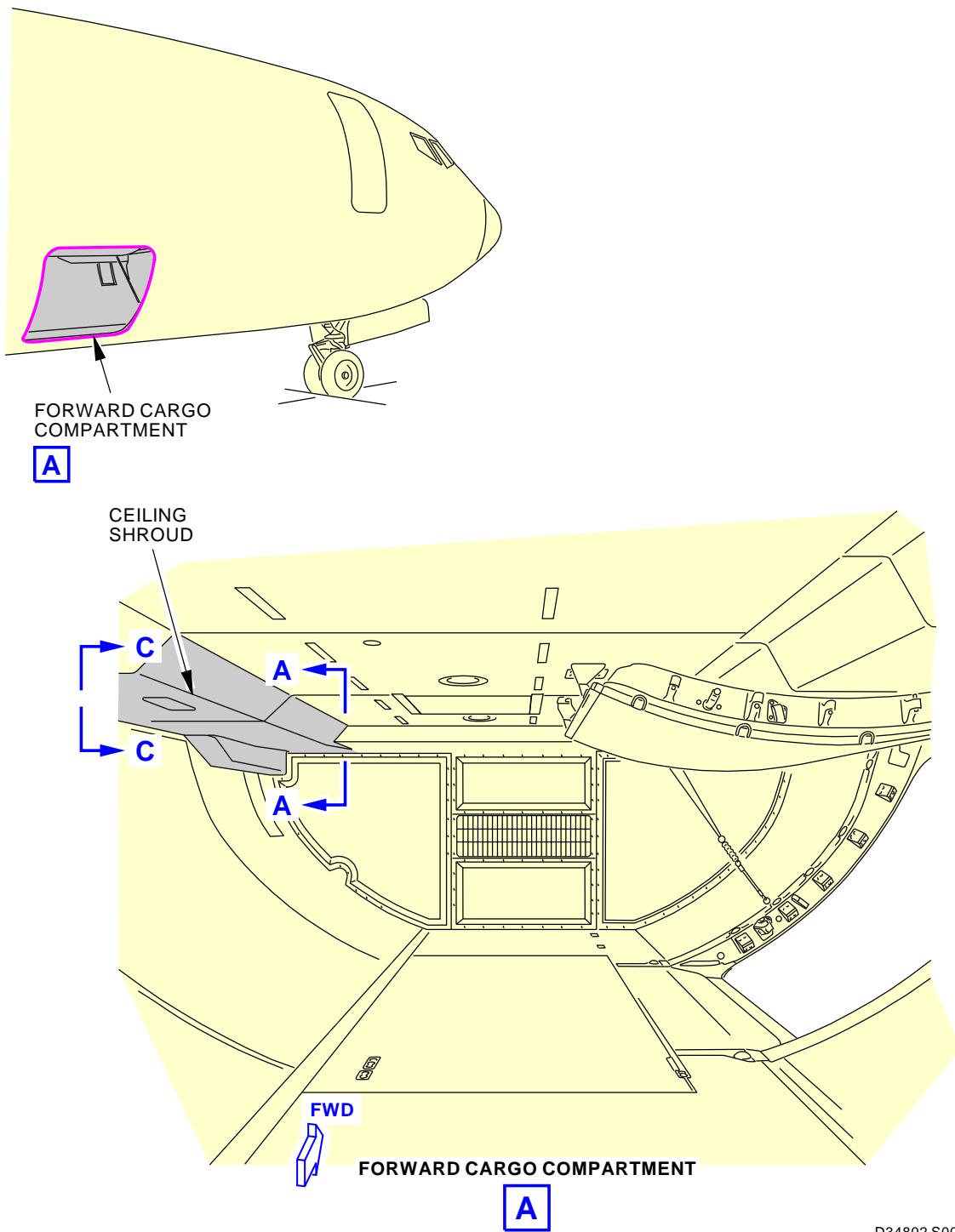
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Cargo Compartment Ceiling Shroud
Figure 802/25-52-01-990-805 (Sheet 1 of 4)

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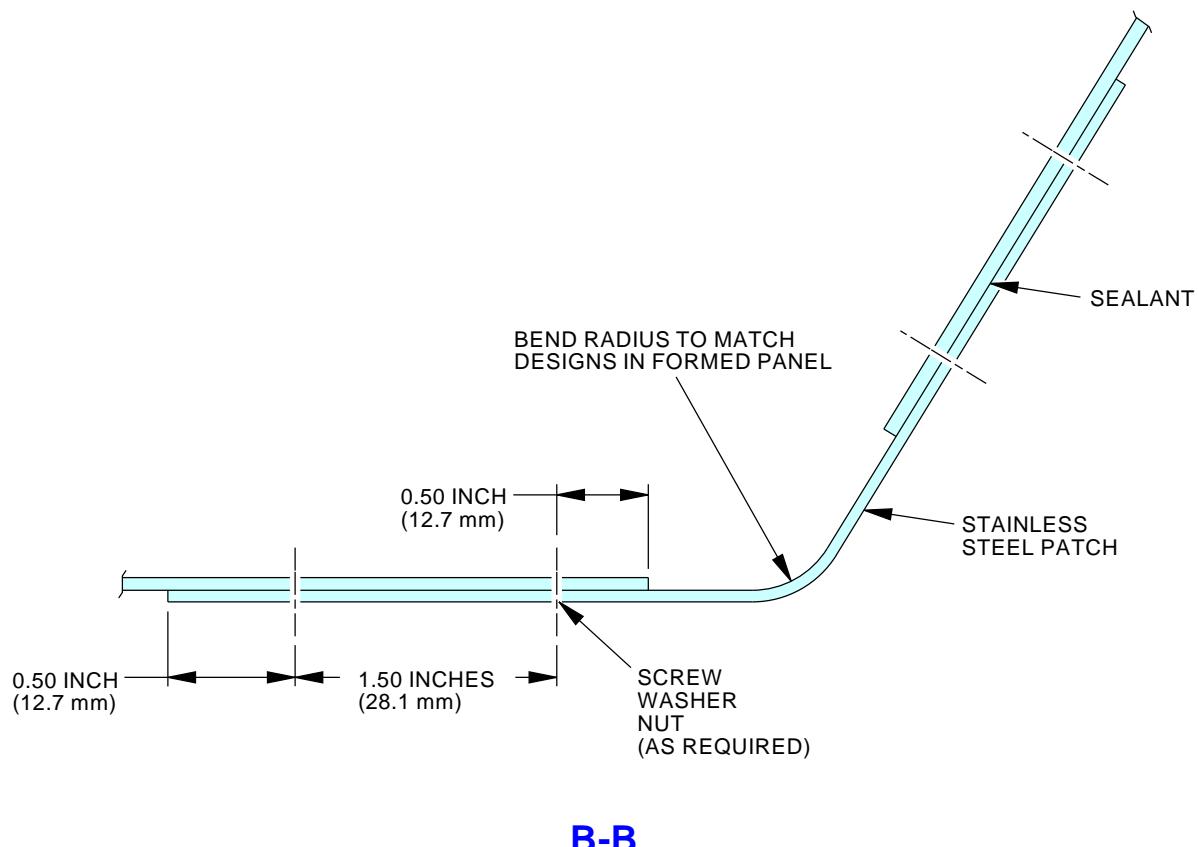
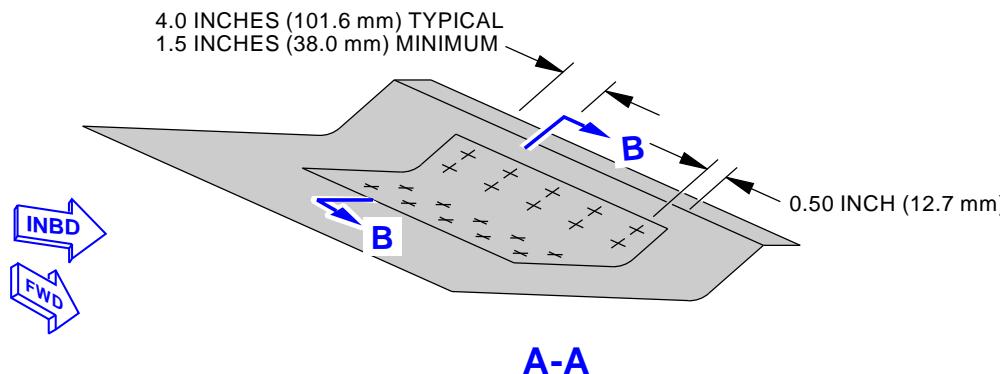
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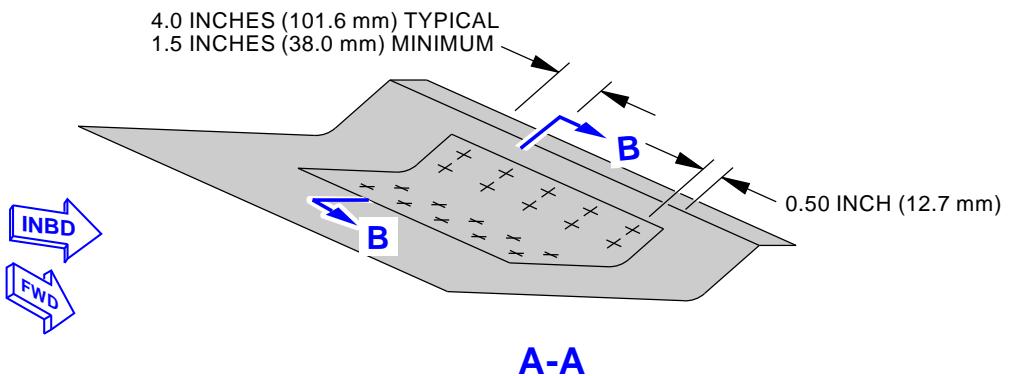
Cargo Compartment Ceiling Shroud
Figure 802/25-52-01-990-805 (Sheet 2 of 4)

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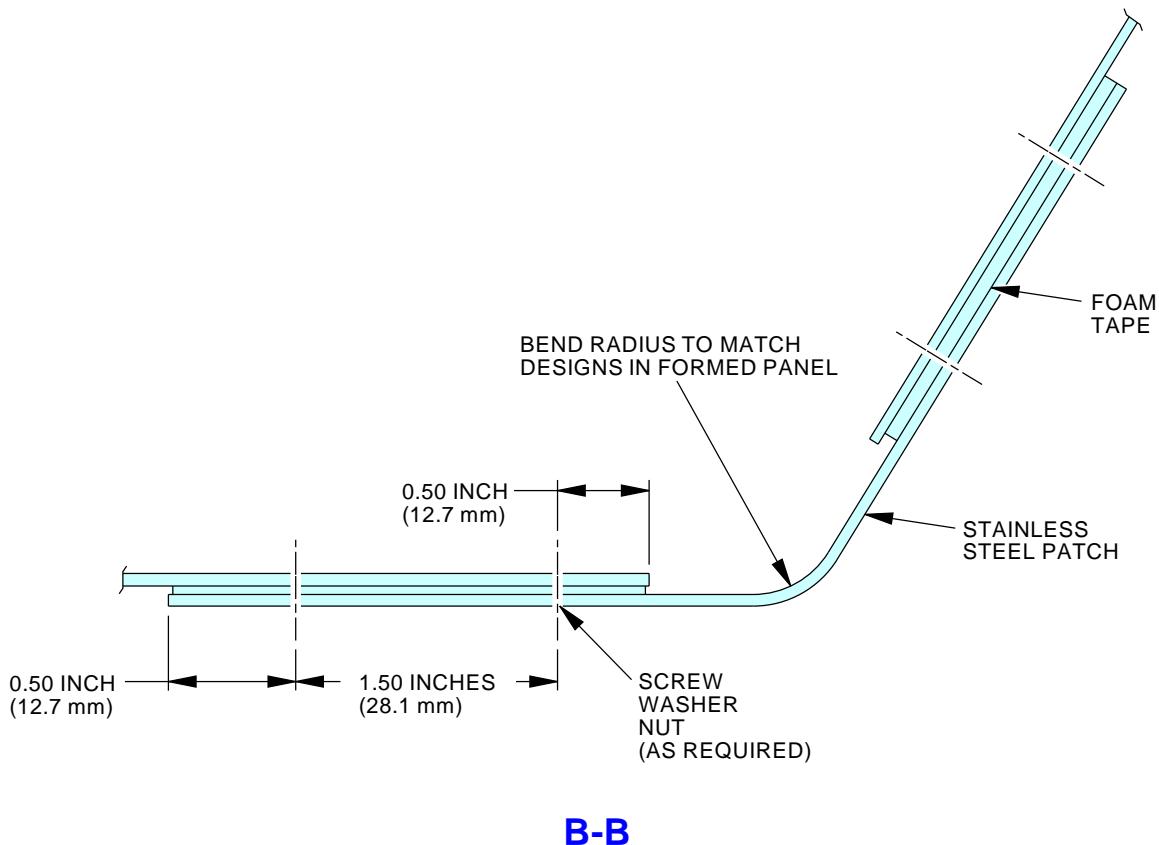
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A-A



B-B

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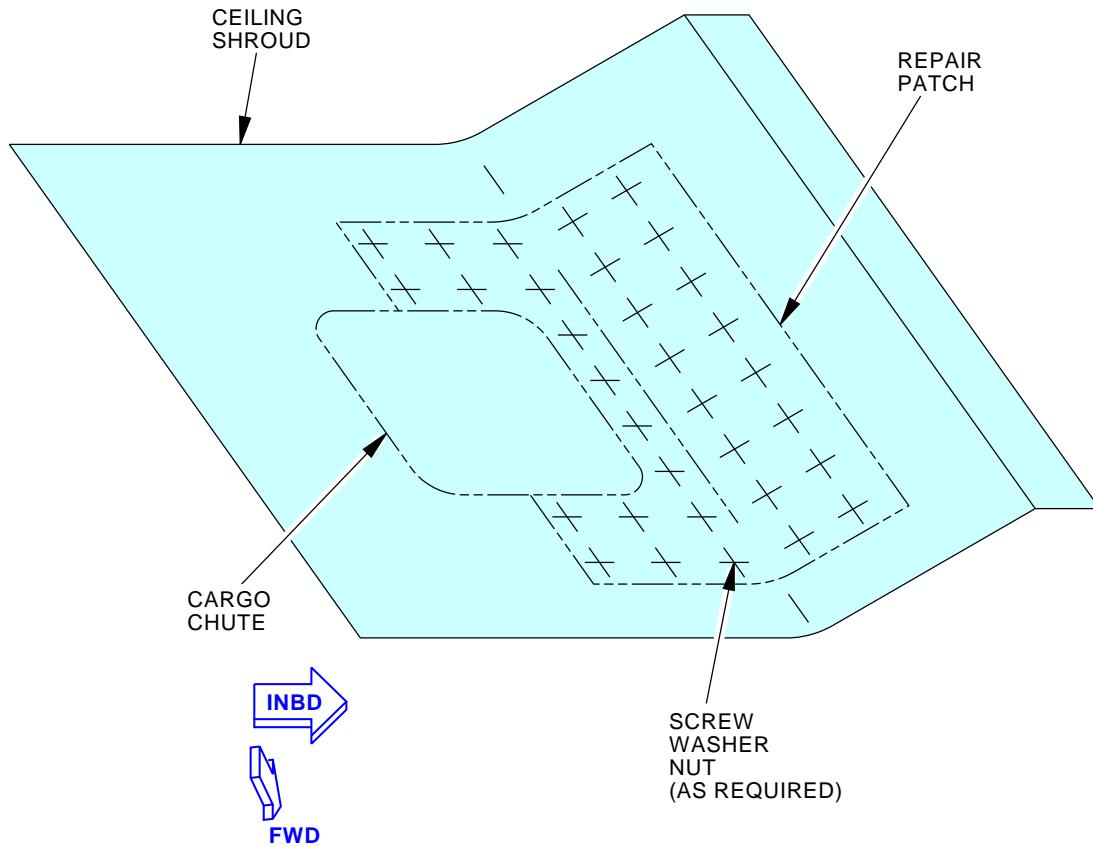
Cargo Compartment Ceiling Shroud
Figure 802/25-52-01-990-805 (Sheet 3 of 4)

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Cargo Compartment Ceiling Shroud
Figure 802/25-52-01-990-805 (Sheet 4 of 4)

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TASK 25-52-01-300-806

6. Neoprene Coated Cargo Liner Repair

A. General

- (1) This task gives instructions to repair the neoprene-coated fiberglass liners in the lower lobe cargo compartments
- (2) There are two repair alternatives. It is only necessary to do one of the repairs that follow:
 - (a) Repair the neoprene-coated liners with mechanical fasteners.
 - (b) Repair the neoprene-coated liner with Lubricated Thread, G01498.
- (3) Liners designed for blow out if decompression occurs are not repairable and should be replaced.
- (4) Refer to this procedure for cargo liner damage limits: CARGO COMPARTMENT - INSPECTION/CHECK, PAGEBLOCK 25-52-00/601.

B. References

Reference	Title
25-52-00 P/B 601	CARGO COMPARTMENT - INSPECTION/CHECK
25-52-06-000-801	Cargo Compartment Sidewall Lining - Removal (P/B 401)
25-52-06-400-801	Cargo Compartment Sidewall Lining - Installation (P/B 401)
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)
25-52-16-000-801	Forward Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)
25-52-16-400-801	Forward Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)
25-52-17-000-801	Forward Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)
25-52-17-400-801	Forward Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward Bulkhead Liner - Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward Bulkhead Liner - Installation (P/B 401)
25-52-19-000-801	Aft Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)
25-52-19-400-801	Aft Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)
52-31-00 P/B 201	CARGO DOOR - MAINTENANCE PRACTICES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1979	Personnel Barrier Equipment - Main Deck Cargo Door, Barrier Assembly



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D. Consumable Materials

Reference	Description	Specification
A00016	Adhesive - Pressure Sensitive Film For Interior Non-Structural Bonding	BMS5-91
A50144	Adhesive - Neoprene (Fire Retardant)	BMS5-7 Type II
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
G01498	Thread - Fiberglass - 11002 BC18 Glass Lube	BAC5437
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223
G50740	Kit - Akro Fireguard AF 450 Soft Liner Repair Kit	

E. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

F. Prepare for the Repair

SUBTASK 25-52-01-010-005

- (1) Open the cargo door if it is necessary.
 - (a) To open the cargo door do the applicable task in this procedure: CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-31-00/201.

SUBTASK 25-52-01-410-002

WARNING: INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (2) Install the personnel barrier, SPL-1979 across the cargo door opening.

SUBTASK 25-52-01-210-007

- (3) Do a visual check to make sure the liner fasteners do not touch any adjacent systems behind the liners and that the liners do not sag.
 - (a) If the liner fasteners touch any adjacent system behind the liner or if the liner sags, do the applicable step to replace the liner:
 - 1) These are the tasks:
 - Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801
 - Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801
 - Forward Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-16-000-801
 - Forward Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-17-000-801
 - Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801

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Aft Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-19-000-801

G. Repair of the Neoprene-coated Liners with Mechanical Fasteners

SUBTASK 25-52-01-020-004

- (1) Remove the fasteners that attach the liner to the structure.

SUBTASK 25-52-01-020-005

- (2) To remove the liner do the applicable task:

- (a) Do this task: Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801
- (b) Do this task: Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801
- (c) Do this task: Forward Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-16-000-801
- (d) Do this task: Forward Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-17-000-801
- (e) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801
- (f) Do this task: Aft Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-19-000-801

SUBTASK 25-52-01-340-066

- (3) Make two fiberglass sheet, G02163 patches.

NOTE: The patch should make a minimum of a 2-inch overlap on the area that is not damaged. For example, the patch dimension that is necessary for a 1.5-inch diameter hole would be a 5.5-inch diameter.

SUBTASK 25-52-01-340-067

- (4) Clean all of the surfaces using alcohol, B00065 to remove the loose particles.

SUBTASK 25-52-01-340-068

- (5) Apply adhesive, A00016 or adhesive, A50144 to the back of the fiberglass patches.

SUBTASK 25-52-01-340-069

- (6) Put the fiberglass patches over the center of the damaged area on the front and the back of the liner.

SUBTASK 25-52-01-340-070

- (7) Apply pressure to the fiberglass patches to make sure there is a good bond.

NOTE: The patch has a smooth surface when there is a good, continuous bond.

SUBTASK 25-52-01-340-071

- (8) Do the steps that follow to permanently attach the fiberglass patches:

- (a) Install bolts, NAS603-5P or equivalent, washers, AN960JD10L, and nuts, MS21042L3, at a maximum of 2 inches apart and 0.5 inch from the edges of the fiberglass patches.
- (b) Make sure there is sufficient clearance between the bolts and the adjacent systems behind the panel.
- (c) Grind or cut the ends of the bolts smooth with the nuts to get sufficient clearance.

SUBTASK 25-52-01-420-006

- (9) To install the liner, do the applicable task:

- (a) Do this task: Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801
- (b) Do this task: Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801

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- (c) Do this task: Forward Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-16-400-801
- (d) Do this task: Forward Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-17-400-801
- (e) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-18-400-801
- (f) Do this task: Aft Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-19-400-801

SUBTASK 25-52-01-900-001

- (10) Replace the damaged panel if sufficient clearance is still not obtained.

H. Repair of the Neoprene-coated Fabric with Fiberglass Thread

SUBTASK 25-52-01-020-006

- (1) Remove the fasteners that attach the liner to the structure.

SUBTASK 25-52-01-020-007

- (2) To remove the liner, do the applicable task:
 - (a) Do this task: Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801
 - (b) Do this task: Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801
 - (c) Do this task: Forward Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-16-000-801
 - (d) Do this task: Forward Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-17-000-801
 - (e) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Removal, TASK 25-52-18-000-801
 - (f) Do this task: Aft Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-19-000-801

SUBTASK 25-52-01-340-072

- (3) Make a fiberglass sheet, G02163 patch.

NOTE: The patch should make a minimum of a 2-inch overlap on the area that is not damaged. For example, the patch dimension that is necessary for a 1.5-inch diameter hole would be a 5.5-inch diameter.

SUBTASK 25-52-01-340-073

- (4) Clean all of the surfaces using alcohol, B00065 to remove the loose particles.

SUBTASK 25-52-01-340-074

- (5) Apply adhesive, A00016 or adhesive, A50144 to the back of the patch.

SUBTASK 25-52-01-340-075

- (6) Put the patch over the center of the damaged area on the front of the liner.

SUBTASK 25-52-01-340-076

- (7) Apply pressure to the patch to make sure there is a good bond.

NOTE: The patch has a smooth surface when there is a good, continuous bond.

SUBTASK 25-52-01-340-077

- (8) Use Lubricated Thread, G01498 to stitch two lines around the edge of the patch.

NOTE: There should be seven, plus or minus one, stitches for each inch.

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SUBTASK 25-52-01-420-007

WARNING: SEAL THE CARGO COMPARTMENT WITH THE LINING. OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE WHEN YOU INSTALL THE LINING. IF YOU INSTALL THE LINING INCORRECTLY, THE FIRE EXTINGUISHING AGENT OR SMOKE CAN CAUSE INJURIES.

- (9) To install the liner, do the applicable task:
- (a) Do this task: Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801
 - (b) Do this task: Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801
 - (c) Do this task: Forward Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-16-400-801
 - (d) Do this task: Forward Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-17-400-801
 - (e) Do this task: Aft Cargo Compartment Forward Bulkhead Liner - Installation, TASK 25-52-18-400-801
 - (f) Do this task: Aft Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-19-400-801

I. The Akro Fireguard System

SUBTASK 25-52-01-300-015

- (1) Refer to the Akro Fireguard AF 450 Soft Liner Kit, G50740 instructions for the steps to apply this repair.

NOTE: The patch must make a minimum overlap of 2.0 in. (5.08 cm) on the area that is not damaged. For example, the minimum patch dimension that is necessary for a 1.5 in. (3.81 cm) diameter hole would be 5.5 in. (13.97 cm) diameter.

— END OF TASK —

TASK 25-52-01-300-807

7. Silicone Impregnated Liner Repair

A. General

- (1) This task is for the repair of silicone impregnated fabric which is used as the cargo door liners.

B. Consumable Materials

Reference	Description	Specification
G01498	Thread - Fiberglass - 11002 BC18 Glass Lube	BAC5437
G50591	Cloth - Silicone Coated Fiberglass (Bisco HT-101)	

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right



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D. Repair the Silicone Impregnated Liner

SUBTASK 25-52-01-300-001

- (1) Use Lubricated Thread, G01498 to stitch the tear together or stitch a patch of Bisco HT-101 cloth, G50591 on the damage.

NOTE: There should be seven, plus or minus one, stitches for each inch and a minimum material overlap of 1 inch.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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CARGO COMPARTMENT SIDEWALL LININGS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks.
 - (1) The removal of the sidewall liners in the cargo compartments.
 - (2) The installation of the sidewall liners in the cargo compartments.
- B. Replacement liners may be manufactured to pattern, using the old liner as a template for measuring the replacement liner. Use an approved liner material meeting the requirements of fabric, G00088 and sheet, G02163. Replacement liners shall be of the same type/gauge as the liner removed.

TASK 25-52-06-000-801

2. Cargo Compartment Sidewall Lining - Removal

(Figure 401)

A. References

Reference	Title
25-52-17-000-801	Forward Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)
25-52-19-000-801	Aft Cargo Compartment Aft Bulkhead Liner - Removal (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50788	Tape - Textile Hook And Loop Fasteners Tape (Polyester Hook & Polyester Loop)	BMS8-285 Type IV

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

D. Remove the Sidewall Lining

SUBTASK 25-52-06-010-001

- (1) If you will remove the liner that is adjacent to the aft bulkhead, then remove the aft bulkhead for access to some of the tape. To remove the aft bulkhead, do the applicable task.

These are the tasks:

Forward Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-17-000-801,
Aft Cargo Compartment Aft Bulkhead Liner - Removal, TASK 25-52-19-000-801.

SUBTASK 25-52-06-020-001

- (2) Remove and discard the Nitto P-629 tape, G50428 (BMS5-146) from the edges of the liner.

EFFECTIVITY
AKS ALL

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SUBTASK 25-52-06-020-005

- (3) Remove and discard the moisture barrier tape, G02304 (BMS8-346) from the edges of the liner that touch the floor panel.

SUBTASK 25-52-06-020-002

- (4) Remove the screws [3], and cap strips [8].

SUBTASK 25-52-06-020-003

- (5) Pull the panel [1] from the structure. It is attached in some locations with hook and loop fastener tape, G50788 [6].

————— END OF TASK ————

TASK 25-52-06-400-801

3. Cargo Compartment Sidewall Lining - Installation

(Figure 401)

A. References

Reference	Title
25-52-17-400-801	Forward Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)
25-52-19-400-801	Aft Cargo Compartment Aft Bulkhead Liner - Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50734	Tape - Flame Retardant Hi-Tak (Av-DEC - HI-TAK HT3935-7FR-XXX)	

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

D. Install the Sidewall Lining

SUBTASK 25-52-06-420-001

- (1) Examine the seal, G02186 [2] on the structure.

- (a) Replace the foam seals if they are damaged or missing.

NOTE: The foam seal must be continuous around all the edges of the opening for the liner.

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SUBTASK 25-52-06-430-001

- (2) Apply the HI-TAK Tape, G50734 on the floor structure under the sidewall panel if it is necessary.

SUBTASK 25-52-06-420-002

- (3) Put the panel [1] in its position.

SUBTASK 25-52-06-420-004

- (4) Apply the moisture barrier tape, G02304 over the panel edge that is on the floor structure.

NOTE: Use the cap strip to mark the position of the tape. One continuous strip is preferred. However a join in the moisture barrier tape is allowed. Make sure the join has a minimum 2 inch and a maximum 6 inch overlap.

- (a) Do not join or overlap the moisture barrier tape within 6 in. (15 cm) of any cap strip splice plate.

SUBTASK 25-52-06-420-003

- (5) Install the cap strips [8] and screws [3].

SUBTASK 25-52-06-110-001

CAUTION: DO NOT LET THE SOLVENT TOUCH PLASTICS, CONTROL CABLES, LUBRICATED AREAS, PLASTIC DECALS, OR PAINTED AREAS OR MARKINGS THAT ARE NOT SKYDROL RESISTANT. THE SOLVENT WILL DAMAGE THESE ITEMS.

- (6) Clean the areas where you will apply tape with solvent, B00083.

SUBTASK 25-52-06-160-001

WARNING: DO NOT PUT TAPE ON THE SMOKE DETECTOR TUBES OR THE FIRE EXTINGUISHER OUTLET TUBES. THE SMOKE DETECTOR AND THE FIRE EXTINGUISHER SYSTEM WILL NOT SENSE A FIRE IF THERE IS TAPE ON THE TUBE OR OUTLETS. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (7) Apply new Nitto P-629 tape, G50428 to all the joints, overlaps, and fasteners. Apply the tape with the minimum number of joints in it.

NOTE: Do not apply tape between the sidewall liner and the aft bulkhead liner. The tape at this joint should go from the sidewall liner to the structure behind the bulkhead liner. The bulkhead liner must be removed to apply tape to this joint. In both the forward and aft cargo compartments, the aft bulkhead does not need tape applied to its joints.

- (a) Make sure the tape is within shelf life limits for optimum tape adhesion.
(b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.
(c) If it necessary to use short pieces of Nitto P-629 tape, G50428, make a minimum overlap of 0.5 in. (12.7 mm).
(d) Push the Nitto P-629 tape, G50428 firmly to make sure there is a good bond.

NOTE: There is a good bond if the surface of the tape is smooth and does not have air bubbles.

SUBTASK 25-52-06-410-001

- (8) If you removed the aft bulkhead liner, then re-install it. To install it, do the applicable task.

These are the tasks:

Forward Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-17-400-801,

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Aft Cargo Compartment Aft Bulkhead Liner - Installation, TASK 25-52-19-400-801.

———— END OF TASK ——

———— EFFECTIVITY ——
AKS ALL

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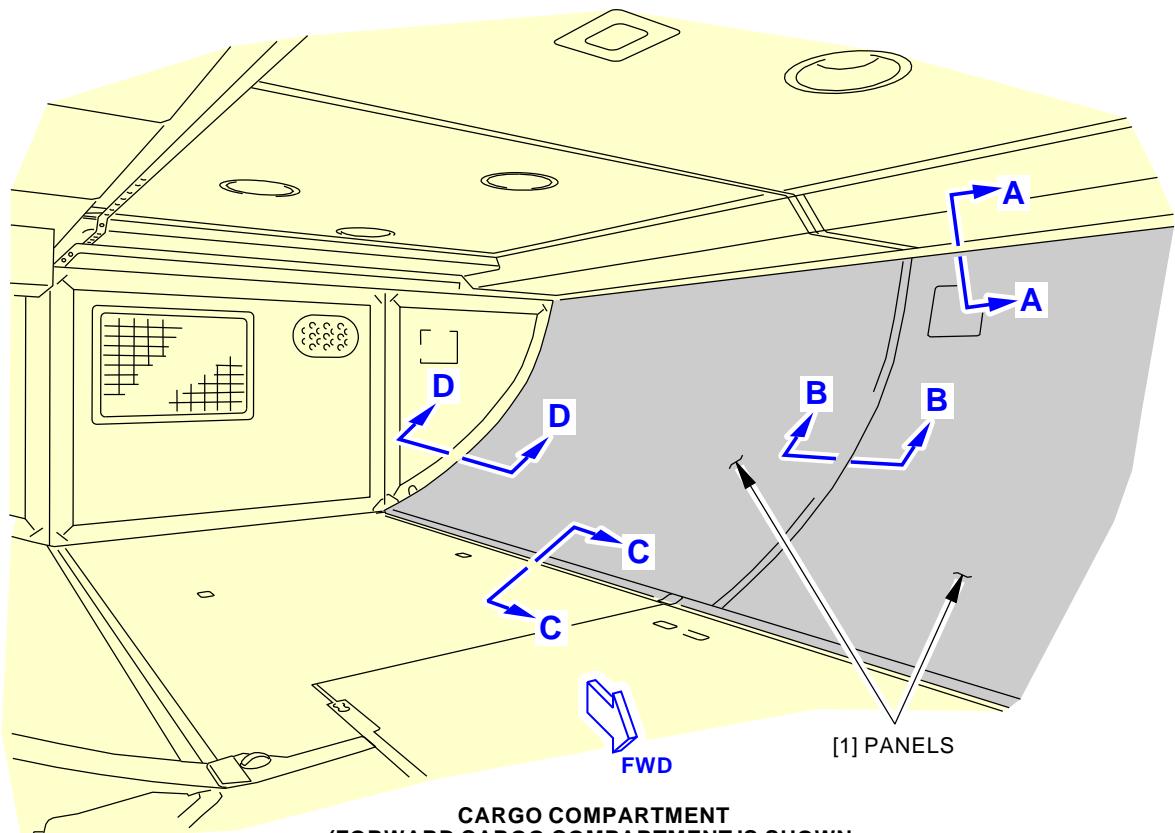
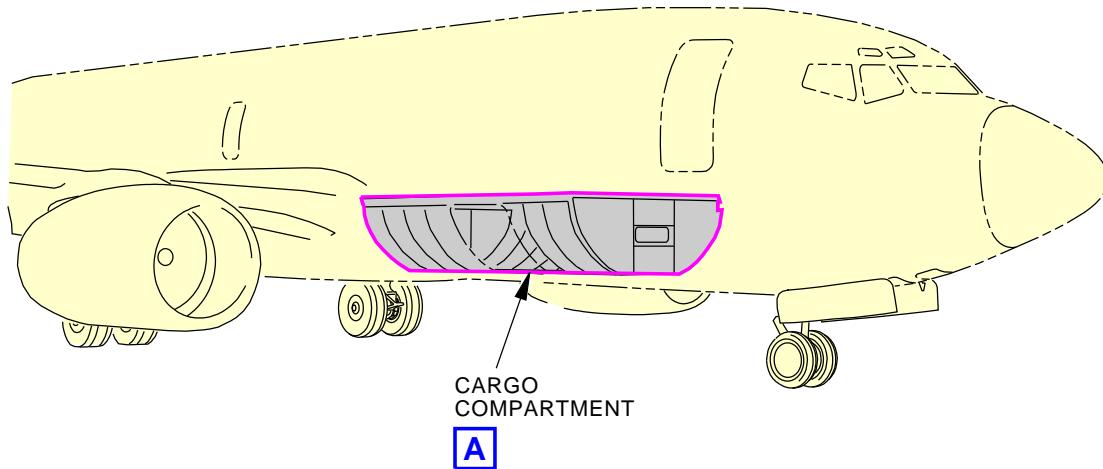
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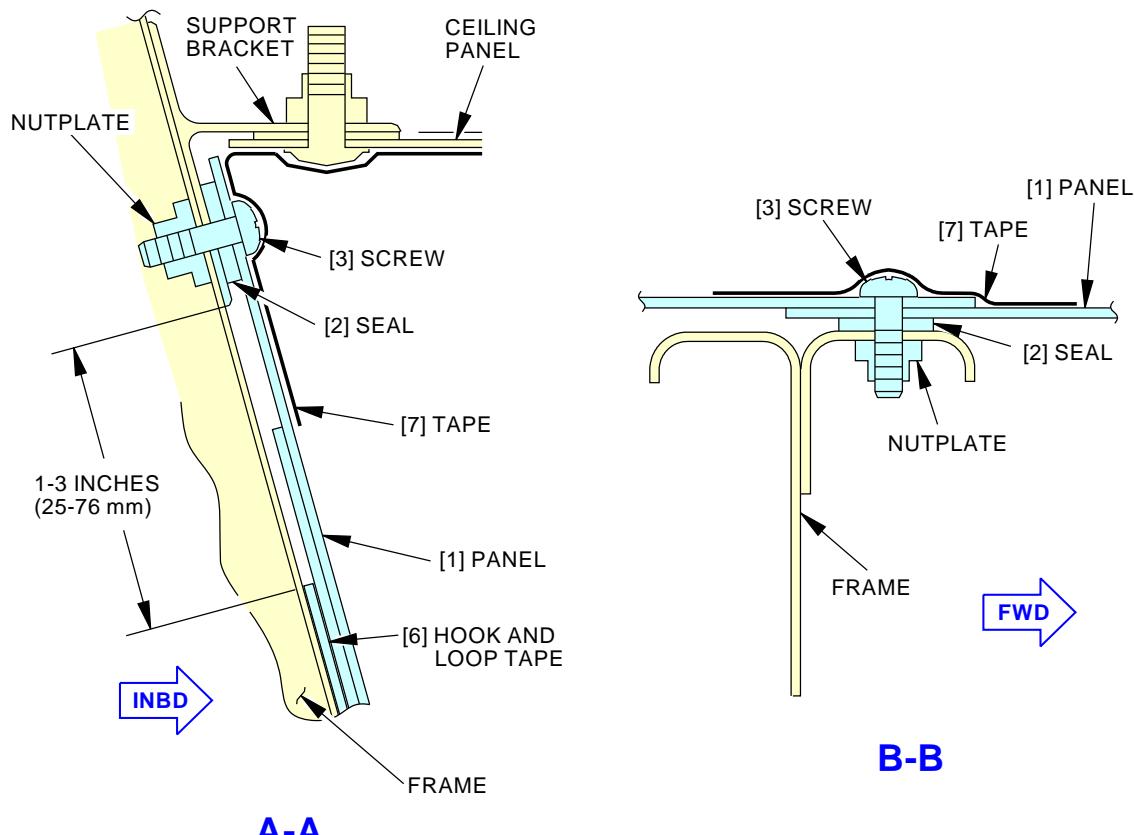
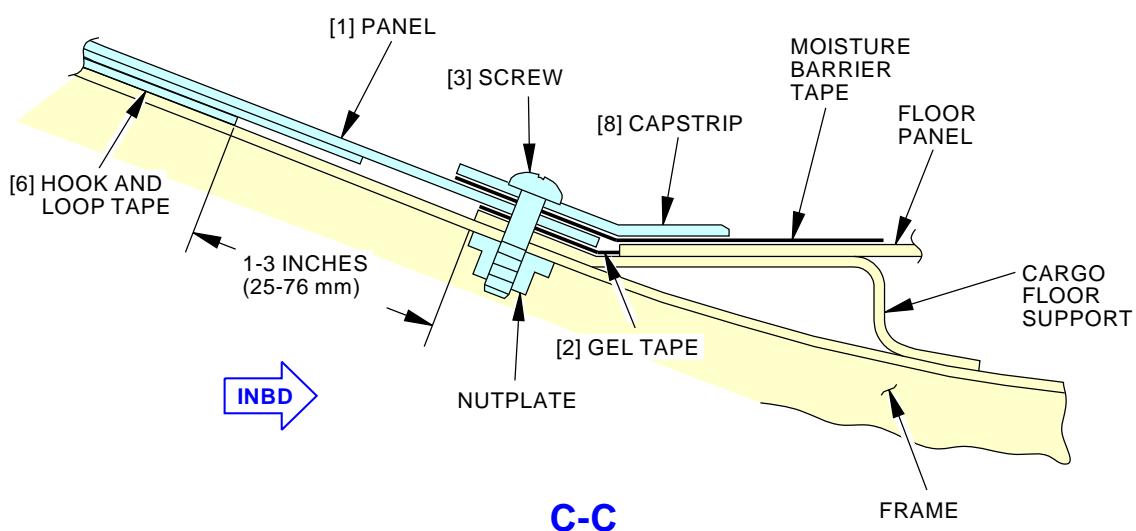
Cargo Compartment Sidewall Lining Installation
Figure 401/25-52-06-990-801 (Sheet 1 of 3)

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B-B


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Cargo Compartment Sidewall Lining Installation
Figure 401/25-52-06-990-801 (Sheet 2 of 3)

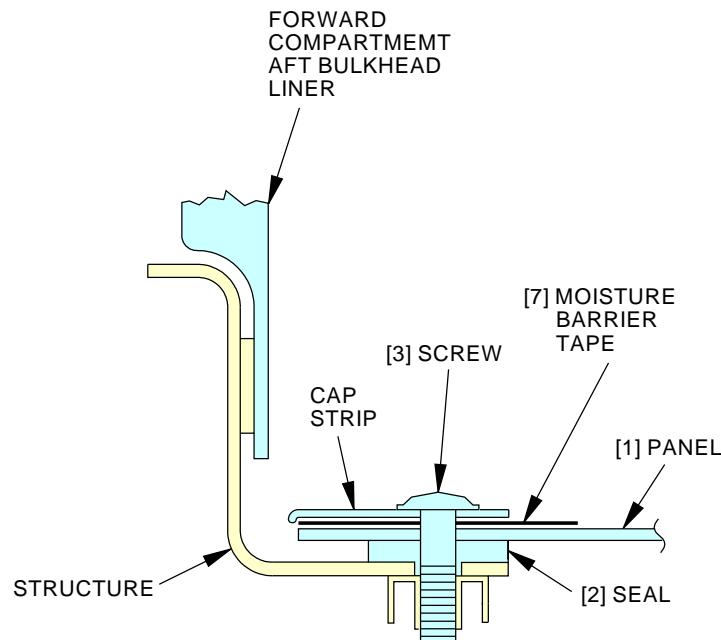
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Cargo Compartment Sidewall Lining Installation
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CARGO COMPARTMENT CEILING LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the ceiling liner from the forward or aft cargo compartment,
 - (2) An installation of the ceiling liner in the forward or aft cargo compartment.
- B. This procedure refers to the ceiling liners in the forward, aft, and bulk cargo compartments as the liners.

TASK 25-52-09-000-801

2. Cargo Compartment Ceiling Liner - Removal

(Figure 401)

A. References

Reference	Title
21-32-05-000-801	Ceiling Blowout Panel Removal (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50788	Tape - Textile Hook And Loop Fasteners Tape (Polyester Hook & Polyester Loop)	BMS8-285 Type IV

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. Remove the ceiling lining

SUBTASK 25-52-09-020-001

- (1) Remove and discard the Nitto P-629 tape, G50428 from around the edges of the liner.

SUBTASK 25-52-09-020-006

- (2) Do this task: Ceiling Blowout Panel Removal, TASK 21-32-05-000-801.

SUBTASK 25-52-09-020-002

- (3) Do the steps that follow to remove these parts from the liner:

- (a) Remove the Screws [7] that attach the Net Fitting Shroud [6] to the liner and remove the Net Fitting Shroud [6].
- (b) Remove the Screws [4] that attach the Ring [5] for the ceiling light to the liner and remove the Ring [5].
- (c) Remove the screws that attach the smoke detector screen to the liner and remove the screen.

SUBTASK 25-52-09-020-003

- (4) Remove the screws that hold the Ceiling Liner [1] to the support structure.

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SUBTASK 25-52-09-020-005

- (5) Carefully move apart the hook and loop fastener tape, G50788 (BMS 8-285) from the upper surface of the Ceiling Liner [1].

SUBTASK 25-52-09-020-004

- (6) Remove the Ceiling Liner [1].

———— END OF TASK ——

EFFECTIVITY
AKS ALL

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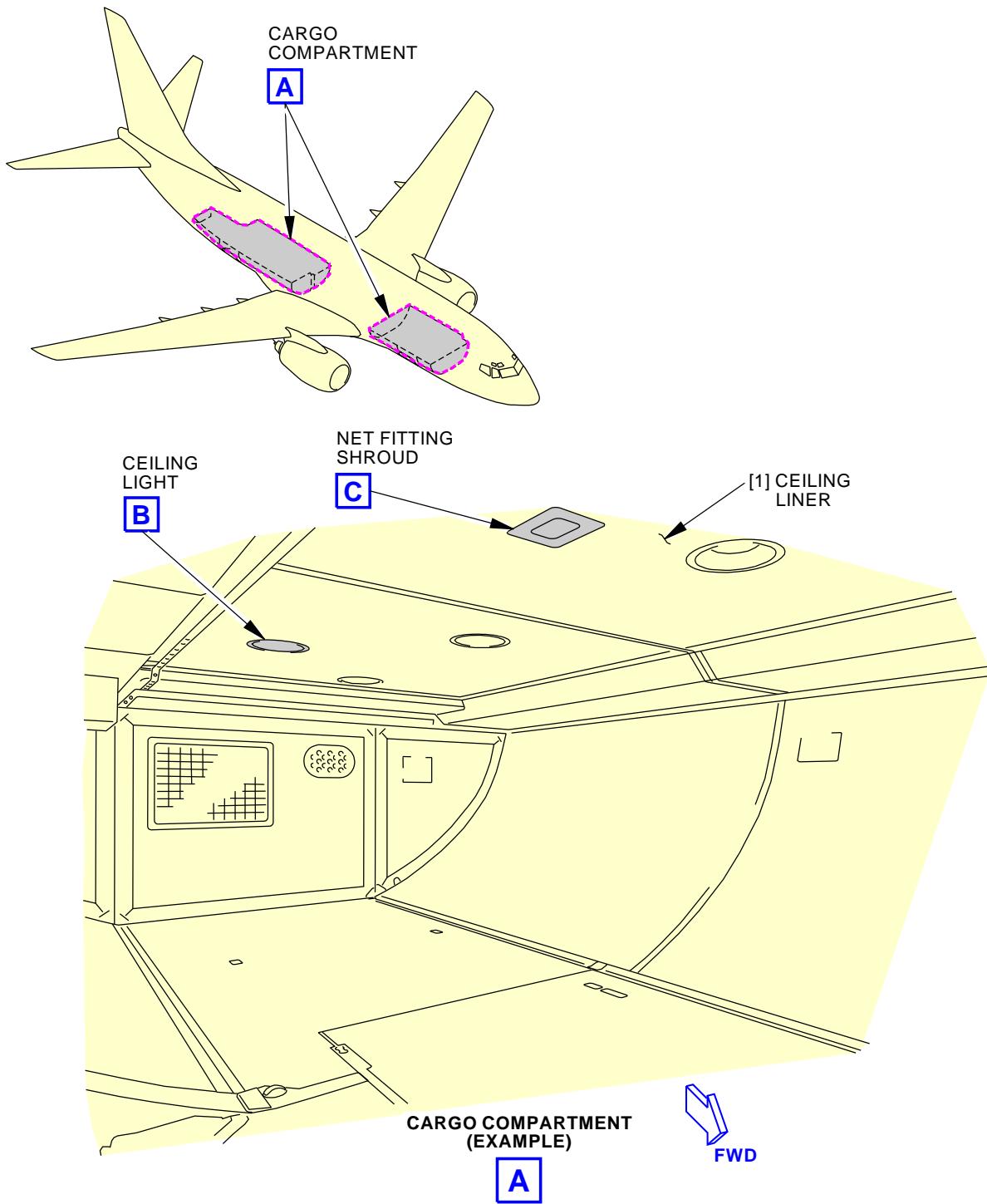
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Ceiling Liner Installation
Figure 401/25-52-09-990-801 (Sheet 1 of 2)

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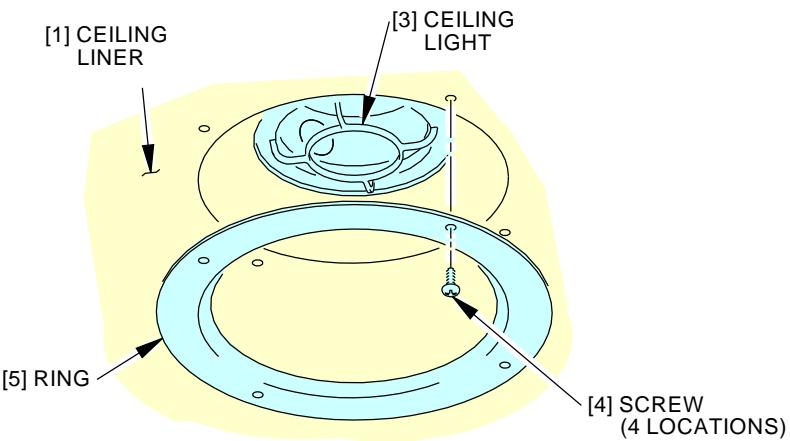
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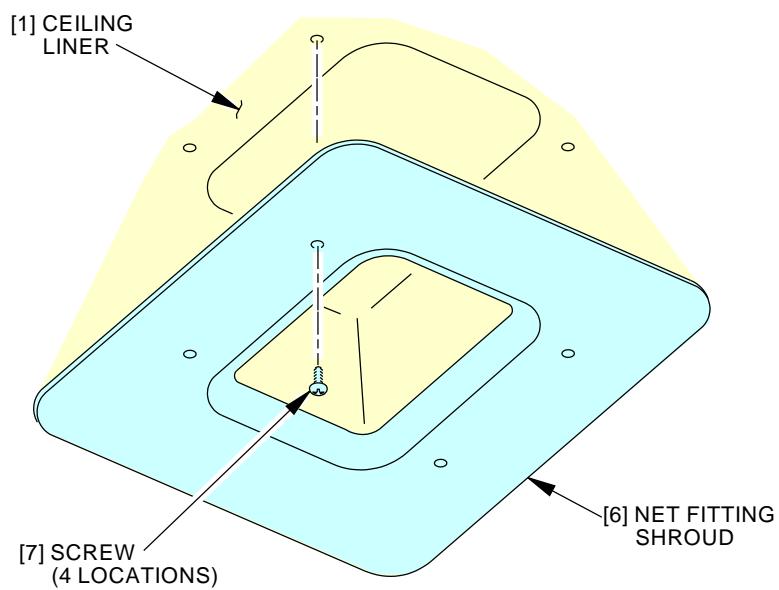


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CEILING LIGHT

B



NET FITTING SHROUD

C

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Ceiling Liner Installation
Figure 401/25-52-09-990-801 (Sheet 2 of 2)

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TASK 25-52-09-400-801

3. Cargo Compartment Ceiling Liner - Installation

(Figure 401)

A. References

Reference	Title
21-32-05-400-801	Ceiling Blowout Panel Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III
G02361	Tape - Cargo Lining Joint Seal	BMS5-146
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50788	Tape - Textile Hook And Loop Fasteners Tape (Polyester Hook & Polyester Loop)	BMS8-285 Type IV

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. Ceiling Liner Installation

SUBTASK 25-52-09-210-001

- (1) Examine the seal, G02186 between the Ceiling Liner [1] and the support structure.

SUBTASK 25-52-09-960-001

- (2) Replace the rubber seals if it is necessary.

NOTE: If a replacement liner is being installed, make sure all placards, such as smoke detector placards, are installed.

SUBTASK 25-52-09-420-001

- (3) Put the Ceiling Liner [1] in its position.

SUBTASK 25-52-09-430-001

- (4) Put pressure on the Ceiling Liner [1] in the areas of the hook and loop fastener tape, G50788 to make sure it is fully attached.

SUBTASK 25-52-09-420-002

- (5) Install the screws to attach the Ceiling Liner [1] to the support structure.

SUBTASK 25-52-09-420-003

- (6) Do the applicable steps that follow to attach the other parts that you removed:

- (a) Put the Ring [5] for the light in its position and install the Screws [4] that attach it to the ceiling light.
(b) Put the Net Fitting Shroud [6] in its position and install its Screws [7].

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SUBTASK 25-52-09-420-005

- (7) Do this task: Ceiling Blowout Panel Installation, TASK 21-32-05-400-801.

SUBTASK 25-52-09-110-001

CAUTION: DO NOT LET THE SOLVENT TOUCH PLASTICS, CONTROL CABLES, LUBRICATED AREAS, PLASTIC DECALS, OR PAINTED AREAS OR MARKINGS THAT ARE NOT SKYDROL RESISTANT. THE SOLVENT WILL DAMAGE THESE ITEMS.

- (8) Clean the areas where you will apply tape with solvent, B00083.

SUBTASK 25-52-09-420-004

WARNING: DO NOT PUT TAPE ON THE SMOKE DETECTOR TUBES OR THE FIRE EXTINGUISHER OUTLET TUBES. THE SMOKE DETECTOR AND THE FIRE EXTINGUISHER SYSTEM WILL NOT SENSE A FIRE IF THERE IS TAPE ON THE TUBE OR OUTLETS. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (9) Apply the new Nitto P-629 tape, G50428 on the screws and edges of the liners and the smoke detector shroud. Apply the tape with the minimum number of joints in it.

NOTE: Do not apply tape between the ceiling liner and the aft bulkhead liner. The tape at this joint should be only on the ceiling liner. In both the forward and aft cargo compartments, the aft bulkhead does not need tape applied to its joints.

NOTE: Do not apply the tape to the blowout panels or cap strips on the ceiling liner.

NOTE: Do not apply tape over installed placards. Applying tape over placards makes them illegible.

- (a) Make sure the tape is within shelf life limits for optimum tape adhesion.
- (b) Where possible, apply the tape to warm surfaces that are approximately 60°F (16°C) or higher, to help promote good adhesion.
- (c) If it is necessary to use short pieces of Nitto P-629 tape, G50428, make a minimum overlap of 0.50 in. (12.70 mm).
- (d) Push the tape, G02361 firmly to make sure there is a good bond.

NOTE: There is a good bond if the surface of the tape is smooth and does not have air bubbles.

- (e) Put the smoke detector screen into position and install with screws.

NOTE: It is not necessary to apply G50428 Nitto-629 tape over the smoke detector screen attach fasteners.

— END OF TASK —

EFFECTIVITY
AKS ALL

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CARGO FLOOR PANEL - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Cargo Floor Panel Removal,
 - (2) Cargo Floor Panel Installation.

TASK 25-52-10-000-801

2. **Cargo Floor Panel Removal**

(Figure 401)

A. **General**

- (1) This task is for the forward cargo compartment and the aft cargo compartment.

B. **Consumable Materials**

Reference	Description	Specification
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. **Location Zones**

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. **Floor Panel Removal**

SUBTASK 25-52-10-020-001

- (1) Remove the screws and bolts that attach the splice plates, cap strips, tiedowns, and floor panel to the support structure.

NOTE: The bolts in different locations are of different lengths. Make a note of the location of the bolts.

SUBTASK 25-52-10-020-005

- (2) Remove the moisture barrier tape, G02304 (BMS8-346) where the cargo sidewall liner meets the floor panel.

SUBTASK 25-52-10-020-002

- (3) Remove the floor panel.

————— END OF TASK —————

TASK 25-52-10-400-801

3. **Cargo Floor Panel - Installation**

(Figure 401)

A. **General**

- (1) This task is for the forward cargo compartment and the aft cargo compartment.

B. **Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

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(Continued)

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G50738	Tape - Flame Retardant Hi-Tak TufSeal, (Av-DEC - HI-TAK HT3000FR-XXX)	

C. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

D. Floor Panel Installation

SUBTASK 25-52-10-210-003

- (1) Make sure that there is no tape on the floor panel or on the airplane structure.

NOTE: The tape cannot be used again. You must replace the tape.

SUBTASK 25-52-10-960-001

- (2) To remove the tape do this step:

- (a) Use a plastic scraper and one of these materials solvent, B00184 (BMS11-7), solvent, B00666 (BMS11-9), or solvent, B00083, to remove any dirt, adhesive or grease from the floor panel or the airplane structure.

SUBTASK 25-52-10-960-002

- (3) To replace the Hi-Tak TufSeal Tape, G50738, do the steps that follow:

- (a) Remove the tape from the floor panel.
(b) Use a plastic scraper and one of these materials solvent, B00184 (BMS11-7), solvent, B00666 (BMS11-9), or solvent, B00083, to remove any dirt, adhesive or grease from the floor panel.
(c) Install the Hi-Tak TufSeal Tape, G50738, to cover the inboard gap between the cap strips.

SUBTASK 25-52-10-420-004

- (4) Apply corrosion inhibiting compound, G00009 (BMS3-23), to the airplane structure where you will install the floor panel.

SUBTASK 25-52-10-420-005

(Figure 402 and Figure 404)

- (5) Install the Hi-Tak TufSeal Tape, G50738, and the gasket to the airplane structure where you will install the floor panel.

NOTE: Gaskets come in many different dimensions. Make sure that you install the correct gasket for the applicable airplane structure.

NOTE: Tape that is 2 in. (51 mm) wide can be used where tape that is 3 in. (76 mm) wide would be excessive and the 2 in. (51 mm) would cover the structure.

- (a) Align the outboard edge of the gasket with the outboard edge of the support structure.

NOTE: The gasket can overhang the inboard edge of the support structure.

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- (b) Make sure that the protective backing is removed from the tape before you install the tape.
NOTE: Make sure that there is no overlap between gasket and tape.
- (c) If the gaskets are not available you can use multiple strips of Hi-Tak TufSeal Tape, G50738, to cover the equivalent area of the gasket.
 - 1) Make sure that individual strips or pieces of tape do not overlap at the edges to prevent high areas.
 - 2) Make sure that the space between each tape strip is 0.063 in. (1.600 mm) or less.
NOTE: This will make sure that the gel is in the space.

SUBTASK 25-52-10-420-008

- (6) Put the floor panel in its correct position.

SUBTASK 25-52-10-420-001

- (7) Apply sealant, A00247 (BMS5-95), on the screws and bolts and install the screws and bolts while the sealant is wet if it is necessary.

SUBTASK 25-52-10-420-007

(Figure 403 and Figure 405)

- (8) Apply the moisture barrier tape, G02304 (BMS8-346), on the part of the floor panel that touches the cargo sidewall liner.
 - (a) Center the moisture barrier tape under the cap strips.
NOTE: Use the cap strip and the measurements to mark the position.
 - (b) Make sure that the tape extends 1.5 in. (38.1 mm) to 2.5 in. (63.5 mm) past the centerline of the splice plate or cap strip.
NOTE: Do not connect or overlap the moisture barrier within 6 in. (152 mm) of the cap strip splice plates.
- (9) Use one continuous strip if possible but you can apply the moisture barrier tape, end to end, if necessary.
 - (a) Make sure that the join has an overlap of minimum 2 in. (51 mm) and a maximum of 6 in. (152 mm).

SUBTASK 25-52-10-820-002

- (10) Put the cap strips, two splice plates and tiedowns in the correct locations.

SUBTASK 25-52-10-420-003

- (11) Apply sealant, A00247 (BMS5-95), between the forward cargo bulkhead and floor panels under the cap strips.

SUBTASK 25-52-10-420-002

- (12) Apply sealant, A00247 (BMS5-95), on all areas of the floor panel that may permit leakage.

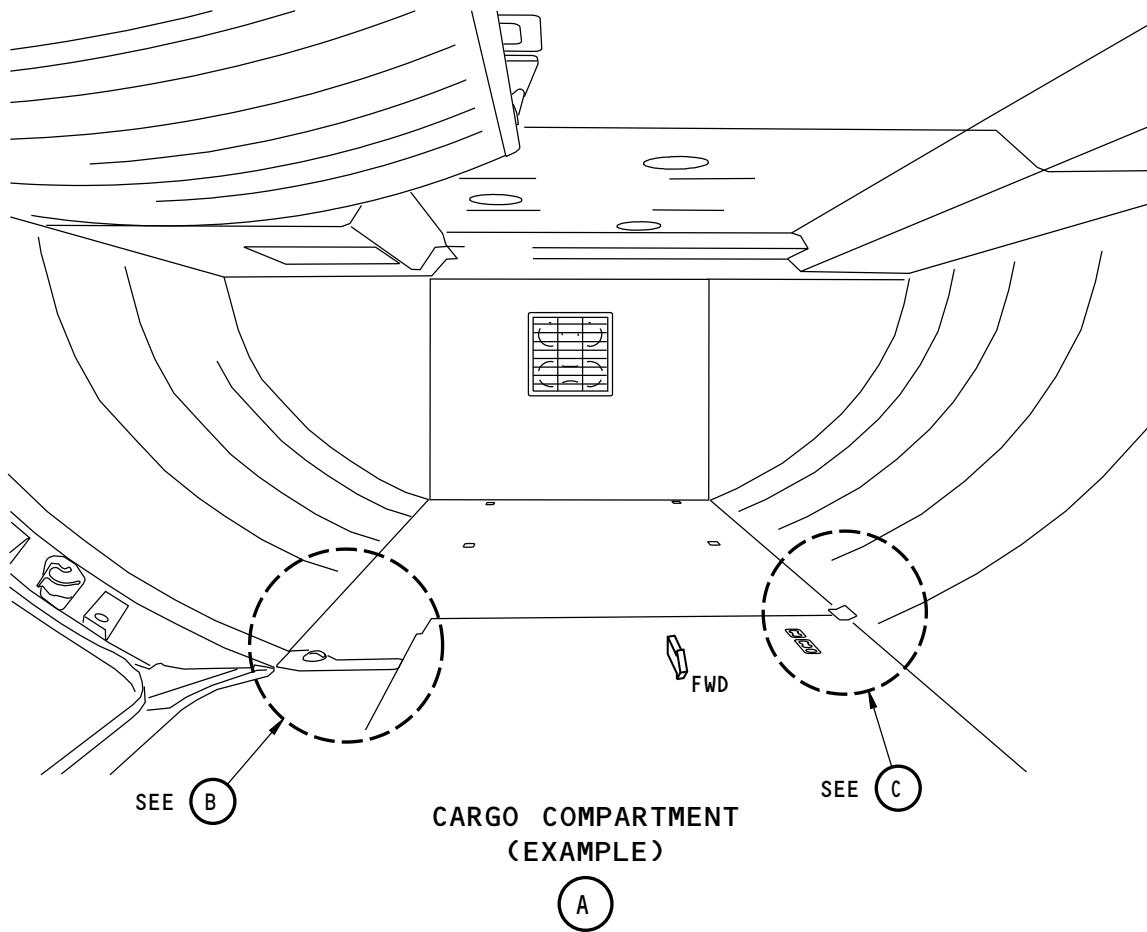
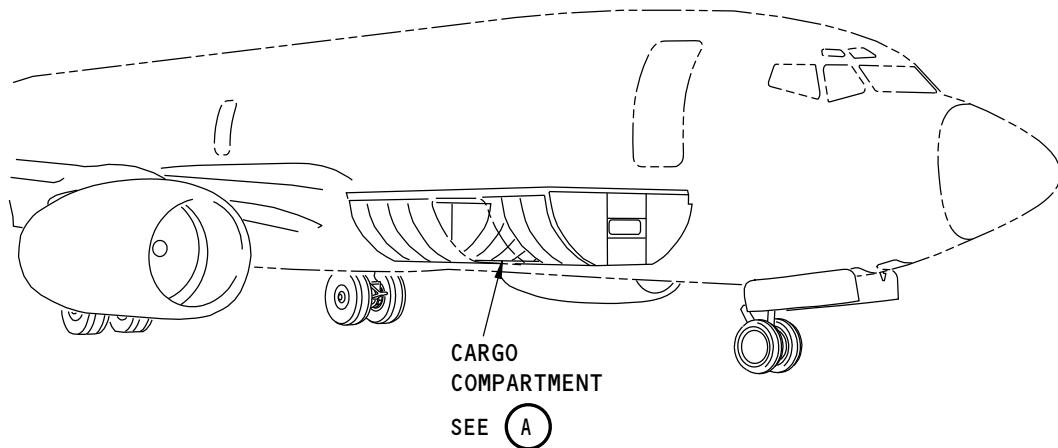
———— END OF TASK ———

EFFECTIVITY
AKS ALL

25-52-10



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AIRCRAFT MAINTENANCE MANUAL



G22262 S0006567714_V1

Floor Panels and Walkways Installation
Figure 401/25-52-10-990-801 (Sheet 1 of 3)

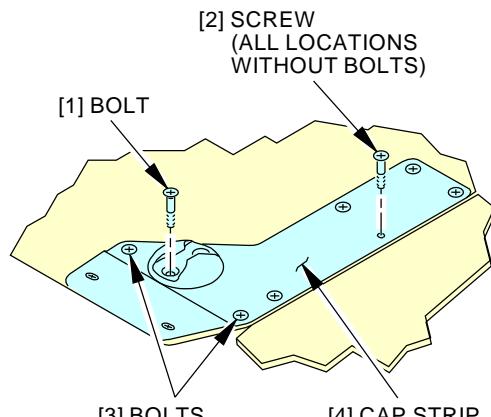
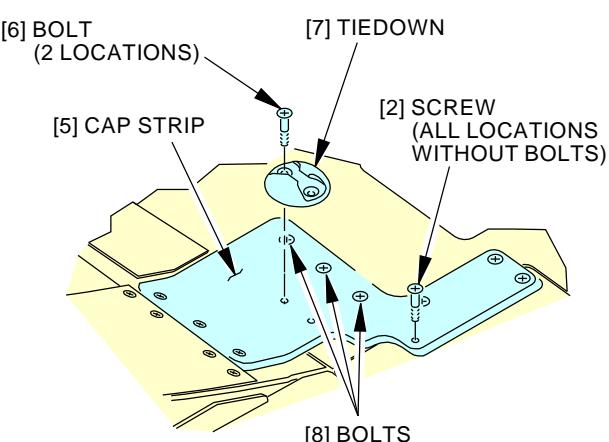
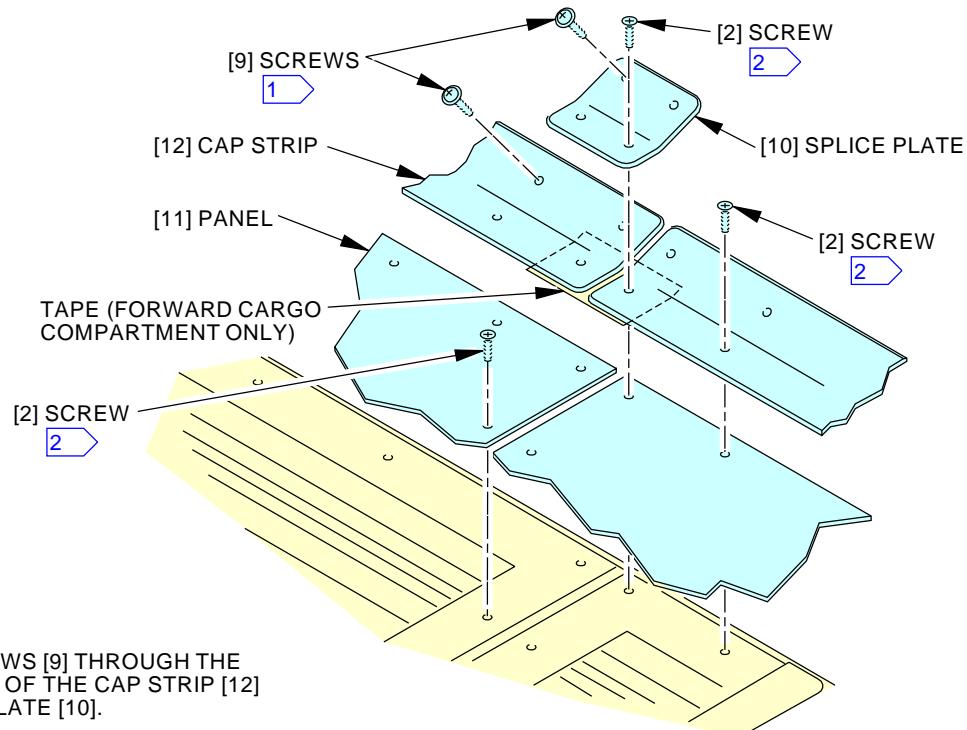
EFFECTIVITY
AKS ALL

25-52-10

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**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**

(FORWARD CARGO COMPARTMENT)

(AFT CARGO COMPARTMENT)
B
B

(EXAMPLE)
C

1 INSTALL SCREWS [9] THROUGH THE ANGLED PART OF THE CAP STRIP [12] AND SPLICE PLATE [10].

2 INSTALL THE SCREWS [2] IN ALL HOLES THAT ARE NOT SPECIFIED OTHERWISE.

D75336 S0000165023_V2

**Floor Panels and Walkways Installation
Figure 401/25-52-10-990-801 (Sheet 2 of 3)**

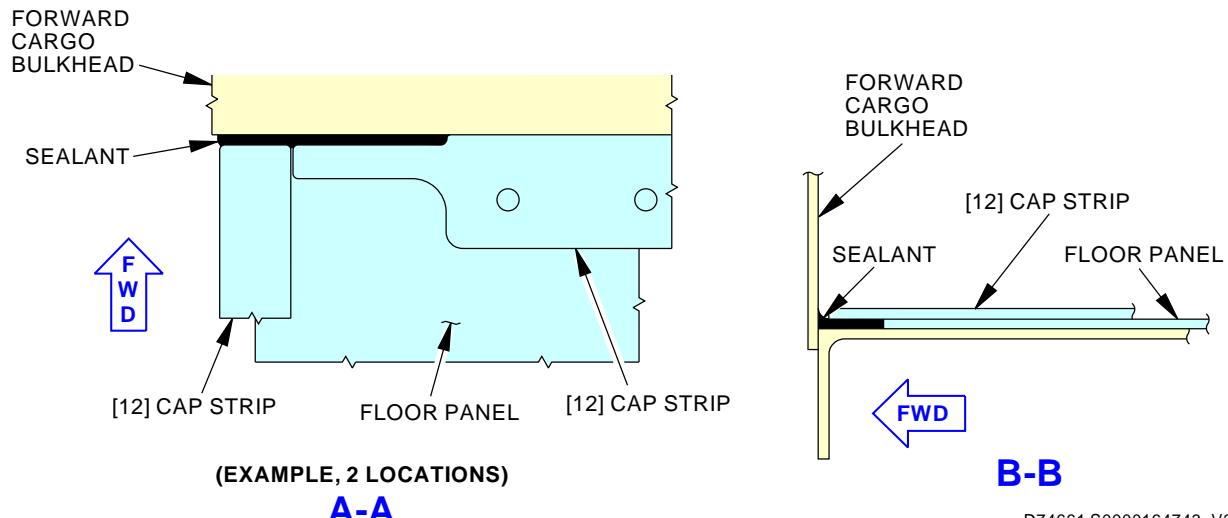
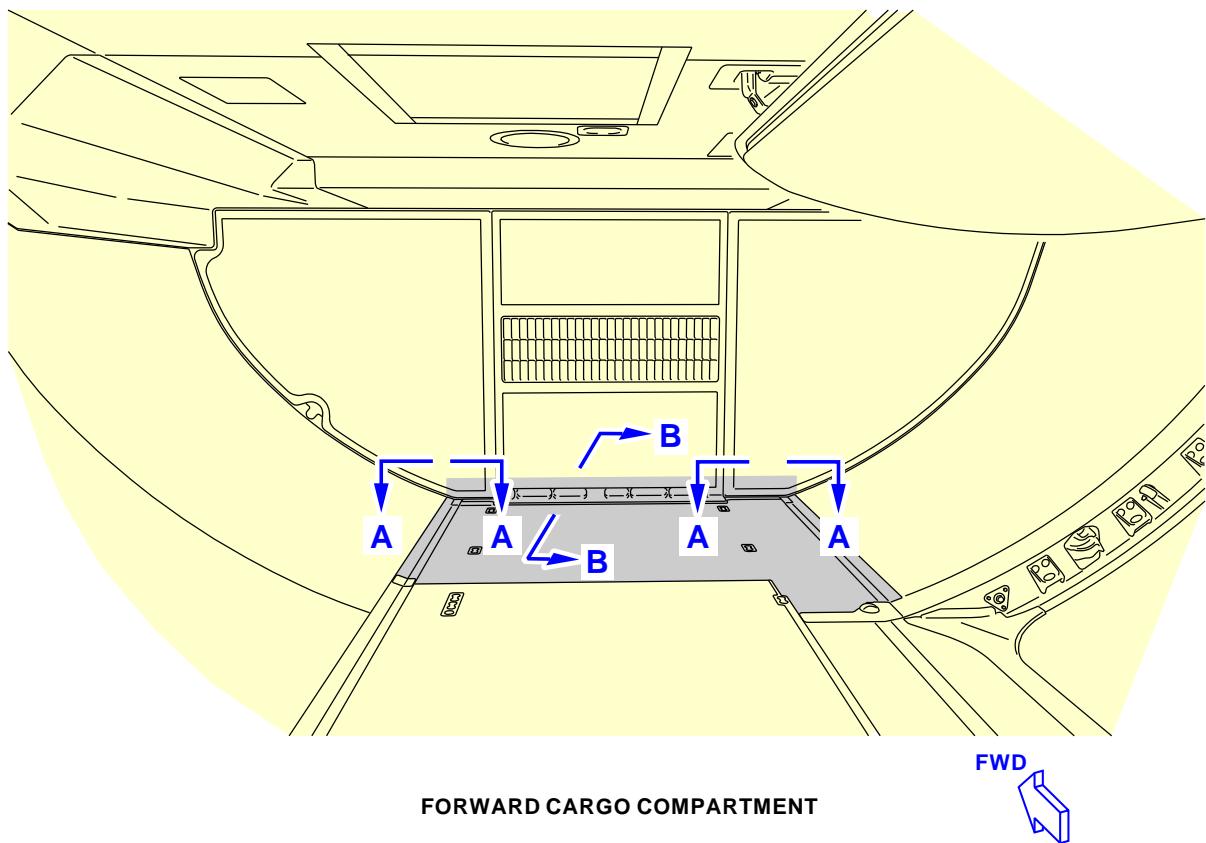
EFFECTIVITY
AKS ALL

25-52-10

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AIRCRAFT MAINTENANCE MANUAL

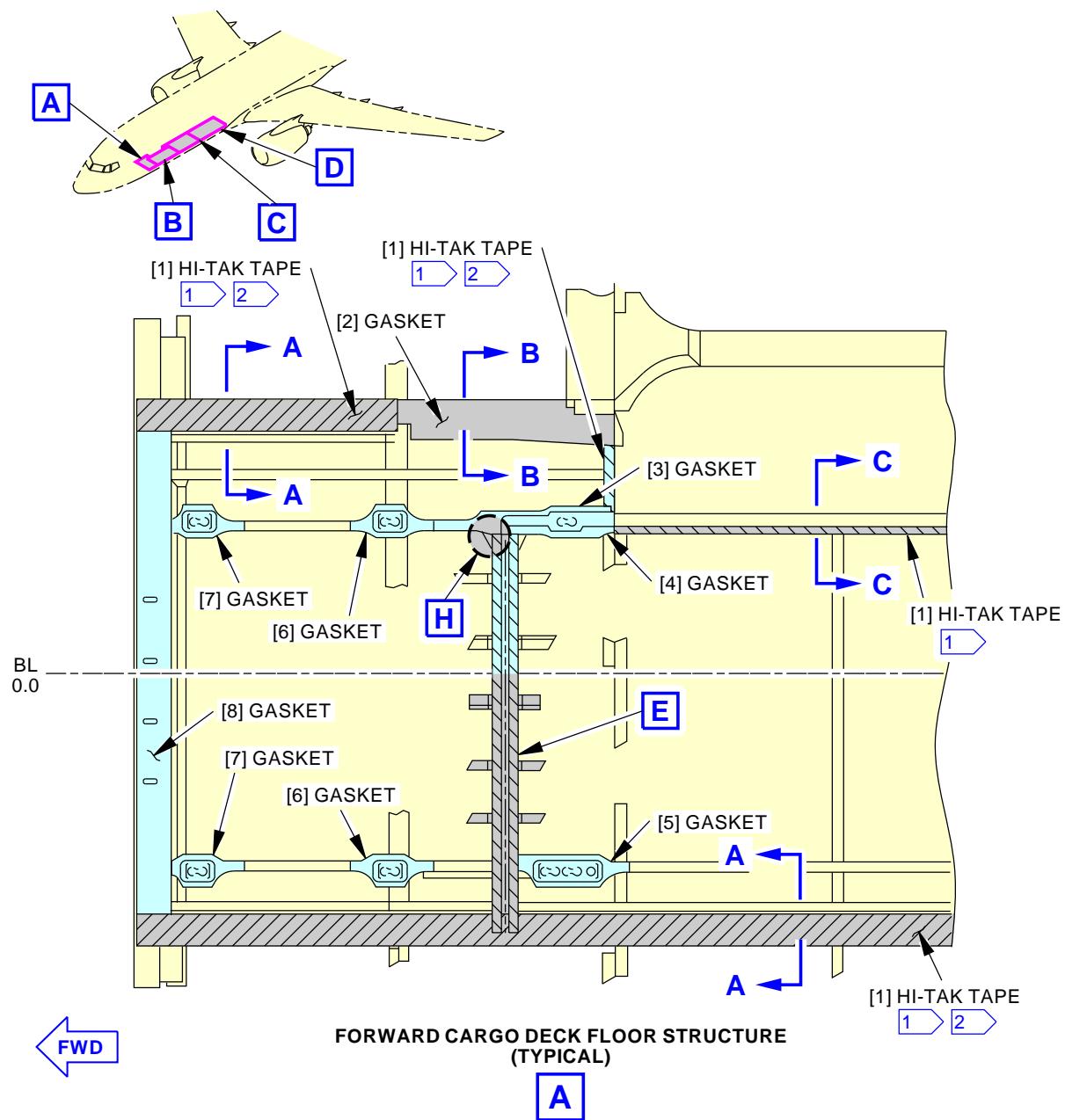


D74661 S0000164743_V2

Floor Panels and Walkways Installation
Figure 401/25-52-10-990-801 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

25-52-10



- 1 A CONTINUOUS STRIP IS PREFERRED. HOWEVER, A JOIN IN THE TAPE IS ALLOWED. MAKE SURE THERE ARE NO GAPS BETWEEN THE TAPE JOINTS. A MAXIMUM OF 0.25 INCH OVERLAP IS ALLOWED.
- 2 ALIGN THE EDGE OF THE TAPE WITH THE OUTBOARD EDGE OF THE SUPPORT STRUCTURE ALONG THE ENTIRE LENGTH OF THE FORWARD CARGO COMPARTMENT.

2304305 S0000522588_V2

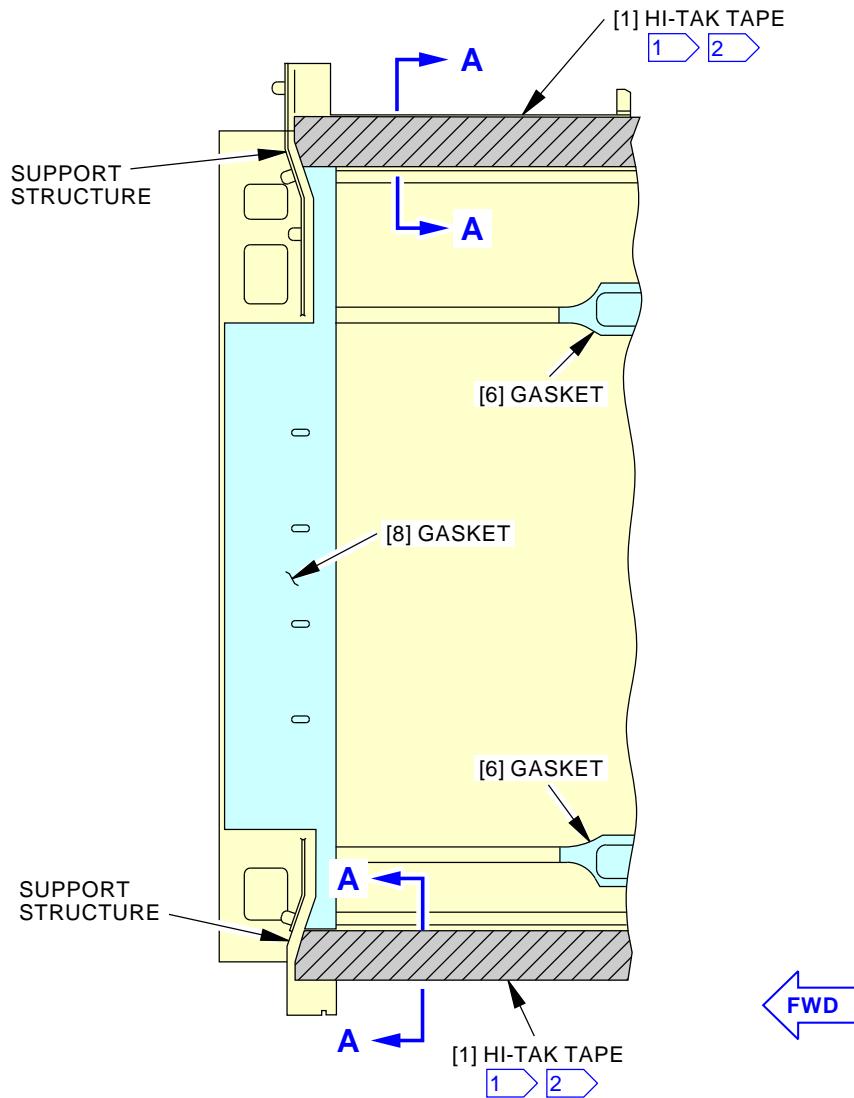
Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 1 of 12)

EFFECTIVITY
AKS ALL

25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



737-700C FORWARD CARGO DECK FLOOR STRUCTURE
(TYPICAL)

A

2304318 S0000522589_V2

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 2 of 12)

EFFECTIVITY
AKS ALL

25-52-10

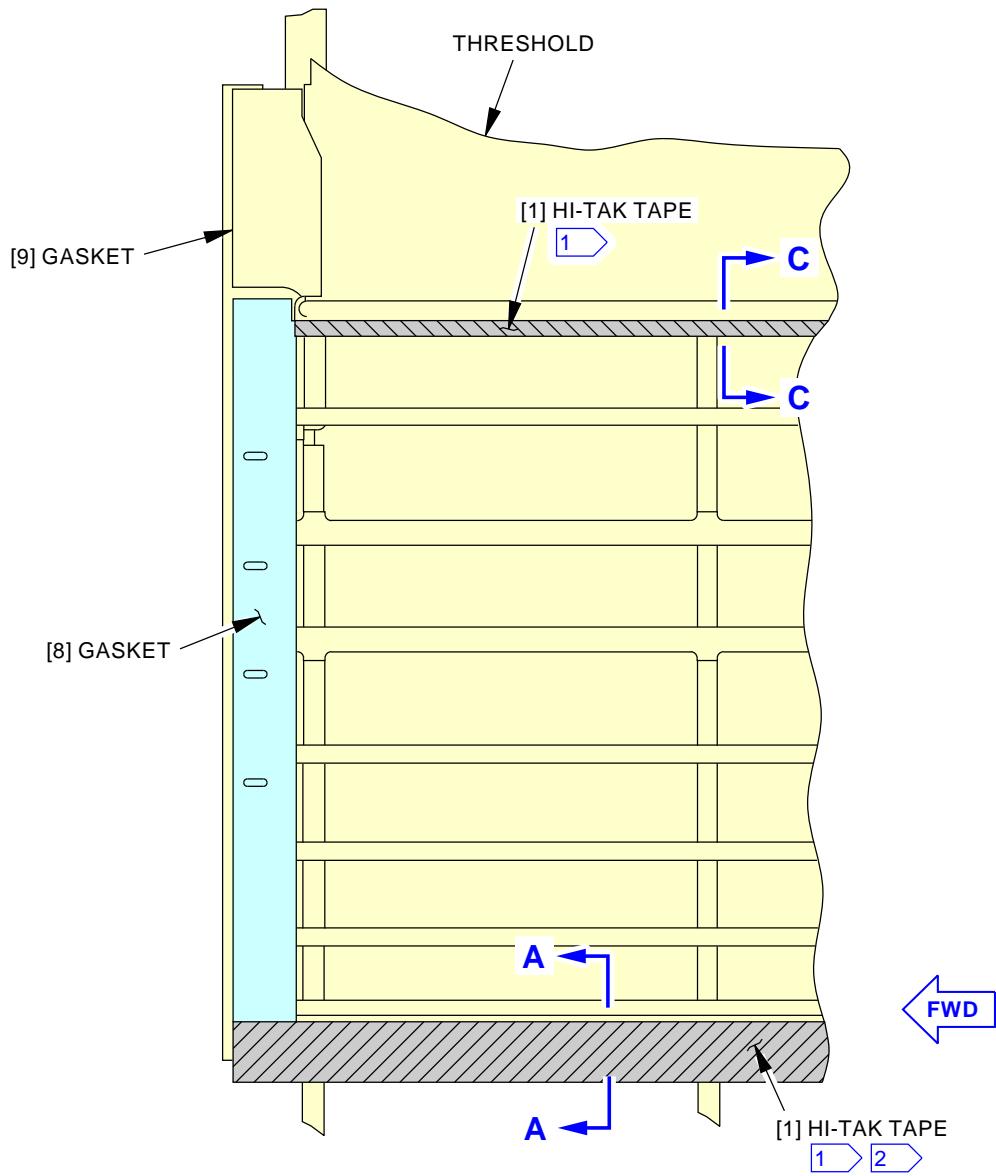
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737-600 FORWARD CARGO DECK FLOOR STRUCTURE
(TYPICAL)

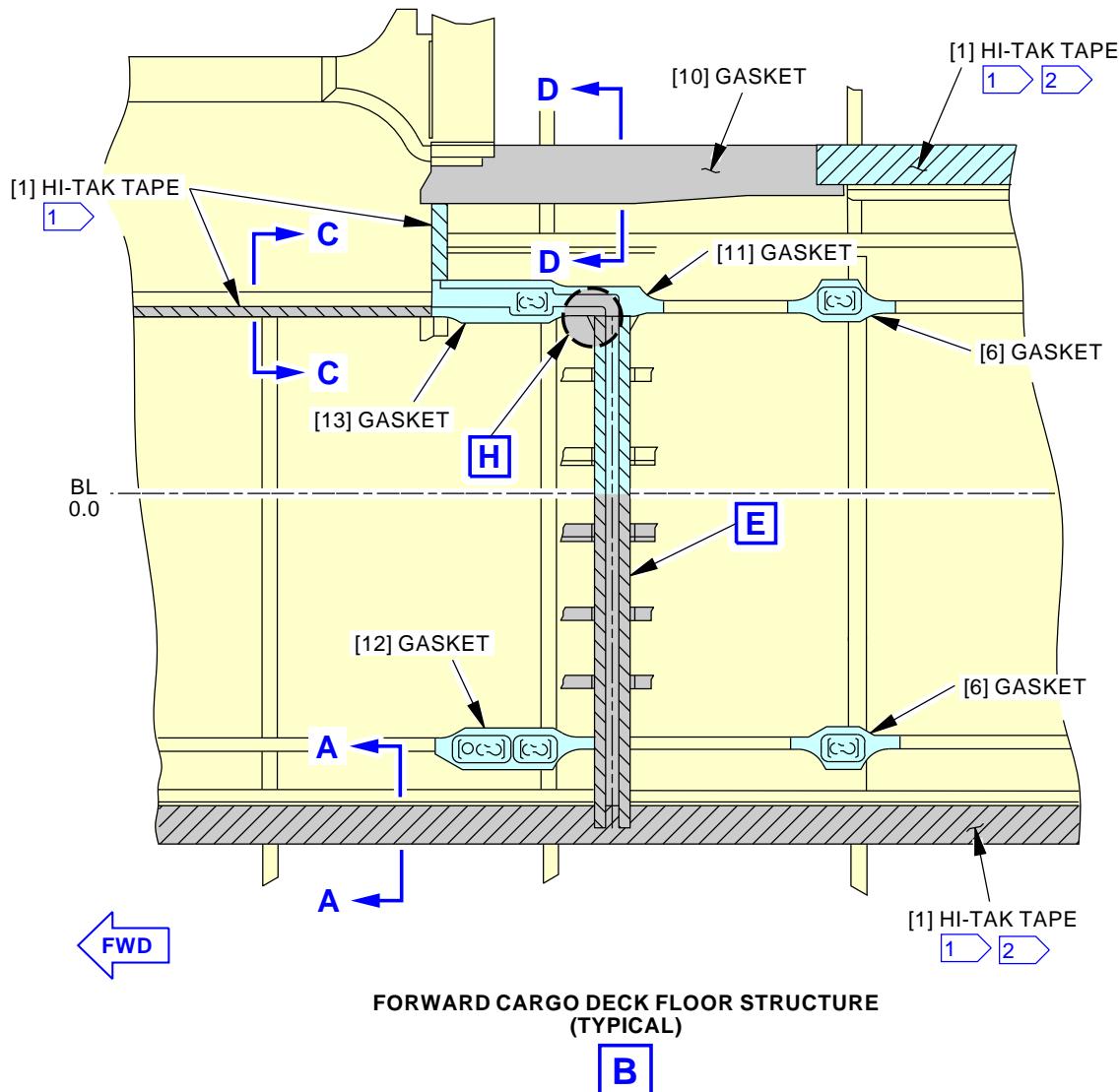
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2304324 S0000522590_V2

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 3 of 12)

EFFECTIVITY
AKS ALL

25-52-10

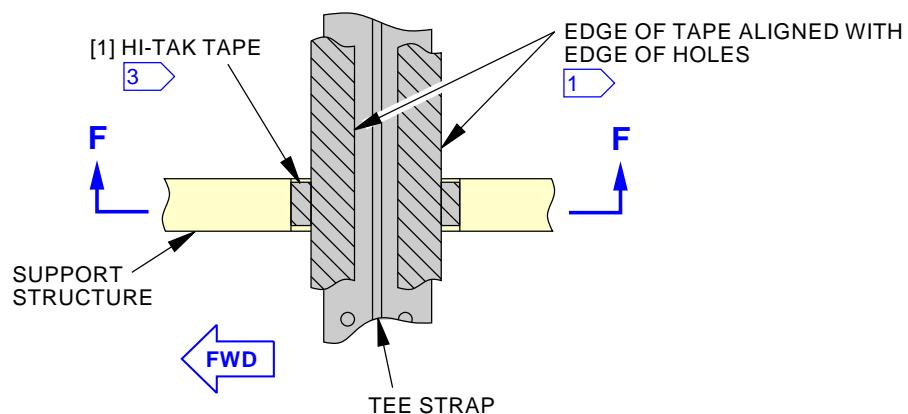
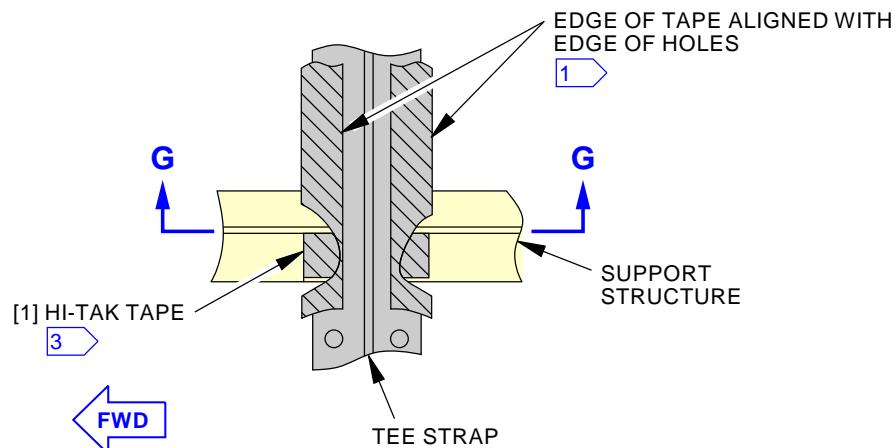


2304351 S0000522591_V2

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 4 of 12)

EFFECTIVITY
 AKS ALL

25-52-10


TEE STRAP WITH JOGGLE (TYPICAL)
F

TEE STRAP WITHOUT JOGGLE (TYPICAL)
F

- 3** LOCATE THE TAPE IN THE CENTER OF THE SUPPORT STRUCTURE.

2304418 S0000522596_V3

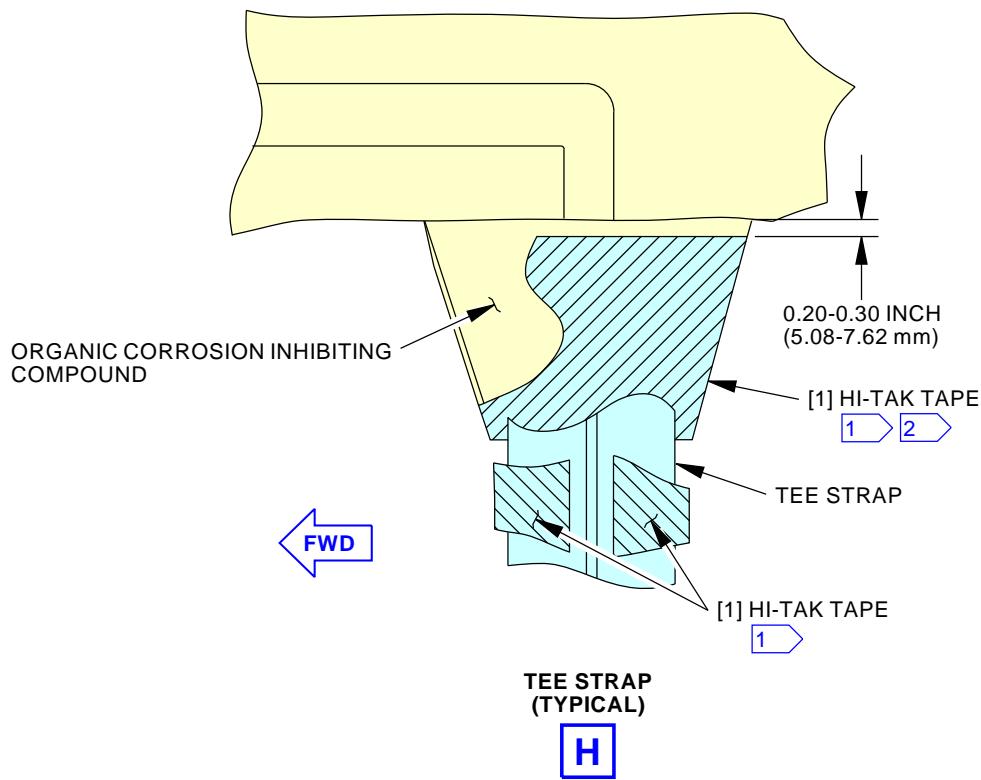
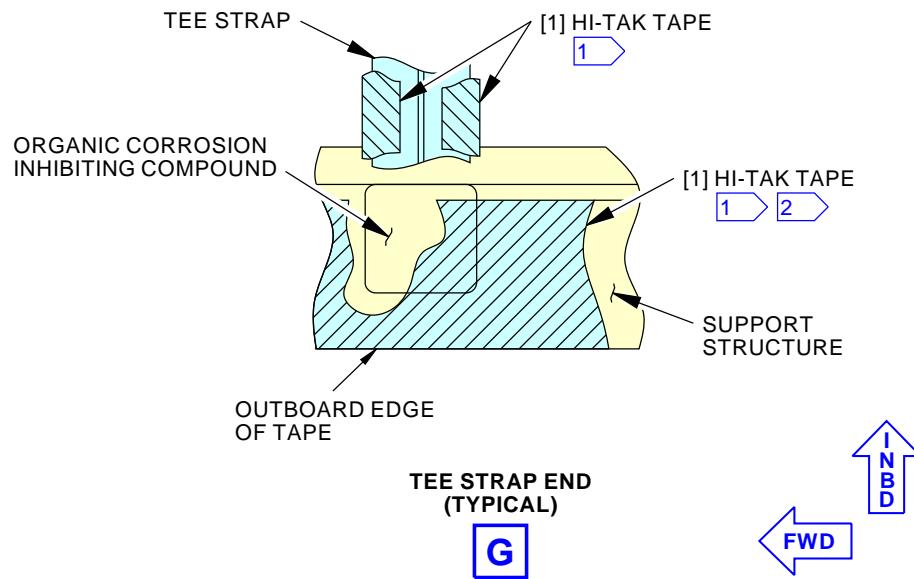
**Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 5 of 12)**

EFFECTIVITY
AKS ALL

25-52-10



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AIRCRAFT MAINTENANCE MANUAL



2304428 S0000522597_V3

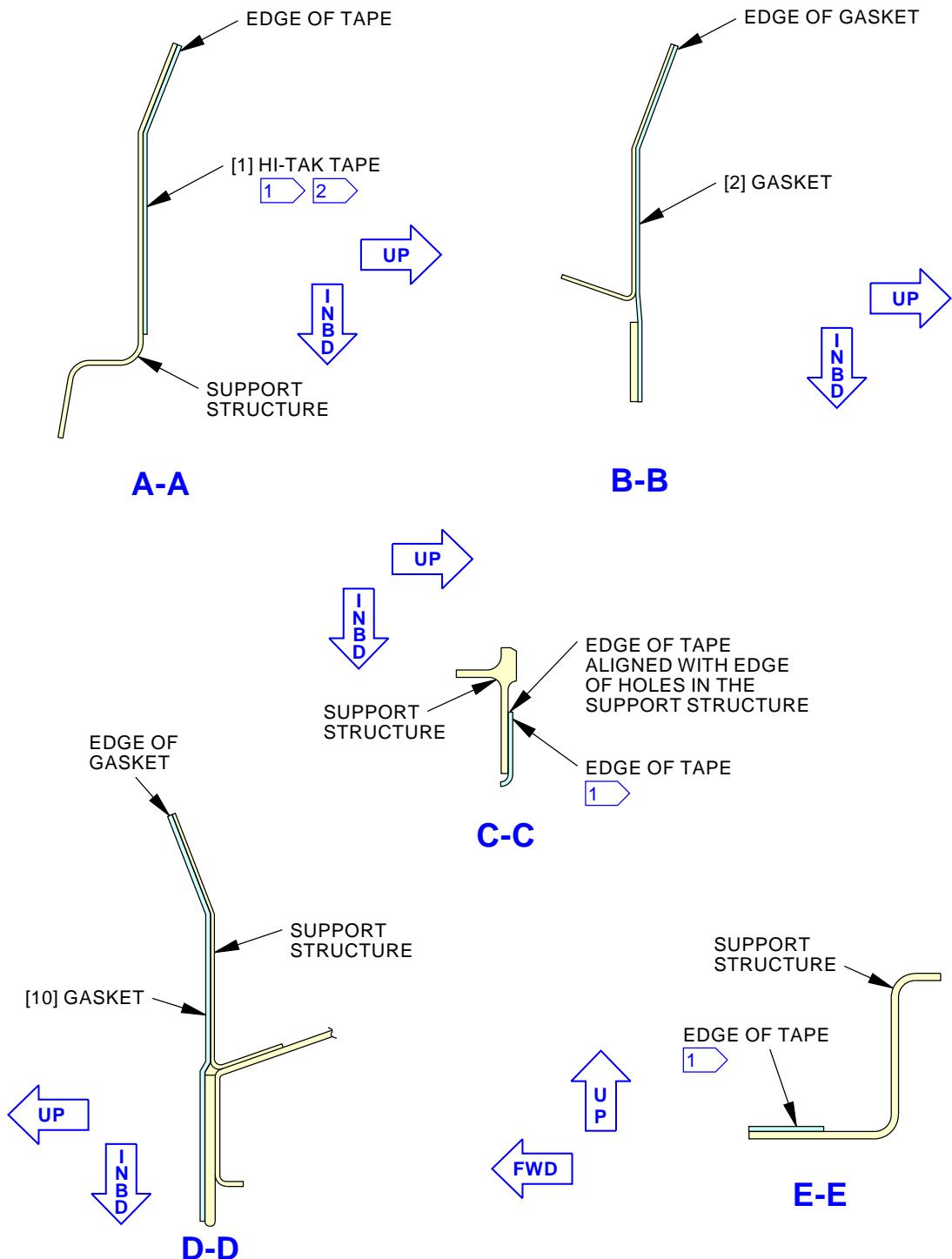
Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 6 of 12)

EFFECTIVITY
AKS ALL

25-52-10

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2304667 S0000522598_V3

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 7 of 12)

EFFECTIVITY

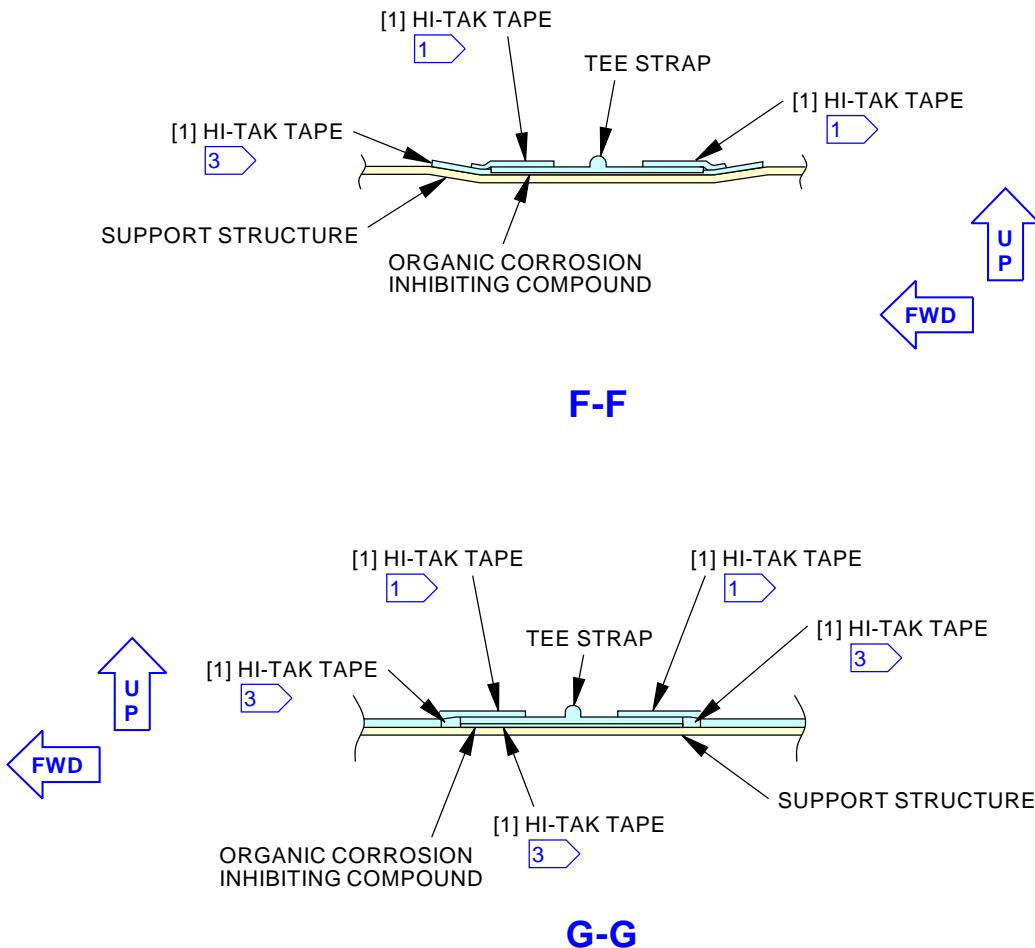
AKS ALL

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2304682 S0000522599_V3

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 8 of 12)

EFFECTIVITY
AKS ALL

D633A101-AKS

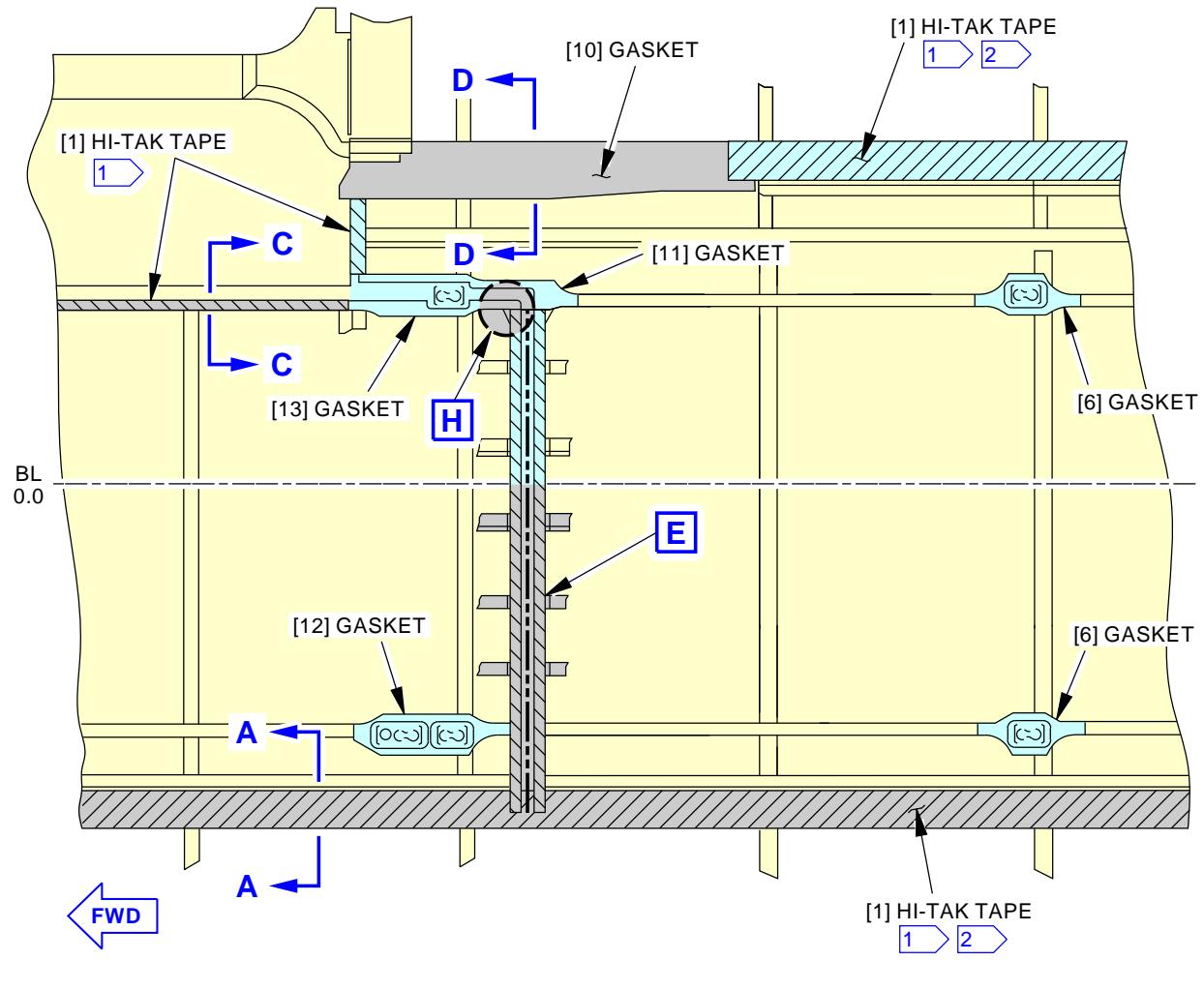
25-52-10

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737-600/700/800/900

AIRCRAFT MAINTENANCE MANUAL



737-700, -700C FORWARD CARGO DECK FLOOR STRUCTURE (TYPICAL)

B

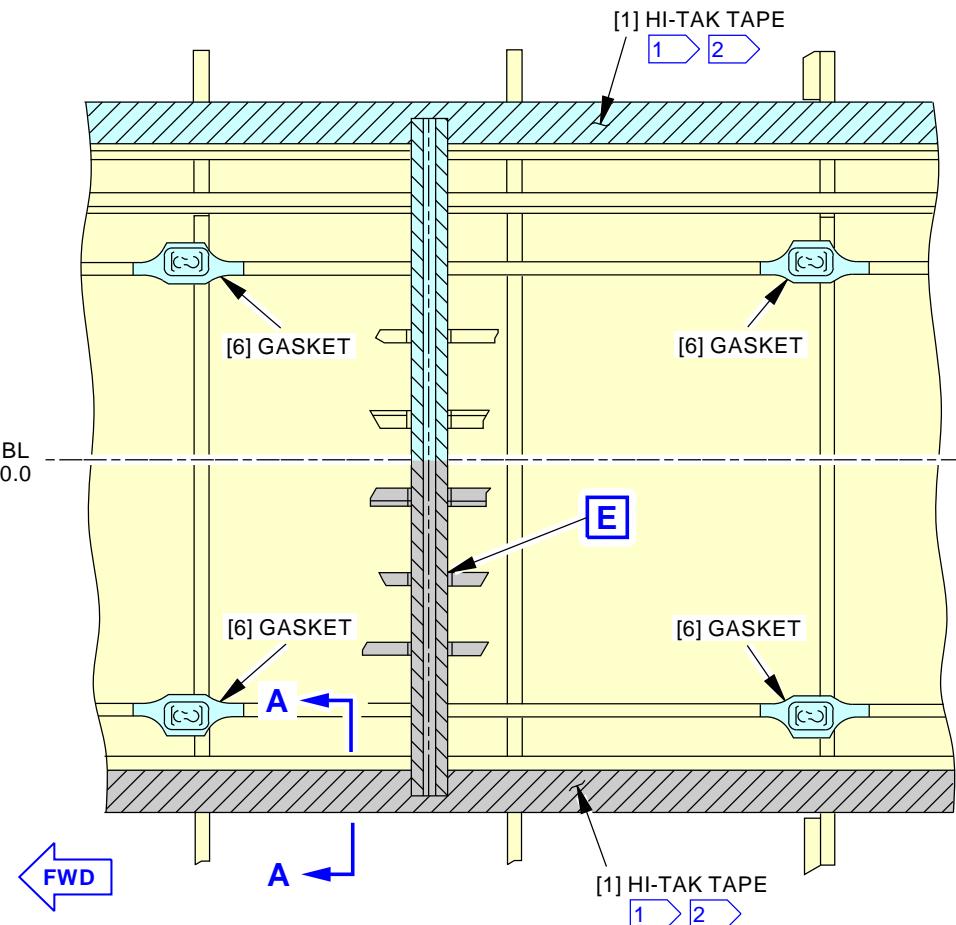
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Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 9 of 12)

EFFECTIVITY
AKS ALL

25-52-10

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**737-800, -900 FORWARD CARGO DECK
FLOOR STRUCTURE
(TYPICAL)**

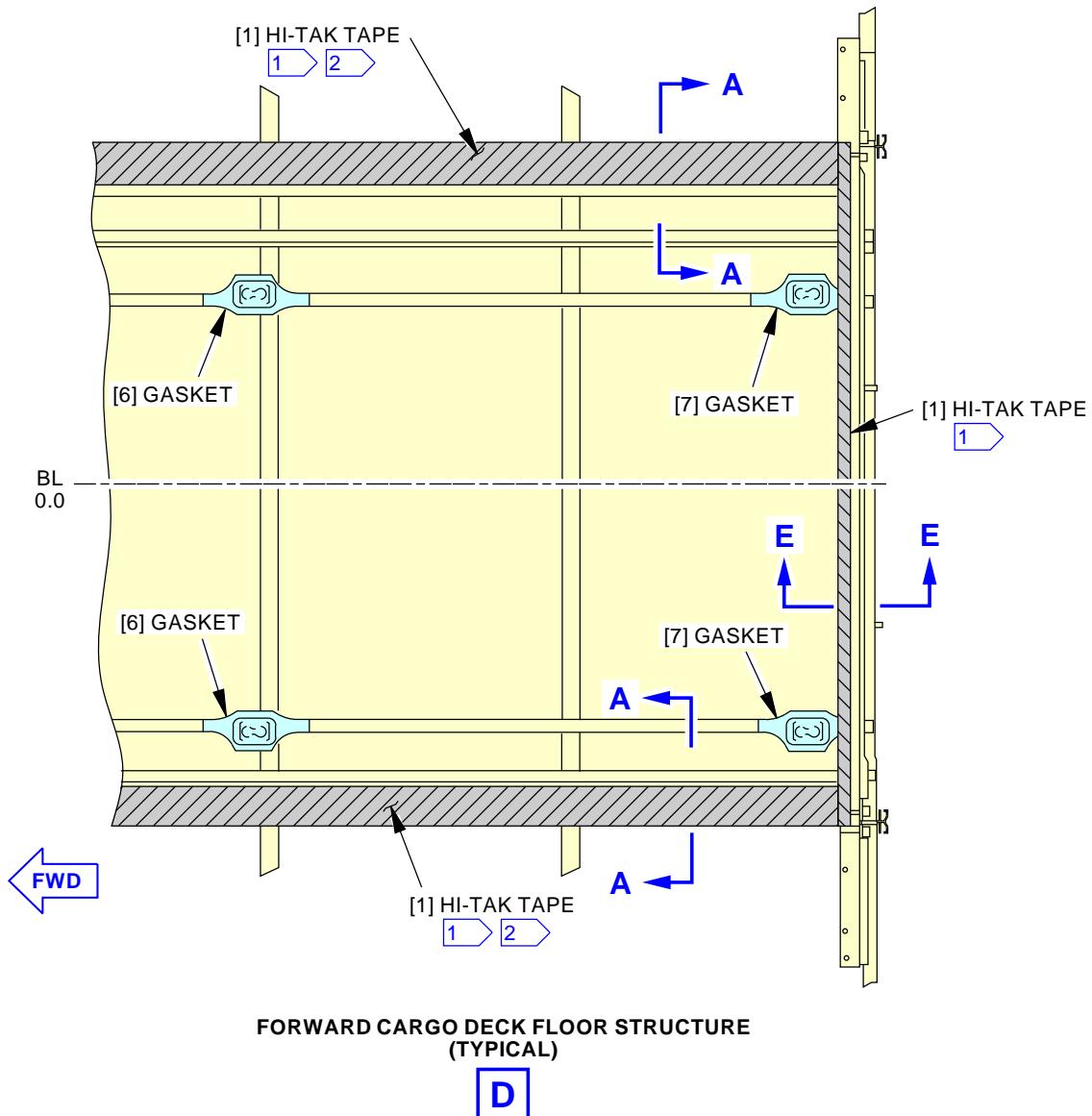
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2304360 S0000522593_V2

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 10 of 12)

EFFECTIVITY
AKS ALL

25-52-10

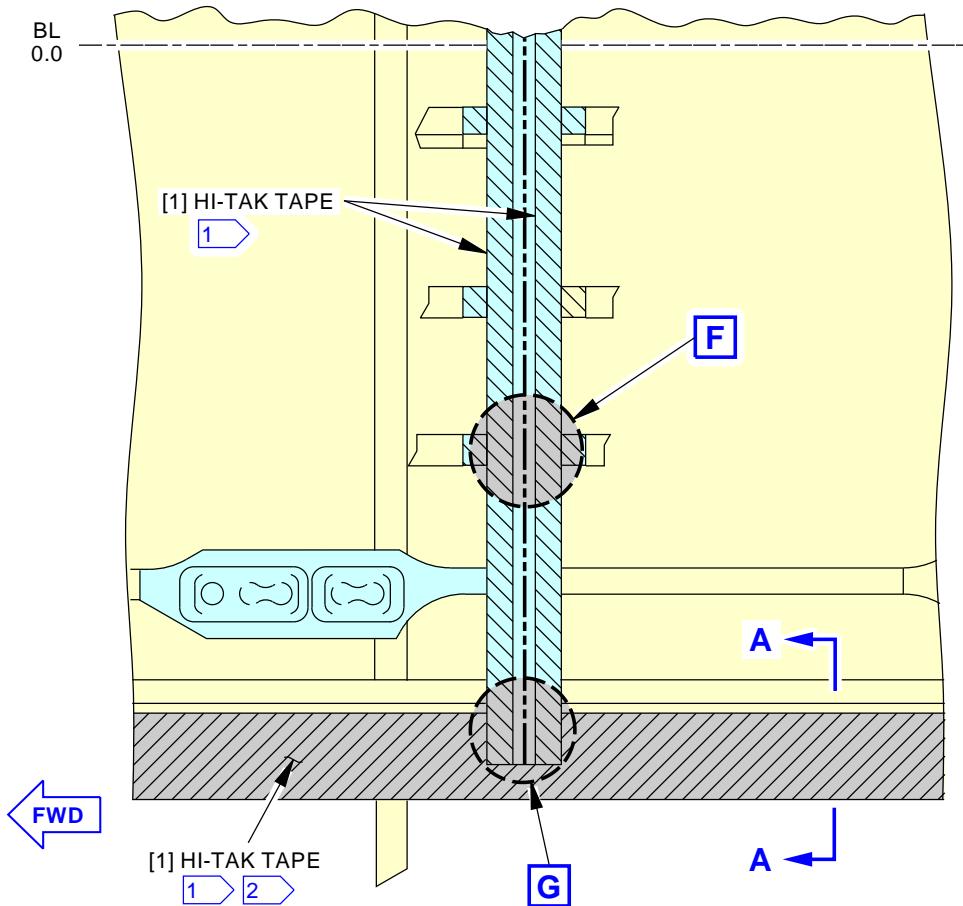


2304397 S0000522594_V2

Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 11 of 12)

EFFECTIVITY
AKS ALL

25-52-10



TEE STRAP (TYPICAL)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)



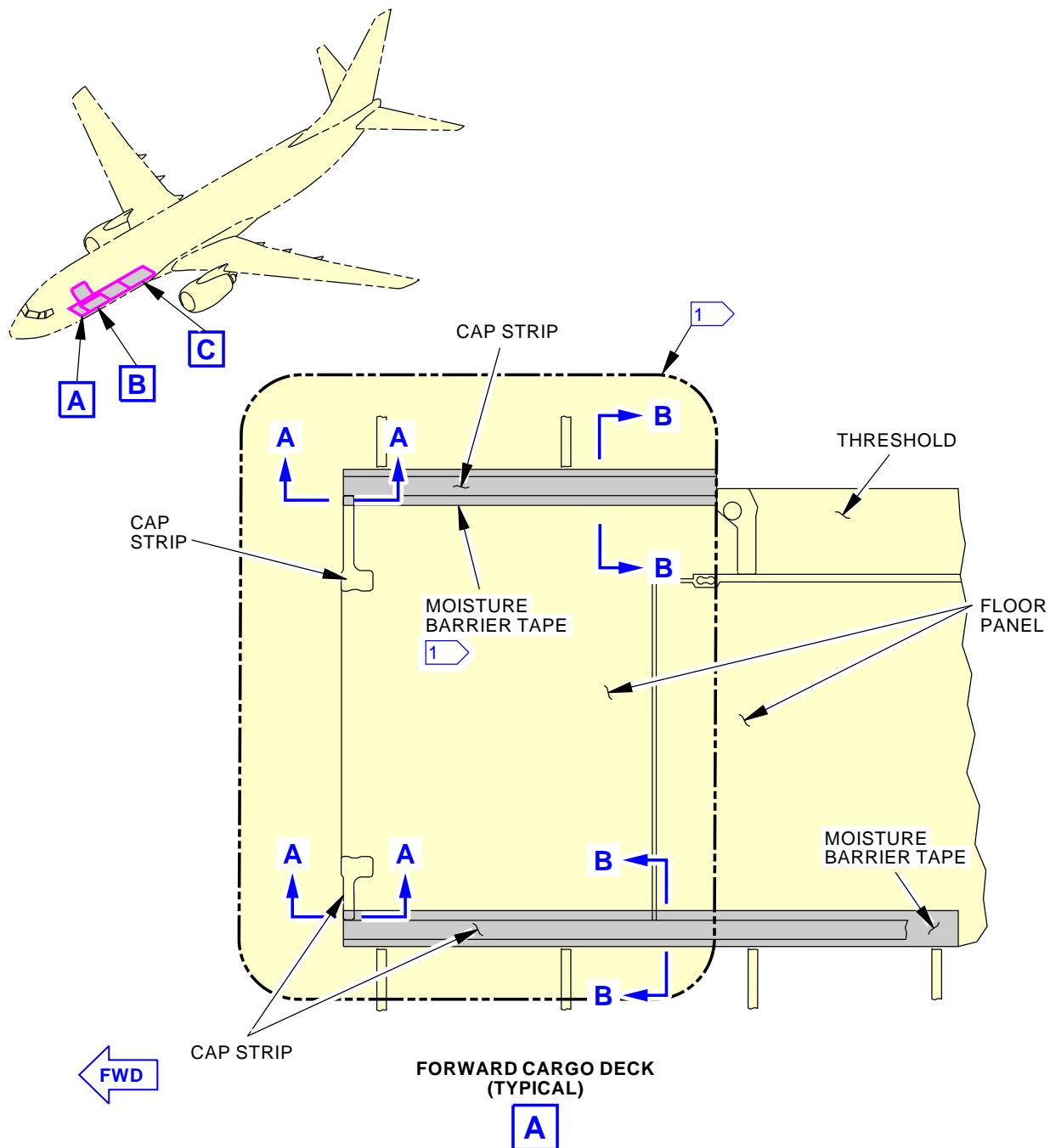
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Forward Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 402/25-52-10-990-807 (Sheet 12 of 12)

EFFECTIVITY
AKS ALL

25-52-10

D633A101-AKS



2304912 S0000522600_V2

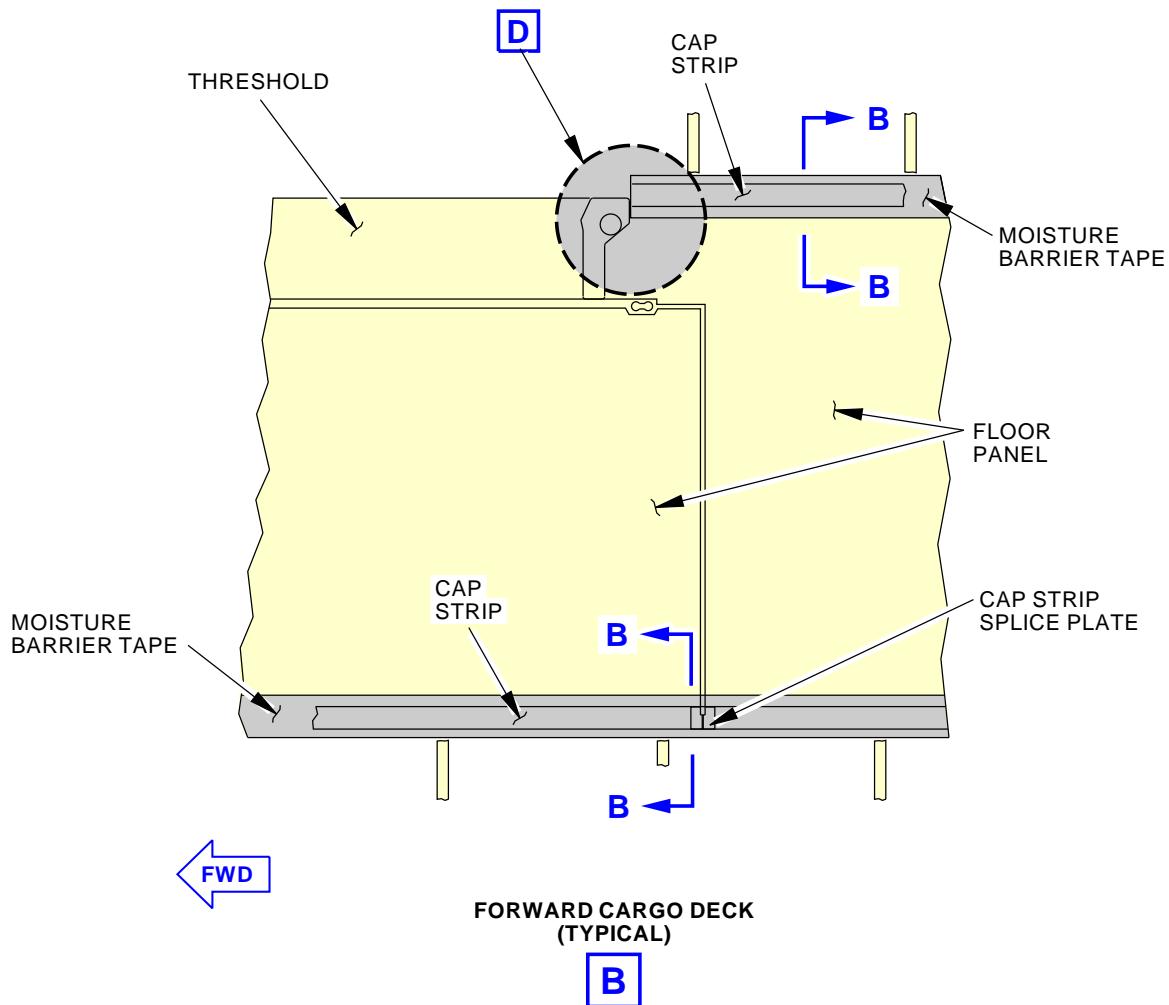
Forward Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 403/25-52-10-990-804 (Sheet 1 of 4)

EFFECTIVITY	AKS ALL
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25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2304913 S0000522601_V2

Forward Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 403/25-52-10-990-804 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

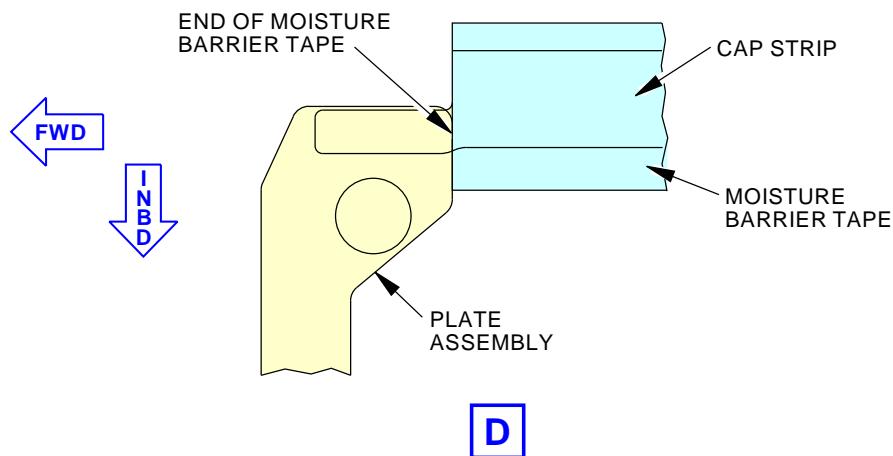
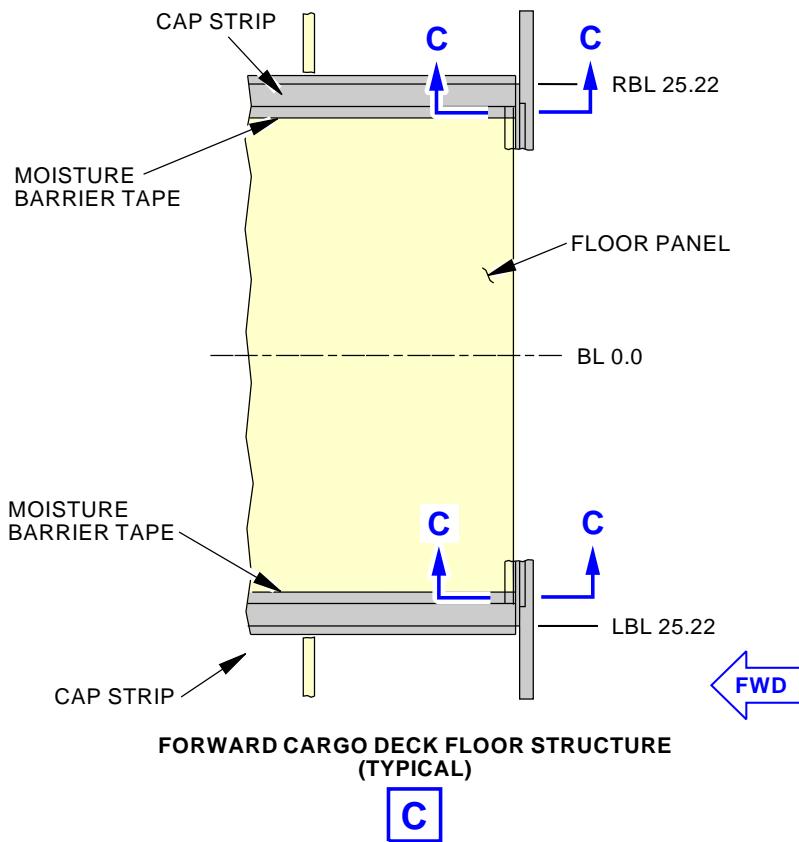
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2304916 S0000522602_V2

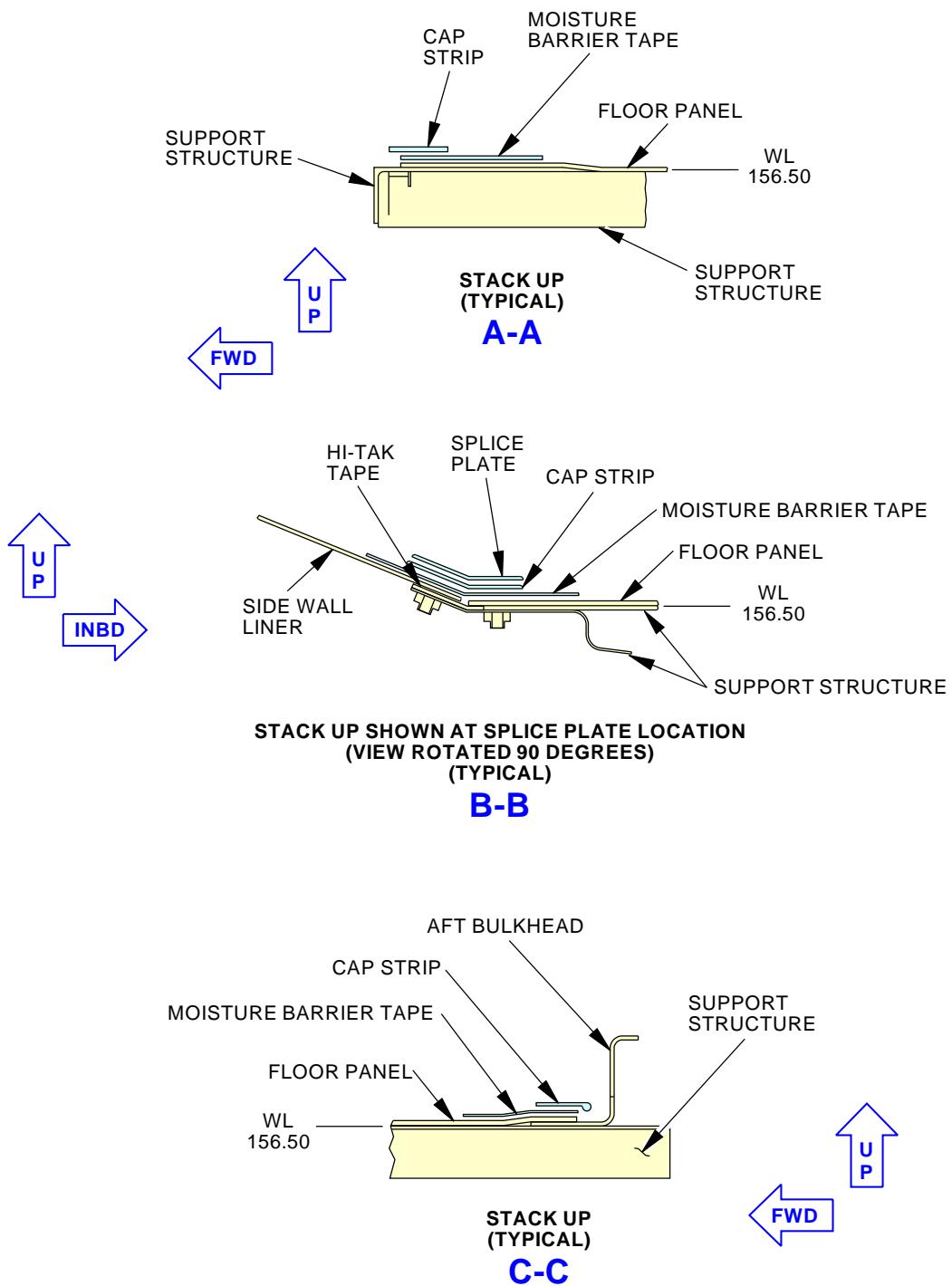
Forward Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 403/25-52-10-990-804 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2304918 S0000522603_V2

Forward Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 403/25-52-10-990-804 (Sheet 4 of 4)

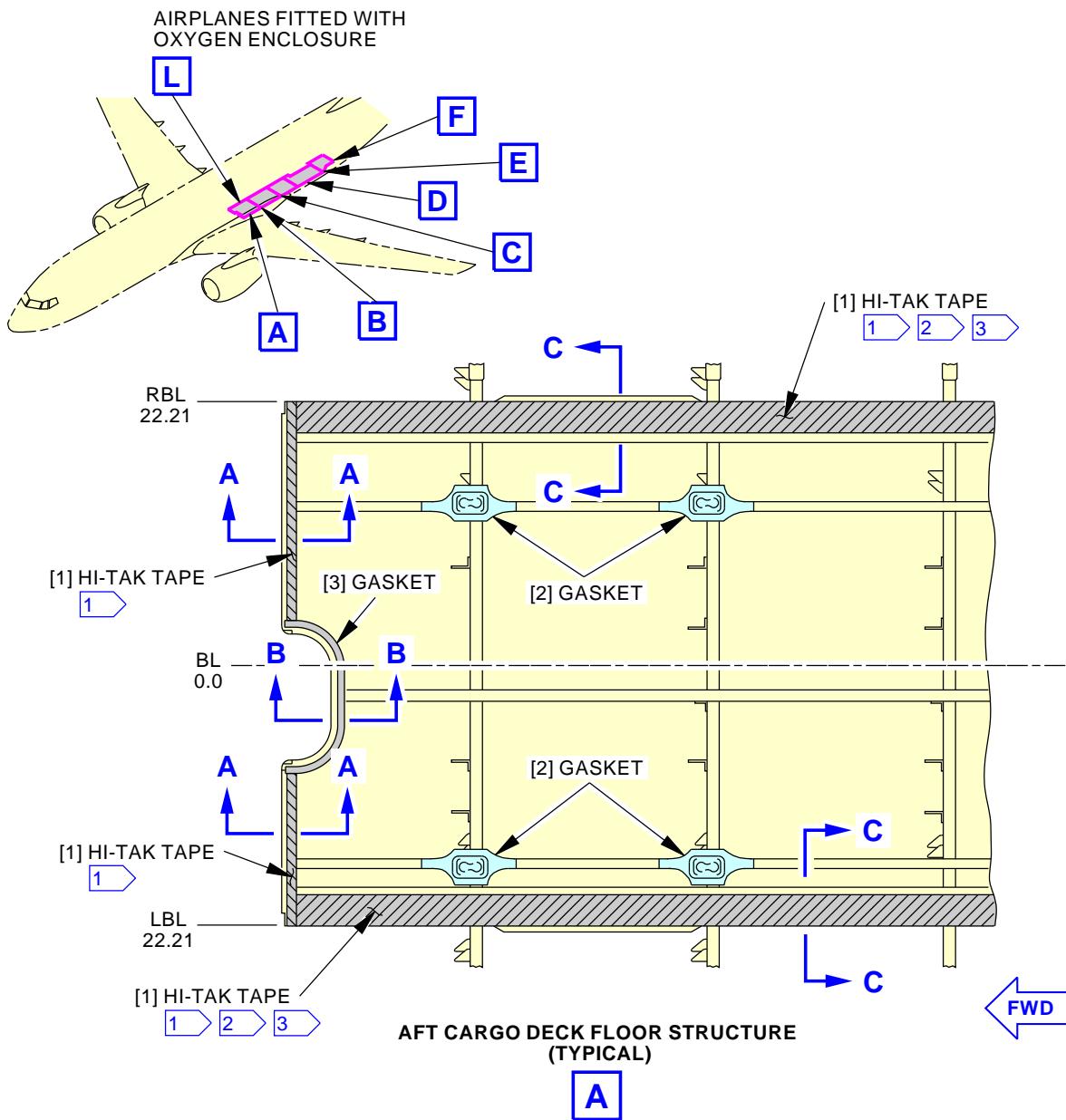
EFFECTIVITY
AKS ALL

25-52-10

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AIRCRAFT MAINTENANCE MANUAL**



- [1] GASKET IS ALLOWED TO OVERHANG THE INBOARD EDGE OF THE SUPPORT STRUCTURE.
- [2] ONE CONTINUOUS STRIP IS PREFERRED. HOWEVER, A JOIN IN THE TAPE IS ALLOWED. MAKE SURE THERE ARE NO GAPS BETWEEN TAPE JOINTS OR TAPE AND GASKET JOINTS. A MAXIMUM OF 0.25 INCH OVERLAP IS ALLOWED.
- [3] ALIGN THE EDGE OF THE TAPE WITH THE OUTBOARD EDGE OF THE SUPPORT STRUCTURE ALONG THE ENTIRE LENGTH OF THE AFT CARGO COMPARTMENT.

2304921 S0000522604_V2

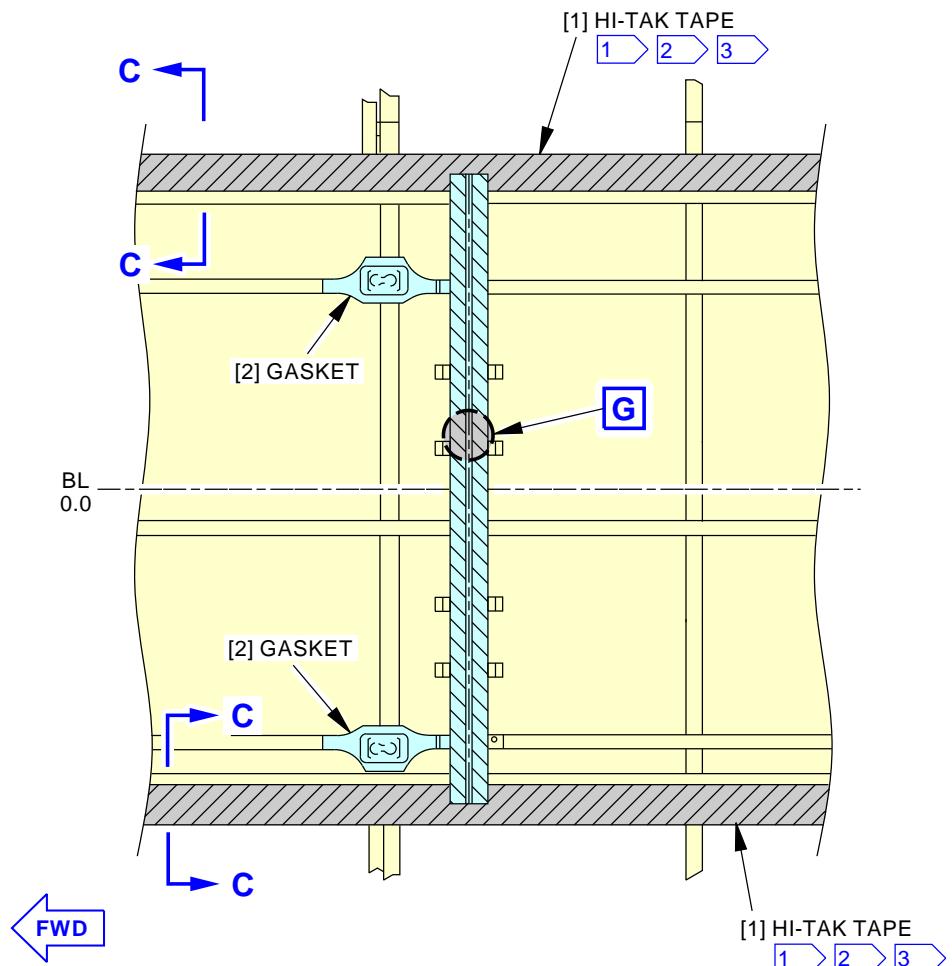
Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 1 of 13)

EFFECTIVITY
AKS ALL

25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



737-700, -700C, -800, -900 AFT CARGO DECK FLOOR
STRUCTURE
(TYPICAL)

B

2304923 S0000522605_V2

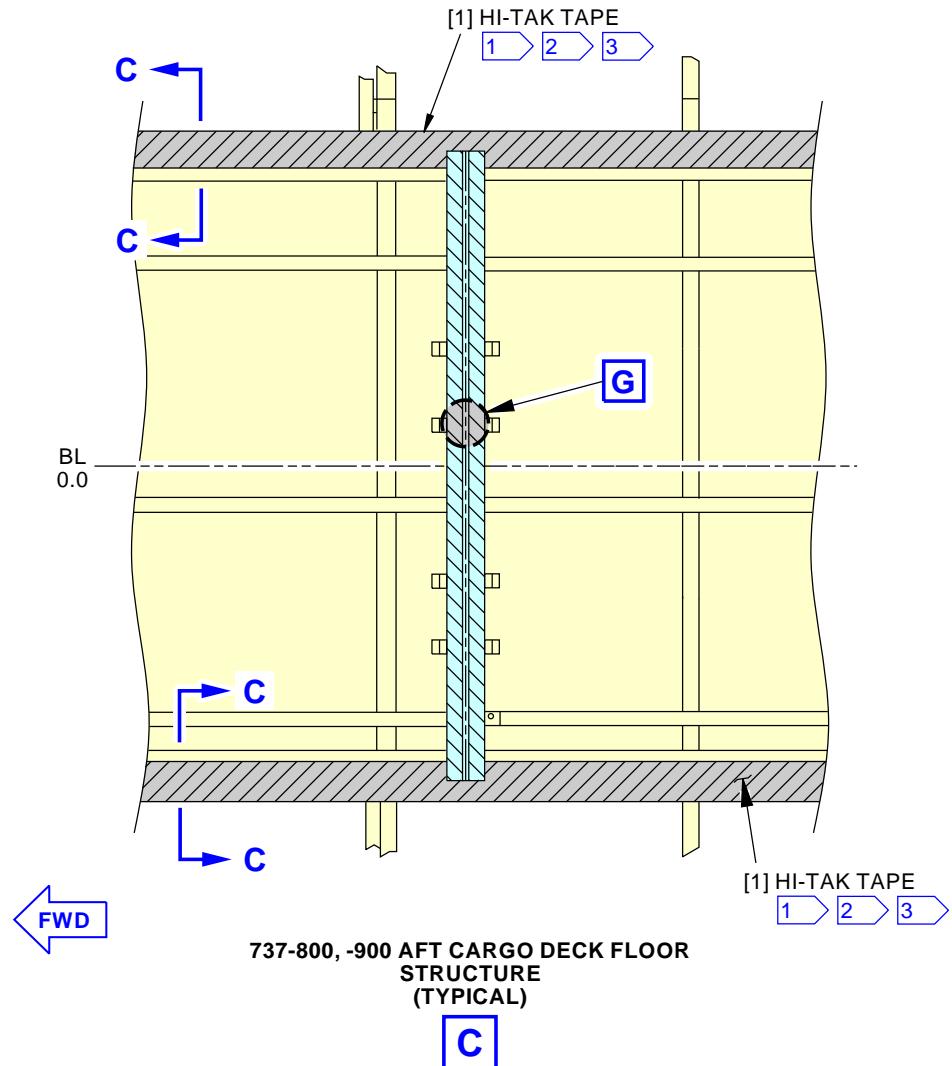
Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 2 of 13)

EFFECTIVITY
AKS ALL

25-52-10



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AIRCRAFT MAINTENANCE MANUAL



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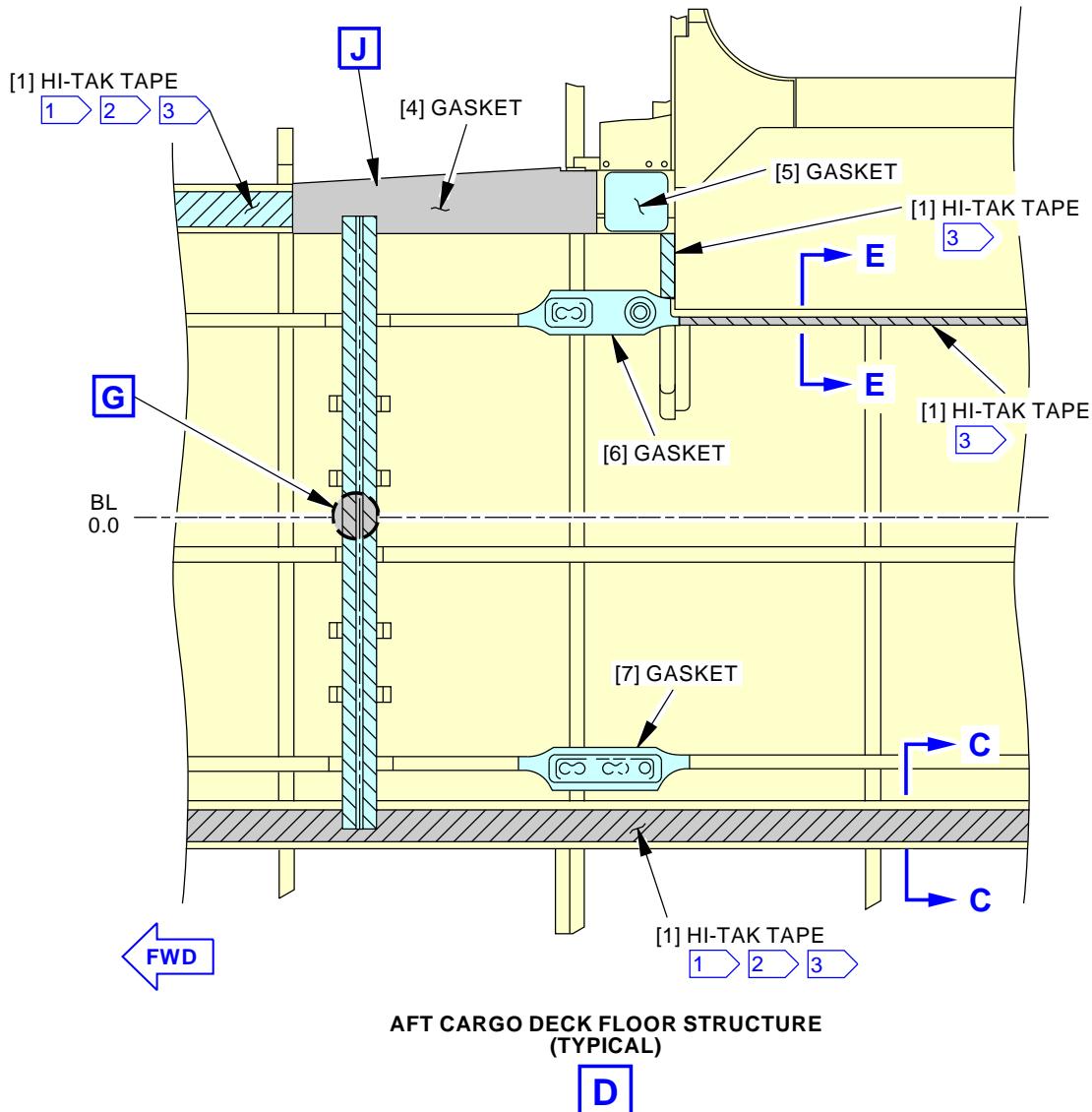
Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 3 of 13)

EFFECTIVITY
AKS ALL

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2304927 S0000522607_V2

Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 4 of 13)

EFFECTIVITY
AKS ALL

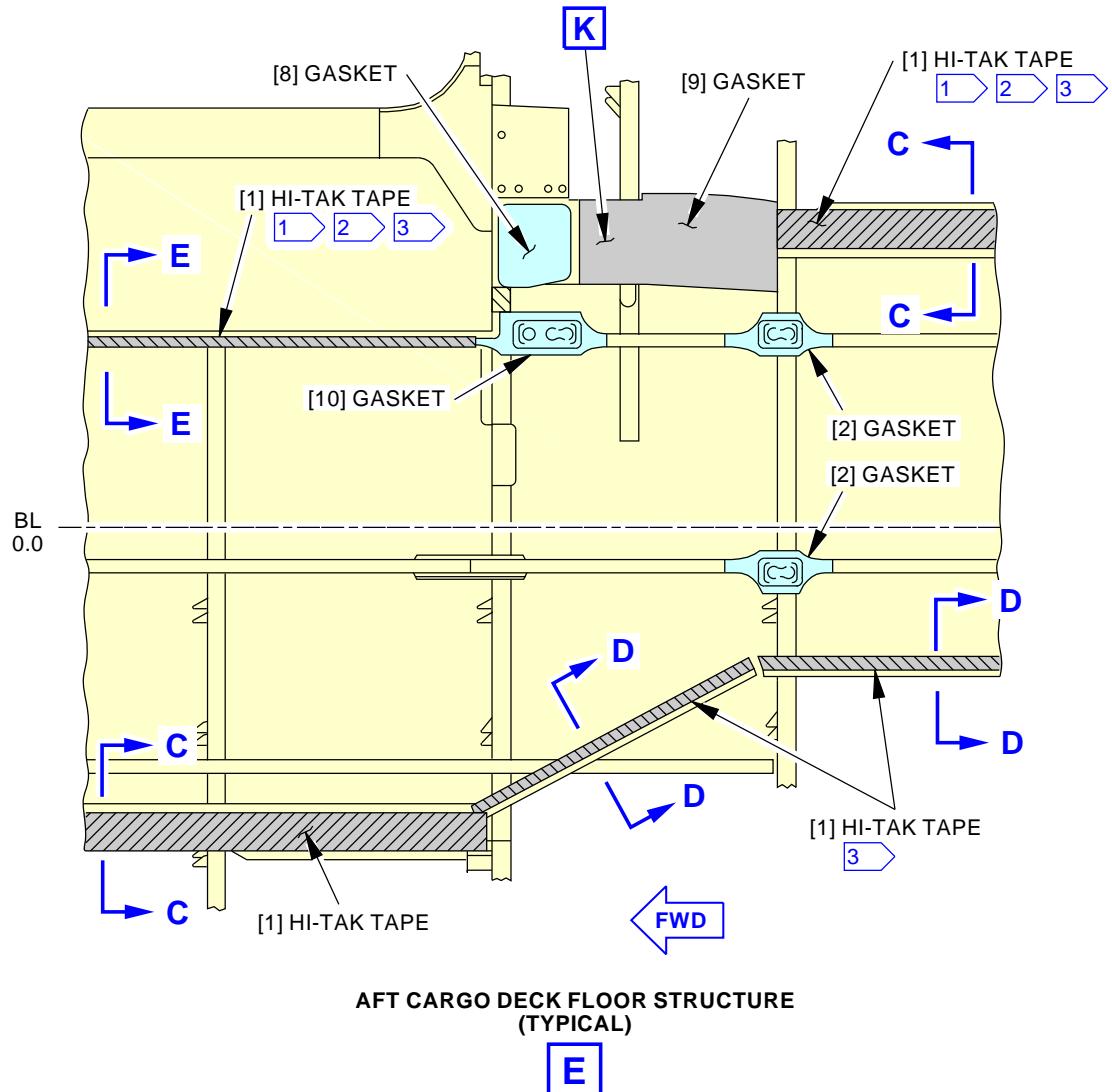
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**Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 5 of 13)**

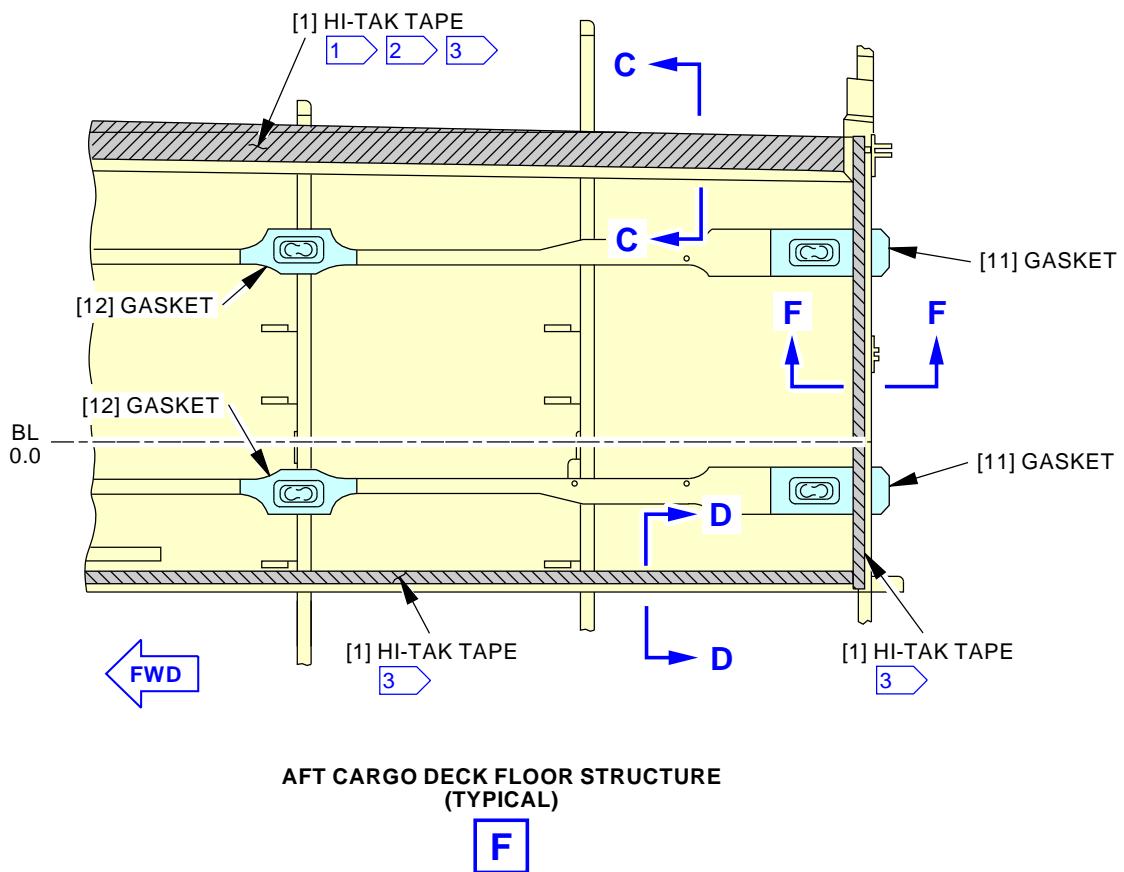
EFFECTIVITY
AKS ALL

25-52-10

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AIRCRAFT MAINTENANCE MANUAL



2304930 S0000522609_V2

Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 6 of 13)

EFFECTIVITY
AKS ALL

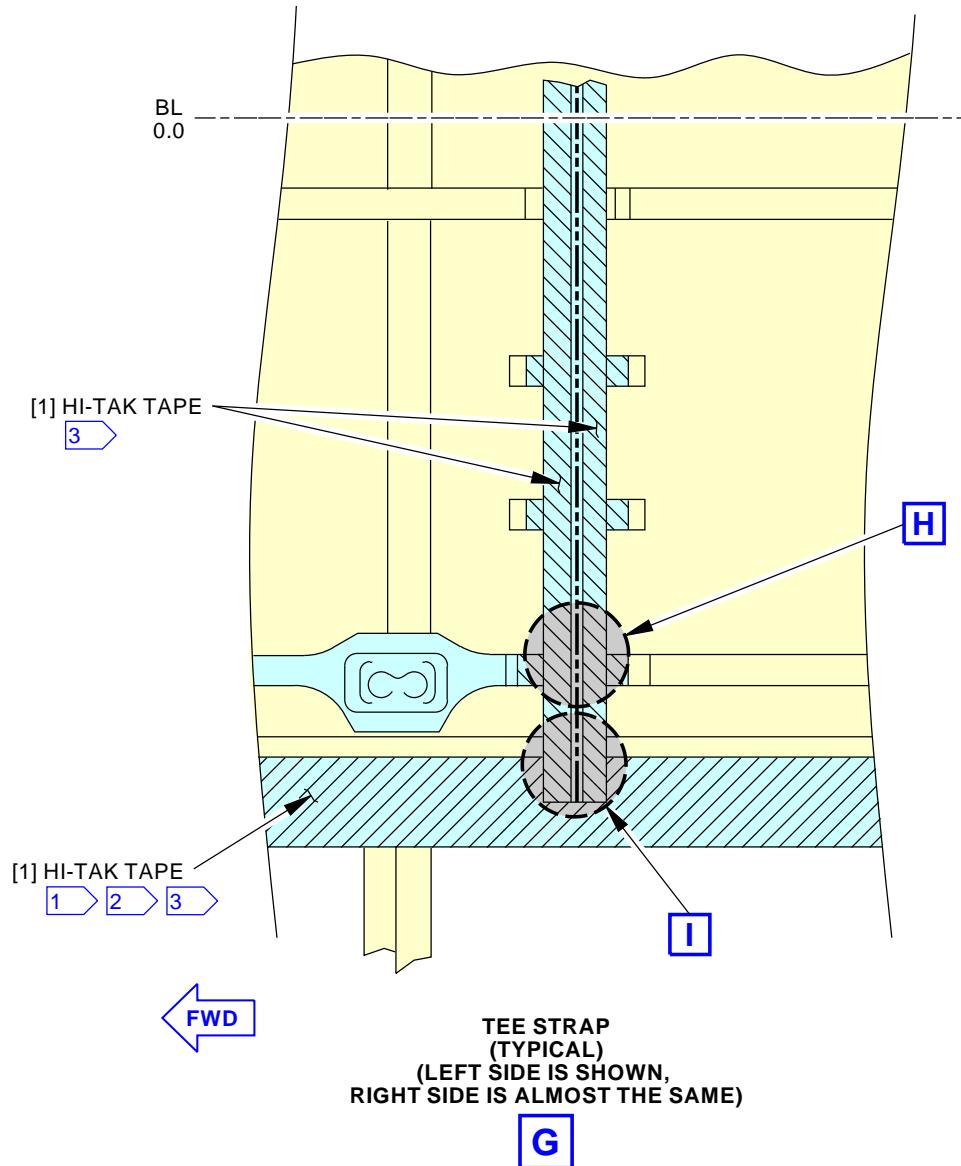
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2304936 S0000522610_V2

Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 7 of 13)

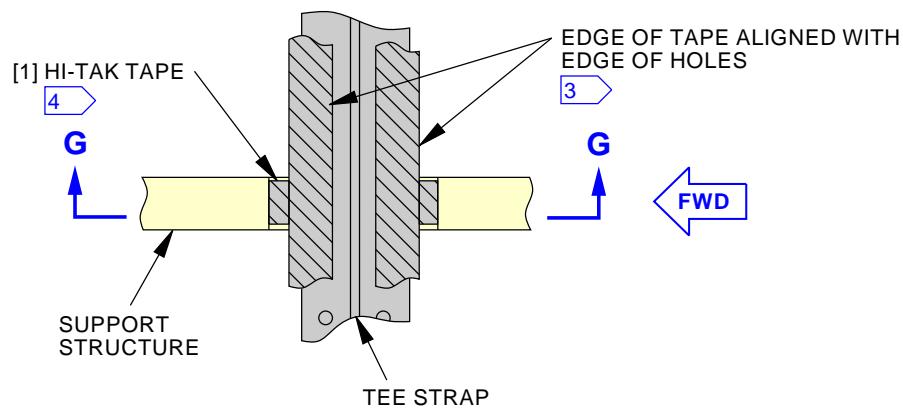
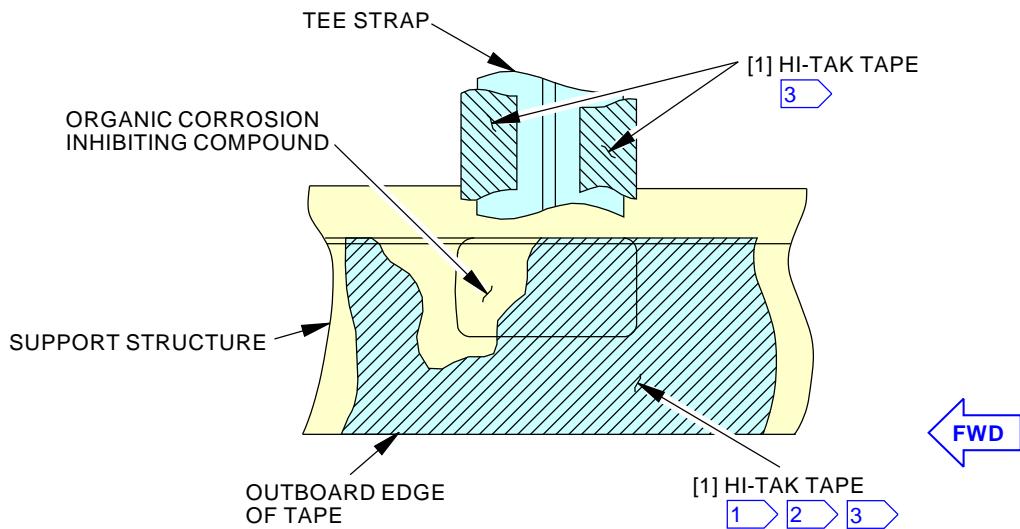
EFFECTIVITY
AKS ALL

25-52-10

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**TEE STRAP WITH JOGGLE
(TYPICAL)**
H

**TEE STRAP END
(TYPICAL)**
I

- 4** LOCATE THE TAPE IN THE CENTER OF THE SUPPORT STRUCTURE.

2304938 S0000522611_V2

**Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 8 of 13)**

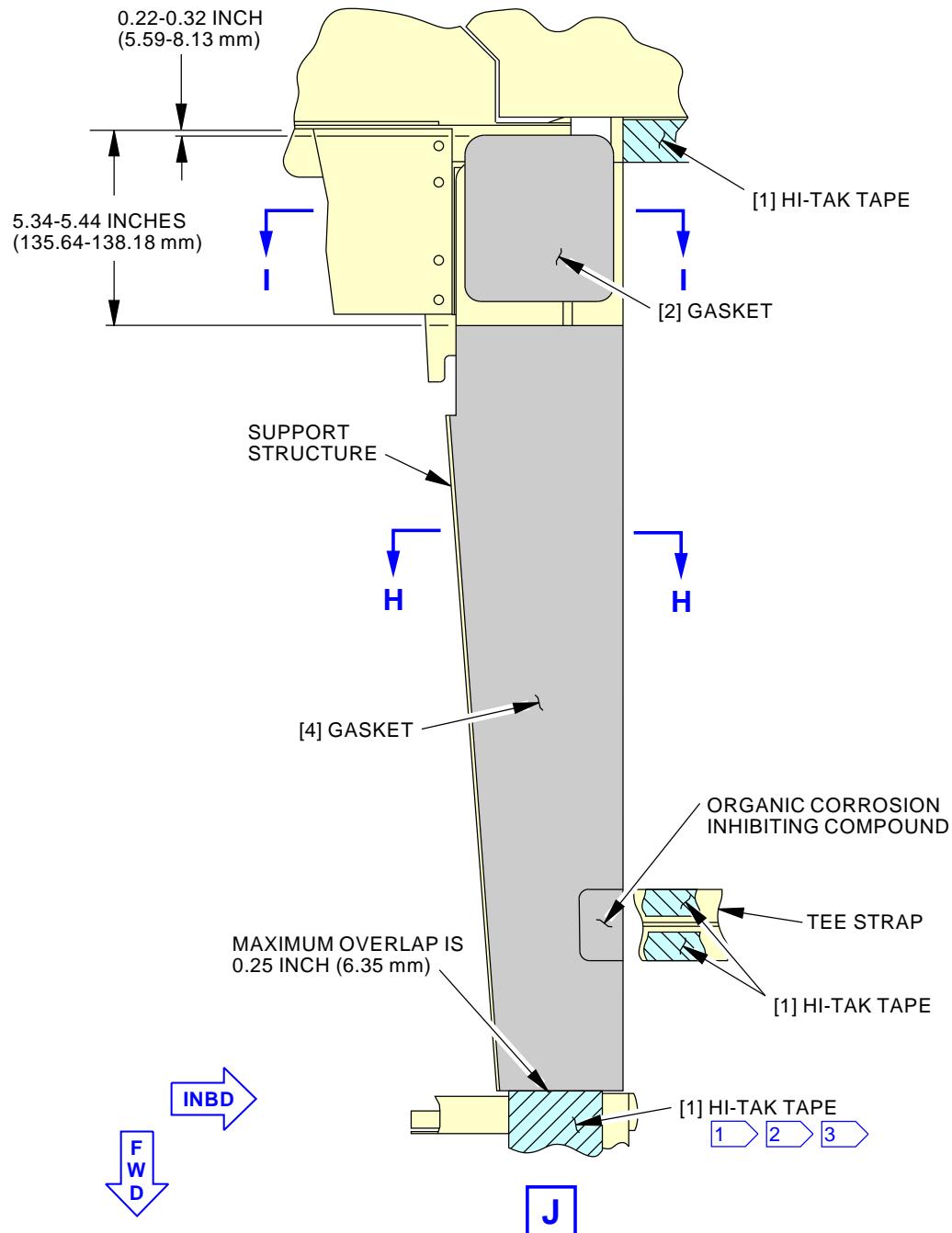
 EFFECTIVITY
 AKS ALL

D633A101-AKS

25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2304953 S0000522612_V2

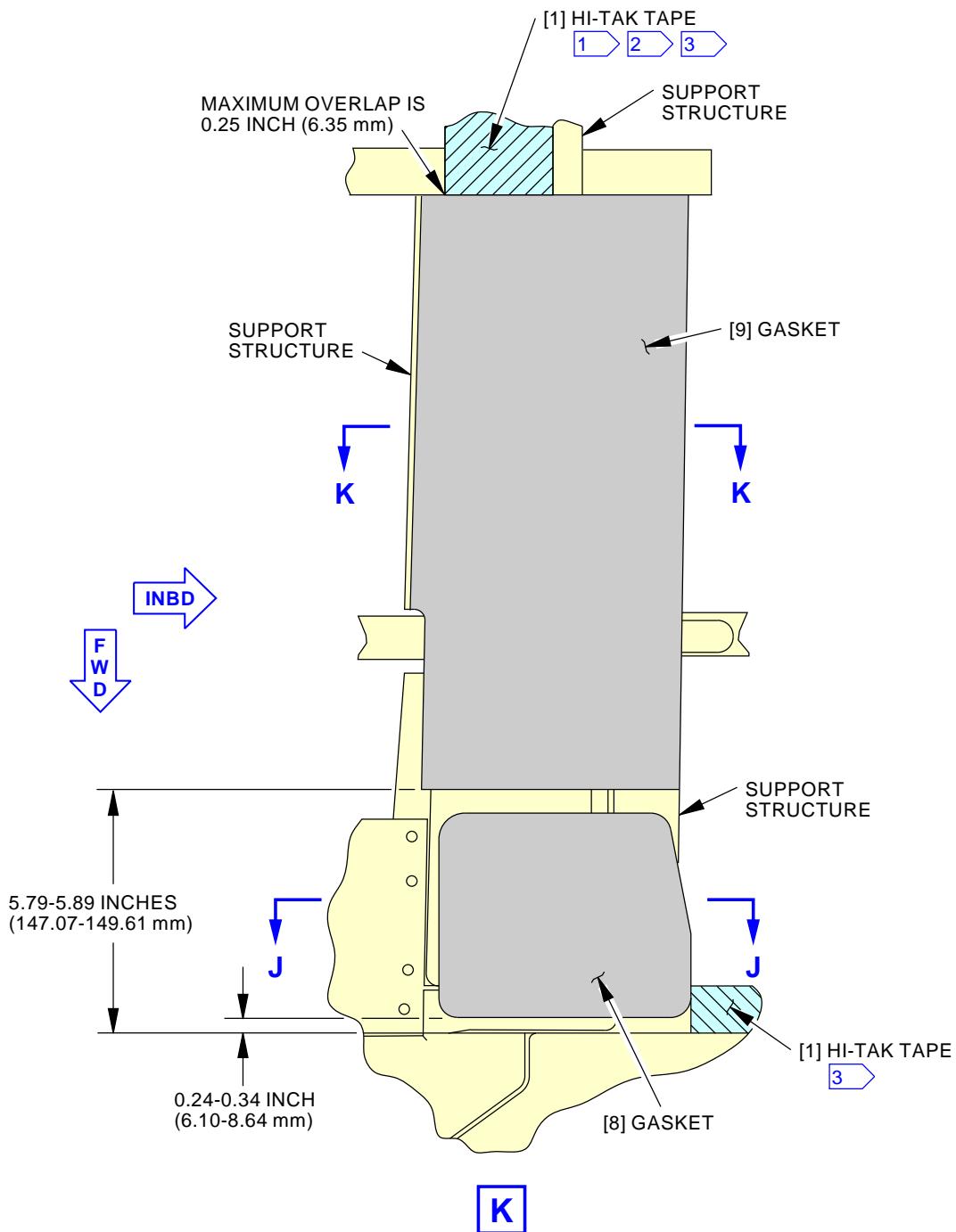
Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 9 of 13)

EFFECTIVITY
AKS ALL

25-52-10

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2306201 S0000522613_V2

Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 10 of 13)

EFFECTIVITY
AKS ALL

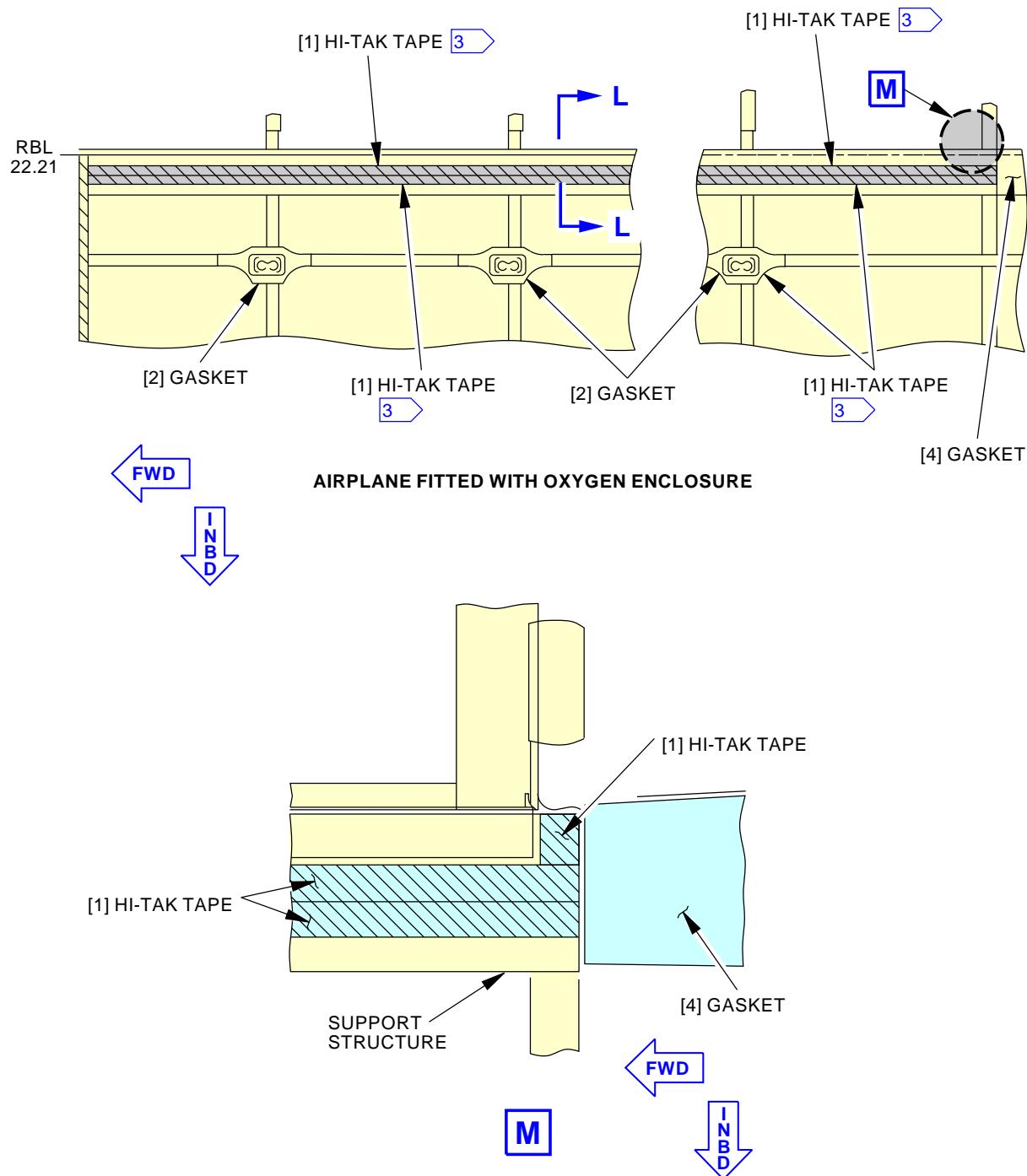
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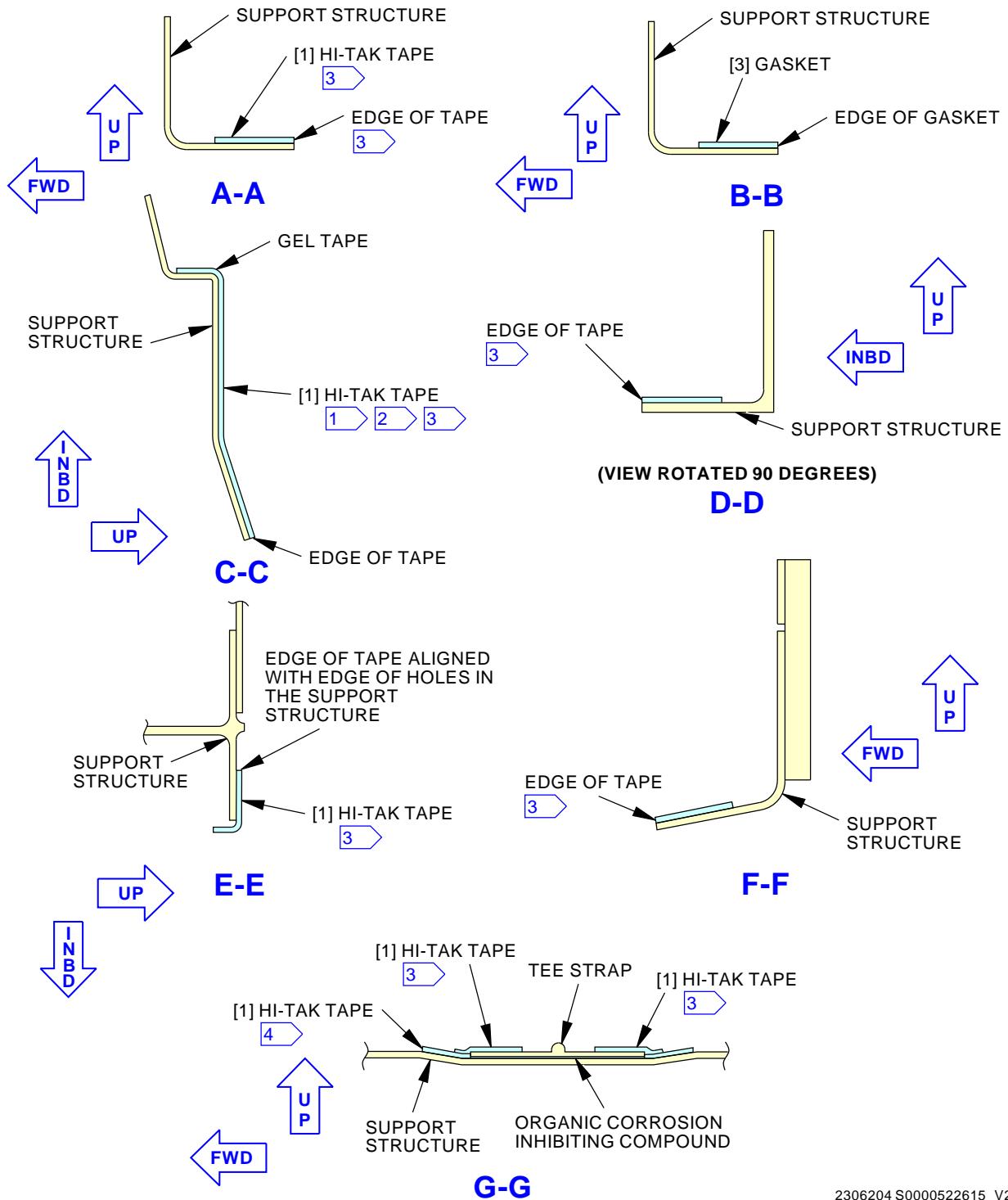
Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 11 of 13)

EFFECTIVITY
AKS ALL

D633A101-AKS

25-52-10

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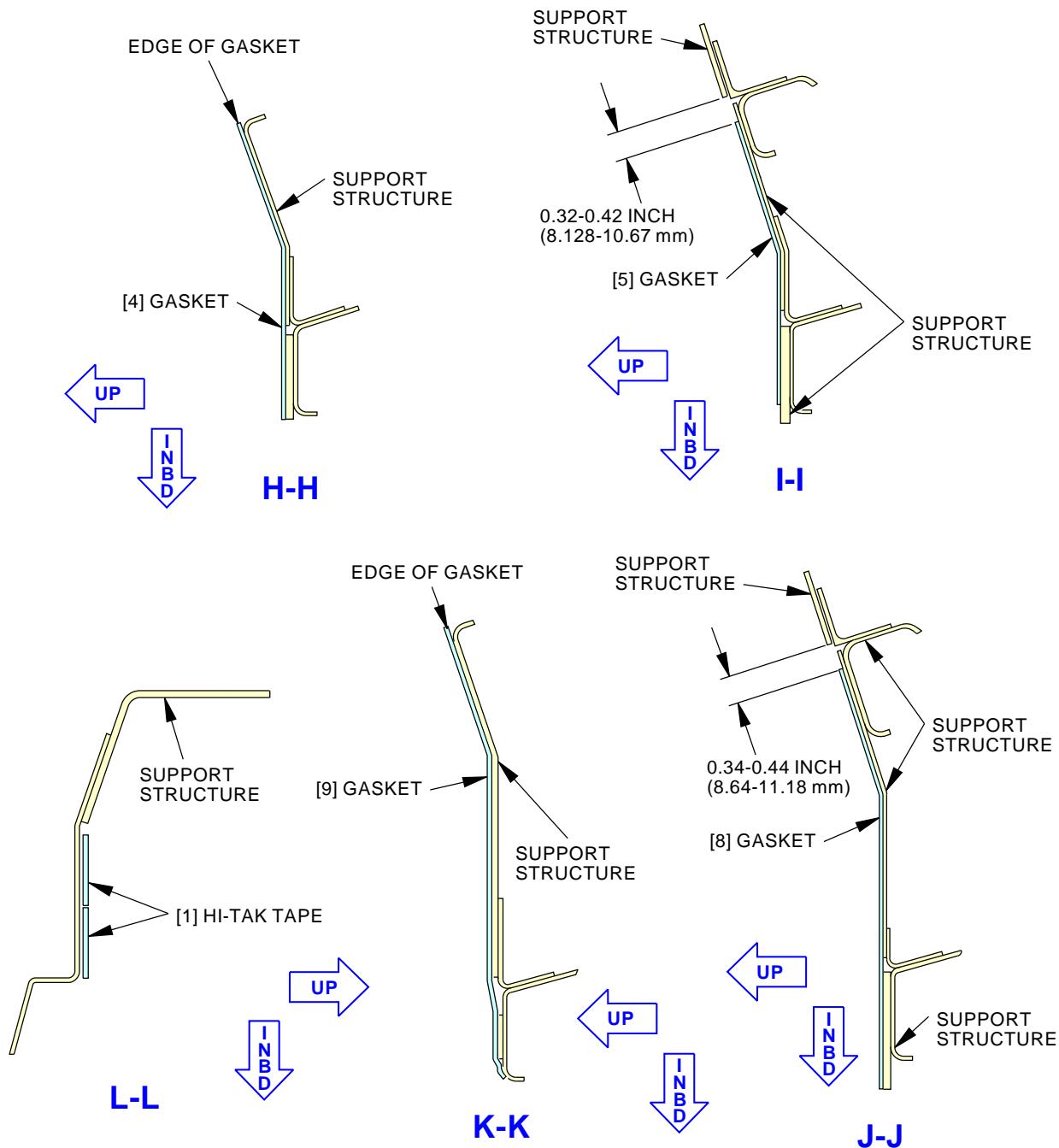


2306204 S0000522615_V2

Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 12 of 13)

 EFFECTIVITY
 AKS ALL

25-52-10



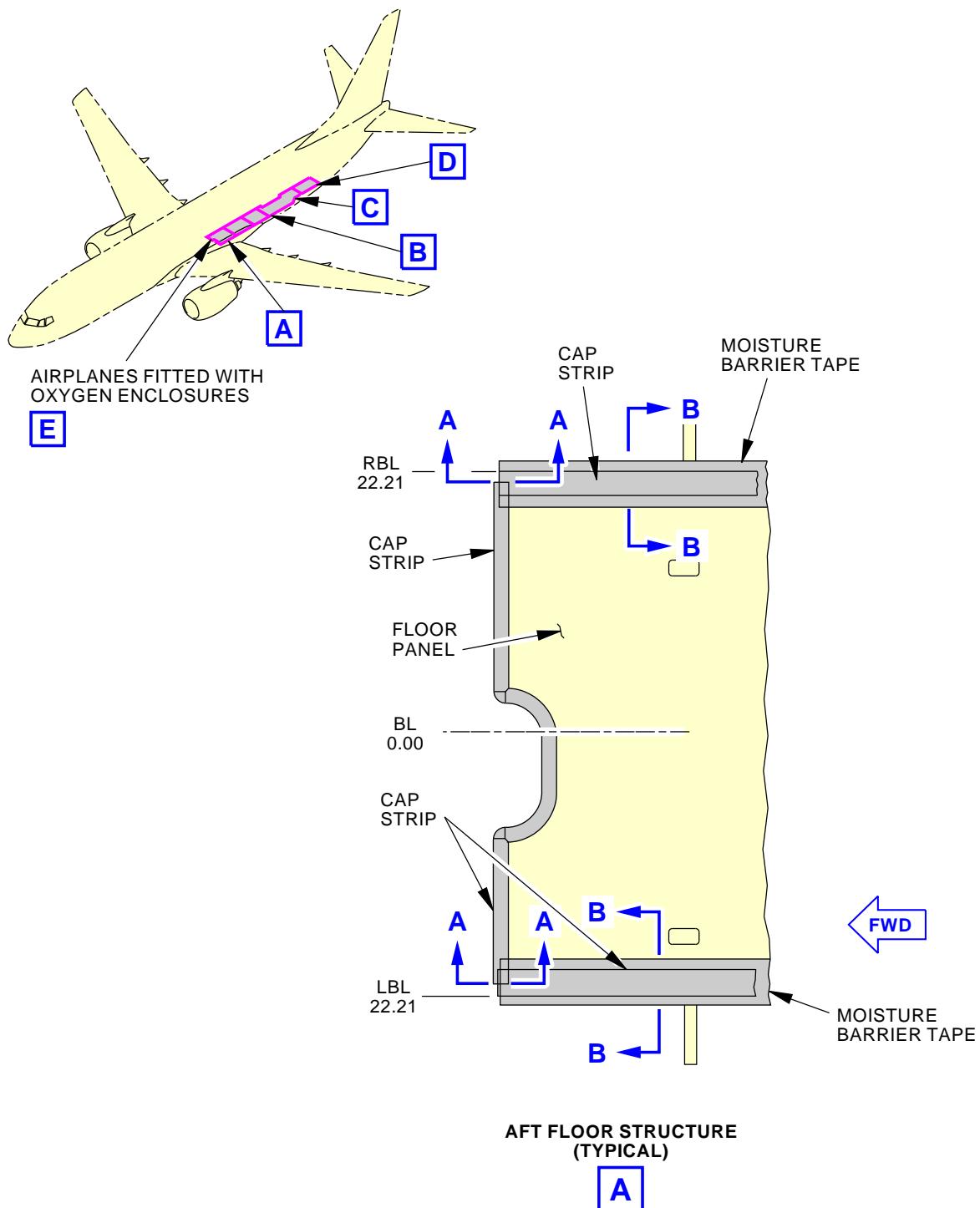
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Aft Cargo Compartment - Cargo Deck - Tape and Gasket Installation
Figure 404/25-52-10-990-805 (Sheet 13 of 13)

EFFECTIVITY	AKS ALL
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25-52-10

D633A101-AKS



2306211 S0000522617_V2

Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 1 of 6)

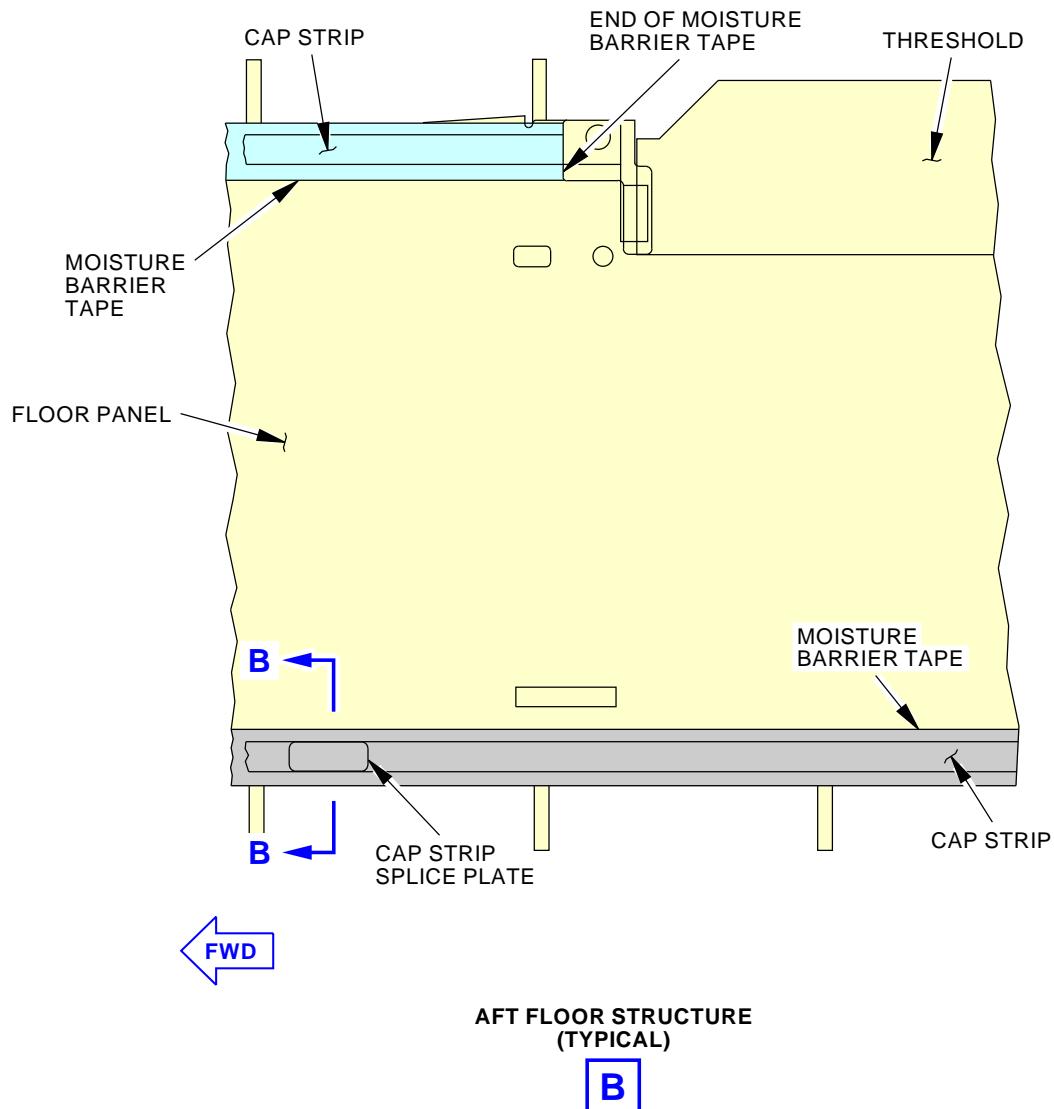
EFFECTIVITY
AKS ALL

25-52-10

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AIRCRAFT MAINTENANCE MANUAL



2306214 S0000522618_V2

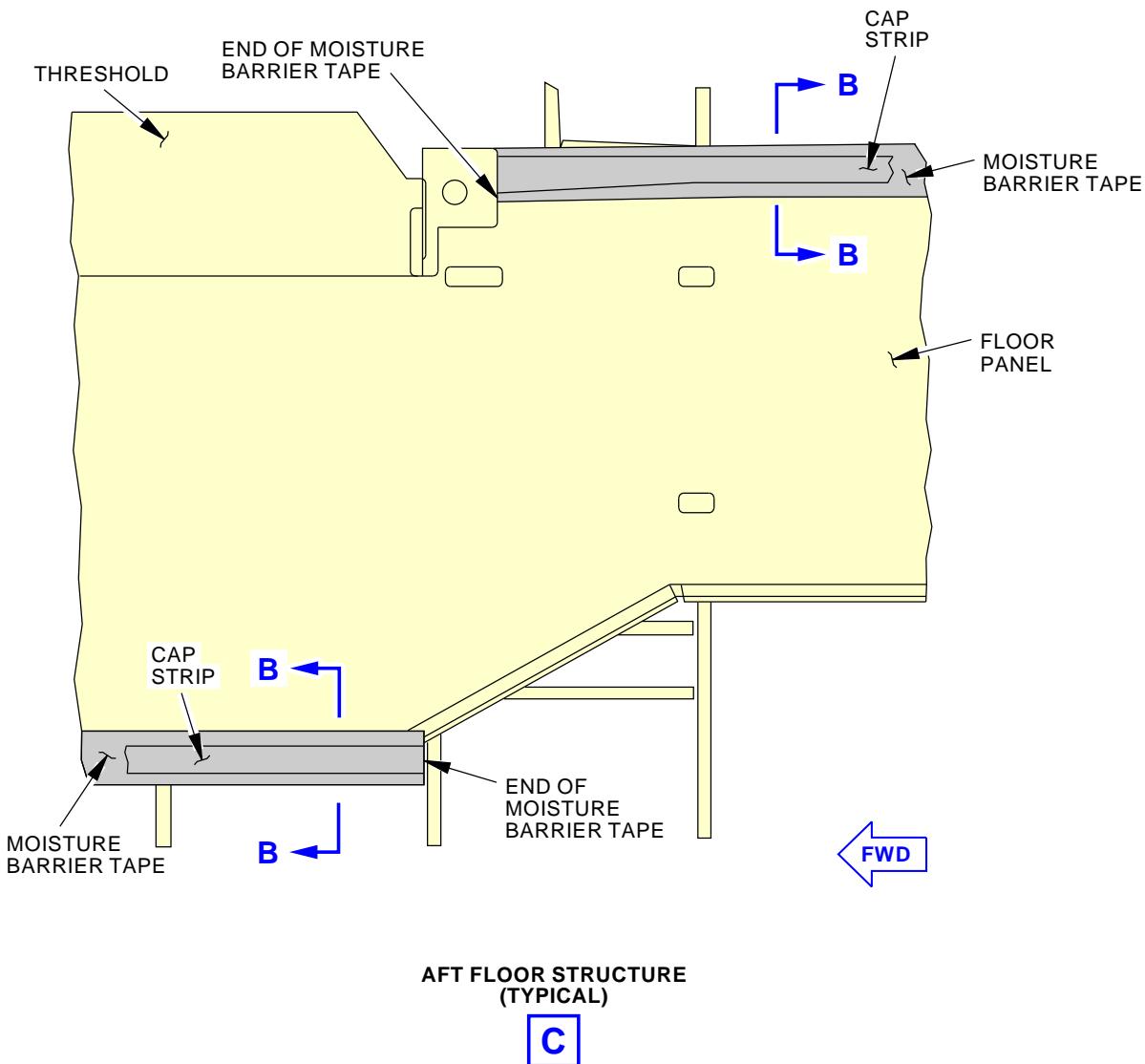
Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 2 of 6)

EFFECTIVITY
AKS ALL

25-52-10

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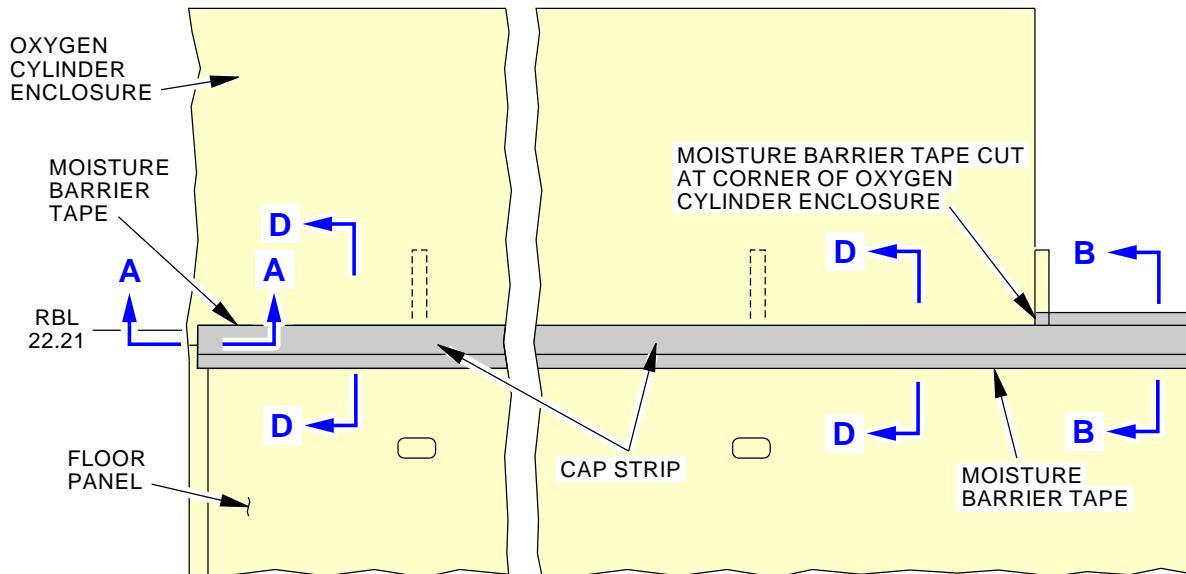
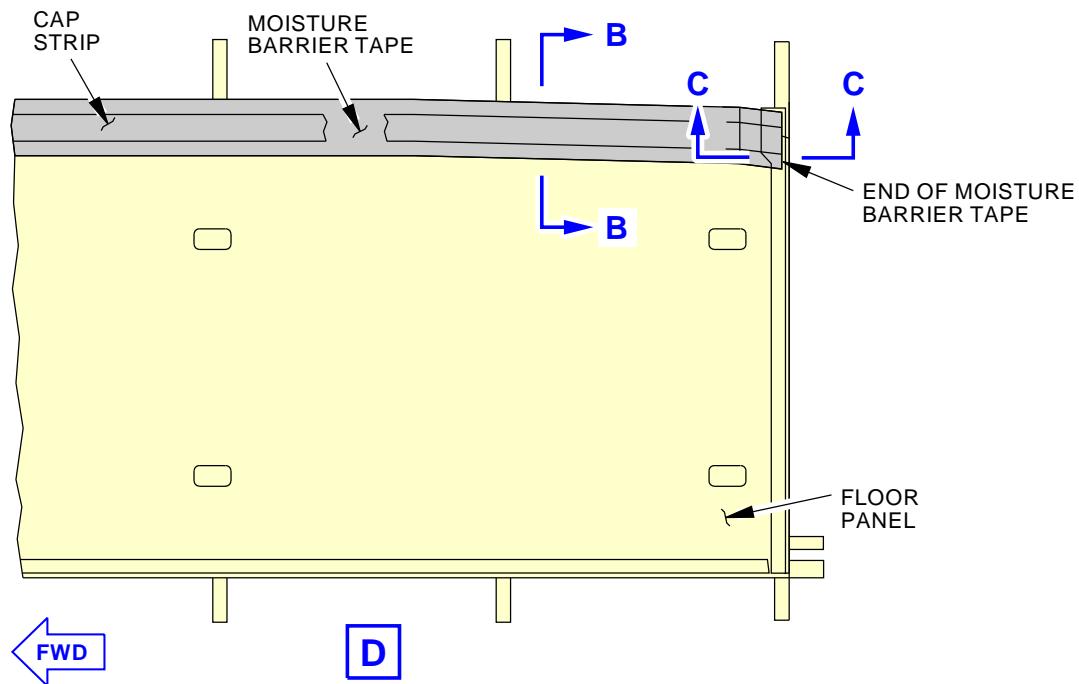
Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 3 of 6)EFFECTIVITY
AKS ALL**25-52-10**

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AIRCRAFT MAINTENANCE MANUAL



AIRPLANES FITTED WITH OXYGEN ENCLOSURE



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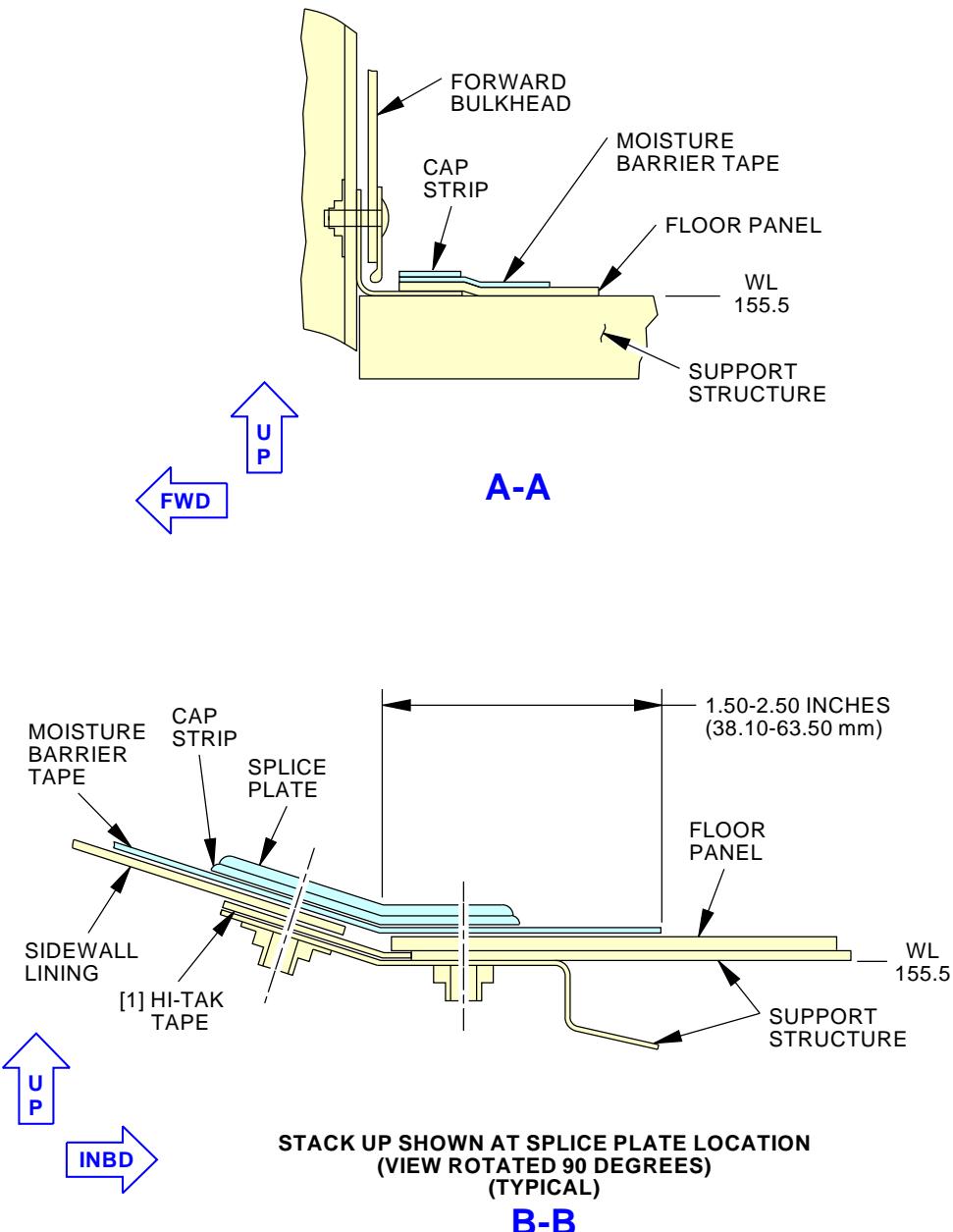
Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 4 of 6)

EFFECTIVITY
AKS ALL

25-52-10



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AIRCRAFT MAINTENANCE MANUAL



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Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 5 of 6)

EFFECTIVITY
AKS ALL

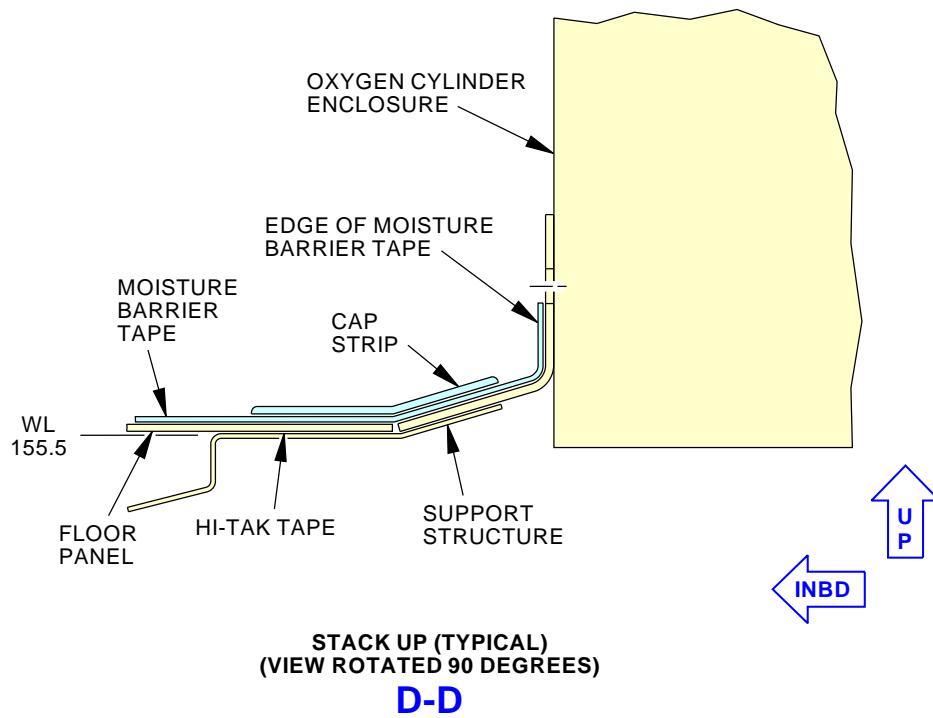
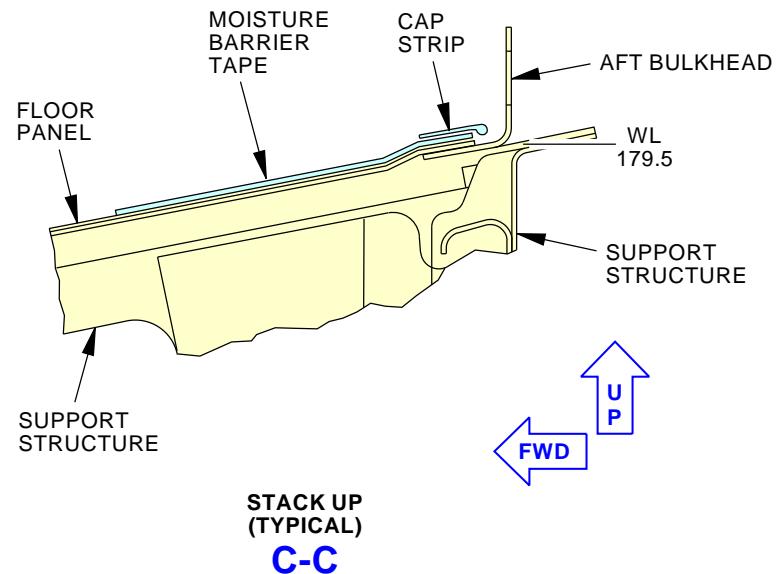
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AIRCRAFT MAINTENANCE MANUAL



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Aft Cargo Compartment - Cargo Deck - Moisture Barrier Tape Installation
Figure 405/25-52-10-990-806 (Sheet 6 of 6)

EFFECTIVITY
AKS ALL

25-52-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

CARGO COMPARTMENT NET - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Cargo Compartment Net Removal.
 - (2) Cargo Compartment Net Installation.
 - (3) Cargo Net Snap Latch Replacement

TASK 25-52-12-020-801

2. Cargo Compartment Net Removal

(Figure 401)

A. References

Reference	Title
52-31-00-580-801	Open the Cargo Door (P/B 201)
52-31-00-580-802	Close the Cargo Door (P/B 201)

B. Location Zones

Zone	Area
100	Lower Half of Fuselage
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Remove the Cargo Compartment Net

SUBTASK 25-52-12-010-001

- (1) Open the cargo door, do this task: Open the Cargo Door, TASK 52-31-00-580-801.

SUBTASK 25-52-12-030-002

- (2) Disengage the net strap buckles to release it from the O-rings on the cargo compartment net.

SUBTASK 25-52-12-030-001

- (3) Loosen the adjustable net straps to release the tension in the net straps, if necessary.

SUBTASK 25-52-12-030-003

- (4) Disconnect the tiedown fittings from the floor attachment anchor plates in the floor and the sidewall.

SUBTASK 25-52-12-030-004

- (5) Disconnect the tiedown fittings from the ceiling attachment anchor plates in the ceiling.

SUBTASK 25-52-12-020-001

- (6) Remove the cargo compartment nets.

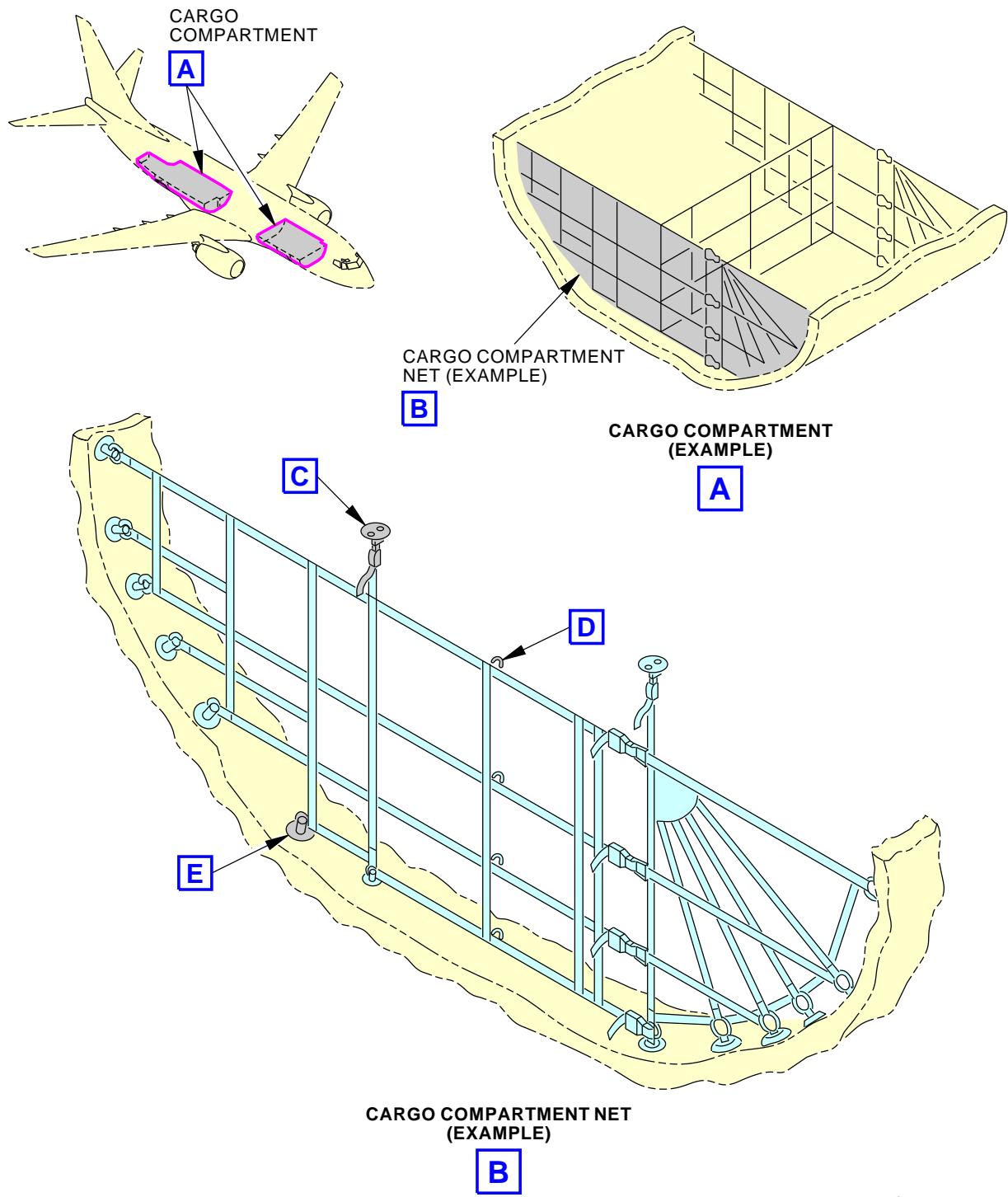
SUBTASK 25-52-12-410-001

- (7) If necessary, close the cargo door, do this task: Close the Cargo Door, TASK 52-31-00-580-802.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-52-12



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Cargo Compartment Net Installation
Figure 401/25-52-12-990-801 (Sheet 1 of 2)

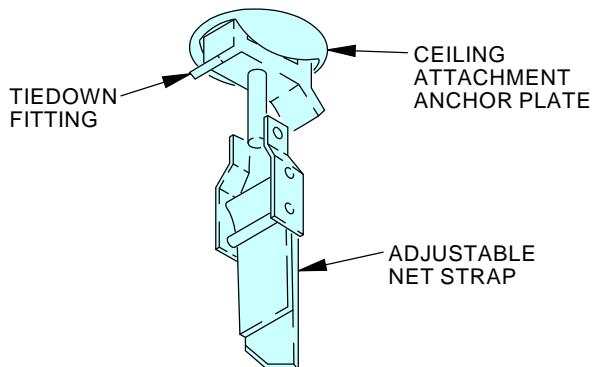
EFFECTIVITY
 AKS ALL

25-52-12

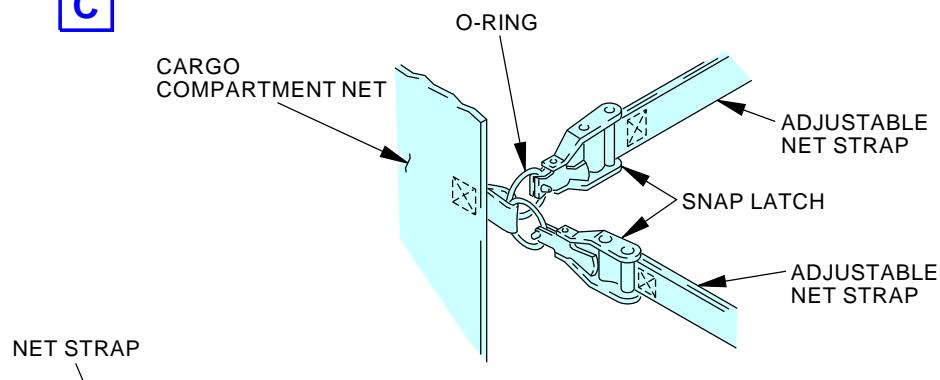
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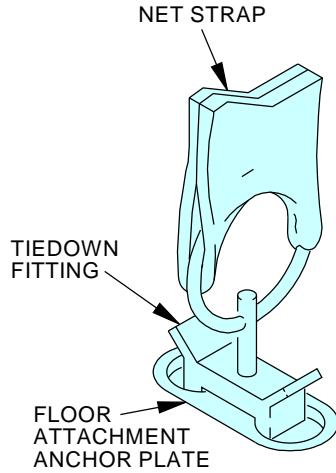
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AIRCRAFT MAINTENANCE MANUAL



C



D



E

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Cargo Compartment Net Installation
Figure 401/25-52-12-990-801 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-52-12



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AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-12-420-801

3. Cargo Compartment Net Installation

(Figure 401)

A. References

Reference	Title
52-31-00-580-801	Open the Cargo Door (P/B 201)
52-31-00-580-802	Close the Cargo Door (P/B 201)

B. Location Zones

Zone	Area
100	Lower Half of Fuselage
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Install the Cargo Compartment Net

SUBTASK 25-52-12-010-003

- (1) To open the cargo door, do this task: Open the Cargo Door, TASK 52-31-00-580-801.

SUBTASK 25-52-12-430-001

- (2) Connect the tiedown fittings to the ceiling attachment anchor plates in the ceiling.

SUBTASK 25-52-12-430-002

- (3) Connect the tiedown fittings to the floor attachment anchor plates in the sidewall and the floor.

SUBTASK 25-52-12-430-003

- (4) Connect the net strap buckles to the O-rings on the cargo compartment net.

SUBTASK 25-52-12-430-004

- (5) Tighten the adjustable net straps to increase the tension in the net straps.

SUBTASK 25-52-12-410-002

- (6) Close the cargo door, do this task: Close the Cargo Door, TASK 52-31-00-580-802.

———— END OF TASK ————

TASK 25-52-12-900-801

4. Cargo Net Snap Latch Replacement

A. Consumable Materials

Reference	Description	Specification
G50386	Thread - Nylon, Class A Size F, Z Twist, Color Flat Gray per TT-L-20A	A-A-59826 (Supersedes V-T-295) Type II
G50387	Thread - Nylon, Class A Size FF, Z Twist, Color Flat Gray per TT-L-20A	A-A-59826 (Supersedes V-T-295) Type II
G50389	Webbing - Textile, Woven Nylon, 1 Inch (25.4 mm) Width, Type XVII, Color Flat Gray Per TT-L-20A	MIL-W-4088 Type XVII
G50390	Webbing - Textile, Woven Nylon, 1 Inch (25.4 mm) Width, Type XVIII, Untreated	MIL-W-4088 Type XVIII



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
G50391	Webbing - Textile, Woven Nylon, Impregnated	MIL-W-27265 class R, Z twist, color flat gray per TT-L-20A

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Snap Latch Replacement

SUBTASK 25-52-12-960-001

- (1) To replace the snap latch do these steps:

- (a) Cut the existing cargo net webbing at the end of the snap latch.
NOTE: These steps can be used with the other net components.
 - 1) Note the stitch pattern.
- (b) Cut a new strip of nylon webbing.
 - 1) Melt the ends to prevent unraveling.
 - 2) Use any of this web material, nylon webbing, G50389, nylon webbing, G50390 or, nylon webbing, G50391.
- (c) Put the web material through the fitting.
- (d) Fold the ends under.
- (e) Sew the new web strip to the existing web material.
 - 1) There should be 8 stitches per inch.
 - 2) The stitch pattern is to be a box - X pattern.
 - 3) Use any of these threads, nylon thread, G50386 or nylon thread, G50387.

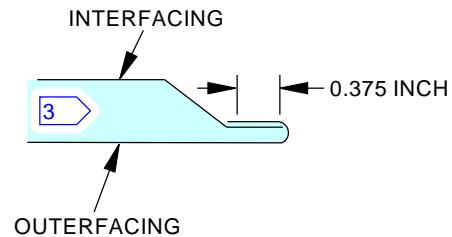
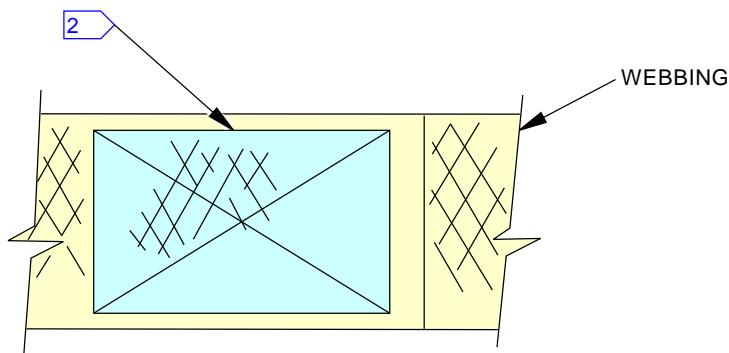
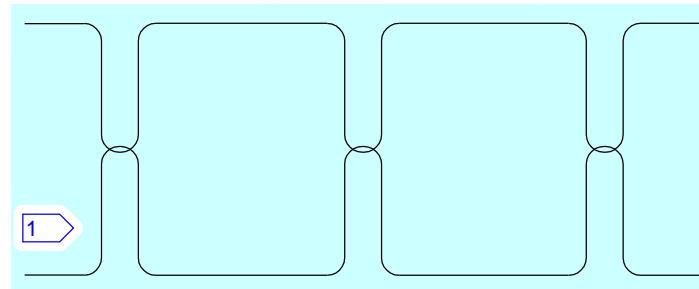
———— END OF TASK ————



25-52-12



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CAUTION:

DO NOT SEW FABRIC TO FABRIC

- 1** STITCH PATTERN FOR ATTACHING FABRIC TO WEBBING
WITH 8 STITCHES PER INCH ALLOWABLE.
- 2** STITCH PATTERN FOR SEWING WEBBING TO WEBBING
WITH 8 STITCHES PER INCH ALLOWABLE.
- 3** FABRIC SEAM AS INDICATED

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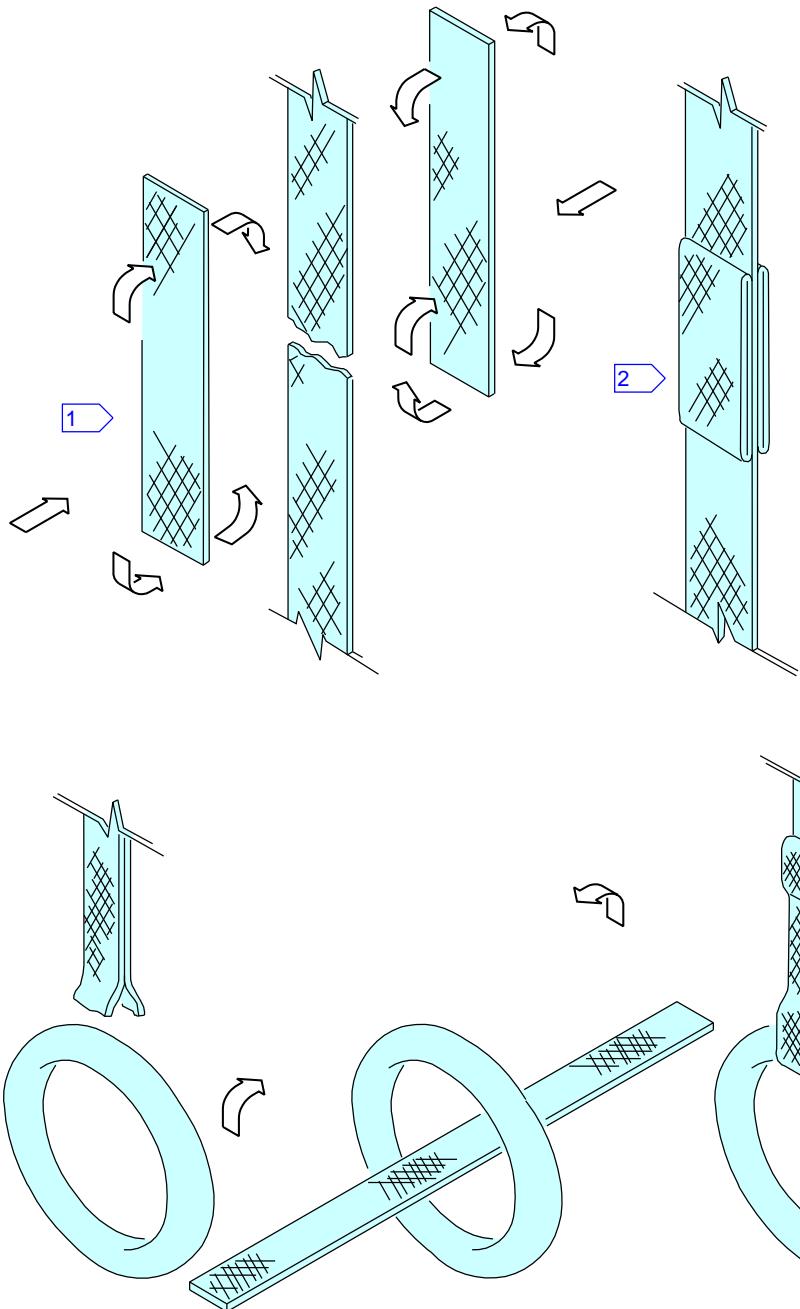
Snap Latch Replacement
Figure 402/25-52-12-990-802 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

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25-52-12

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Snap Latch Replacement
Figure 402/25-52-12-990-802 (Sheet 2 of 2)

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AIRCRAFT MAINTENANCE MANUAL

FORWARD CARGO COMPARTMENT FORWARD BULKHEAD LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Forward Cargo Compartment Forward Bulkhead Liner Removal,
 - (2) Forward Cargo Compartment Forward Bulkhead Liner Installation.

TASK 25-52-16-000-801

2. Forward Cargo Compartment Forward Bulkhead Liner - Removal

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

B. Procedure

(Figure 401)

SUBTASK 25-52-16-020-001

- (1) Release the 1/4 turn fasteners that are around the edges of the bulkhead liner [1].

SUBTASK 25-52-16-020-002

- (2) Remove the liner [1].

NOTE: Make sure the foam seals are attached to the airplane structure when you remove the liner.

SUBTASK 25-52-16-020-003

- (3) Release the 1/4 turn fasteners that are around the edges of the pressure relief panel [2].

SUBTASK 25-52-16-020-004

- (4) Remove the pressure relief panel [2].

NOTE: Make sure the foam seals are attached to the airplane structure when you remove the panel.

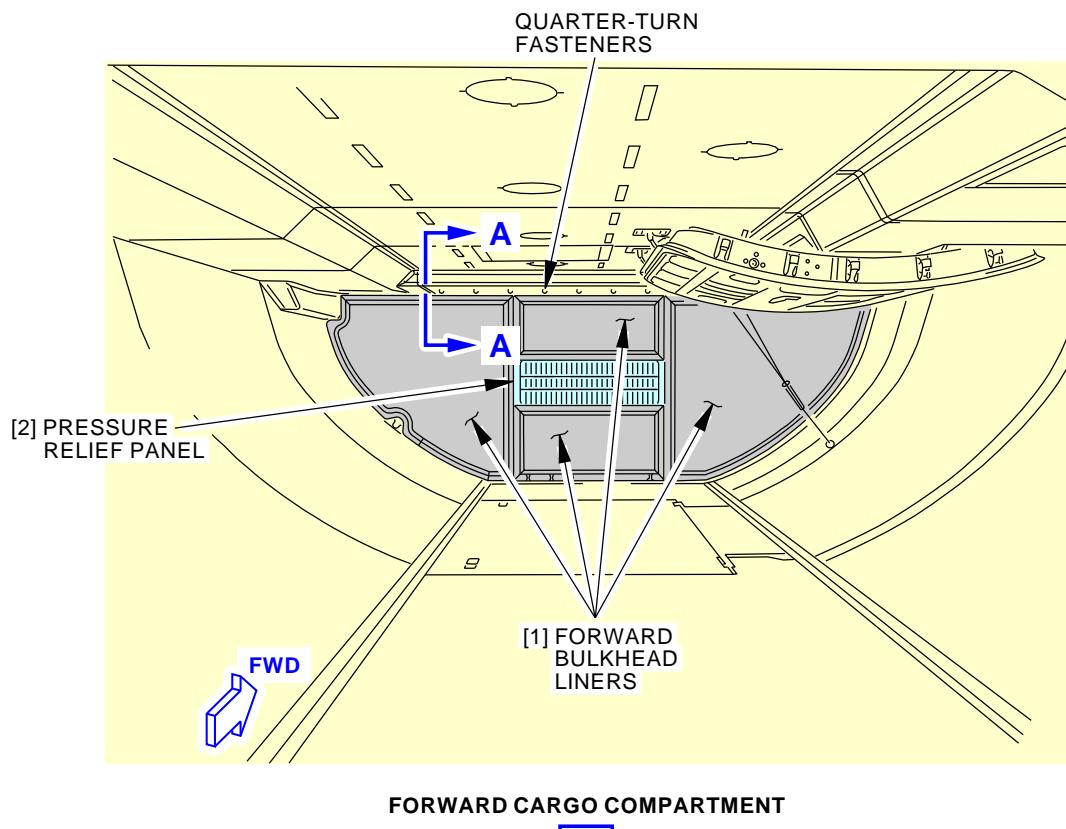
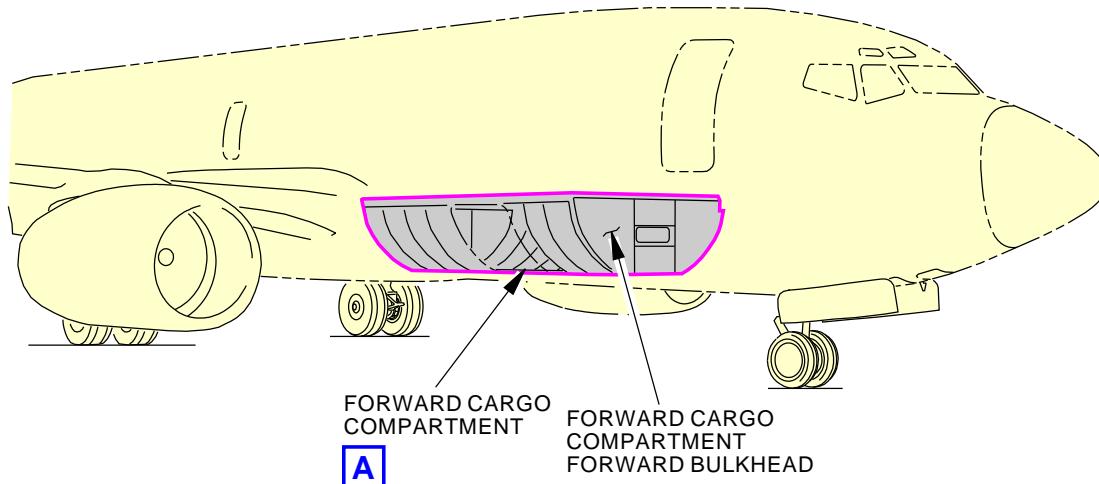
———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-52-16



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AIRCRAFT MAINTENANCE MANUAL



G95657 S0006567719_V3

Forward Cargo Compartment Forward Bulkhead Liner Installation
Figure 401/25-52-16-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

25-52-16

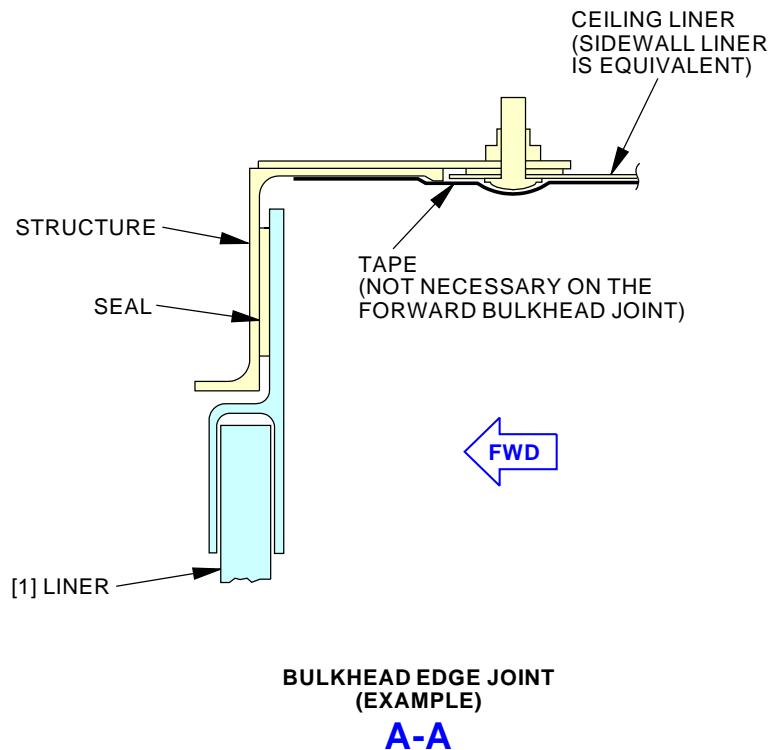
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Forward Cargo Compartment Forward Bulkhead Liner Installation
Figure 401/25-52-16-990-801 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-52-16-400-801

3. Forward Cargo Compartment Forward Bulkhead Liner - Installation

A. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III

B. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

C. Procedure

(Figure 401)

SUBTASK 25-52-16-210-001

- (1) Examine the seal, G02186, on the airplane structure.
 - (a) Replace the foam seals if they are damaged or missing.

NOTE: The foam seal must be continuous around all the edges of the opening for the liner.

SUBTASK 25-52-16-420-001

- (2) Put the pressure relief panel [2] in its position.

SUBTASK 25-52-16-420-002

- (3) Lock the 1/4 turn fasteners that are around the edges of the pressure relief panel [2].

SUBTASK 25-52-16-420-003

- (4) Put the liner [1] in its position.

SUBTASK 25-52-16-420-004

- (5) Lock the 1/4 turn fasteners that are around the edges of the liner [1].

NOTE: You do not need to apply tape to seal this liner.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-52-16



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AIRCRAFT MAINTENANCE MANUAL

FORWARD CARGO COMPARTMENT AFT BULKHEAD LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Forward Cargo Compartment Aft Bulkhead Liner Removal,
 - (2) Forward Cargo Compartment Aft Bulkhead Liner Installation.

TASK 25-52-17-000-801

2. Forward Cargo Compartment Aft Bulkhead Liner - Removal

(Figure 401)

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

B. Procedure

SUBTASK 25-52-17-020-001

- (1) Release the 1/4 turn fasteners that are around the edges of the bulkhead.

SUBTASK 25-52-17-020-002

- (2) Remove the lining.

NOTE: Make sure the foam seals are attached to the structure when you remove the lining.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

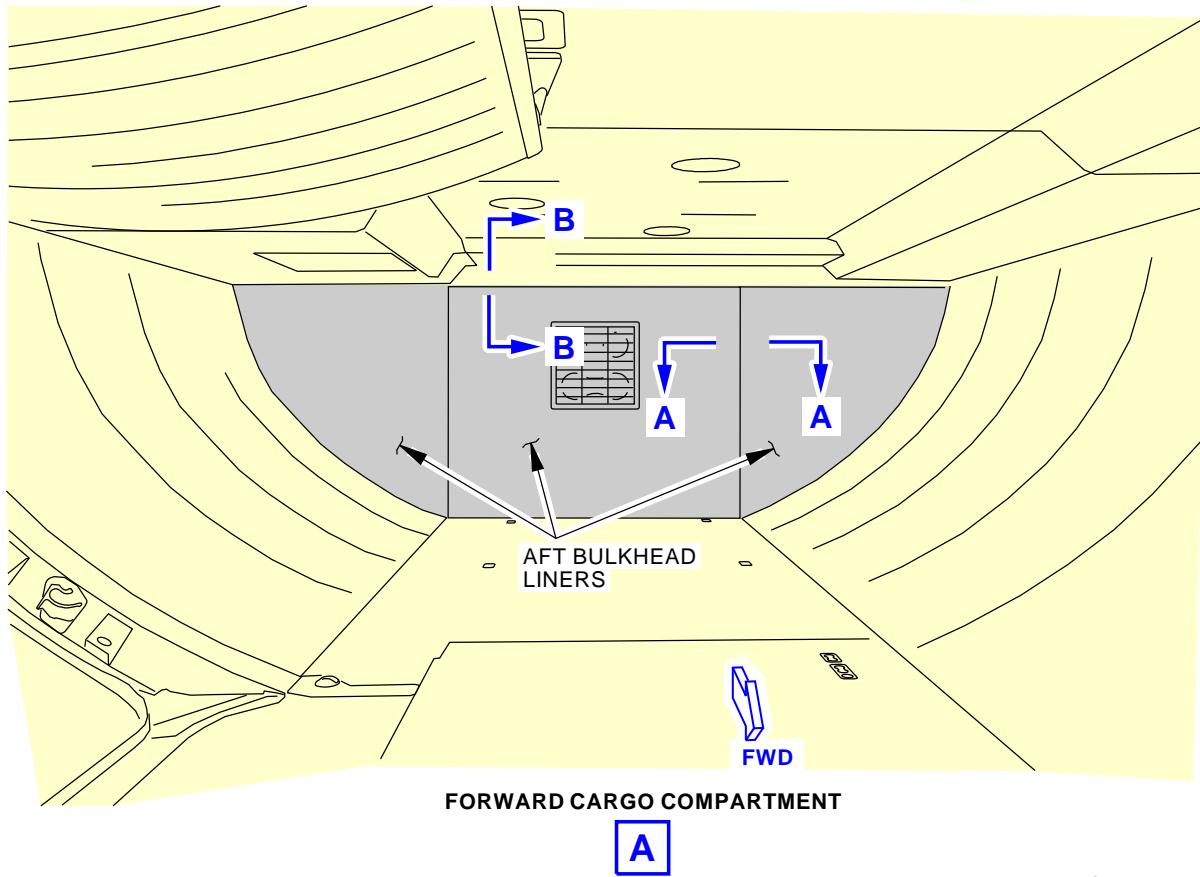
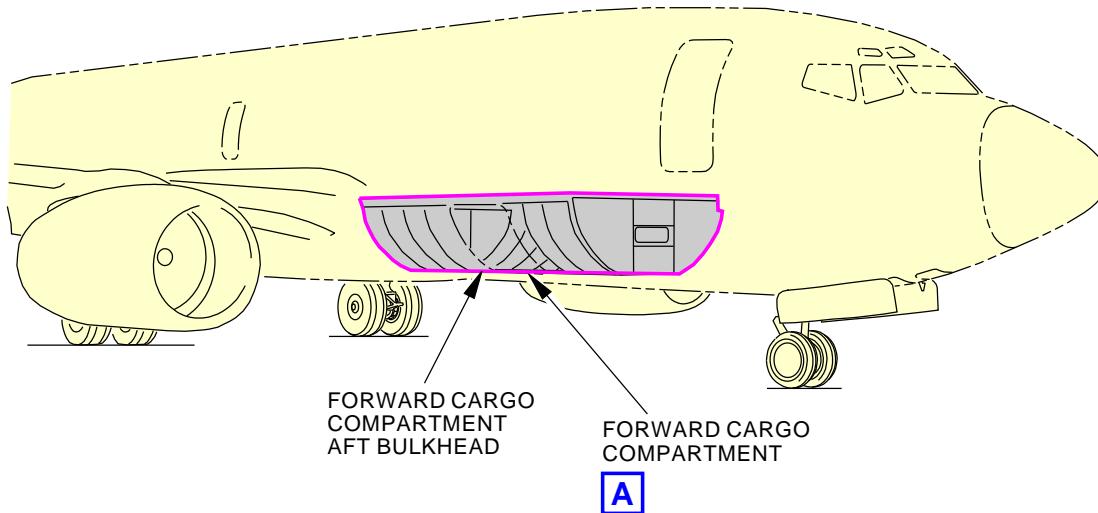
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Forward Cargo Compartment Aft Bulkhead Liner Installation
Figure 401/25-52-17-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

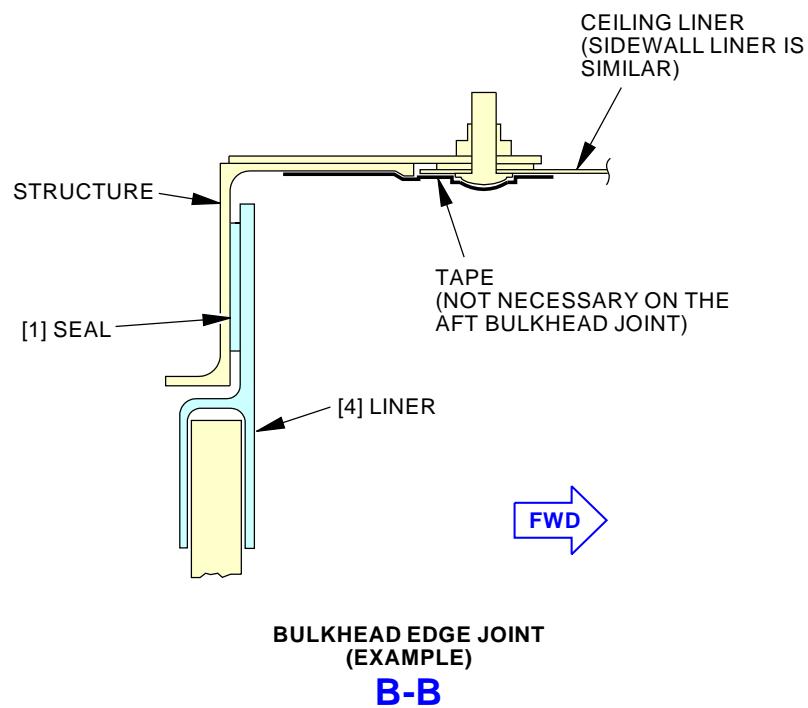
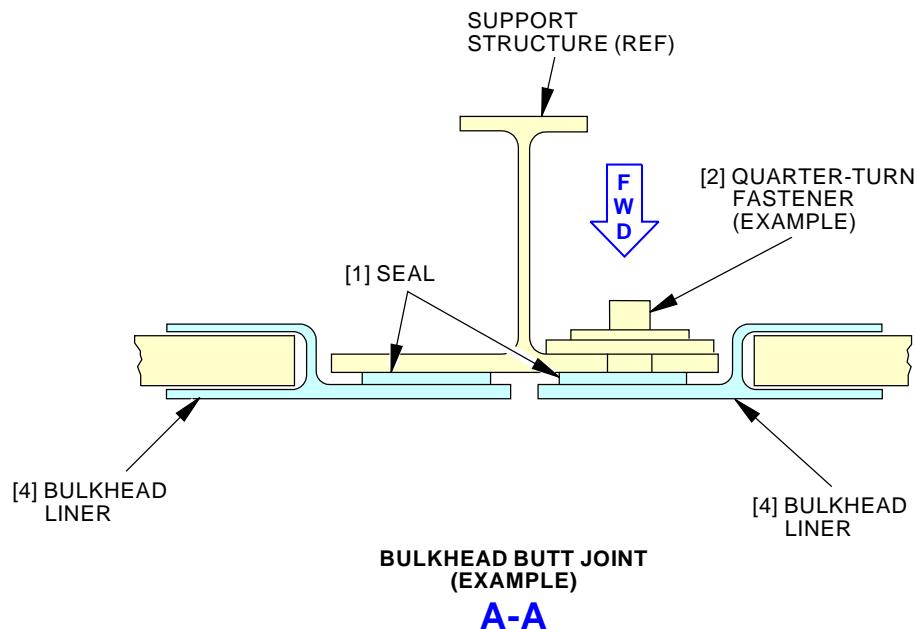
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AIRCRAFT MAINTENANCE MANUAL



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Forward Cargo Compartment Aft Bulkhead Liner Installation
Figure 401/25-52-17-990-801 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-52-17



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AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-17-400-801

3. Forward Cargo Compartment Aft Bulkhead Liner - Installation
(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III

B. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

C. Procedure

SUBTASK 25-52-17-210-001

- (1) Examine the seal, G02186, on the structure.

- (a) Replace the foam seals if they are damaged or missing.

NOTE: The foam seal must be continuous around all the edges of the opening for the liner.

SUBTASK 25-52-17-420-001

- (2) Put the liner in its position.

SUBTASK 25-52-17-420-002

- (3) Lock the quarter-turn fasteners that are around the edge of the liner.

NOTE: You do not need to apply tape to seal this liner.

———— END OF TASK ————

EFFECTIVITY

AKS ALL

25-52-17



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AIRCRAFT MAINTENANCE MANUAL

AFT CARGO COMPARTMENT FORWARD BULKHEAD LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Aft Cargo Compartment Forward Bulkhead Liner Removal,
 - (2) Aft Cargo Compartment Forward Bulkhead Liner Installation.

TASK 25-52-18-000-801

2. Aft Cargo Compartment Forward Bulkhead Liner - Removal

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146

B. Location Zones

Zone	Area
100	Lower Half of Fuselage
145	Aft Cargo Compartment Equipment Bay - Left

C. Remove the Liner

SUBTASK 25-52-18-020-001

- (1) Remove and discard the Nitto P-629 tape, G50428.

SUBTASK 25-52-18-020-002

- (2) Remove the screws [7] from the cap strips [6] and remove the cap strips [6].

SUBTASK 25-52-18-020-003

- (3) Remove the liners in this sequence: [1], [2], [3], and then [4] or [5]. To remove them, remove the screws [7] from the liner.

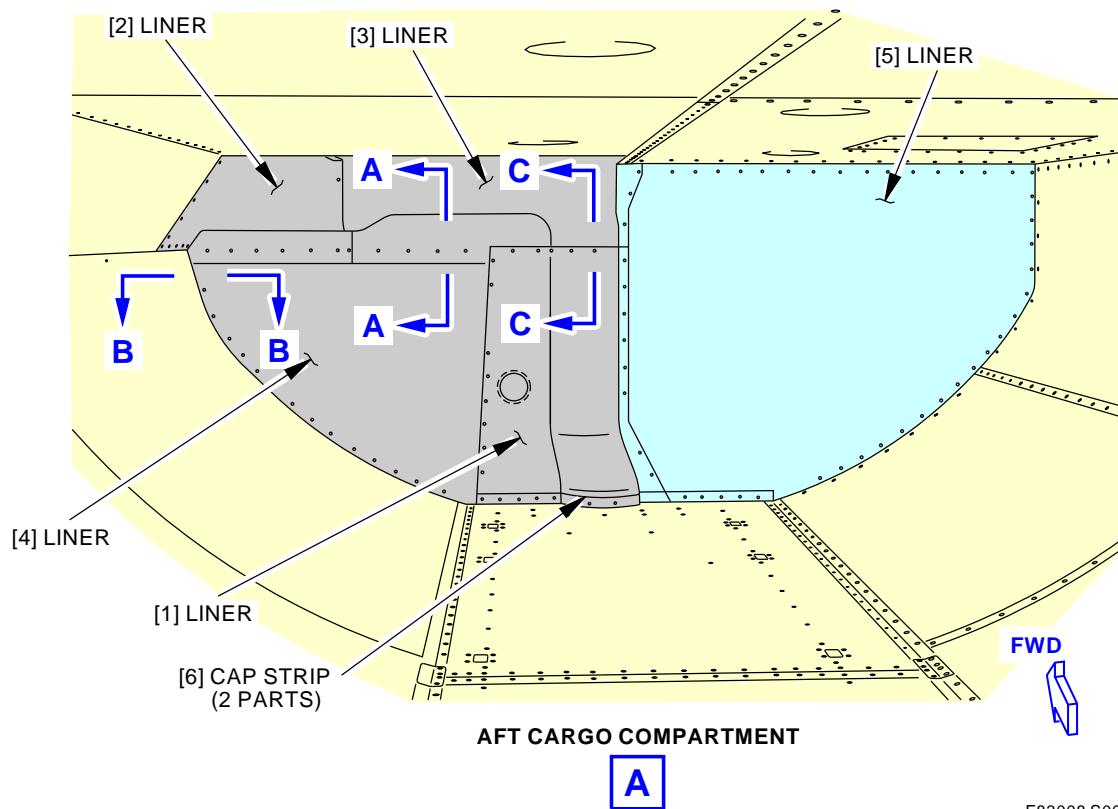
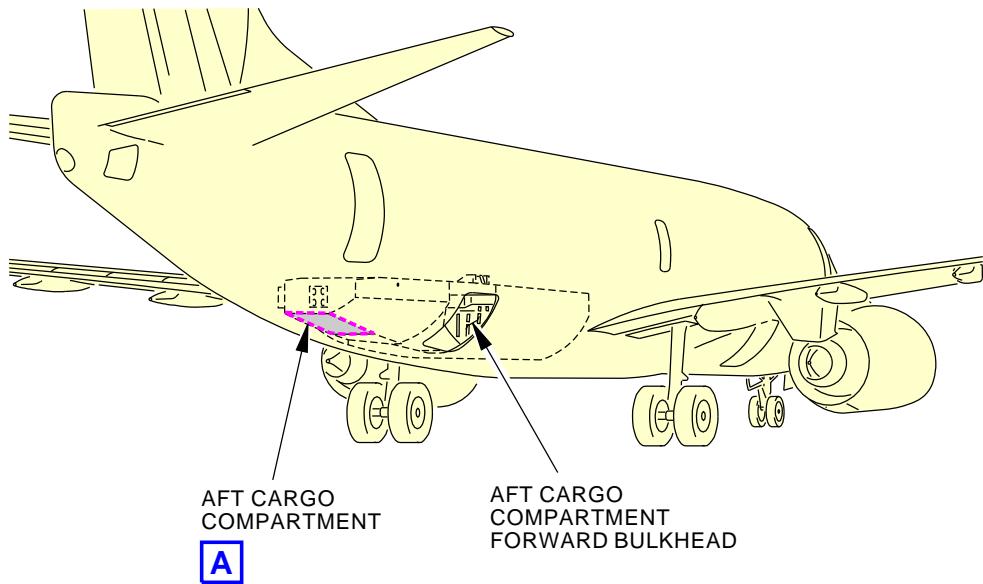
———— END OF TASK ————



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Aft Cargo Compartment Forward Bulkhead Liner Installation
Figure 401/25-52-18-990-801 (Sheet 1 of 2)

EFFECTIVITY
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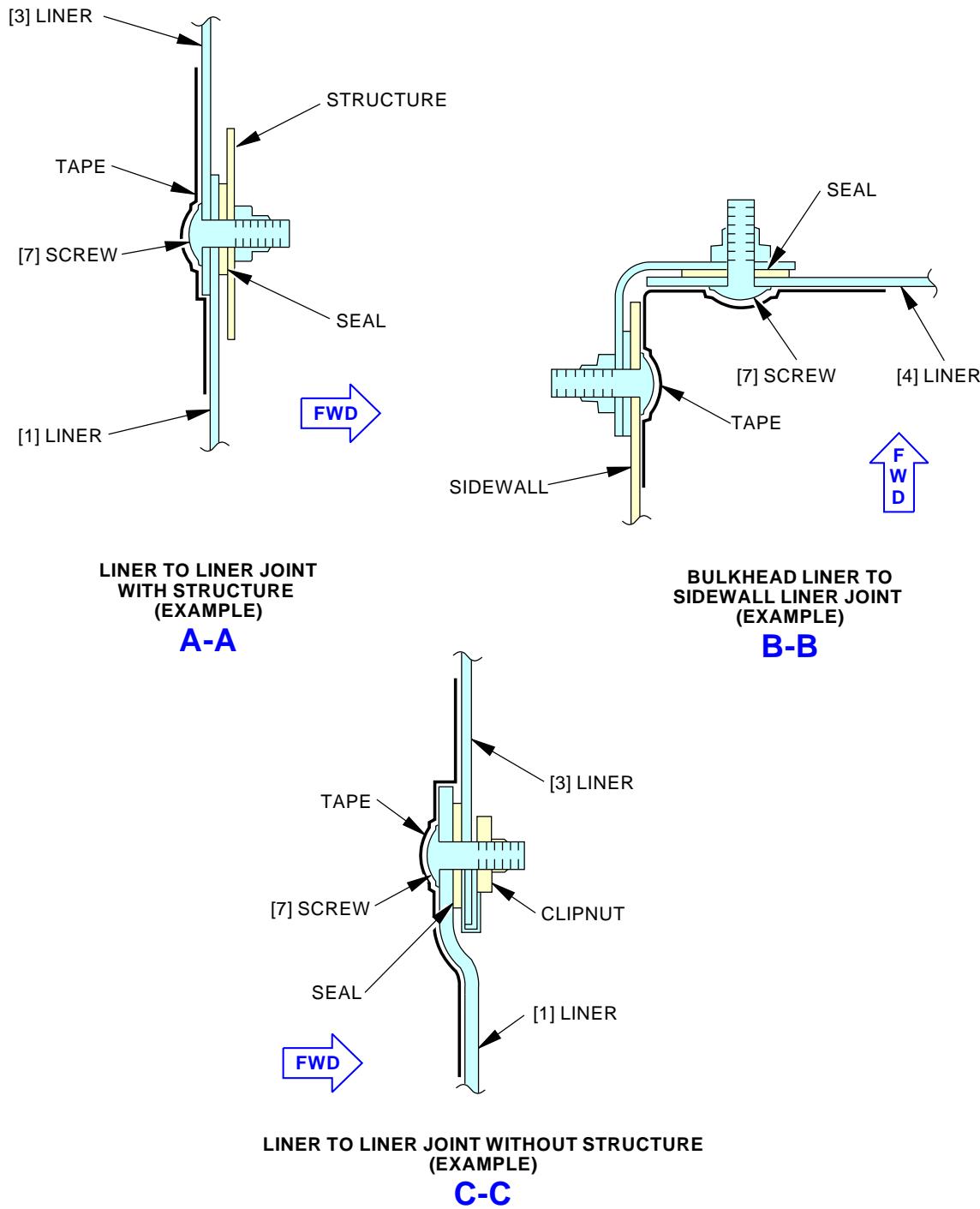
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Aft Cargo Compartment Forward Bulkhead Liner Installation
Figure 401/25-52-18-990-801 (Sheet 2 of 2)

EFFECTIVITY	AKS ALL
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AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-18-400-801

3. Aft Cargo Compartment Forward Bulkhead Liner - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146

B. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left

C. Install the Liner

SUBTASK 25-52-18-210-001

- (1) Examine the seal, G02186, on the structure. Also examine seal, G02186, on the liners.

NOTE: The foam seal must be continuous around all the edges of the opening for each piece of the liner. Most of the foam seals should be on the structure. However, there should be foam seals between the liners when two liners have an overlap at a location where there is no structure. That is, where the liner has clip nuts on it, it should have a foam seal.

- (a) Replace the foam seals if they are damaged or missing.

SUBTASK 25-52-18-420-001

- (2) Install the liners in this sequence: [4] and [5], then [3], [2], and [1]. To install the liners, put the liner in its position and install the screws [7].

SUBTASK 25-52-18-420-002

- (3) Install the cap strips [6] with the screws [7].

SUBTASK 25-52-18-420-003

- (4) Install new Nitto P-629 tape, G50428, on all the joints and edges of the liners.

———— END OF TASK ————



25-52-18



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AIRCRAFT MAINTENANCE MANUAL

AFT CARGO COMPARTMENT AFT BULKHEAD PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Aft Cargo Compartment Aft Bulkhead Liner Removal,
 - (2) Aft Cargo Compartment Aft Bulkhead Liner Installation.

TASK 25-52-19-000-801

2. Aft Cargo Compartment Aft Bulkhead Liner - Removal

(Figure 401)

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Procedure

SUBTASK 25-52-19-020-001

- (1) Release the 1/4 turn fasteners that are around the edges of the bulkhead liner [1].

SUBTASK 25-52-19-020-002

- (2) Remove the liner [1].

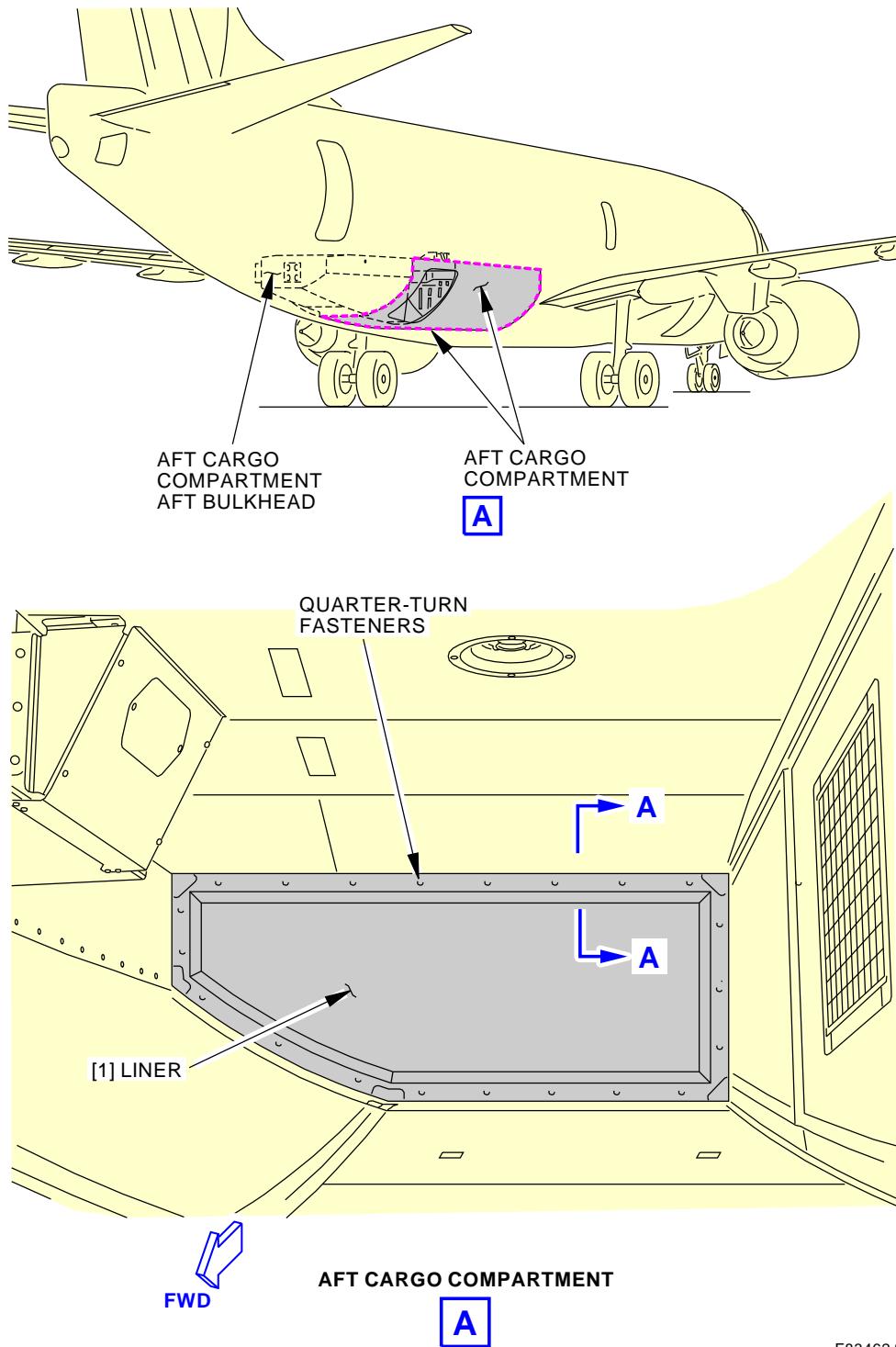
NOTE: Make sure the foam seals are attached to the structure when you remove the liner.

———— END OF TASK ————

EFFECTIVITY

AKS ALL

25-52-19



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Aft Cargo Compartment Aft Bulkhead Liner Installation
Figure 401/25-52-19-990-801 (Sheet 1 of 2)

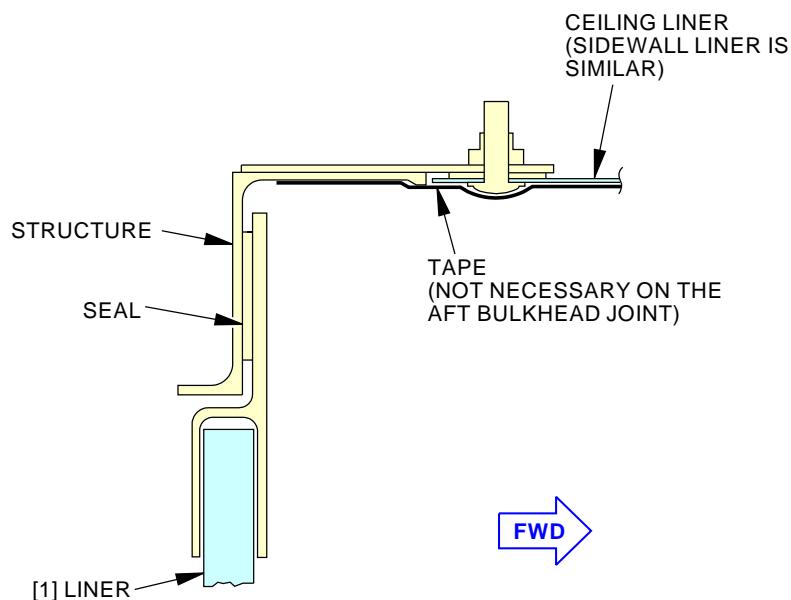
EFFECTIVITY
AKS ALL

25-52-19

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



BULKHEAD EDGE JOINT (EXAMPLE)

A-A

F83836 S0006567740_V3

Aft Cargo Compartment Aft Bulkhead Liner Installation
Figure 401/25-52-19-990-801 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-52-19



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AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-19-400-801

3. Aft Cargo Compartment Aft Bulkhead Liner - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III

B. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Procedure

SUBTASK 25-52-19-210-001

- (1) Examine the seal, G02186, on the structure.

- (a) Replace the foam seals if they are damaged or missing.

NOTE: The foam seal must be continuous around all the edges of the opening for the liner.

SUBTASK 25-52-19-420-001

- (2) Put the liner [1] in its position.

SUBTASK 25-52-19-420-002

- (3) Lock the 1/4 turn fasteners that are around the edges of the liner [1].

NOTE: You do not need to apply tape to seal this liner.

———— END OF TASK ———



25-52-19



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AIRCRAFT MAINTENANCE MANUAL

WASTE TANK ENCLOSURE PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Waste Tank Enclosure Panel Removal
 - (2) Waste Tank Enclosure Panel Installation

TASK 25-52-20-000-801

2. Waste Tank Enclosure Panel - Removal

(Figure 401)

A. General

- (1) This task removes one of the panels that make up the waste tank enclosure. Do this task for the remaining panels if it is necessary to remove the full enclosure.

B. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left

C. Procedure

SUBTASK 25-52-20-020-001

- (1) Release the 1/4 turn fasteners.

SUBTASK 25-52-20-020-002

- (2) Remove the panel [1] from the support structure.

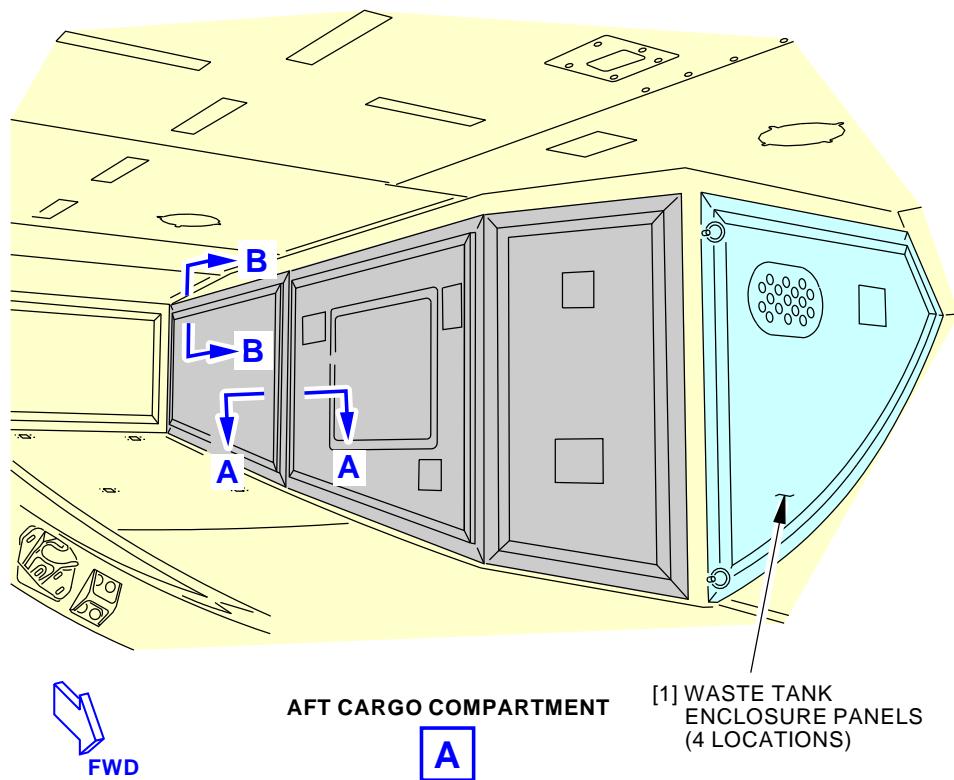
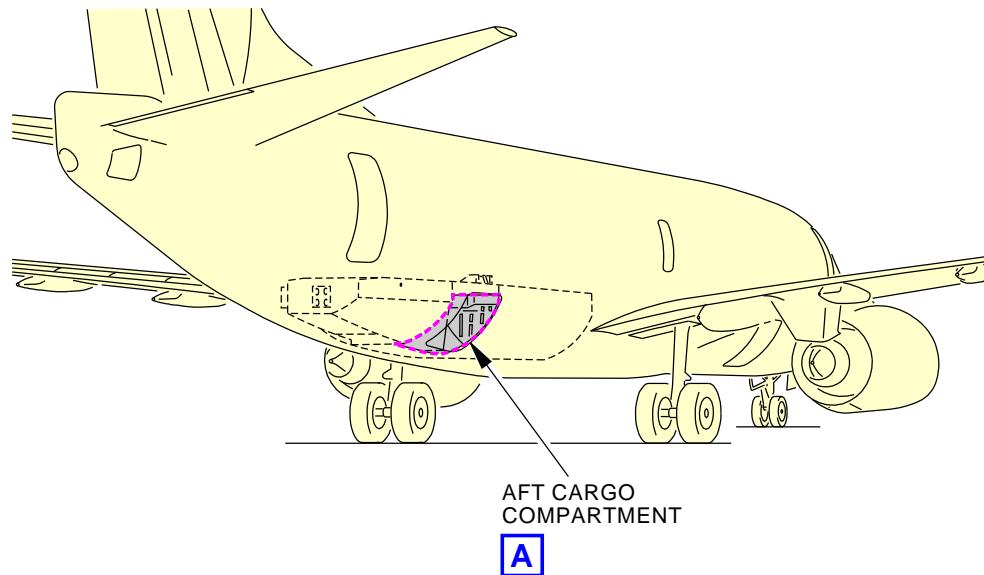
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25-52-20



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Waste Tank Enclosure Panels Installation
Figure 401/25-52-20-990-801 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

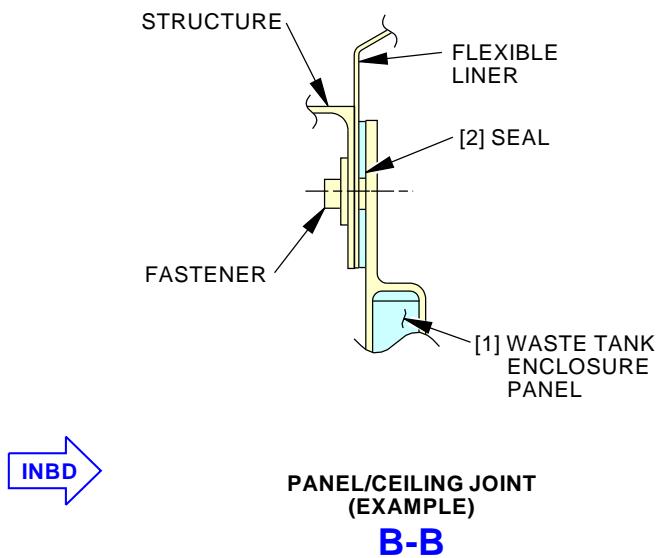
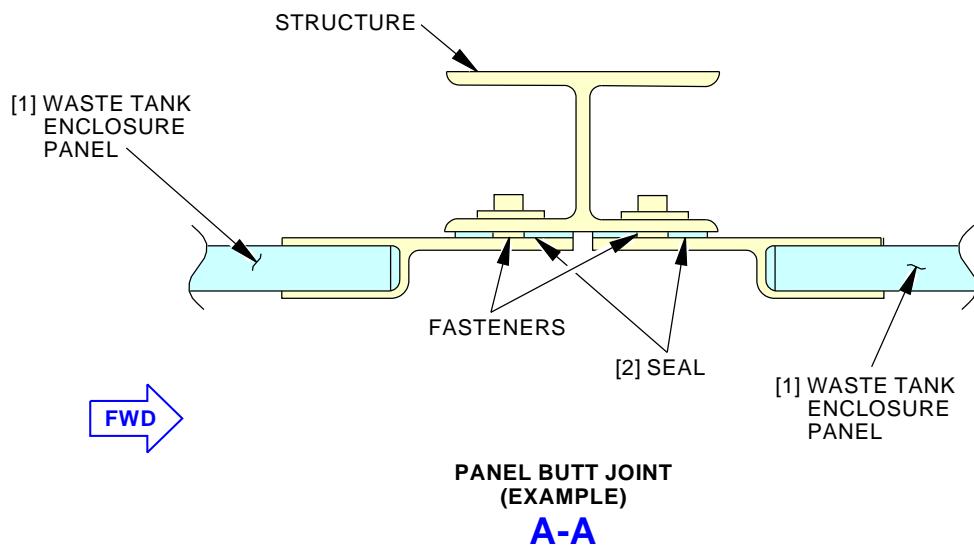
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Waste Tank Enclosure Panels Installation
Figure 401/25-52-20-990-801 (Sheet 2 of 2)

EFFECTIVITY	AKS ALL
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25-52-20



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TASK 25-52-20-400-801

3. Waste Tank Enclosure Panel - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III

B. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left

C. Procedure

SUBTASK 25-52-20-210-001

- (1) Examine the seal, G02186, [2] on the structure.

- (a) Replace the foam seals [2] if they are damaged or missing.

NOTE: The foam seal must be continuous around all the edges of the opening for the liner.

SUBTASK 25-52-20-210-002

- (2) Make sure the small flexible liner section (between the top of the panel and the ceiling liner) is in its position.

NOTE: The holes in the flexible liner must align with the fasteners in the structure.

SUBTASK 25-52-20-420-001

- (3) Put the panel [1] against the support structure.

SUBTASK 25-52-20-420-002

- (4) Turn the quick-release fasteners clockwise to attach the panel [1] to the support structure.

NOTE: You do not need to apply tape to seal this liner.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-52-20



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AIRCRAFT MAINTENANCE MANUAL

ESCAPE ROPES AND LIFE LINES - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains these tasks:
 - (1) Flight Compartment Escape Rope Removal
 - (2) Flight Compartment Escape Rope Installation
 - (3) Flight Compartment Escape Rope Inspection
 - (4) Emergency Exit Door Life Line Removal
 - (5) Emergency Exit Door Life Line Installation
 - (6) Emergency Exit Door Life Line Check

TASK 25-61-10-000-801

2. Flight Compartment Escape Rope Removal

(Figure 201)

A. General

- (1) An escape rope (also called an escape lanyard) is installed in the flight compartment above the captain's seat and above the first officer's seat.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-61-10-010-001

- (1) Open the cover for the escape rope [1].

SUBTASK 25-61-10-020-001

- (2) Open the hook and loop (Velcro) strap and pull the escape rope [1] from its compartment.
 - (a) If it is necessary, remove the cotter pin/safety pin [2] from the escape rope [1] anchor plate.

NOTE: The escape rope anchor plate is attached to the lanyard ring at the end of the escape rope [1].

SUBTASK 25-61-10-020-002

- (3) Pull the anchor fitting against the spring and disengage the anchor fitting from the anchor plate.

———— END OF TASK ————

TASK 25-61-10-400-801

3. Flight Compartment Escape Rope Installation

(Figure 201)

A. General

- (1) An escape rope (also called an escape lanyard) is installed in the flight compartment above the captain's seat and above the first officer's seat.

EFFECTIVITY
AKS ALL

25-61-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-61-10-420-001

- (1) Install the anchor fitting in the anchor plate.

SUBTASK 25-61-10-420-002

- (2) Make sure the anchor fitting is correctly engaged in the detent at the center of the anchor plate.

- (a) If it is necessary, install the cotter pin/safety pin [2] to the escape rope [1] anchor plate.

NOTE: The escape rope anchor plate is attached to the lanyard ring at the end of the escape rope [1].

SUBTASK 25-61-10-420-003

WARNING: IF PERSONNEL USED THE ESCAPE ROPE, REPLACE IT. YOU CANNOT EXAMINE THE CORE FOR DAMAGE. IF YOU DO NOT REPLACE A USED ESCAPE ROPE, INJURIES TO PERSONS CAN OCCUR.

- (3) Wind the escape rope [1] into a coil in its compartment. Wind it so that the loose end of the rope ends at the center of the coil. Keep approximately the last 4 in. (102 mm) of rope out of the coil.

- (a) Use the hook and loop (Velcro) straps to hold the escape rope [1] in its position. Put the free end of the escape [1] rope between the hook and loop straps. Make sure that the end of the escape rope [1] is easy to see and to get a hold of.

SUBTASK 25-61-10-410-001

- (4) Close the cover.

- (a) Make sure the latch holds the cover closed.

———— END OF TASK ————

TASK 25-61-10-210-801

4. Flight Compartment Escape Rope Inspection

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) An escape rope (also called an escape lanyard) is installed in the flight compartment above the captain's seat and above the first officer's seat.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Procedure

SUBTASK 25-61-10-020-010

- (1) Do this task: Flight Compartment Escape Rope Removal, TASK 25-61-10-000-801.



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SUBTASK 25-61-10-210-010

WARNING: IF PERSONNEL USED THE ESCAPE ROPE, REPLACE IT. YOU CANNOT EXAMINE THE CORE FOR DAMAGE. IF YOU DO NOT REPLACE A USED ESCAPE ROPE, INJURIES TO PERSONS CAN OCCUR.

- (2) Do a check of the escape rope and aircraft records for evidence that it was used. If you find evidence that the escape rope was used, replace the escape rope:
- Flight Compartment Escape Rope Removal, TASK 25-61-10-000-801
 - Flight Compartment Escape Rope Installation, TASK 25-61-10-400-801

SUBTASK 25-61-10-210-001

- (3) Do this check of each escape rope:
- (a) Make sure the rope is not wet or knotted.
 - (b) Make sure the rope is not fraying or have any worn areas.
- 1) If the escape rope is fraying or has worn areas, replace it.

SUBTASK 25-61-10-210-004

- (4) Make sure the anchor plate is not loose or corroded.
(5) Make sure the anchor fitting is not bent or corroded.

SUBTASK 25-61-10-210-006

- (6) Do this task: Flight Compartment Escape Rope Installation, TASK 25-61-10-400-801.

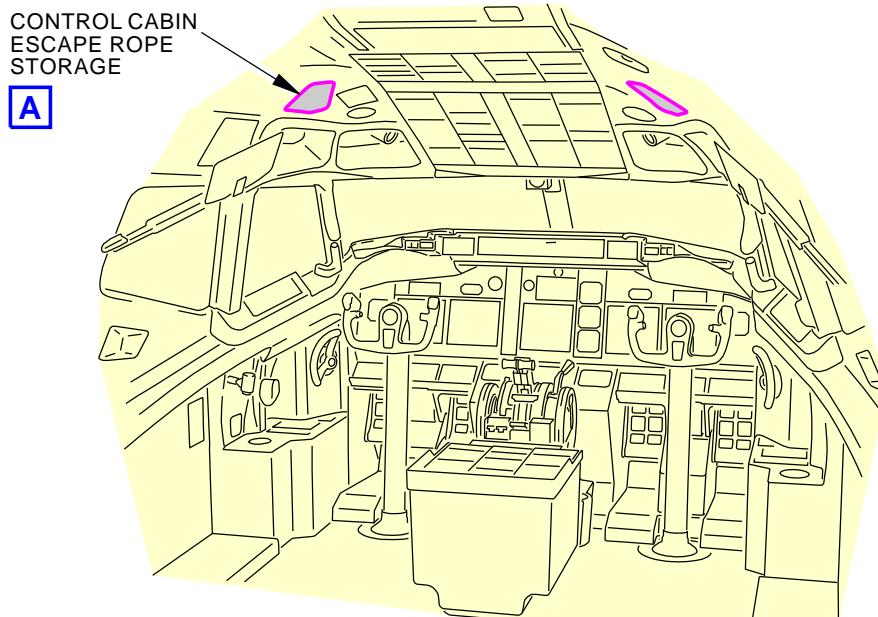
———— END OF TASK ————

EFFECTIVITY
AKS ALL

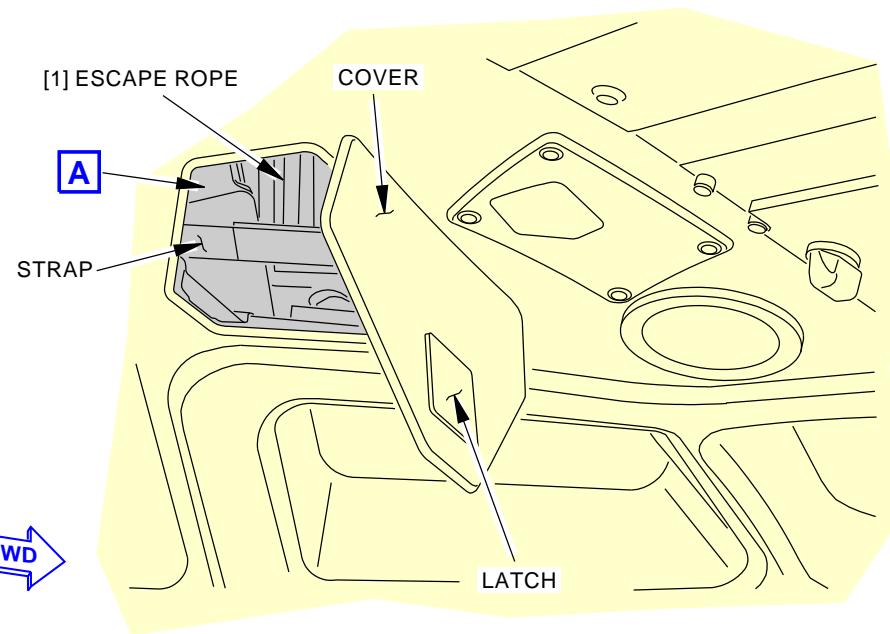
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



FLIGHT COMPARTMENT



CONTROL CABIN ESCAPE ROPE STORAGE
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)



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Escape Rope Installation
Figure 201/25-61-10-990-803 (Sheet 1 of 2)

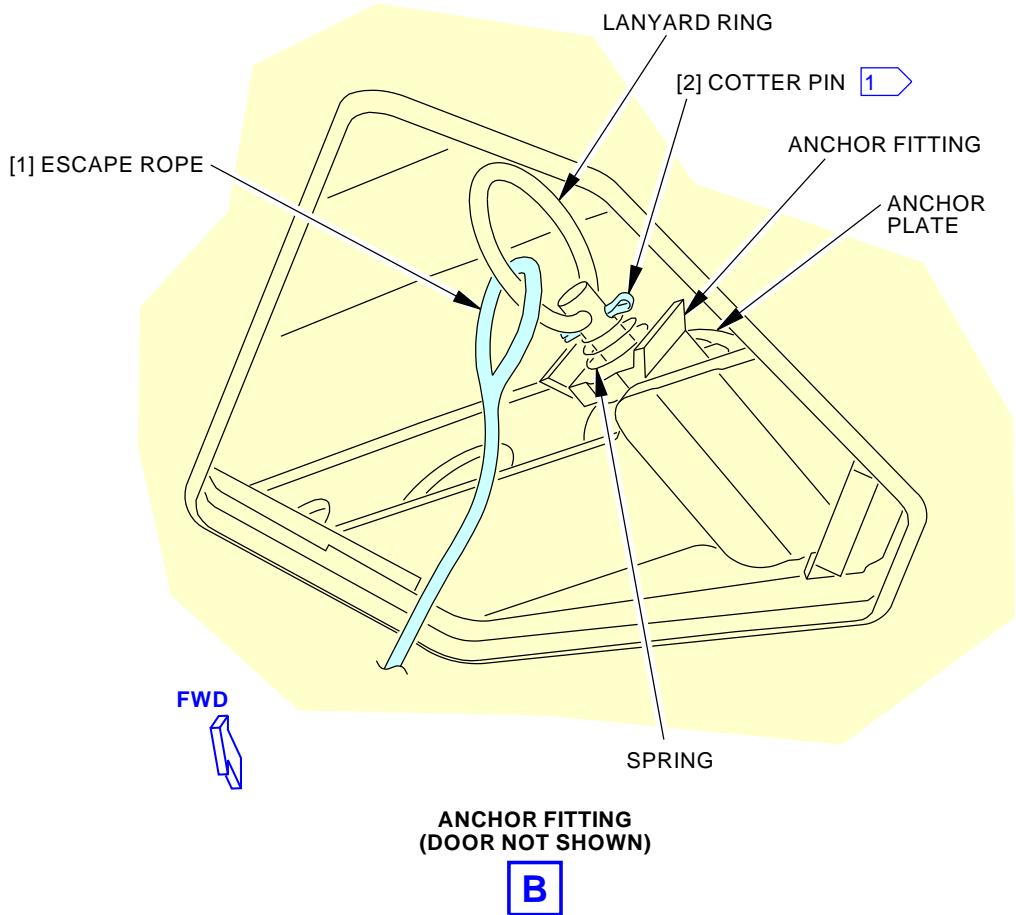
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IF THE LANYARD RING HAS A HOLE IN THE SHAFT NEAR THE SPRING, MAKE SURE THAT THE COTTER PIN IS INSTALLED.

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Escape Rope Installation
Figure 201/25-61-10-990-803 (Sheet 2 of 2)

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

TASK 25-61-10-000-802

5. Emergency Exit Door Life Line Removal

(Figure 202)

A. General

- (1) The life line (also called the escape strap) is kept in a stowage tube installed behind the sidewall and the ceiling panels of the passenger compartment. One end of the life line is attached to the doorway structure of the emergency exit door. In an emergency, the hook end of the life line is attached to the fitting on the wing. The life line is used to help the passengers when they are on the wing.
- (2) The Left Emergency Exit Door (STA 589.5), a Right Emergency Exit Door (STA 589.5), a Left Emergency Exit Door (STA 627.5), and a Right Emergency Exit Door (STA 627.5). The stowage tube that contains the life line is located over the Left Emergency Exit Door (627.5) and the Right Emergency Exit Door (STA 627.5).

B. References

Reference	Title
25-21-20 P/B 401	EMERGENCY EXIT DOORWAY LINING - REMOVAL/INSTALLATION

C. Location Zones

Zone	Area
833	Left Emergency Exit (STA 627.5)
843	Right Emergency Exit (STA 627.5)

D. Procedure

SUBTASK 25-61-10-010-007

WARNING: MAKE SURE THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

- (1) Open the emergency exit door.

SUBTASK 25-61-10-010-004

- (2) Open the cloth cover that holds the hook and life line [21].

SUBTASK 25-61-10-020-004

- (3) Pull the life line [21] out of the stowage tube.

SUBTASK 25-61-10-020-011

- (4) Remove the sidewall lining EMERGENCY EXIT DOORWAY LINING - REMOVAL/INSTALLATION, PAGEBLOCK 25-21-20/401

SUBTASK 25-61-10-020-005

- (5) Remove the nut [23], washers [24], and the bushing [22] that attach the life line anchor to the retainer.

SUBTASK 25-61-10-020-008

- (6) Remove the life line [21].

— END OF TASK —

EFFECTIVITY
AKS ALL

25-61-10



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 25-61-10-400-802

6. Emergency Exit Door Life Line Installation

(Figure 202)

A. General

- (1) The life line (also called the escape strap) is kept in a stowage tube installed behind the sidewall and the ceiling panels of the passenger compartment. One end of the life line is attached to the doorway structure of the emergency exit door. In an emergency, the hook end of the life line is attached to the fitting on the wing. The life line is used to help the passengers when they are on the wing.
- (2) The Left Emergency Exit Door (STA 589.5), a Right Emergency Exit Door (STA 589.5), a Left Emergency Exit Door (STA 627.5), and a Right Emergency Exit Door (STA 627.5). The stowage tube that contains the life line is located over the Left Emergency Exit Door (627.5) and the Right Emergency Exit Door (STA 627.5).

B. References

Reference	Title
25-21-20 P/B 401	EMERGENCY EXIT DOORWAY LINING - REMOVAL/INSTALLATION

C. Consumable Materials

Reference	Description	Specification
G00291	Tape - Aluminum Foil, Scotch 425	AMS-T-23397 / L-T-80

D. Location Zones

Zone	Area
833	Left Emergency Exit (STA 627.5)
843	Right Emergency Exit (STA 627.5)

E. Procedure

SUBTASK 25-61-10-420-018

- (1) Use Scotch 425 Aluminum Foil Tape, G00291, to keep the lifeline [21] folded. Wind the Scotch 425 Aluminum Foil Tape, G00291, a maximum of 1.5 times around the lifeline at each of the three locations shown (Figure 202).

SUBTASK 25-61-10-420-019

- (2) Push the life line [21] into the stowage tube.

SUBTASK 25-61-10-420-020

- (3) Install the washers [24], bushing [22], and the nut [23] to attach the life line anchor to the retainer.

SUBTASK 25-61-10-420-011

- (4) Close the cloth cover.

SUBTASK 25-61-10-420-023

- (5) Install the sidewall lining EMERGENCY EXIT DOORWAY LINING - REMOVAL/INSTALLATION, PAGEBLOCK 25-21-20/401

SUBTASK 25-61-10-420-021

- (6) Close the emergency exit door.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-61-10



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TASK 25-61-10-710-801

7. Emergency Exit Door Life Line Check

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) The life line (also called the escape strap) is kept in a stowage tube installed behind the sidewall and the ceiling panels of the passenger compartment. One end of the life line is attached to the doorway structure of the emergency exit door. In an emergency, the hook end of the life line is attached to the fitting on the wing. The life line is used to help the passengers when they are on the wing.
- (2) The Left Emergency Exit Door (STA 589.5), a Right Emergency Exit Door (STA 589.5), a Left Emergency Exit Door (STA 627.5), and a Right Emergency Exit Door (STA 627.5). The stowage tube that contains the life line is located over the Left Emergency Exit Door (627.5) and the Right Emergency Exit Door (STA 627.5).

B. Tools/Equipment

Reference	Description
STD-130	Brush - Soft-bristle Stainless Steel Wire

C. Consumable Materials

Reference	Description	Specification
D50080	Lubricant - Solid Film	MIL-PRF-46010 Type 1 (Supersedes MIL-L-8937)
G51031 [C10-105]	Abrasive - 120 Grit, Aluminum Oxide, Sandpaper Roll	

D. Location Zones

Zone	Area
833	Left Emergency Exit (STA 627.5)
843	Right Emergency Exit (STA 627.5)

E. Procedure

SUBTASK 25-61-10-010-008

WARNING: MAKE SURE THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

- (1) Open the emergency exit door.

SUBTASK 25-61-10-010-006

- (2) Open the cloth cover that holds the hook and life line [21].

SUBTASK 25-61-10-020-009

- (3) Pull the hook end of the life line [21] out over the wing.
 - (a) Make sure the life line [21] can be attached to the fitting on the wing.

SUBTASK 25-61-10-210-008

- (4) Do these steps to examine the condition of the life line [21]:

- (a) Make sure the life line [21] has no worn areas.
 - (b) Make sure the life line [21] is not wet.

EFFECTIVITY
AKS ALL

25-61-10



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AIRCRAFT MAINTENANCE MANUAL

- (c) Make sure the anchor on the end of the life line [21] is not loose, corroded, or cracked.

SUBTASK 25-61-10-210-009

- (5) Do these steps to examine the condition of the hook assembly:

- (a) Make sure that the hook assembly operates correctly.

- 1) The spring keeper snap hook on the hook must open smoothly.
- 2) The spring must close the spring keeper snap hook.

- (b) If the hook is bent, replace the life line.

NOTE: It is recommended that all new emergency hook assemblies are cadmium plated for better wear resistance.

- (c) Make sure that there is no corrosion on the hook assembly.

- 1) If corrosion prevents the operation of the hook assembly, replace the life line.

- a) Make sure that there is no corrosion on the spring.

<1> If the spring is missing or the keeper snap hook is defective, replace the life line.

- b) Remove corrosion on the spring keeper snap hook or the hook with mechanical procedures.

- 2) If there is minor corrosion, remove it.

- a) Use a soft-bristle stainless steel wire brush, STD-130 or sandpaper, G51031 [C10-105].

- (d) Add protection to the hook assembly with dry film lubricant.

- 1) Apply solid film lubricant, D50080 or equivalent heat cured dry film lubricant to the hook assembly.

NOTE: This lubricant will decrease worn parts, corrosion, prevent galling, and limit metal seizures.

NOTE: This lubricant looks almost the same as corrosion. If possible, use an Everlube lubricant but in a clear color.

SUBTASK 25-61-10-420-013

- (6) Fold the life line [21] as shown (Figure 202).

SUBTASK 25-61-10-420-016

- (7) Put the hook into the retainer and close the cloth cover.

SUBTASK 25-61-10-420-022

- (8) Close the emergency exit door.

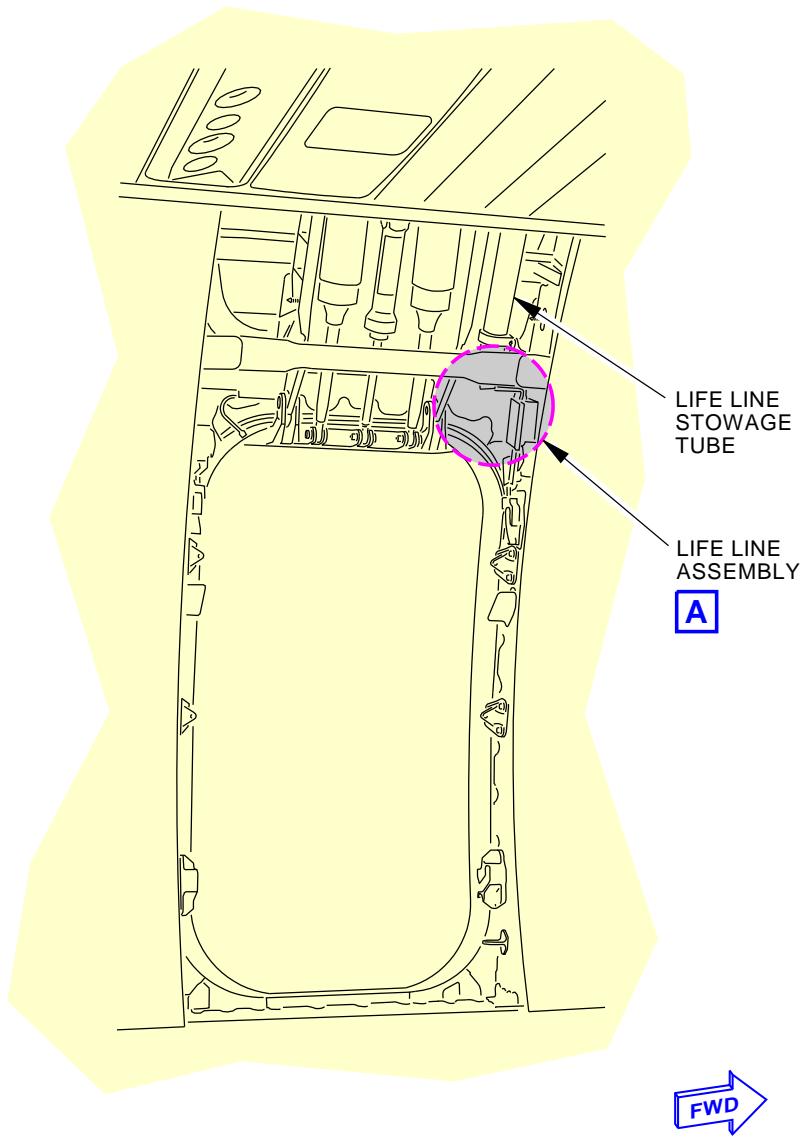
———— END OF TASK ———



25-61-10



737-600/700/800/900
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EMERGENCY EXIT DOOR
(DOOR SHOWN IN OPEN POSITION)
(DOOR LINER REMOVED)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

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Emergency Exit Door Life Line Installation
Figure 202/25-61-10-990-802 (Sheet 1 of 3)

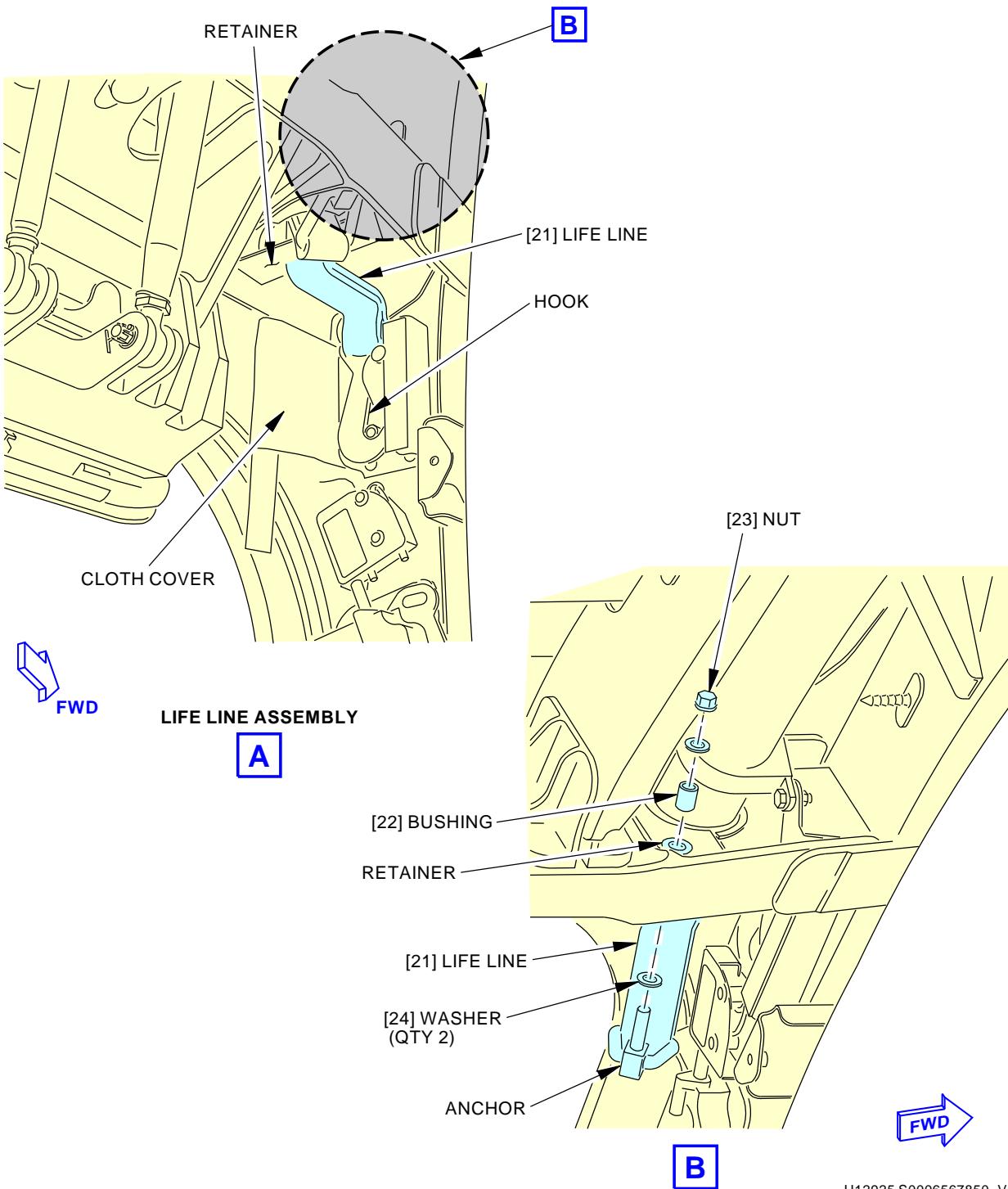
EFFECTIVITY
AKS ALL

25-61-10

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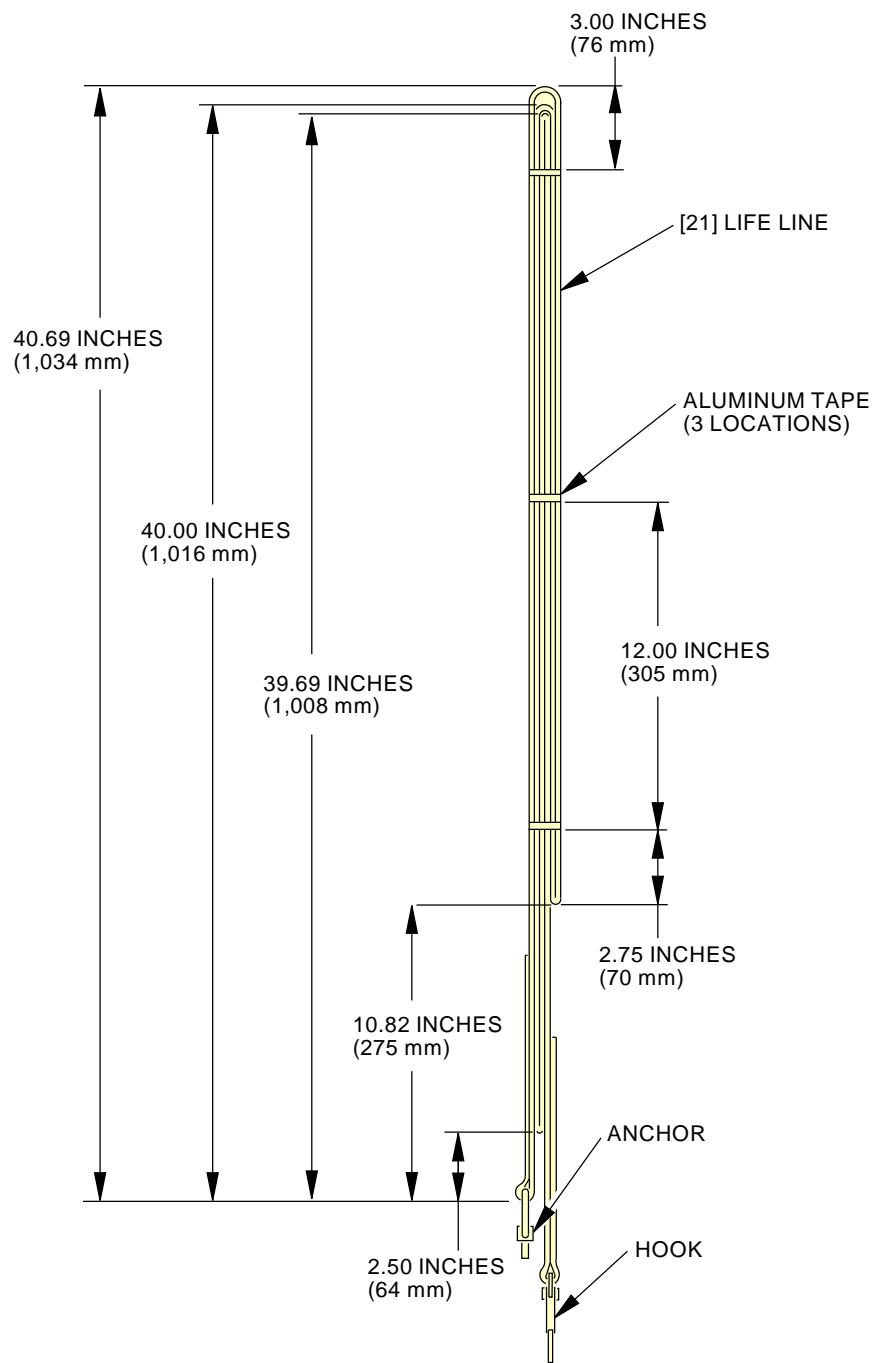
Emergency Exit Door Life Line Installation
Figure 202/25-61-10-990-802 (Sheet 2 of 3)

EFFECTIVITY
AKS ALL

25-61-10



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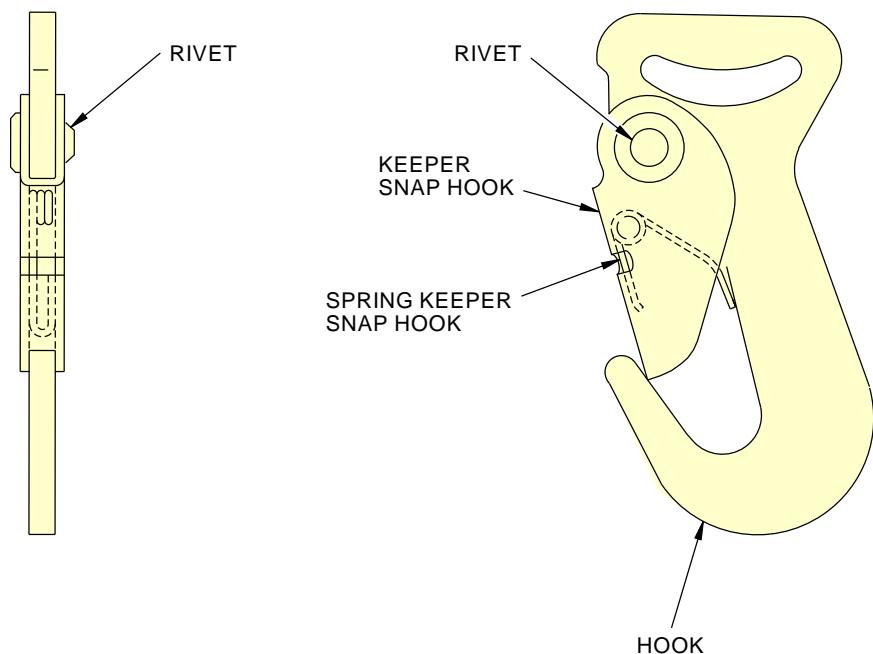
Emergency Exit Door Life Line Installation
Figure 202/25-61-10-990-802 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

25-61-10



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AIRCRAFT MAINTENANCE MANUAL



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Emergency Exit Door Life Line Inspection
Figure 203/25-61-10-990-804

EFFECTIVITY
AKS ALL

25-61-10

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DOOR WARNING STRAP REEL - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
 - (1) Door warning strap reel removal
 - (2) Door warning strap reel installation
 - (3) Post-Installation door warning strap reel test

TASK 25-61-13-000-801

2. Door Warning Strap Reel Removal

A. General

- (1) A door warning strap reel are installed on the doorways.

B. References

Reference	Title
25-21-46-000-801	Sidewall Panel - Removal (P/B 401)
25-24-15-000-807	Fixed Class Divider - Removal (P/B 401)
25-31-11-000-801	Galley No. 1 - Removal (P/B 401)
25-31-21-000-801	Galley No. 2 - Removal (P/B 401)
25-31-41-000-801-005	Galley No. 4 - Removal (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for removal

SUBTASK 25-61-13-000-001

- (1) If it is necessary, do this task: Fixed Class Divider - Removal, TASK 25-24-15-000-807.

SUBTASK 25-61-13-000-002

- (2) If it is necessary, do this task: Galley No. 1 - Removal, TASK 25-31-11-000-801.

SUBTASK 25-61-13-000-003

- (3) If it is necessary, do this task: Galley No. 2 - Removal, TASK 25-31-21-000-801.

SUBTASK 25-61-13-000-009

- (4) If it is necessary, do this task: Galley No. 4 - Removal, TASK 25-31-41-000-801-005.

SUBTASK 25-61-13-020-001

- (5) Do this task to remove the adjacent sidewall panels for access to the door warning strap reel:
Sidewall Panel - Removal, TASK 25-21-46-000-801.

E. Procedure

SUBTASK 25-61-13-000-005

- (1) Slide the strap through slit on retainer.

SUBTASK 25-61-13-000-006

- (2) Remove (4) fasteners [2] for the door warning strap reel [1].

SUBTASK 25-61-13-000-007

- (3) Remove the door warning strap reel [1].

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-61-13



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AIRCRAFT MAINTENANCE MANUAL

TASK 25-61-13-400-801

3. Door Warning Strap Reel Installation

(Figure 401)

A. References

Reference	Title
25-21-46-400-801	Sidewall Panel - Installation (P/B 401)
25-24-15-400-806	Fixed Class Divider - Installation (P/B 401)
25-31-11-400-801	Galley No. 1 - Installation (P/B 401)
25-31-21-400-801	Galley No. 2 - Installation (P/B 401)
25-31-41-400-801-005	Galley No. 4 - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-61-13-400-001

- (1) Put the door warning strap reel [1] into position.

SUBTASK 25-61-13-400-002

- (2) Slide the strap [3] through slit on retainer [4].

SUBTASK 25-61-13-400-003

- (3) Mount the door warning strap reel [1] with (4) fasteners [2].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-61-13-420-001

- (1) Do this task to install the adjacent sidewall panels: Sidewall Panel - Installation, TASK 25-21-46-400-801.

SUBTASK 25-61-13-400-004

- (2) If it is necessary, do this task: Fixed Class Divider - Installation, TASK 25-24-15-400-806.

SUBTASK 25-61-13-400-005

- (3) If it is necessary, do this task: Galley No. 1 - Installation, TASK 25-31-11-400-801.

SUBTASK 25-61-13-400-006

- (4) If it is necessary, do this task: Galley No. 2 - Installation, TASK 25-31-21-400-801.

SUBTASK 25-61-13-400-007

- (5) If it is necessary, do this task: Galley No. 4 - Installation, TASK 25-31-41-400-801-005.

———— END OF TASK ————

TASK 25-61-13-800-801

4. Post-Installation Door Warning Strap Reel Test

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage



25-61-13



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B. Procedure

SUBTASK 25-61-13-800-001

- (1) Pull the strap out of the reel and attach the strap to the fitting on the opposite door frame.

SUBTASK 25-61-13-800-002

- (2) Unhook the strap from the fitting.

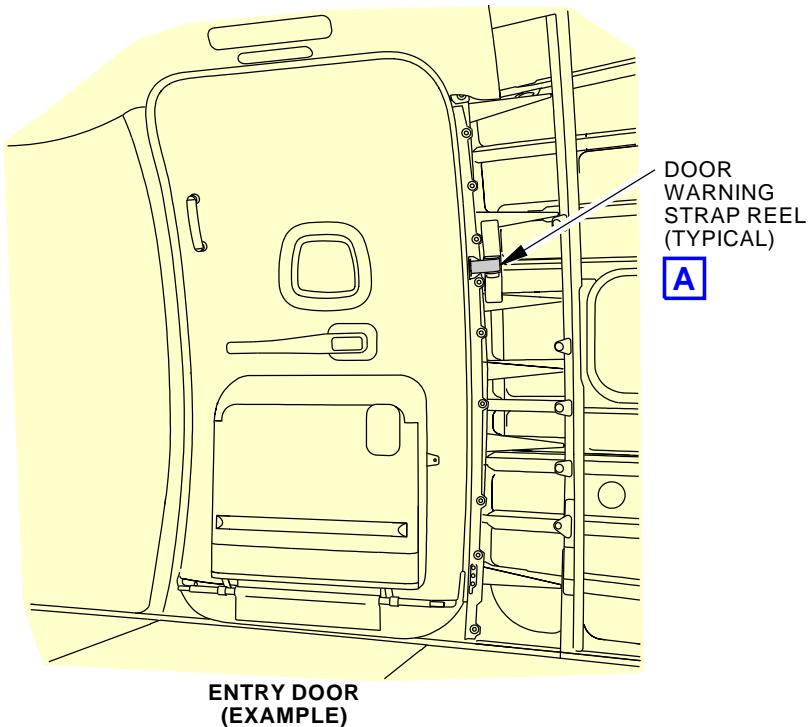
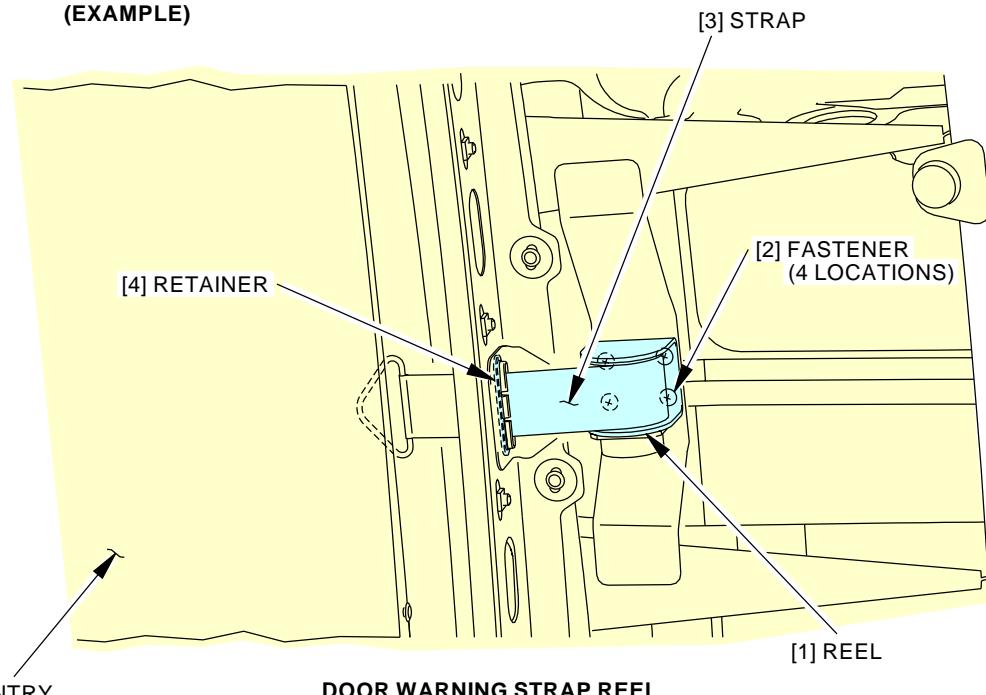
SUBTASK 25-61-13-800-003

- (3) Make sure the strap retracts back into the door warning strap reel.

———— END OF TASK ————

EFFECTIVITY
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25-61-13

ENTRY DOOR
(EXAMPLE)

N60484 S0006567857_V2

Door Warning Strap Reel Installation
Figure 401/25-61-13-990-801EFFECTIVITY
AKS ALL**25-61-13**



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DETACHABLE EMERGENCY EQUIPMENT - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Life Jacket Restoration
 - (2) Over-Water Survival Kit Restoration (If Installed)
 - (3) Megaphone Operational Test
 - (4) Megaphone Battery Replacement
 - (5) Emergency Locator Transmitter Battery Replacement (If Installed)
 - (6) Detachable Emergency Equipment Visual Check
 - (7) Flashlight Check (With Flashing or Push to Test LED Indicator)
 - (8) Flashlight Battery Replacement (With Flashing LED Indicator)
 - (9) Smoke Hood (Protective Breathing Equipment) Inspection
 - (10) Smoke Hood (Protective Breathing Equipment) Restoration
 - (11) First Aid Kit Restoration
 - (12) Medical Kit Restoration
- C. This procedure contains tasks that are necessary to make the Automated Customized Task Cards. Most of the tasks in this procedure do not contain detailed instructions. Use the standard method of your airline to do these tasks.

TASK 25-64-00-900-801

2. Life Jacket Restoration

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-001

- (1) Replace the life jackets.
 - (a) Use the standard method of your airline to replace the life jackets.

————— END OF TASK ————

TASK 25-64-00-900-803

3. Over-Water Survival Kit Restoration (If Installed)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-003

- (1) Replace the over-water survival kits.

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- (a) Use the standard method of your airline to replace the over-water survival kits.

———— END OF TASK ————

TASK 25-64-00-710-801

4. Megaphone Operational Test

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-020-001

- (1) Disconnect the clamp and remove the megaphone from the mounting bracket.

SUBTASK 25-64-00-710-001

- (2) Put the microphone near your mouth while you point the horn at the opposite end of the airplane.

SUBTASK 25-64-00-710-002

- (3) Pull the trigger while you count slowly in a clear voice.

SUBTASK 25-64-00-710-003

- (4) Make sure your voice can be heard clearly by another person at the opposite end of the airplane.

SUBTASK 25-64-00-710-004

- (5) If the voice output is weak, do these steps:

- (a) Do this task: Megaphone Battery Replacement, TASK 25-64-00-900-804.
- (b) Do the operational test above again.
- (c) If the voice output remains weak, replace the megaphone.

SUBTASK 25-64-00-710-006

- (6) If you have a megaphone type that has a long lanyard and siren, do the steps that follow to examine the megaphone siren (optional):

NOTE: The megaphone may have a long lanyard with an alarm plug which operates as an anti-theft alarm.

- (a) Remove the alarm plug pin to start the siren automatically.

- 1) If the alarm is of usual amplitude and sound, the megaphone is good.
 - a) Insert the alarm pin to stop the siren when you release the handle.
- 2) If the output is low, sound character is unusual, or there is no sound, do these steps:
 - a) Do this task: Megaphone Battery Replacement, TASK 25-64-00-900-804.
 - b) Do the operational test above again.
 - c) If new batteries do not help, replace the megaphone.

NOTE: Make sure to put the alarm pin back and release the handle on the bad megaphone.

———— EFFECTIVITY ————
AKS ALL

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SUBTASK 25-64-00-420-001

- (7) Attach the megaphone on the mounting bracket with the clamp.

———— END OF TASK ——

TASK 25-64-00-900-804

5. Megaphone Battery Replacement

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-004

- (1) Replace the batteries in the megaphones.
(a) Use the manufacturer's maintenance recommendations for the megaphone or the standard method of your airline to replace the batteries.

———— END OF TASK ——

TASK 25-64-00-900-805

6. Emergency Locator Transmitter Battery Replacement (If Installed)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-005

- (1) Replace the batteries in the emergency locator transmitter.
(a) Use the standard method of your airline to replace the batteries.

———— END OF TASK ——

TASK 25-64-00-210-802

7. Detachable Emergency Equipment Visual Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-210-002

- (1) Make sure the following pieces of emergency equipment are installed in the applicable locations.

NOTE: Also, make sure they have no visible defects. Use the standard method of your airline to do this check.

- (a) Smoke goggles
(b) Crash ax

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- (c) Flash lights
- (d) First aid kits
- (e) Medical kits
- (f) Fire gloves

———— END OF TASK ————

TASK 25-64-00-200-802

8. Flashlight Check (With Flashing or Push To Test - LED Indicator)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-210-005

- (1) Do a check of the LED and compare with the limits in the table below. Follow the instructions if you find that the operation is not in the limits.
- (2) Remove the flashlight from the mounting bracket.
- (3) If the light does not come on or is weak, refer to the table to identify the problem and do the corrective action.

| AKS 001-010, 013, 015-018, 020-025, 027

Table 201/25-64-00-993-802

Symptom	Probable Cause	Corrective Action
LED is not flashing.	Battery is depleted.	Replace battery.
	Lamp is burned out.	Replace lamp.
	LED is inoperative.	Return unit for service.
	Defective Bracket. Flashlight did not turn off when installed in bracket.	Return entire system to factory for check.
LED is flashing at interval of 10 seconds or greater.	Battery is at or beyond cutoff point.	Replace battery within 10 days.
Flashlight does not turn on when removed from bracket.	Unauthorized use of flashlight. Battery depleted.	Replace battery.
	Lamp is burned out.	Replace lamp.
	Battery pack not installed or connected.	Check battery and connection.
	Broken contacts in flashlight body.	Return flashlight for service.
	Defective bracket. Flashlight did not turn off when installed in bracket.	Return entire system to factory for check.

———— EFFECTIVITY ————
AKS ALL

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AKS 011, 012, 014, 019, 026, 028-999

Table 202/25-64-00-993-801

Mounting Symptom	Probable Cause	Corrective Action
Mounting bracket LED does not illuminate when the push-to test button is pressed	Battery pack is depleted or has failed.	Remove the handlight from the mounting bracket. If the handlight does not turn ON immediately remove and replace the battery pack. After replacing the battery pack, verify that the handlight is ON when the handlight is not in the mounting bracket. Reinsert the handlight in the mounting bracket and verify that the LED turns on green when the push-to-test button is pressed
	Electrical failure in handlight electronics.	If changing the battery pack does not turn the handlight ON, there is an electrical failure in the handlight electronics. Refer to REPAIR for repair procedures
	Electrical failure in mounting bracket electronics.	If the handlight turns ON when it is removed from the mounting bracket, there is an electrical failure in the mounting bracket. Replace the mounting bracket. Return defective unit to repair station.
	Pogo contacts not making contact.	Rotate and ensure pogo contacts are making contact. Refer to ASSEMBLY for handlight installation procedures.
	Battery pack installed incorrectly (backwards).	Install battery correctly. Refer to ASSEMBLY for handlight installation procedures.
Handlight does not turn ON when it is removed from the mounting bracket.	Battery pack is depleted or has failed	Replace the battery pack. After replacing the battery pack, verify that the handlight is ON when the handlight is not in the mounting bracket. Reinsert the handlight in the mounting bracket and verify that the LED turns on green when the push-to-test button is pressed.
	Electrical failure in handlight electronics.	If changing the battery pack does not turn the handlight ON, there is an electrical failure in the handlight electronics. Refer to REPAIR for repair procedures

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AKS 011, 012, 014, 019, 026, 028-999 (Continued)

Table 202/25-64-00-993-801 (Continued)

Mounting Symptom	Probable Cause	Corrective Action
Handlight does not turn OFF when returned to its mounting bracket.	Electrical failure in mounting bracket or handlight head assembly electronics.	If the handlight does not turn OFF when it is returned to the mounting bracket, there may be an electrical failure in the mounting bracket. Insert another handlight in the mounting bracket. If that handlight does not turn OFF, the failure is in the mounting bracket electronics. Replace the mounting bracket. If the second handlight turns OFF when it is inserted in the mounting bracket, the electrical failure is in the handlight head assembly electronics. Replace handlight.
Mounting bracket LED Illuminates red (flashes red once) when the push-to test button is pressed. The monitoring circuit continues to check the battery every ten seconds and emit a red flash until the battery is replaced.	The battery pack charge is low.	The battery pack should be changed at earliest possible service. The operator has approximately three weeks to replace the battery.

AKS ALL

SUBTASK 25-64-00-420-003

- (4) Install the flashlight in the mounting bracket.

————— END OF TASK ————

TASK 25-64-00-900-806

9. Flashlight Battery Replacement (With Flashing or Push To Test - LED Indicator)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-007

- (1) Replace the batteries in the flashlights.
 - (a) Use the manufacturer's maintenance recommendations for the flashlight or the standard method of your airline to replace the batteries.
- (2) Do this task: Flashlight Check (With Flashing or Push To Test - LED Indicator),
TASK 25-64-00-200-802

————— END OF TASK ————

TASK 25-64-00-200-801

10. Smoke Hood (Protective Breathing Equipment) Inspection

NOTE: This procedure is a scheduled maintenance task.

————— EFFECTIVITY ————

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A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-210-004

- (1) Use the applicable steps that follow to do an inspection of the smoke hoods:

NOTE: There are various shapes and sizes of smoke hoods. Most smoke hood containers have warning indicators that show when the smoke hood is no longer good for use.

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- (a) Do a visual check of the tamper tags to make sure they are not broken or ripped.

AKS ALL; AIRPLANES WITH SMOKE HOOD CONTAINERS WITH AN INDICATOR WINDOW

CAUTION: DO ONLY A VISUAL CHECK OF THE INDICATOR WINDOW ON THE CONTAINER. IF YOU OPEN THE CONTAINER, YOU CAN CAUSE DAMAGE TO THE SMOKE HOOD OR OTHER COMPONENTS.

- (b) Do a visual check of the indicator window on the container to make sure the smoke hood has not filled the window.

AKS ALL; AIRPLANES WITH SMOKE HOOD CONTAINERS WITH MOISTURE INDICATOR STRIPS

- (c) Do a visual check of the indicator window on the container to make sure the moisture indicator strip has not changed to pink.

NOTE: The color of the moisture indicator may change, but not to pink, and remain serviceable. If the color of the moisture indicator changes to gray or white, the unit is still serviceable.

AKS ALL; AIRPLANES WITH SMOKE HOOD CONTAINERS WITHOUT AN INDICATOR WINDOW

- (d) Feel the smoke hood to make sure it remains hard and solid.

NOTE: The smoke hood is vacuum packed. If the smoke hood feels soft, then the package has a leak.

AKS ALL

———— END OF TASK ————

TASK 25-64-00-900-807

11. Smoke Hood (Protective Breathing Equipment) Restoration

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

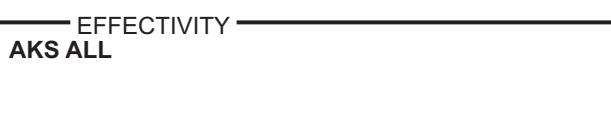
B. Procedure

SUBTASK 25-64-00-900-008

- (1) Replace the smoke hoods.

- (a) Use the standard method of your airline to replace the smoke hoods.

———— END OF TASK ————



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TASK 25-64-00-900-808

12. First Aid Kit Restoration

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-009

- (1) Replace the first aid kit.
 - (a) Use the standard method of your airline to replace the first aid kit.

———— END OF TASK ————

TASK 25-64-00-900-809

13. Medical Kit Restoration

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-900-010

- (1) Replace the medical kit.
 - (a) Use the standard method of your airline to replace the medical kit.

———— END OF TASK ————



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EMERGENCY LOCATOR TRANSMITTER - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks.
 - (1) Removal of the Emergency Locator Transmitter (ELT).
 - (2) Installation of the Emergency Locator Transmitter (ELT).

TASK 25-64-00-000-801

2. Emergency Locator Transmitter (ELT) Removal

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-00-020-011

- (1) Loosen the straps on the emergency locator transmitter from the support bracket.

SUBTASK 25-64-00-020-003

- (2) Remove the Emergency Locator Transmitter (ELT) from its stowage bracket.

SUBTASK 25-64-00-020-012

- (3) Make sure the four-position switch (if installed) is set to the correct position per the airline's regulatory requirements.

NOTE: The four-position switch should be set to the OFF position.

NOTE: Some ELTs have a three-position ON/OFF/ARMED switch. The three-position switch should be set to the OFF position.

———— END OF TASK ————

TASK 25-64-00-400-801

3. Emergency Locator Transmitter (ELT) Installation

A. Procedure

SUBTASK 25-64-00-010-001

- (1) Remove the packing label (if installed) from the ELT.

SUBTASK 25-64-00-410-002

- (2) Make sure that the antenna is in its stowed position in the lanyard guide and under the retainer clip.



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SUBTASK 25-64-00-420-015

- (3) Put the switch (if installed) to the correct position per the airline's regulatory requirements.

NOTE: The four-position switch should be set to the ARM position.

NOTE: Some ELTs have a three-position ON/OFF/ARMED switch. The three-position switch should be set to the ARMED position.

NOTE: Some portable ELTs have LED indicators. The LED indicator will indicate a successful self-test by blinking eight flashes (with a 0.5 second delay between flashes) if the result is acceptable or by not blinking if there is one or more failures during self-test. The LED will also indicate that the unit is in "Transmit" mode, by blinking continuously every two seconds. The LED remains unlit when the unit is in "Armed" mode or "Off" mode.

SUBTASK 25-64-00-420-004

- (4) Install the Emergency Locator Transmitter (ELT) on its stowage bracket.

SUBTASK 25-64-00-420-016

- (5) Tighten the straps on the stowage bracket.

———— END OF TASK ———

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DOOR-MOUNTED ESCAPE SYSTEM - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) A restoration of the escape system after an escape slide deployment.
 - (2) Door-mounted escape system - deactivation.
 - (3) Door-mounted escape system - activation.

TASK 25-66-00-840-801

2. Escape System Restoration

(Figure 201)

A. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover Removal (P/B 401)
25-66-01-400-803	Escape Slide Pack and Cover Installation (P/B 401)

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Procedure

SUBTASK 25-66-00-840-001

- (1) Restore the escape slide as follows:

NOTE: Three persons are necessary to do parts of this procedure. One person in the aircraft disconnects the escape slide. One person on a ladder, external to the aircraft, opens the aspirator flapper door and lowers the escape slide. One person on the ground receives the escape slide.

WARNING: DO NOT USE THE WARNING STRAP TO SUPPORT THE WEIGHT OF A PERSON. IF THE WARNING STRAP SUPPORTS THE WEIGHT OF A PERSON IT CAN BREAK. IF THE WARNING STRAP BREAKS, INJURY TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Install the door warning strap across the door opening.
- (b) Disconnect the wires from the battery pack to the escape slide lights.

NOTE: The battery pack is located on the bottom surface of the escape slide near the inflation cylinder.

- (c) Open the aspirator flapper door to deflate the escape slide until the escape slide is soft.
- NOTE:** Make sure the escape slide keeps its shape.

- (d) Disconnect the girt bar from the floor-mounted escape slide brackets.

NOTE: Release tension in the girt to disconnect the girt bar easily.



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WARNING: BE CAREFUL WHEN YOU LOWER THE ESCAPE SLIDE. THE ESCAPE SLIDE WEIGHS APPROXIMATELY 50 POUNDS (22.7 KILOGRAMS). IF THE ESCAPE SLIDE AND ITS COMPONENTS FALL, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

CAUTION: MAKE SURE THE AREA BELOW THE ESCAPE SLIDE IS CLEAR BEFORE YOU LOWER THE ESCAPE SLIDE TO THE GROUND. OBJECTS BELOW THE SLIDE CAN CAUSE DAMAGE TO THE SLIDE AND ITS COMPONENTS.

- (e) Carefully lower the escape slide to the person on the ground.
- (f) Carefully install a clamp on the aspirator to fully deflate the escape slide.
- (g) Remove the clamp from the aspirator.
- (h) Refer to the instructions from the escape slide manufacturer to examine, repair, and repack the escape slide.

SUBTASK 25-66-00-840-002

- (2) Restore the door as follows:

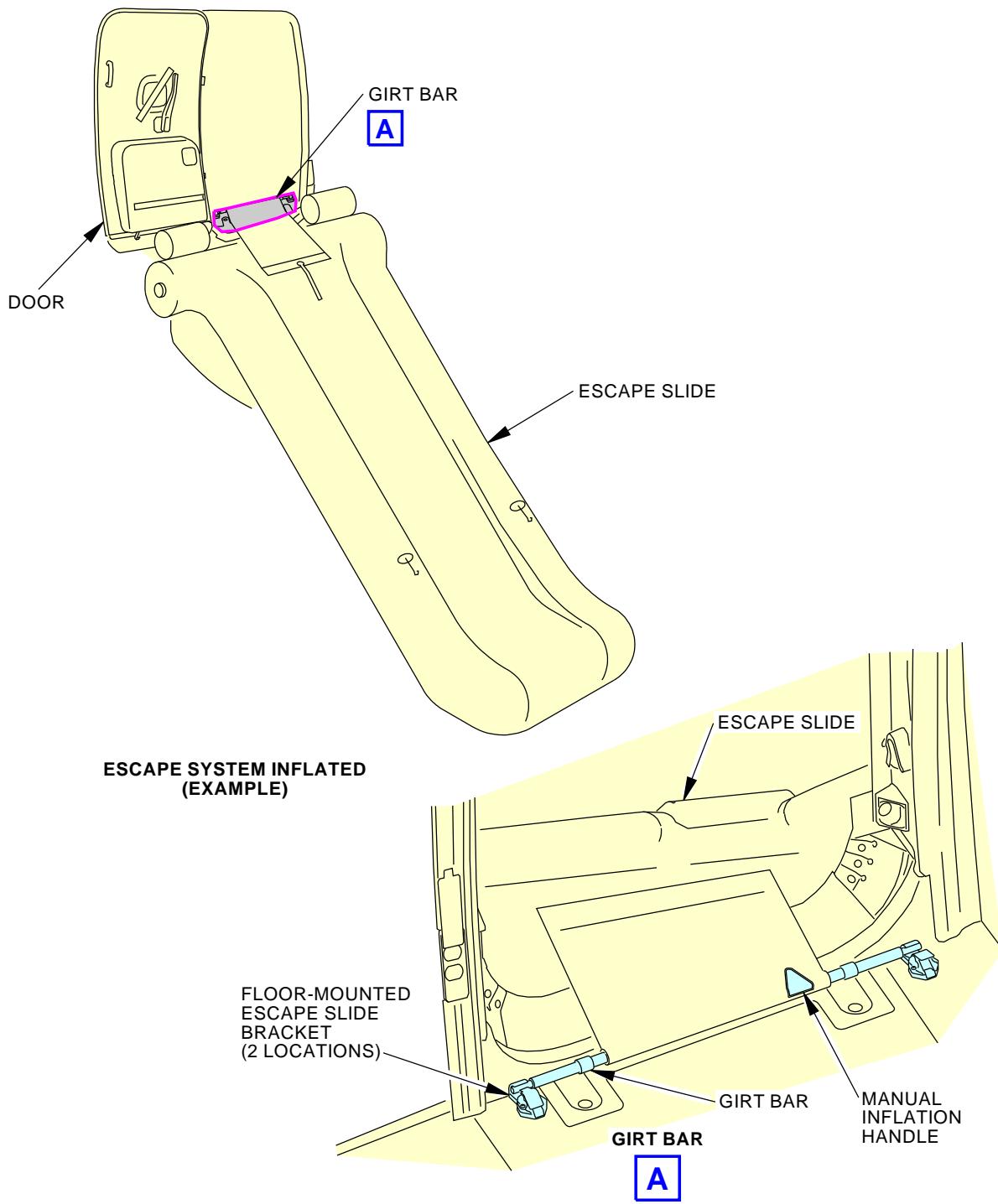
- (a) Remove the door warning strap from across the door opening if it is installed.
- (b) Close and latch the door.
- (c) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.
 NOTE: The escape slide pack and girt bar are not in the cover.
- (d) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-803.

———— END OF TASK ————

EFFECTIVITY
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Escape System Restoration
Figure 201/25-66-00-990-801EFFECTIVITY
AKS ALL**25-66-00**

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TASK 25-66-00-040-801

3. Door-Mounted Escape System - Deactivation

A. General

- (1) This task will deactivate the door-mounted escape system.

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Procedure

SUBTASK 25-66-00-210-002

WARNING: KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure that there is no blockage in the area near the door from the fuselage to 33 ft (10 m) outboard of the fuselage and from 6 ft (2 m) t forward of the door to 6 ft (2 m) aft of the door.

SUBTASK 25-66-00-020-001

- (2) For forward and aft door slides, do these steps:
- Stow the girt bar in the girt bar retainer clips on the slide compartment.
 - Use nylon zip ties to attach the girt bar in its position.
 - Install a DO NOT OPERATE tag on the girt bar.

SUBTASK 25-66-00-020-002

- (3) For mid-cabin exit door slides, do these steps:
- Remove the escape slide girt brackets from the door sill.
 - Install the safety pin into the pressure reservoir.
NOTE: The safety pin is in the pouch on the inboard face of the escape slide.
 - Install a DO NOT OPERATE tag on the escape slide safety pin.

D. Door-Mounted Escape System - Tryout

NOTE: This tryout is to make sure that the door-mounted escape system is in a zero energy state.

SUBTASK 25-66-00-210-007

- (1) For forward and aft door slides, do these steps:
- Make sure that the slide girt bar is stowed and attached in the girt bar retainer clips with nylon zip ties.
 - Make sure that the DO NOT OPERATE tag is installed.

SUBTASK 25-66-00-210-008

- (2) For mid-cabin exit door slides, do these steps:
- Make sure that the escape slide girt brackets are disconnected from the door sill.
 - Make sure that the safety pin is installed in the pressure reservoir valve.
 - Make sure that the DO NOT OPERATE tag is installed.

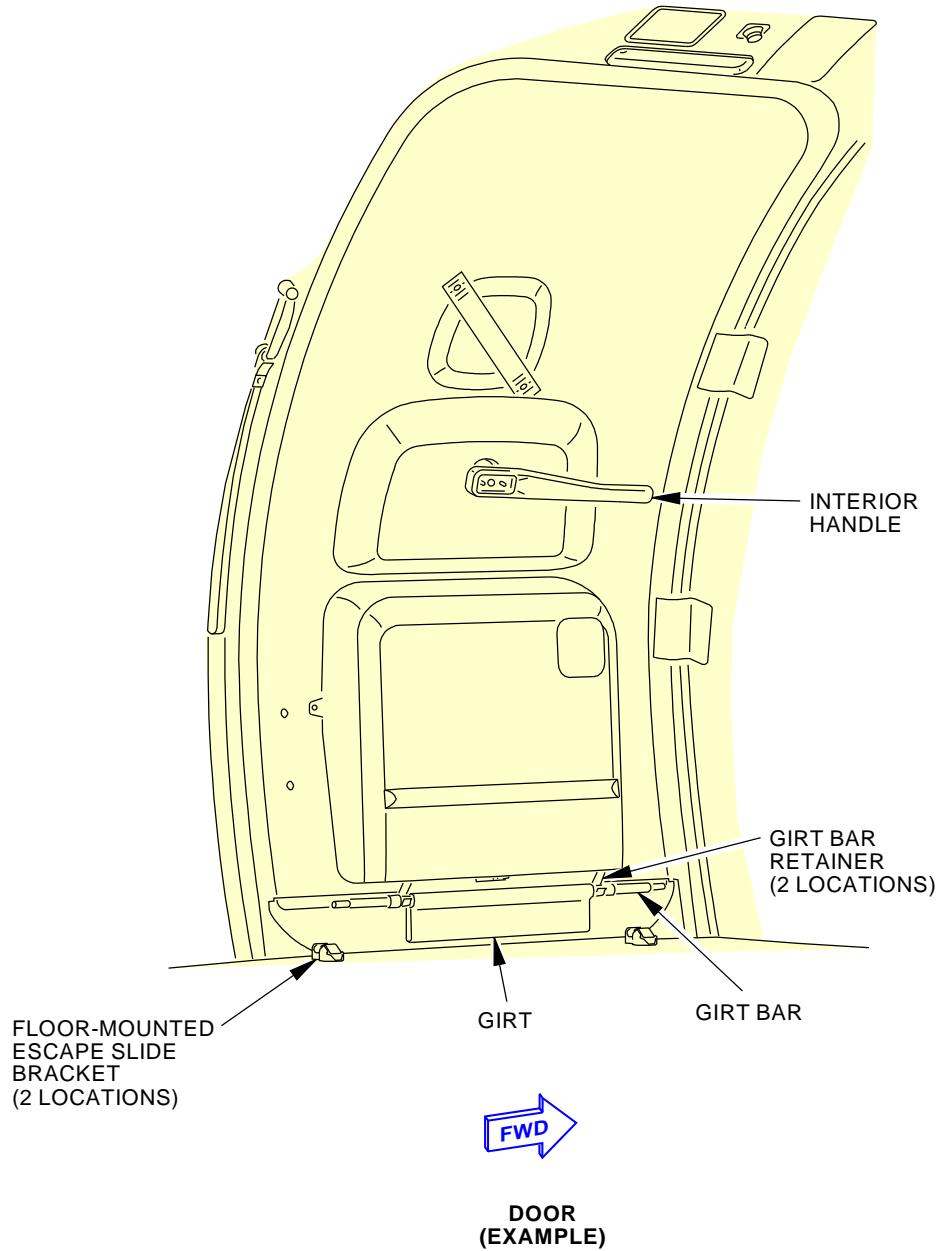
———— END OF TASK ————

EFFECTIVITY
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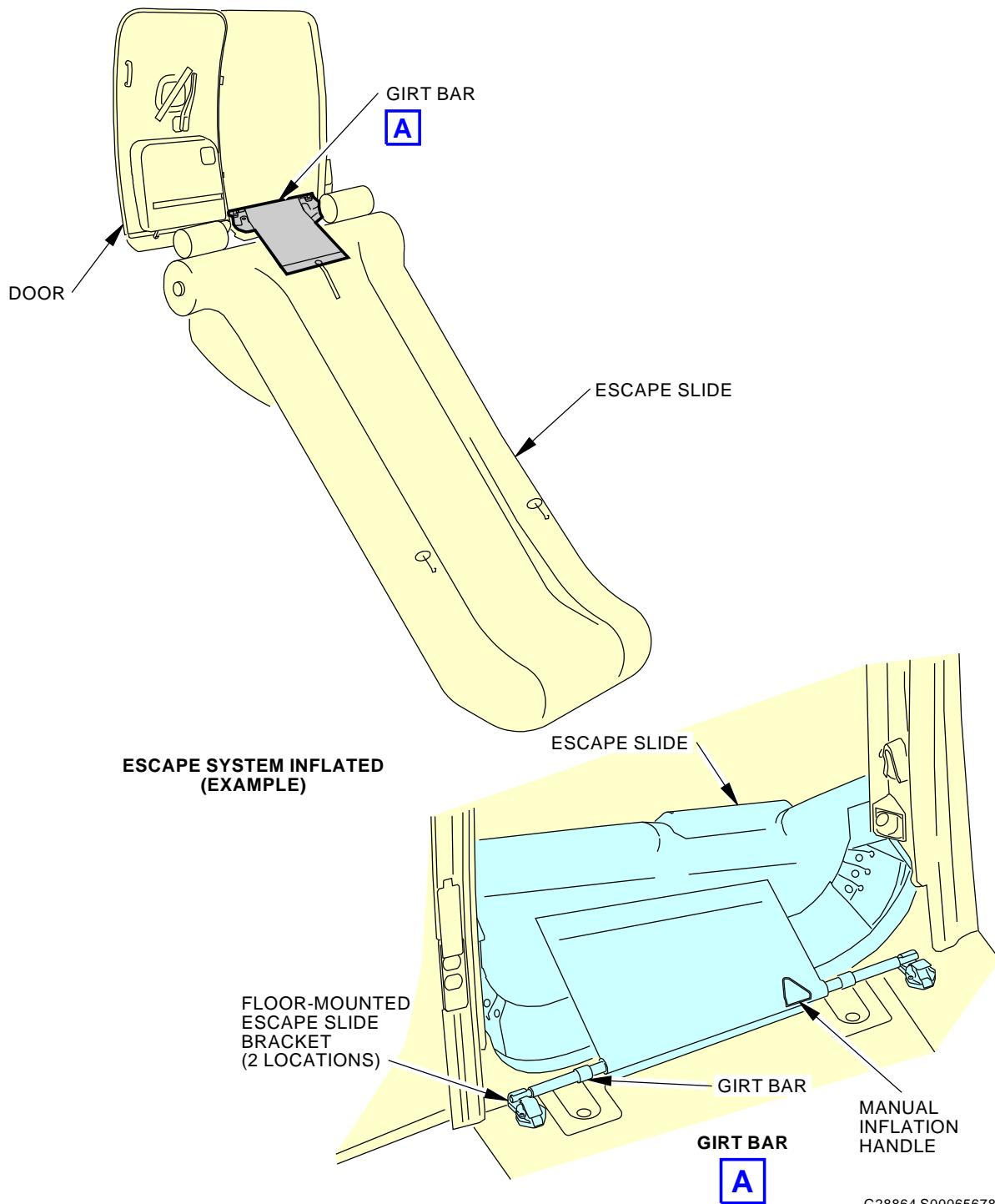


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Door-Mounted Escape System
Figure 202/25-66-00-990-803 (Sheet 1 of 2)

EFFECTIVITY
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Door-Mounted Escape System
Figure 202/25-66-00-990-803 (Sheet 2 of 2)

EFFECTIVITY
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TASK 25-66-00-440-801

4. Door-Mounted Escape System - Activation

(Figure 202)

A. General

- (1) This task will activate the door-mounted escape system.

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Procedure

SUBTASK 25-66-00-210-005

WARNING: KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure that there is no blockage in the area near the door from the fuselage to 33 ft (10 m) outboard of the fuselage and from 6 ft (2 m) forward of the door to 6 ft (2 m) aft of the door.

SUBTASK 25-66-00-420-001

- (2) For forward and aft door slides, do these steps:
- Remove the DO NOT OPERATE tag from the escape slide girt bar.
 - Remove the nylon zip ties used to attach the girt bar in the girt bar retainer clips on the slide compartment.

SUBTASK 25-66-00-420-002

- (3) For mid-cabin exit door slides, do these steps:
- Remove the DO NOT OPERATE tag from the escape slide safety pin.
 - Attach the escape slide girt brackets to the door sill.
 - Remove the safety pin from the pressure reservoir valve.
 - Put the safety pin back into the pouch on the inboard face of the escape slide.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-66-00



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AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SYSTEM - ADJUSTMENT/TEST

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) An operational test of the escape system.

TASK 25-66-00-710-801

2. Escape System Operational Test

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
25-66-00-840-801	Escape System Restoration (P/B 201)
25-66-01-200-801	Escape Slide Pack Inflation Cylinder Check (P/B 601)

B. Tools/Equipment

Reference	Description
STD-1146	Pad - Protective, Ensolite or Equivalent 1/2 Inch by 72 Inches by 96 Inches

C. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Prepare for the Test

SUBTASK 25-66-00-860-001

- (1) Prepare the airplane for the test as follows:

CAUTION: YOU MUST ATTACH THE PROTECTIVE PAD TO THE FUSELAGE BELOW THE APPLICABLE DOOR. IF YOU DO NOT INSTALL THE PROTECTIVE PAD, DAMAGE TO THE FUSELAGE SKIN AND PAINT CAN OCCUR.

- (a) Install the protective pad, STD-1146 to the fuselage below the applicable door with the long side parallel to the ground.
- (b) Put a pad on the ground where the escape slide will inflate.
- (c) Make sure the door is closed and latched.

SUBTASK 25-66-00-210-001

- (2) Do this task: Escape Slide Pack Inflation Cylinder Check, TASK 25-66-01-200-801.

E. Test

SUBTASK 25-66-00-710-001

- (1) Do the operational test of the escape system:
 - (a) Remove the girt bar from the girt bar retainers on the cover.
 - (b) Install the girt bar in the floor-mounted escape slide brackets.

EFFECTIVITY	AKS ALL
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25-66-00



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WARNING: MAKE SURE THERE ARE NO PERSONS OR EQUIPMENT IN THE AREA BELOW THE DOOR WHERE THE SLIDE WILL INFLATE. WHEN THE SLIDE DEPLOYS, INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (c) Move the interior handle to the open position and open the door fully.
- (d) Make sure the escape slide fully inflates in 0-10 seconds after the escape slide releases from the door.

NOTE: The escape slide must inflate automatically to pass the operational test.

- (e) If the escape slide does not inflate automatically, pull the manual inflation handle to inflate the escape slide.
- (f) Make sure the escape slide is fully inflated.
- (g) Make sure the lights on the slide are on.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-66-00-860-002

- (1) Do this task: Escape System Restoration, TASK 25-66-00-840-801.

———— END OF TASK ————

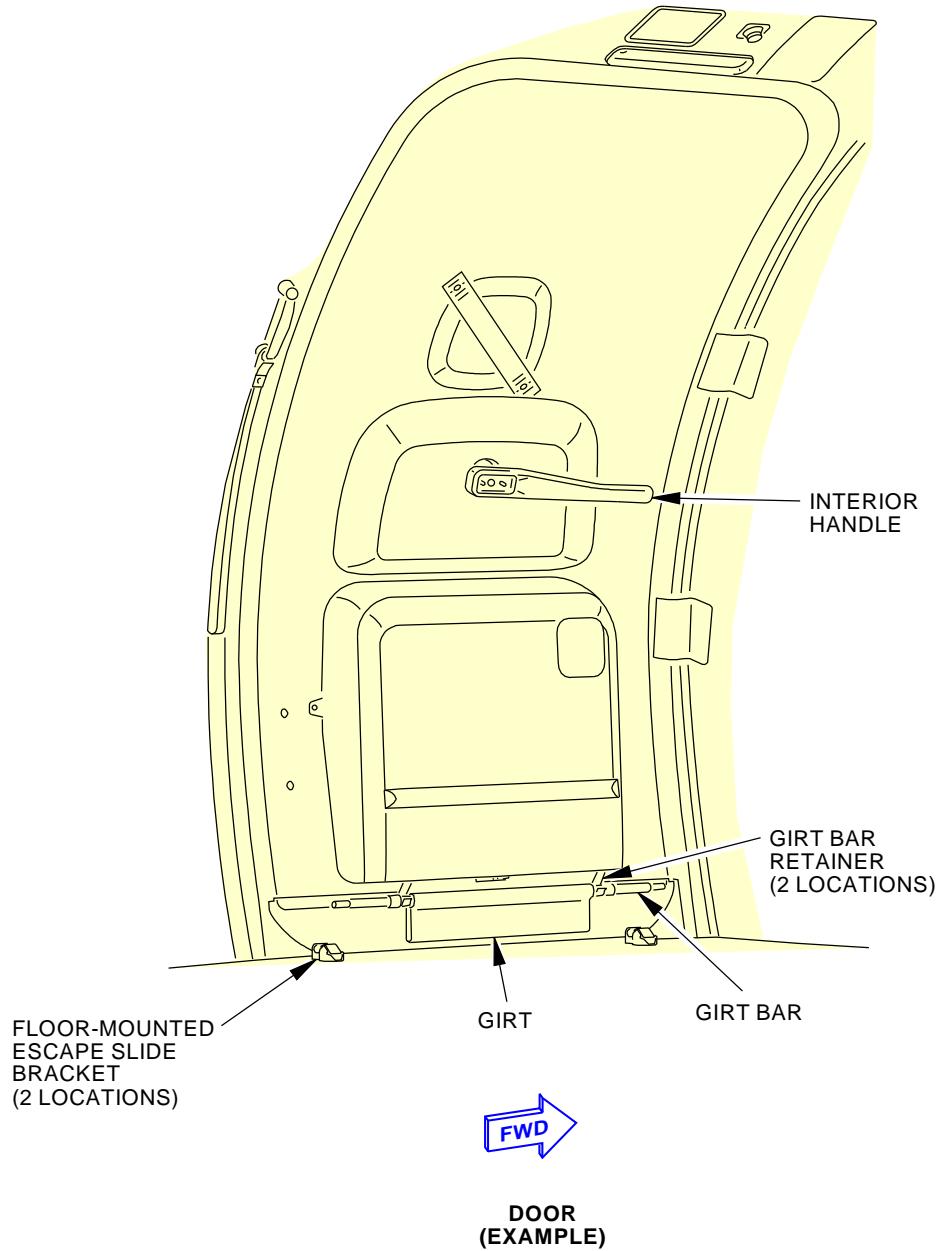
EFFECTIVITY
AKS ALL

25-66-00

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AIRCRAFT MAINTENANCE MANUAL



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Escape System Operational Test
Figure 501/25-66-00-990-802 (Sheet 1 of 2)

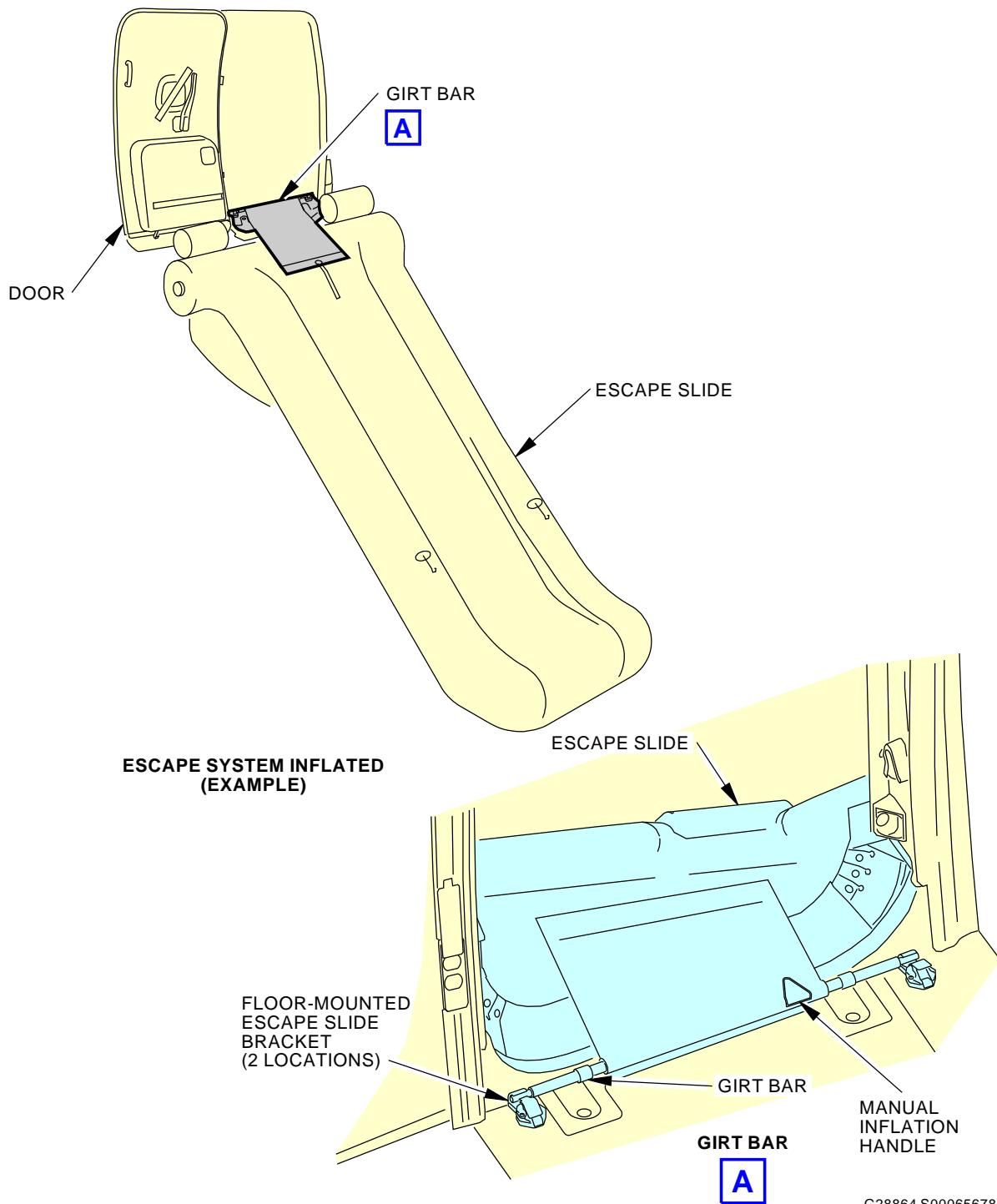
EFFECTIVITY
AKS ALL

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Escape System Operational Test
Figure 501/25-66-00-990-802 (Sheet 2 of 2)

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25-66-00

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SYSTEM - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) A removal of the escape slide pack and cover.
 - (2) An installation of the escape slide pack and cover.
 - (3) A removal of the escape slide pack.
 - (4) An installation of the escape slide pack.
 - (5) A removal of the escape slide girt bar.
 - (6) An installation of the escape slide girt bar.
- C. This procedure is the same for the entry or galley service door.
- D. Two persons are necessary to lift or move the escape slide pack and cover. The weight of the escape slide pack and cover is approximately 55 pounds (24.94 kilograms).

TASK 25-66-01-000-801

2. Escape Slide Pack and Cover Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Prepare for the Removal

SUBTASK 25-66-01-860-001

- (1) Make sure the door is safe as follows:
 - (a) Make sure the door is closed and latched.

WARNING: MAKE SURE THE GIRT BAR IS INSTALLED IN THE GIRT BAR RETAINER. IF THE GIRT BAR IS NOT INSTALLED IN THE GIRT BAR RETAINERS, ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN OCCUR. THIS CAN CAUSE INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT.

- (b) Make sure the girt bar [4] is installed in the girt bar retainers [5].

C. Removal

SUBTASK 25-66-01-020-001

- (1) Remove the escape slide pack and cover [2] from the door as follows:
 - (a) Remove the screws [9] and washers [10] that attach the cover [3] to the door.
 - 1) Make a note of the screw [9] lengths and locations for the subsequent installation.



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- (b) Pull the top of the cover [3] inboard until it is clear of the door structure.

NOTE: When the compartment is open, the escape slide pack can expand. Plan the work so the compartment is open for a minimum time to avoid the expansion of the escape slide pack.

WARNING: THE ESCAPE SLIDE PACK AND COVER WEIGH APPROXIMATELY 55 POUNDS (24.94 KILOGRAMS). BE CAREFUL WHEN YOU LIFT OR MOVE THE ESCAPE SLIDE PACK AND COVER. IF YOU LIFT OR MOVE THE ESCAPE SLIDE PACK AND COVER INCORRECTLY, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (c) Lift and remove the escape slide pack and cover [2] to disengage the lower fitting [15] from the bottom support bracket [14].
- (d) Put the escape slide pack and cover [2] on a clean horizontal surface with the cover backing pan [11] against the horizontal surface.

SUBTASK 25-66-01-860-006

- (2) Do the following steps to install the safety pin [19] in the inflation cylinder valve [17]:
- (a) Remove the latch [7] from the latch bracket [13].
- (b) Open the cover [3] to get access to the inflation cylinder valve [17].

WARNING: INSTALL THE SAFETY PIN IN THE INFLATION CYLINDER IF YOU REMOVE THE COVER. WITHOUT THE SAFETY PIN, THE ESCAPE SLIDE OR SLIDE-RAFT CAN INFLATE ACCIDENTALLY. IF IT INFLATES, INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (c) Remove the safety pin [19] from the pocket [18].
- (d) Put the safety pin [19] into the inflation cylinder valve [17].

————— END OF TASK ————

TASK 25-66-01-400-803

3. Escape Slide Pack and Cover Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Prepare for the Installation

SUBTASK 25-66-01-410-004

- (1) If the escape slide pack [26] is not installed in the cover [3], do this task: Escape Slide Pack Installation, TASK 25-66-01-400-801.

SUBTASK 25-66-01-410-005

- (2) Make sure the door is closed and latched.

SUBTASK 25-66-01-410-006

- (3) Do the following steps to make sure that the safety pin [19] is not installed in the inflation cylinder valve [17]:

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- (a) Put the escape slide pack and cover [2] on a clean flat horizontal surface with the backing pan [11] against the clean flat horizontal surface.
- (b) Remove the latch [7] from the latch bracket [13].
- (c) Open the cover [3] sufficiently to see the inflation cylinder valve [17].

WARNING: REMOVE THE SAFETY PIN FROM THE INFLATION CYLINDER VALVE. THE ESCAPE SLIDE WILL NOT OPERATE IF THE SAFETY PIN IS IN THE INFLATION CYLINDER VALVE. IF THE ESCAPE SLIDE DOES NOT OPERATE, PERSONS MAY BE INJURED.

- (d) Make sure a safety pin [19] is not installed in the inflation cylinder valve [17].

CAUTION: BE CAREFUL WHEN YOU MOVE THE ESCAPE SLIDE PACK. WHEN THE SAFETY PIN IS REMOVED FROM THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. THIS CAN CAUSE INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT.

- 1) Remove the safety pin [19] from the inflation cylinder valve [17].
- 2) Put the safety pin [19] into the pocket [18] on the escape slide pack [26].

- (e) Close the cover [3].
- (f) Install the latch [7] into the latch bracket [13].

C. Installation

SUBTASK 25-66-01-420-004

- (1) Install the escape slide pack and cover [2] on the door as follows:

WARNING: BE CAREFUL WHEN YOU LIFT THE ESCAPE SLIDE PACK AND COVER. THE ESCAPE SLIDE WEIGHS APPROXIMATELY 55 POUNDS (24.94 KILOGRAMS). IF YOU ARE NOT CAREFUL, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Install the escape slide pack and cover [2] on the door.
 - 1) Make sure that the ball end of the lower fitting [15] goes through the opening in the bottom support bracket [14].

- (b) Push the top of the escape slide pack and cover [2] outboard until it is against the door.

NOTE: When the compartment is open, the escape slide pack can expand. Plan the work so the compartment is open for a minimum time to avoid the expansion of the escape slide pack.

- (c) Install the screws [9] and washers [10] that attach the cover [3] to the door.
 - 1) Make sure to use the correct length screw [9], as noted in the removal procedure.
- (d) Make sure you can arm the escape slide by installing the girt bar [4] into the floor-mounted brackets [8].
- (e) Install the girt bar [4] into the girt bar retainer [5].

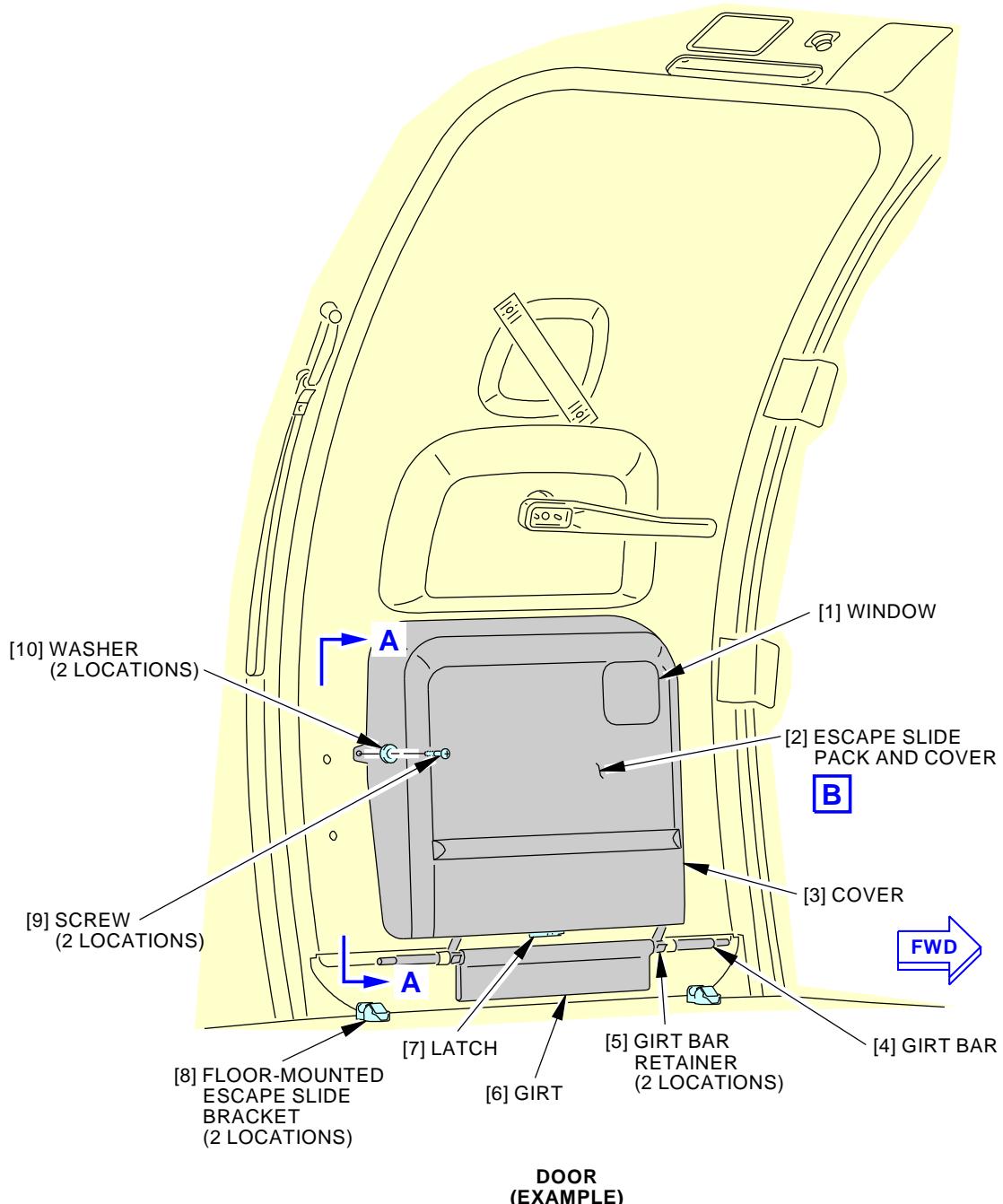
NOTE: The length of the girt bar for the FWD Door is 33.2 in. (84.3 cm) long.

The length for the girt bar for the AFT Door is 29.2 in. (74.2 cm) long.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-66-01

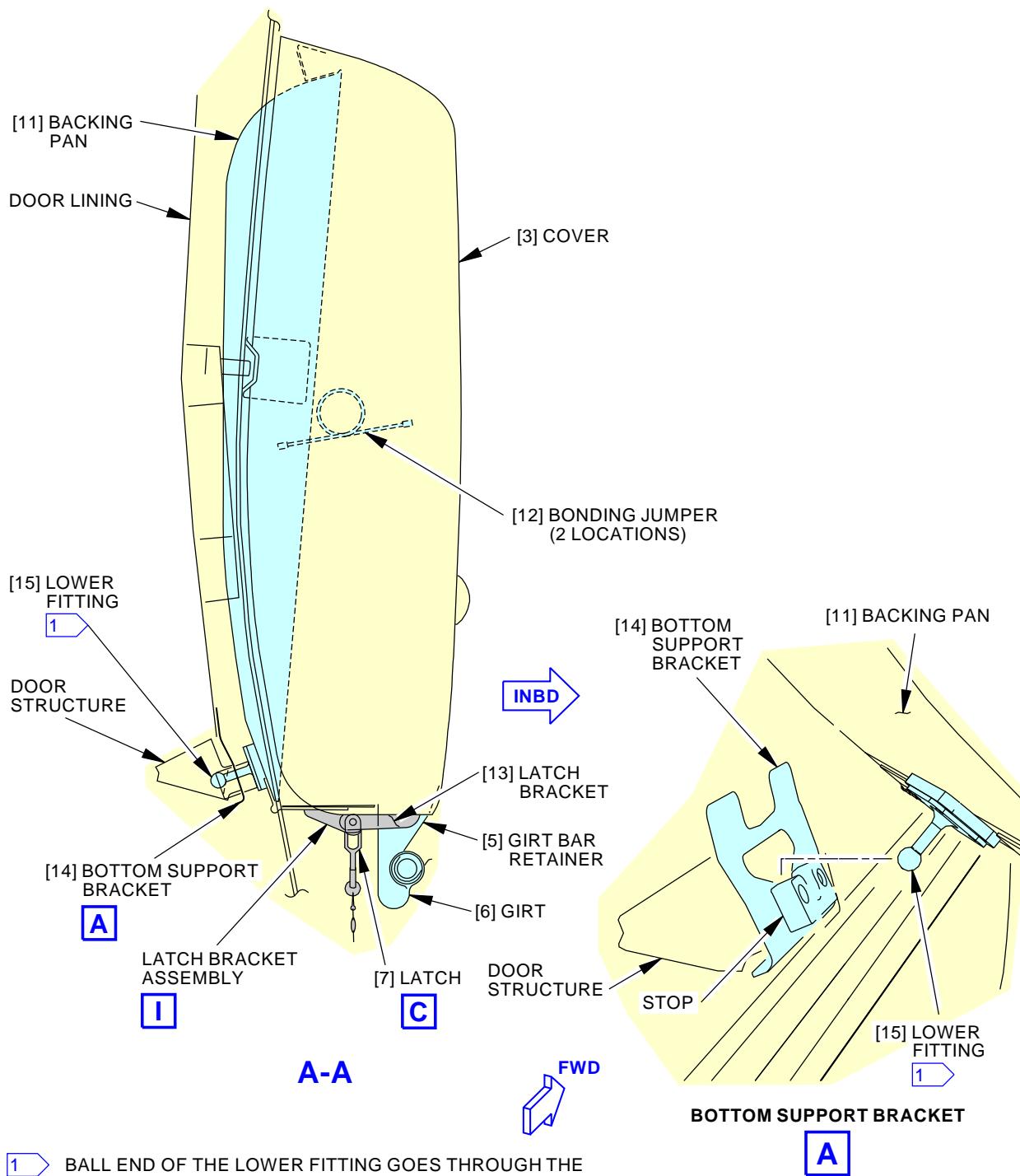


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Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 1 of 7)

EFFECTIVITY
AKS ALL

25-66-01



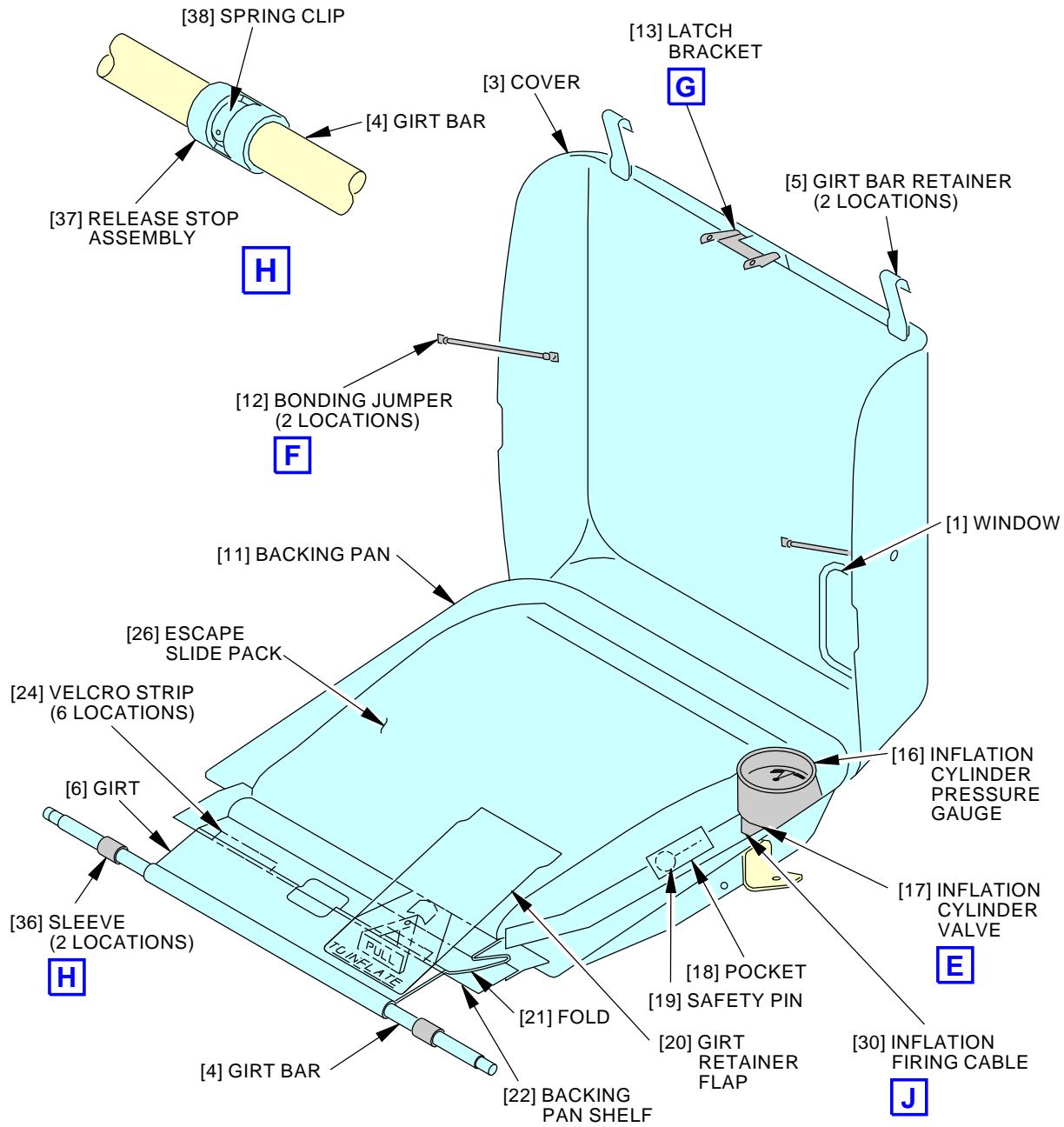
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Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 2 of 7)

EFFECTIVITY
AKS ALL

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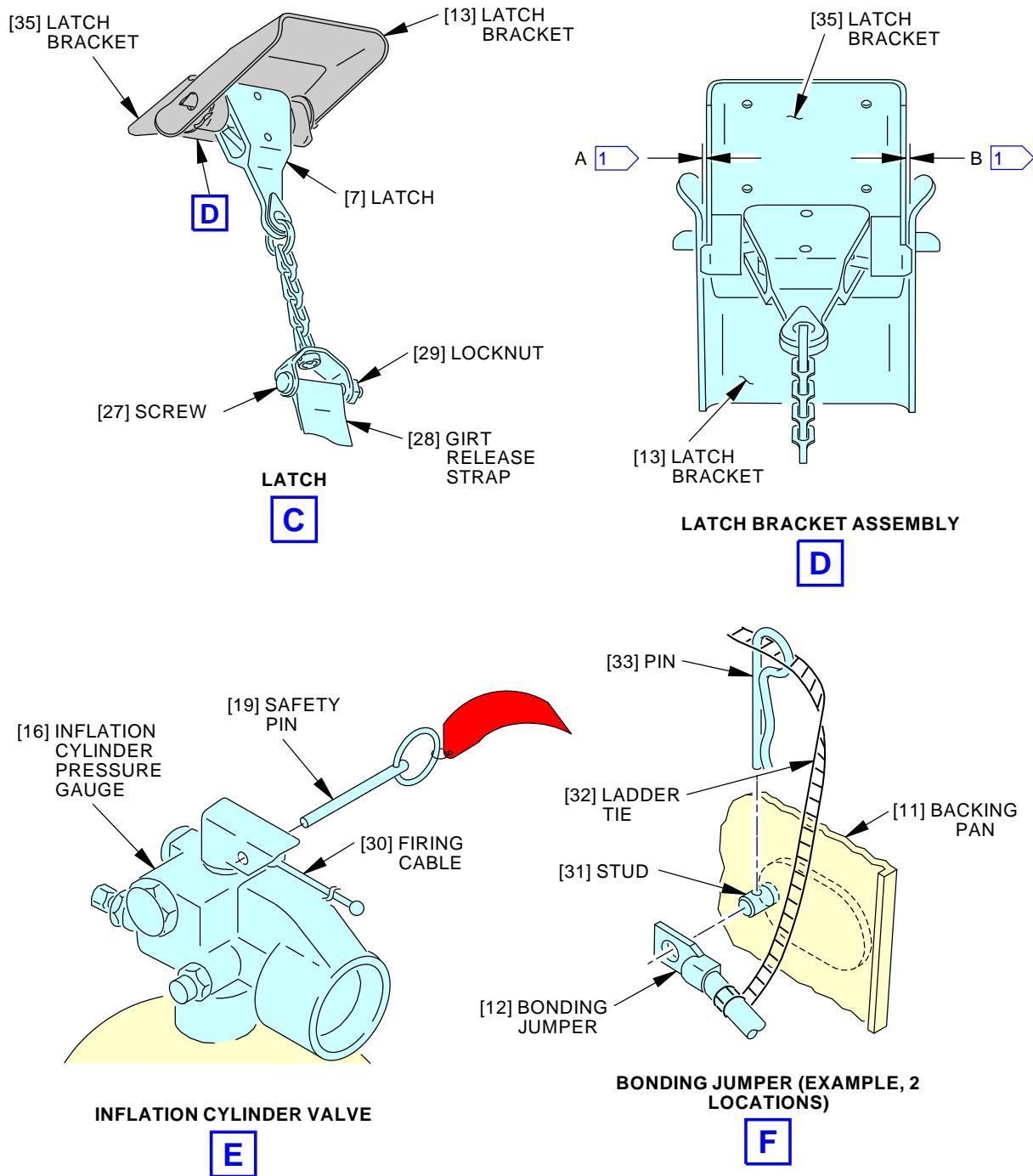
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**ESCAPE SLIDE PACK AND COVER
(GALLEY SERVICE DOOR)**
B

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**Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 3 of 7)**
EFFECTIVITY
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25-66-01

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**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**


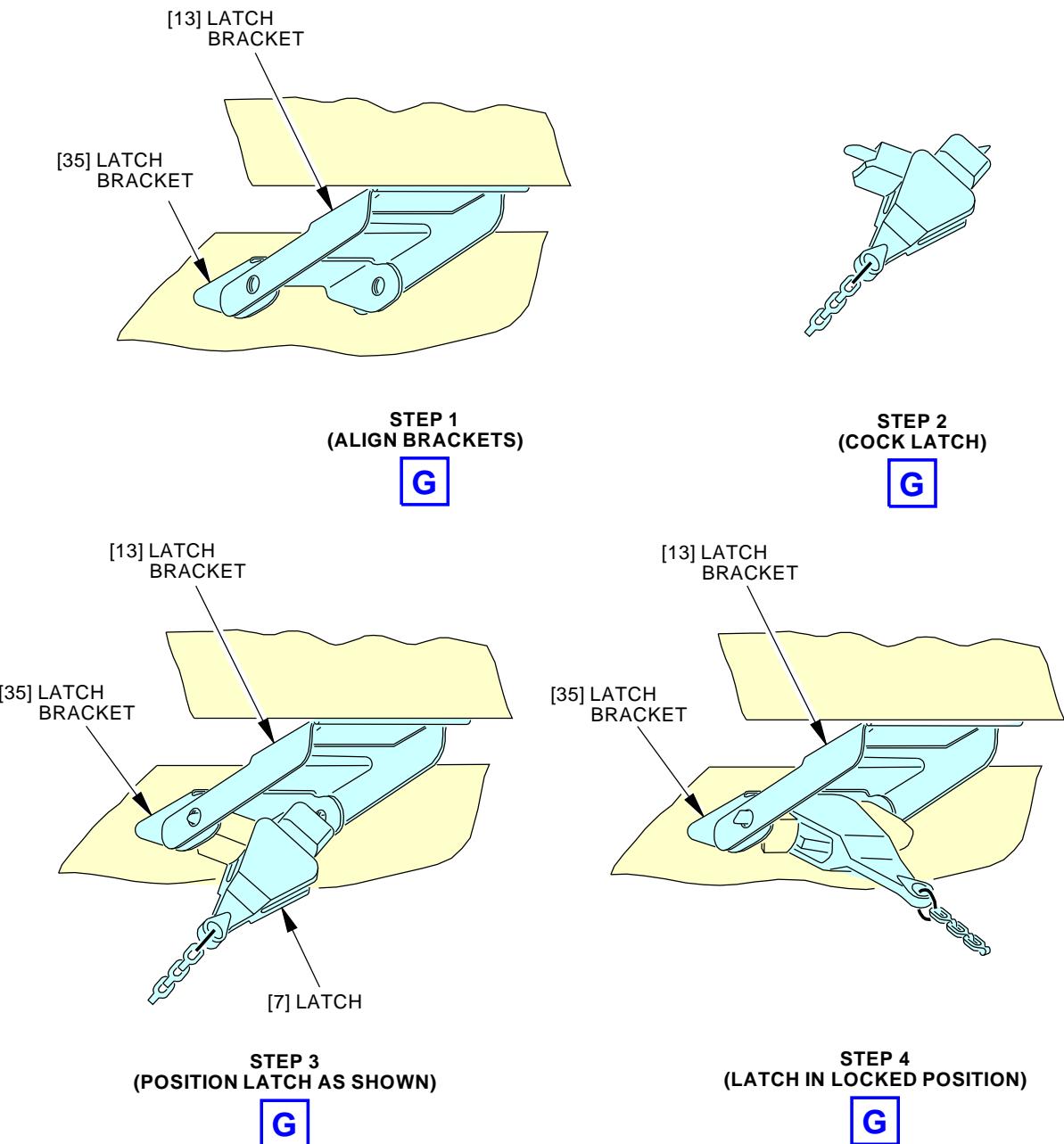
1 THE SUM OF THE CLEARANCES AT A AND B MUST BE NO MORE THAN 0.01 INCH (0.254 mm)

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Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 4 of 7)

EFFECTIVITY
AKS ALL

25-66-01



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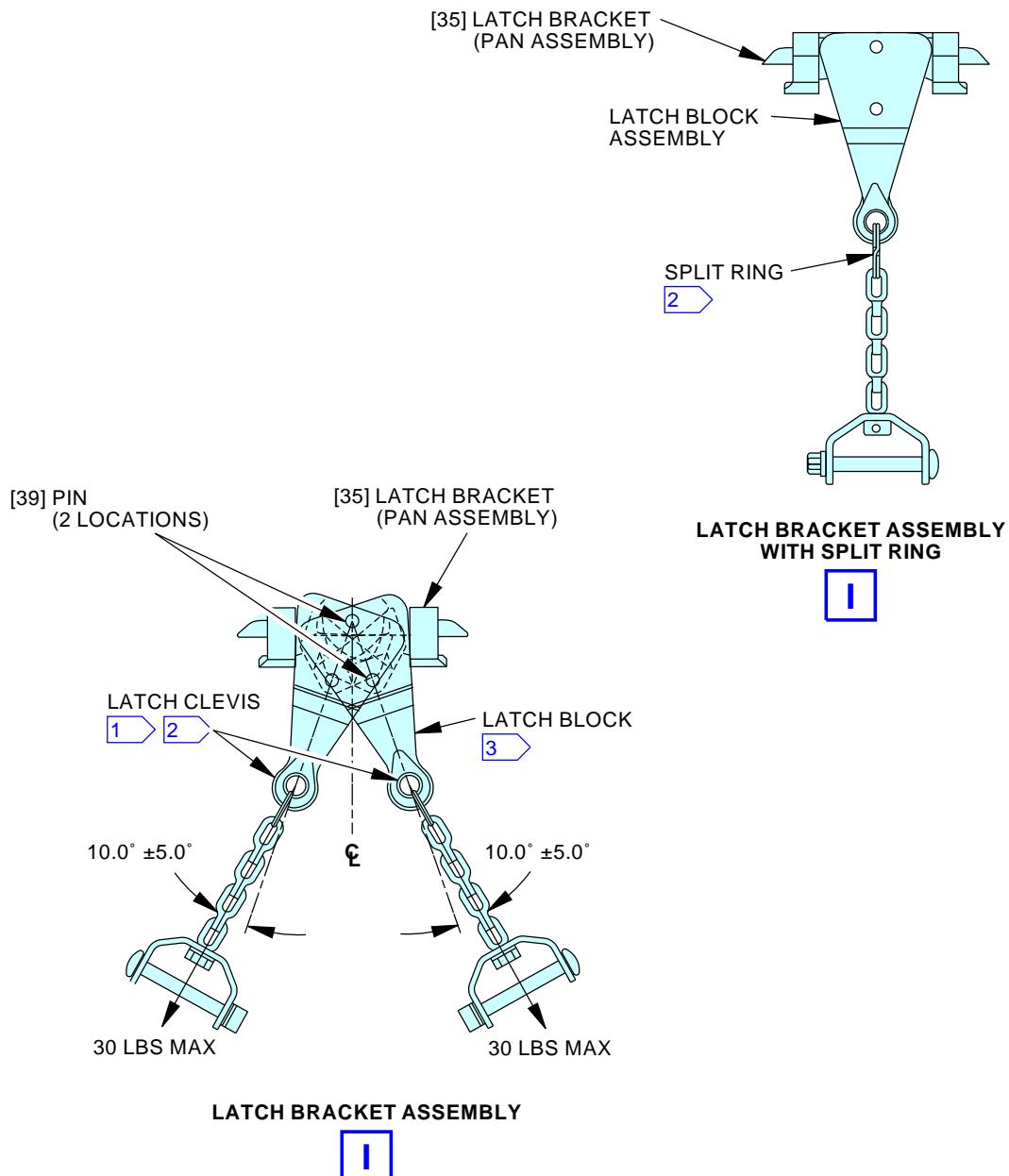
Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 5 of 7)

EFFECTIVITY
AKS ALL**25-66-01**

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- [1] MAKE SURE THAT THE CLEVIS CAN ROTATE FREELY IN THE LATCH BLOCK ASSEMBLY.
- [2] EACH ESCAPE SLIDE WILL HAVE ONE LATCH CLEVIS OR ONE SPLIT RING.
- [3] USE A MAXIMUM OF 30 POUNDS OF FORCE TO RELEASE THE LATCH.

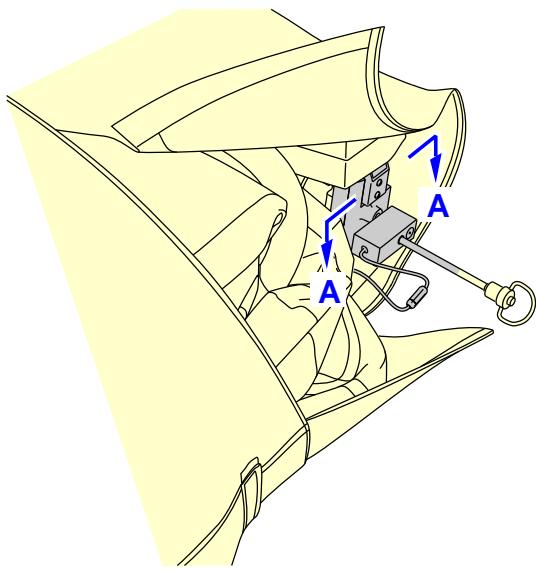
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Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 6 of 7)

EFFECTIVITY
AKS ALL

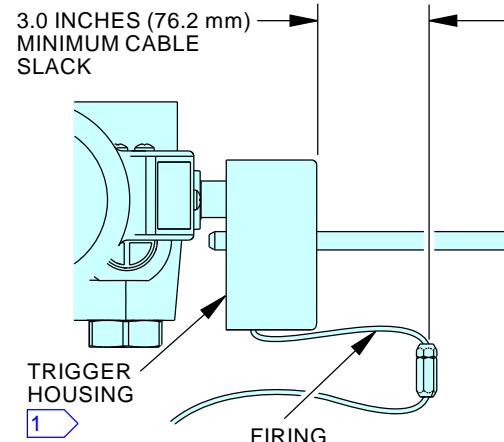
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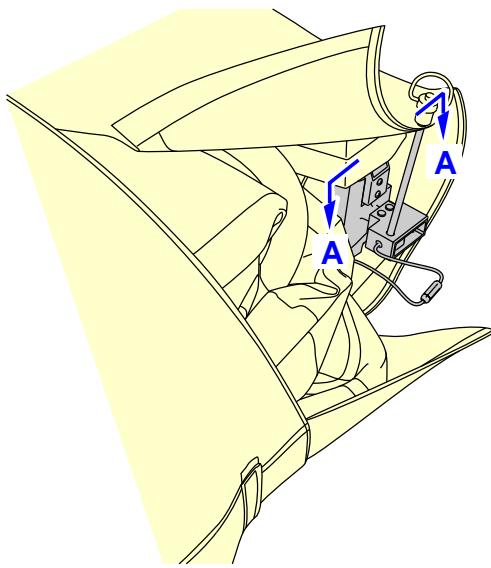


**INFLATION FIRING CABLE
(ESCAPE SLIDE WITH TRIGGER HOUSING)**

J

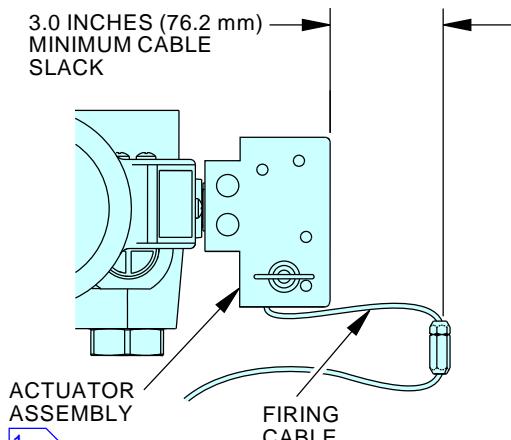


A-A



**INFLATION FIRING CABLE
(ESCAPE SLIDE WITH ACTUATOR ASSEMBLY)**

J



A-A

- 1** EACH ESCAPE SLIDE WILL HAVE ONE TRIGGER HOUSING OR ONE ACTUATOR ASSEMBLY

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Escape System Installation
Figure 401/25-66-01-990-805 (Sheet 7 of 7)

EFFECTIVITY
AKS ALL

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TASK 25-66-01-000-802

4. Escape Slide Pack Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Prepare for the Removal

SUBTASK 25-66-01-010-001

- (1) If the escape slide pack and cover [2] are installed on the door, do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

C. Removal

SUBTASK 25-66-01-420-001

- (1) Remove the escape slide pack [26] from the cover [3] as follows:

- (a) Remove the girt bar [4] from the girt bar retainers [5].
- (b) Remove the latch [7] from the latch bracket [13].
- (c) Open the cover [3] to get access to the bonding jumpers [12].

NOTE: When the compartment is open, the escape slide pack can expand. Plan the work so the compartment is open for a minimum time to avoid the expansion of the escape slide pack.

- (d) Remove the pin [33], ladder tie [32], and stud [31] that attach the bonding jumpers [12] to the backing pan [11] as shown.
- (e) Fully open the cover [3] to get access to the escape slide pack [26].
- (f) Remove the safety pin [19] from the pocket [18] on the escape slide pack [26].

WARNING: IF THE SAFETY PIN IS NOT IN THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (g) Put the safety pin [19] into the inflation cylinder valve [17] as shown.
- (h) Remove the escape slide pack [26] from the backing pan [11] and put it on a clean horizontal surface.

NOTE: The slide must be installed in the transport box immediately after removal from the backing pan. If it takes too long, the slide will grow and not fit into the backing pan.

- (i) If required, remove the locknut [29] and screw [27] to remove the latch [7] from the girt release strap [28].

NOTE: The latch [7] may be needed for a replacement escape slide.

———— END OF TASK ———

EFFECTIVITY
AKS ALL

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TASK 25-66-01-400-801

5. Escape Slide Pack Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
25-66-01-990-803	Figure: Escape System Inspection (P/B 601)

B. Consumable Materials

Reference	Description	Specification
D00113	Lubricant - Solid Film, Liquid Dispersed	BMS3-8
D00670	Oil - Penetrating (For Loosening Frozen Metallic Parts)	A-A-50493
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

C. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Prepare for the Installation

SUBTASK 25-66-01-860-002

- (1) Make sure the cover [3] and backing pan [11] are on a clean horizontal surface with the backing pan [11] against the clean horizontal surface.

SUBTASK 25-66-01-860-004

- (2) Make sure the cover [3] is open.

NOTE: When the compartment is open, the escape slide pack can expand. Plan the work so the compartment is open for a minimum time to avoid the expansion of the escape slide pack.

SUBTASK 25-66-01-600-001

- (3) Lubricate the latch assembly.

- (a) Apply solid film lubricant, D00113 to the escape slide latch.
- (b) Apply penetrating oil, D00670 to the pins [39].
- (c) Apply penetrating oil, D00670 to the pins [39] again to make sure that the oil fully penetrates the pins.
- (d) If there is too much penetrating oil, D00670, use a cotton wiper, G00034 to remove the unwanted oil from the latch assembly.

SUBTASK 25-66-01-700-002

- (4) Do a check of the latch release, Figure 25-66-01-990-803.

- (a) Move the latch block [35] to the left or right side until the latch block [35] cannot move.

NOTE: The test starts when you pull the latch block [35] to the side and it cannot continue to move.

- (b) Use a spring force scale to pull the latch chain in the same direction.

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AKS ALL

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- 1) Pull the latch chain or cable in the same direction $10 \pm 5^\circ$ arc (0.17 ± 0.09 rad).
- (c) Make sure that the latch assembly releases with no more than 30 lbf (133 N).

SUBTASK 25-66-01-700-003

- (5) Do the steps for the check of the latch release again.

- (a) Move the latch block [35] in the opposite direction.

NOTE: To complete the latch release check, it is necessary to do the check again in the opposite direction.

SUBTASK 25-66-01-860-005

WARNING: IF THE SAFETY PIN IS NOT IN THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (6) Make sure the safety pin [19] is in the inflation cylinder valve [17].

E. Installation of the Escape Slide Pack

SUBTASK 25-66-01-420-002

- (1) Install the escape slide pack [26] in the cover [3] as follows:

NOTE: The slide must be installed in the backing pan immediately after removal from the transport box. If it takes too long, the slide will grow and not fit into the backing pan.

- (a) Put the escape slide pack [26] in the backing pan [11].

NOTE: If the escape slide pack expands and can not be fitted into the compartment, a new escape slide pack must be installed.

- (b) Carefully extend the girt [6].

- (c) Make a "Z" fold [21] in the girt [6] as shown.

- (d) Align and push together the velcro strips [24] on the bottom side of the girt [6] with the velcro strips [24] on the backing pan shelf [22].

NOTE: The velcro strips should be clean and function as intended.

- (e) Align and push together the velcro strip [24] on the girt retainer flap [20] and the velcro strip [24] on the girt [6].

- (f) If required, install the screw [27] and locknut [29] to attach the latch [7] to the girt release strap [28].

- 1) Make sure that the screw [27] extends through the locknut [29] by 1 to 2 threads.

- (g) Make sure that there is at least the minimum amount of slack in the firing cable [30] near the inflation cylinder [17] (Figure 401).

- (h) If there is not enough slack in the firing cable [30] (Figure 401), do these steps:

- 1) Do not remove the safety pin [19].

- 2) Make sure the slide is correctly installed in the backing pan [11].

- 3) Make sure the "Z" fold [21] in the girt [6] is correct. Make sure the velcro strip [24] on the girt retainer flap [20] and the velcro strip [24] on the girt [6] are attached.

- 4) Make sure that there is at least the minimum amount of slack in the firing cable [30] near the inflation cylinder valve [17] (Figure 401).

- a) Hold the firing cable [30] at the inflation cylinder valve [17] and pull the slack from the cable.



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- <1> Pull the slack in the firing cable [30] away from the girt [6], in the direction of the inflation cylinder valve [17] until all slack is removed and the minimum amount of slack is achieved. If the minimum slack is not achieved, the escape slide pack [26] must be repacked.
- <2> Place the slack in the firing cable between the back of the aspirator and the inflation cylinder valve [17].

WARNING: BE CAREFUL WHEN YOU HANDLE THE ESCAPE SLIDE PACK. WHEN THE SAFETY PIN IS REMOVED FROM THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. THIS CAN CAUSE INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT.

- (i) Remove the safety pin [19] from the inflation cylinder valve [17].
- (j) Put the safety pin [19] into the pocket [18] on the escape slide pack [26].
- (k) Close the cover [3].
- (l) Make sure that you can clearly see the pressure gauge [16] of the inflation cylinder in the window [1]. If necessary, adjust as follows:
 - 1) Fully open the cover [3] to get access to the escape slide pack [26].
 - 2) Remove the safety pin [19] from the pocket [18] and install safety pin [19] in the inflation cylinder valve [17].
 - 3) Move the escape slide pack [26] to get the pressure gauge [16] in the center of the window [1].
 - 4) Make sure that there is the minimum amount of slack in the inflation firing cable [30] near the inflation cylinder valve [17] (Figure 401).
 - a) Hold the firing cable [30] at the inflation cylinder valve [17] and pull the slack from the cable.
 - <1> Pull the slack in the firing cable [30] away from the girt [6], in the direction of the inflation cylinder valve [17] until all slack is removed and the minimum amount of slack is achieved. If the minimum slack is not achieved, the escape slide pack [26] must be repacked.
 - <2> Place the slack in the firing cable between the back of the aspirator and the inflation cylinder valve [17].
 - 5) Remove the safety pin [19] from the inflation cylinder valve [17].
 - 6) Put the safety pin [19] into the pocket [18] on the escape slide pack [26].
 - (m) Close the cover [3] sufficiently to connect the bonding jumpers [12] to the backing pan [11].
 - (n) Install the stud [31], ladder tie [32] and pin [33] to attach the bonding jumpers [12] to the backing pan [11].
 - (o) Close the cover [3].
 - (p) Make sure the distance between the center of the lower edge of the cover [3] to the center of the girt bar [4] is 10.5 in. (266.7 mm) to 12.0 in. (304.8 mm).
 - (q) Align the holes in the latch bracket [13] and latch bracket [35] to install the latch [7].
 - (r) Install the latch [7] in the latch bracket [13] and latch bracket [35] as shown.
 - (s) Make sure that the sum of the clearances at 'A' and 'B' between the latch bracket [13] and latch bracket [35] is no more than 0.01 in. (0.25 mm) (Figure 401).

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- (t) Install the girt bar [4] in the girt bar retainers [5].

— END OF TASK —

TASK 25-66-01-400-804

6. Escape Slide Pack Installation (Unscheduled)

(Figure 401)

A. References

Reference	Title
25-66-01-990-803	Figure: Escape System Inspection (P/B 601)

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Prepare for the Installation

SUBTASK 25-66-01-860-009

- (1) Make sure the cover [3] and backing pan [11] are on a clean horizontal surface with the backing pan [11] against the clean horizontal surface.

SUBTASK 25-66-01-860-010

- (2) Make sure the cover [3] is open.

NOTE: When the compartment is open, the escape slide pack can expand. Plan the work so the compartment is open for a minimum time to avoid the expansion of the escape slide pack.

SUBTASK 25-66-01-700-004

- (3) Do a check of the latch release, Figure 25-66-01-990-803.

- (a) Move the latch block [35] to the left or right side until the latch block [35] cannot move.

NOTE: The test starts when you pull the latch block [35] to the side and it cannot continue to move.

- (b) Use a spring force scale to pull the latch chain in the same direction.

- 1) Pull the latch chain or cable in the same direction $10 \pm 5^\circ$ arc (0.17 ± 0.09 rad).

- (c) Make sure that the latch assembly releases with no more than 30 lbf (133 N).

SUBTASK 25-66-01-700-005

- (4) Do the steps for the check of the latch release again.

- (a) Move the latch block [35] in the opposite direction.

NOTE: To complete the latch release check, it is necessary to do the check again in the opposite direction.

SUBTASK 25-66-01-420-006

WARNING: IF THE SAFETY PIN IS NOT IN THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (5) Make sure the safety pin [19] is in the inflation cylinder valve [17].

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D. Installation of the Escape Slide Pack

SUBTASK 25-66-01-400-001

- (1) Install the escape slide pack [26] in the cover [3] as follows:

NOTE: The slide must be installed in the backing pan immediately after removal from the transport box. If it takes too long, the slide will grow and not fit into the backing pan.

- (a) Put the escape slide pack [26] in the backing pan [11].

NOTE: If the escape slide pack expands and can not be fitted into the compartment, a new escape slide pack must be installed.

- (b) Connect the escape slide strap [23] and the backing pan strap [25] under the escape slide pack [26].

- (c) Carefully extend the girt [6].

- (d) Make a "Z" fold [21] in the girt [6] as shown.

- (e) Align and push together the velcro strips [24] on the bottom side of the girt [6] with the velcro strips [24] on the backing pan shelf [22].

NOTE: The velcro strips should be clean and function as intended.

- (f) Align and push together the velcro strip [24] on the girt retainer flap [20] and the velcro strip [24] on the girt [6].

- (g) If required, install the screw [27] and locknut [29] to attach the latch [7] to the girt release strap [28].

- 1) Make sure that the screw [27] extends through the locknut [29] by 1 to 2 threads.

- (h) Make sure that there is at least the minimum amount of slack in the firing cable [30] near the inflation cylinder [17] (Figure 401).

- (i) If there is not enough slack in the firing cable [30] (Figure 401), do these steps:

- 1) Do not remove the safety pin [19].

- 2) Make sure the slide is correctly installed in the backing pan [11].

- 3) Make sure the "Z" fold [21] in the girt [6] is correct. Make sure the velcro strip [24] on the girt retainer flap [20] and the velcro strip [24] on the girt [6] are attached.

- 4) Make sure that there is at least the minimum amount of slack in the firing cable [30] near the inflation cylinder valve [17] (Figure 401).

- a) Hold the firing cable [30] at the inflation cylinder valve [17] and pull the slack from the cable.

<1> Pull the slack in the firing cable [30] away from the girt [6], in the direction of the inflation cylinder valve [17] until all slack is removed and the minimum amount of slack is achieved. If the minimum slack is not achieved, the escape slide pack [26] must be repacked.

<2> Place the slack in the firing cable between the back of the aspirator and the inflation cylinder valve [17].

WARNING: IF THE SAFETY PIN IS NOT IN THE INFLATION CYLINDER VALVE, THE ESCAPE SLIDE CAN ACCIDENTALLY INFLATE. ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (j) Carefully remove the safety pin [19] from the inflation cylinder valve [17].

- (k) Put the safety pin [19] into the pocket [18] on the escape slide pack [26].

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- (l) Close the cover [3].
- (m) Make sure that you can clearly see the pressure gauge [16] of the inflation cylinder in the window [1]. If necessary, adjust as follows:
 - 1) Fully open the cover [3] to get access to the escape slide pack [26].
 - 2) Remove the safety pin [19] from the pocket [18] and install safety pin [19] in the inflation cylinder valve [17].
 - 3) Move the escape slide pack [26] to get the pressure gauge [16] in the center of the window [1].
 - 4) Make sure that there is the minimum amount of slack in the inflation firing cable [30] near the inflation cylinder valve [17] (Figure 401).
 - a) Hold the firing cable [30] at the inflation cylinder valve [17] and pull the slack from the cable.
 - <1> Pull the slack in the firing cable [30] away from the girt [6], in the direction of the inflation cylinder valve [17] until all slack is removed and the minimum amount of slack is achieved. If the minimum slack is not achieved, the escape slide pack [26] must be repacked.
 - <2> Place the slack in the firing cable between the back of the aspirator and the inflation cylinder valve [17].
 - 5) Remove the safety pin [19] from the inflation cylinder valve [17].
 - 6) Put the safety pin [19] into the pocket [18] on the escape slide pack [26].
 - (n) Close the cover [3] sufficiently to connect the bonding jumpers [12] to the backing pan [11].
 - (o) Install the stud [31], ladder tie [32] and pin [33] to attach the bonding jumpers [12] to the backing pan [11].
 - (p) Close the cover [3].
 - (q) Make sure the distance between the center of the lower edge of the cover [3] to the center of the girt bar [4] is 10.5 in. (266.7 mm) to 12.0 in. (304.8 mm).
 - (r) Align the holes in the latch bracket [13] and latch bracket [35] to install the latch [7].
 - (s) Install the latch [7] in the latch bracket [13] and latch bracket [35] as shown.
 - (t) Make sure that the sum of the clearances at 'A' and 'B' between the latch bracket [13] and latch bracket [35] is no more than 0.01 in. (0.25 mm) (Figure 401).
 - (u) Install the girt bar [4] in the girt bar retainers [5].

— END OF TASK —

TASK 25-66-01-000-803

7. Escape Slide Girt Bar Removal

(Figure 401)

A. Tools/Equipment

Reference	Description
STD-1242	Hammer - Standard
STD-3908	Punch - Standard



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B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Prepare for the Removal

SUBTASK 25-66-01-860-007

- (1) The door should be fully closed or fully open to do this procedure.
 - (a) Remove the girt bar [4] from the girt bar retainers [5].

D. Escape Slide Girt Bar Removal

SUBTASK 25-66-01-020-002

- (1) For the girt bars with a sleeve [36] and spring pin on each end of the girt bar [4], do these steps:
 - (a) Remove one spring pin from one of the sleeves [36] using a standard hammer, STD-1242 and standard punch, STD-3908.
NOTE: Use pliers to help in the removal when the pin is not fully out of the sleeve [36].
 - (b) Slide the sleeve [36] off the girt bar [4].
 - (c) Pull the girt bar [4] out of the girt bar material [6].
- 1) Record the length of the girt bar for each door for the subsequent installation task.

SUBTASK 25-66-01-020-003

- (2) For the girt bars with the release stop assembly [37] and spring clip [38], do these steps:
 - (a) Using a flat head screw driver or equivalent, lift the spring clip [38] until the pin comes out of the hole in the release stop assembly [37].
 - (b) Slide the release stop assembly [37] off the girt bar [4].
 - (c) Pull the girt bar [4] out of the girt bar material [6].
- 1) Record the length of the girt bar for each door for the subsequent installation task.

———— END OF TASK ————

TASK 25-66-01-000-804

8. Escape Slide Girt Bar Installation

(Figure 401)

A. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Prepare for the Installation

SUBTASK 25-66-01-860-008

- (1) The door should be fully closed or fully open to do this procedure.



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C. Escape Slide Girt Bar Installation

SUBTASK 25-66-01-020-004

- (1) For the girt bars with a sleeve [36] and spring pin on each end of the girt bar [4], do these steps:

(a) Refer to the length of the girt bar that was recorded during the removal task.

(b) Make sure that you install the correct length girt bar for each door.

NOTE: The length of the girt bar for the FWD Door is 33.2 in. (84.3 cm) long.

The length for the girt bar for the AFT Door is 29.2 in. (74.2 cm) long.

(c) With a sleeve [36] and spring pin removed from one end, slide the girt bar [4] through the girt bar material [6].

(d) Slide the sleeve [36] on to the girt bar [4].

(e) Align the holes in the sleeve [36] with the holes in the girt bar [4].

(f) Install a spring pin in the hole.

NOTE: The spring pin should be flush with each end of the sleeve [36] when completed.

SUBTASK 25-66-01-020-005

- (2) For the girt bars with the release stop assembly [37] and spring clip [38], do these steps:

(a) With the release stop assembly [37] removed from the girt bar [4], slide the girt bar [4] through the girt bar material [6].

(b) Slide the release stop assembly [37] on to the girt bar [4].

(c) Align the hole in the girt bar [4] with the hole in the release stop assembly [37].

NOTE: When the holes are properly aligned, the spring clip [38] pin will release and engage the hole on the release stop assembly [37] and girt bar [4].

(d) When the spring clip [38] is engaged, make sure the release stop assembly [37] will not rotate around the girt bar [4].

NOTE: The release stop assembly [37] will not rotate when installed correctly.

———— END OF TASK ————



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DOOR-MOUNTED ESCAPE SYSTEM - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Escape Slide Pack Inflation Cylinder Check.
 - (2) Escape Slide Pack Check.

TASK 25-66-01-200-801

2. Escape Slide Pack Inflation Cylinder Check

(Figure 601)

A. General

- (1) The pressure gage of the escape slide pack inflation cylinder has a temperature compensator.

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Procedure

SUBTASK 25-66-01-210-001

- (1) Do a check of the inflation cylinder pressure level:

- (a) Make sure the inflation cylinder temperature is constant (+- 5 degrees F / +- 3 degrees C) for two hours or more.
- (b) Look through the window in the cover at the inflation cylinder pressure gage.
- (c) Make sure the pressure indicator needle is in the GO band (green) or not more than one needle width to the right of the GO band (green).

NOTE: It is best to do a check on the pressure gage when it has been at a constant temperature for 2 hours or more. The GO band (green) moves more quickly than the pressure gage needle in response to a large temperature change. This can cause an incorrect pressure indication.

- (d) If you will do an initial install of the escape slide assembly, make sure the pressure indicator needle aligns with the black line on the GO band (green).

NOTE: The escape slide will operate with the pressure indicator needle at the left side of the GO band (green). This is not recommended for the initial installation of the escape slide assembly.

———— END OF TASK ————

TASK 25-66-01-200-802

3. Escape Slide Pack Check

(Figure 602)

A. Location Zones

Zone	Area
831	Forward Entry Door

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(Continued)

Zone	Area
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Procedure

SUBTASK 25-66-01-210-002

- (1) Do a check of the escape slide pack as follows:

- (a) Repair or replace the slide pack or the girt if you find damage.

NOTE: Refer to the vendor Component Maintenance Manual for repair instructions.

- (b) Make sure Velcro strips on the girt are attached to Velcro strips on the backing pan shelf.

- (c) Make sure the fasteners that attach the escape slide pack cover to the door are tight.

- (d) Examine the escape slide girt bar:

- 1) Remove the girt bar from the girt bar retainer clips.

- 2) Remove the pins and collars to release the girt bar.

- 3) Make sure there is no corrosion on the girt bar.

- 4) Examine the girt bar retainer clips as follows:

- a) Make sure that there is no deformation in the retainer clips (Figure 602, view A-A).

- b) If there is retainer clip deformation, replace the clips or bend the clips to conform with (Figure 602, view A-A)..

- 5) Install the pins and collars on the girt bar.

- 6) Install the girt bar in the girt bar retainer clips.

- a) Make sure that the girt bar is firmly positioned in the retainer clips.

- (e) Make sure there is no corrosion on the latch.

- 1) Make sure that the spring pins are not corroded or bent.

- (f) Do a check of the latch assembly.

- 1) Make sure that the latch block assembly turns freely.

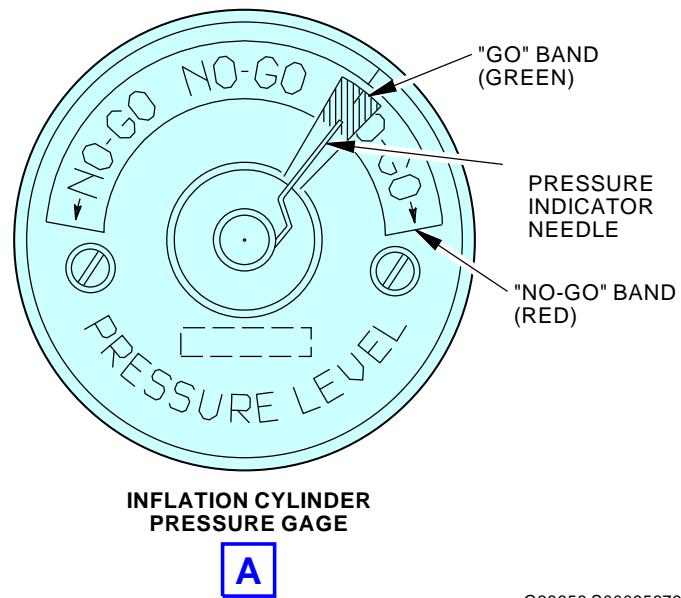
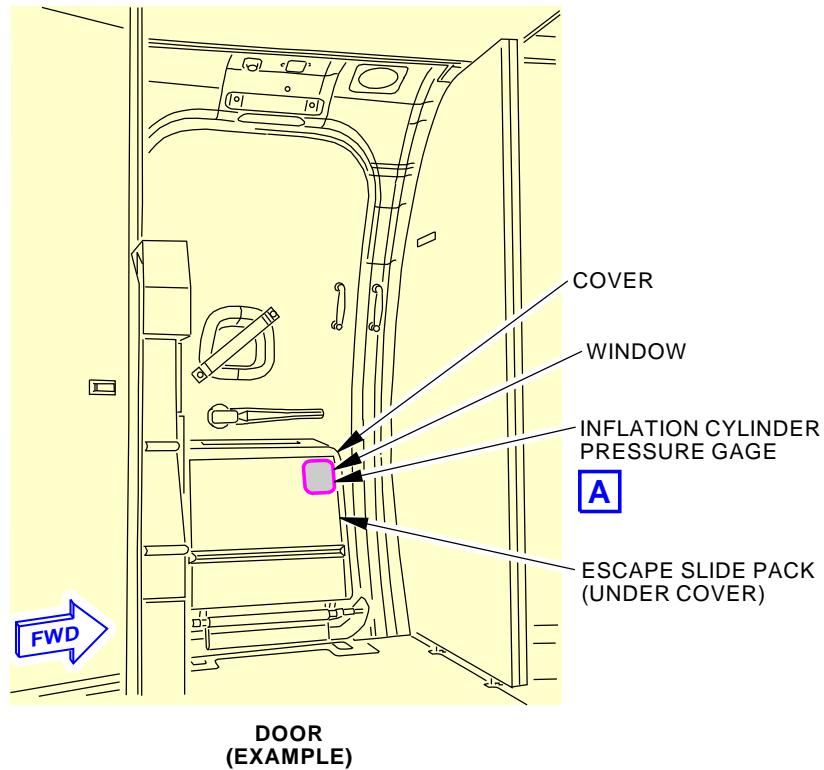
- 2) Make sure that the clevis bolt turns freely in the latch block.

- (g) Make sure that the latch operates easily throughout its range of angular motion.

— END OF TASK —



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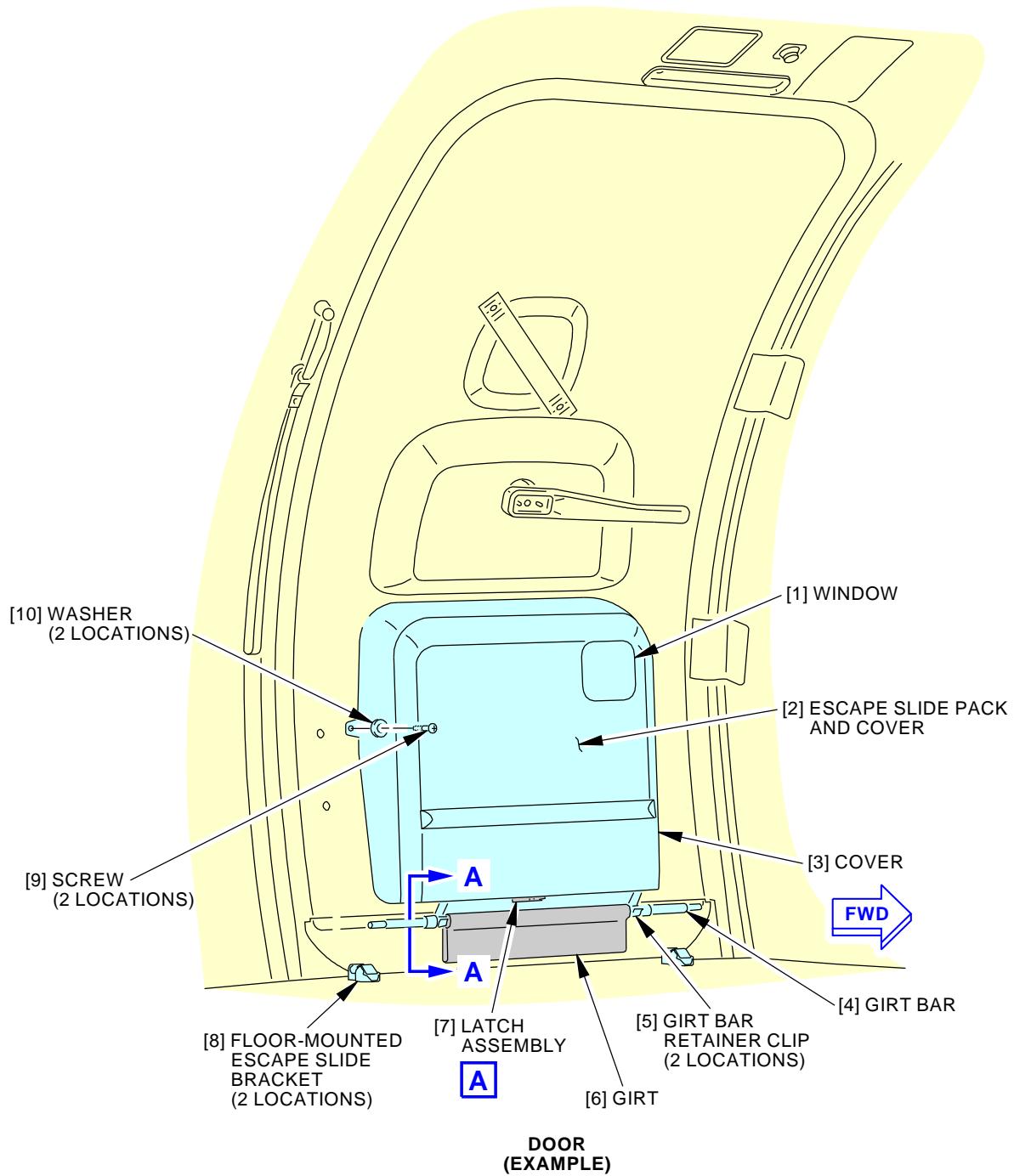


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Escape Slide Pack Inflation Cylinder Check
Figure 601/25-66-01-990-802

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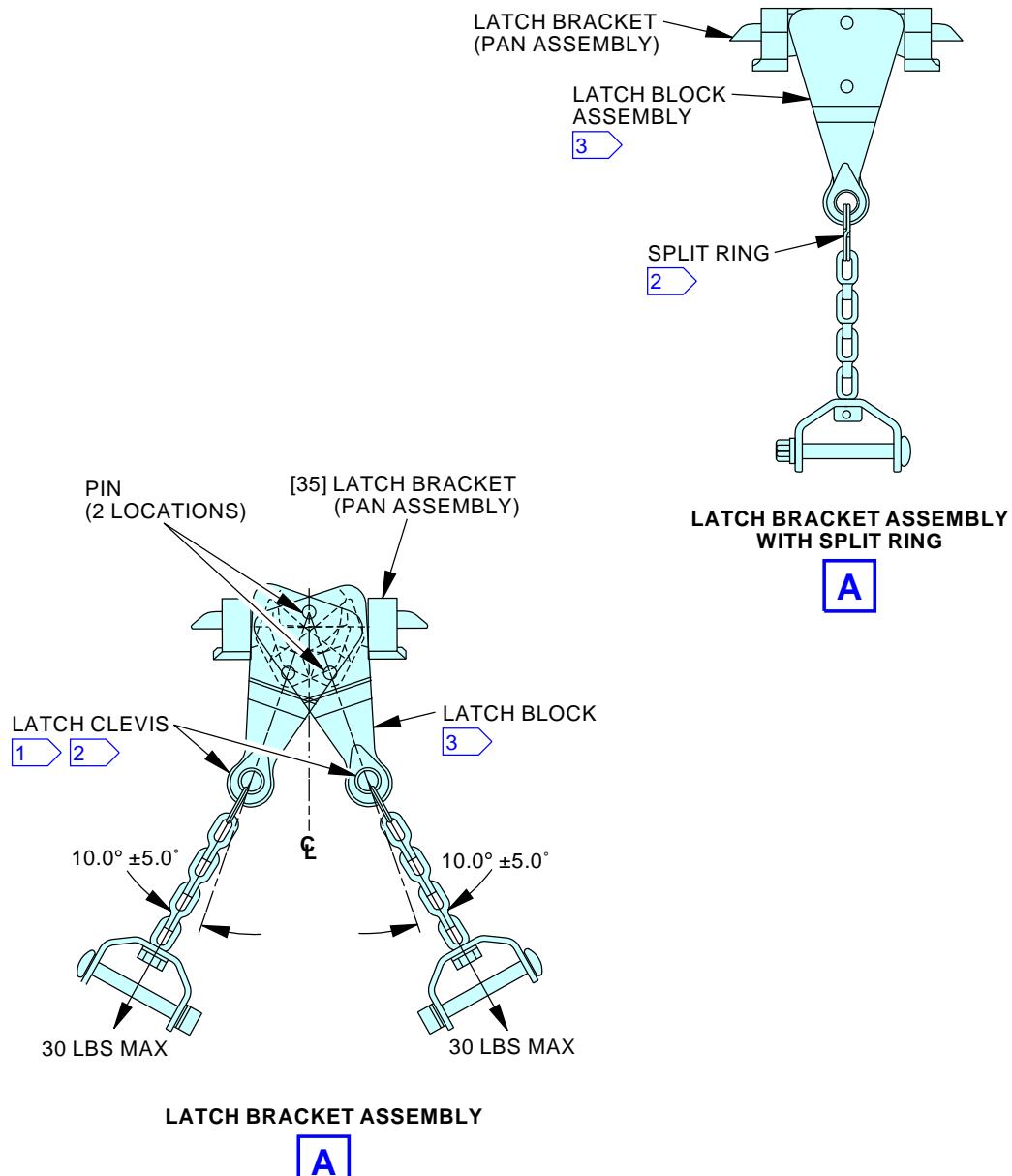
Escape System Inspection
Figure 602/25-66-01-990-803 (Sheet 1 of 3)

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- [1] MAKE SURE THAT THE CLEVIS CAN ROTATE FREELY IN THE LATCH BLOCK ASSEMBLY.
- [2] EACH ESCAPE SLIDE WILL HAVE ONE LATCH CLEVIS OR ONE SPLIT RING.
- [3] THE LATCH ASSEMBLY RELEASES AT 10 DEGREES, ± 5 DEGREES, WITH A MAXIMUM OF 30 LBF (133.45 NM).

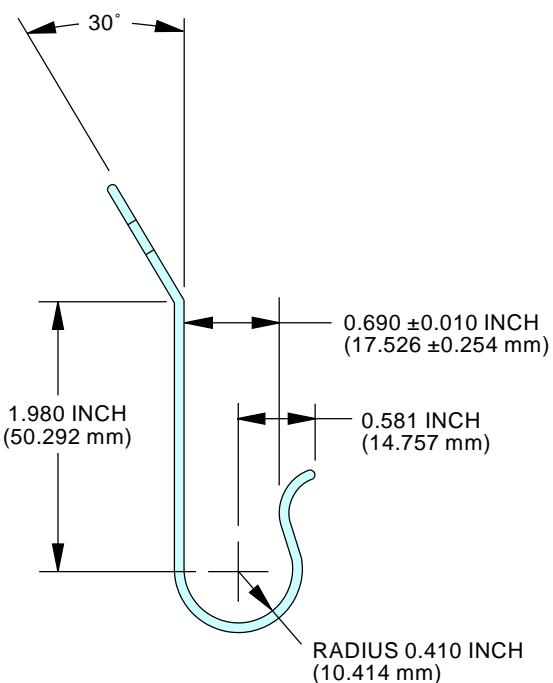
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Escape System Inspection
Figure 602/25-66-01-990-803 (Sheet 2 of 3)

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RETAINER CLIP 65C16820-11/12

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Escape System Inspection
Figure 602/25-66-01-990-803 (Sheet 3 of 3)

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FLOOR-MOUNTED ESCAPE SLIDE BRACKETS - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
 - (1) The removal of the entry or galley service door floor-mounted escape slide brackets.
 - (2) The installation of the entry or galley service door floor-mounted escape slide brackets.
- B. There are two floor-mounted escape slide brackets: one on each side of the door sill. The removal and installation of the brackets are the same.

TASK 25-66-02-000-801

2. Floor-Mounted Escape Slide Bracket Removal

(Figure 201)

A. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

B. Procedure

SUBTASK 25-66-02-020-001

- (1) Remove the bracket [1] of the floor-mounted escape slide floor:
 - (a) Remove the bolts [2] and lock washers [3] that attach the bracket [1] to the adapter plate [5].
 - (b) Pull the bracket [1] and shim [7] from the adapter plate [5].
 - (c) Remove the screws [6] that attach the adapter plate [5] to the floor.
NOTE: The screws [6] do not always have the same length. Identify the screws [6] and their correct locations for the subsequent installation.
 - (d) Remove the adapter plate [5] from the floor.

— END OF TASK —

TASK 25-66-02-400-801

3. Floor-Mounted Escape Slide Bracket Installation

(Figure 201)

A. References

Reference	Title
20-30-95-910-801	Final Cleaning Prior to Aerodynamic Smoothing and Fairing (Series 95) (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A50030	Adhesive - Translucent RT Vulcanizing Silicone Rubber - RTV6708	BAC5010 Type 109 Grade 2
A50057	Adhesive - Silicone Rubber, RTV157	BAC5010 Type 60

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(Continued)

Reference	Description	Specification
B01015	Solvent - Final Cleaning Prior To Aerodynamic Smoothing And Fairing (AMM 20-30-95/201) - Series 95	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

C. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Procedure

SUBTASK 25-66-02-420-001

- (1) Install the bracket [1] of the floor-mounted escape slide floor:
 - (a) Examine the adapter plate [5] for corrosion.
 - (b) If you find corrosion, replace the adapter plate [5].
 - (c) Clean the screws [6] and the holes in the adapter plate [5] with Series 95 solvent, B01015 (TASK 20-30-95-910-801).
 - (d) Dry the screws [6] and the holes in the adapter plate [5] with a clean cotton wiper, G00034.
 - (e) Apply RTV6708 adhesive, A50030 to the screws [6] and the holes in the adapter plate [5].
NOTE: adhesive, A50057 is optional to RTV6708 adhesive, A50030.
 - (f) Put the adapter plate [5] over the holes in the floor.
NOTE: Note: There is a placard on the adapter plate. Obey the direction of the arrow on the placard.
 - (g) Install the screws [6].
 - (h) Put the shim [7] and bracket [1] in their correct position on the adapter plate [5].
 - (i) Install the bolts [2] and lock washers [3] to attach the bracket [1] to the adapter plate [5].
 - (j) Make sure the adapter plate [5] and the bracket [1] are in the correct positon (Ref. Figure 201).

E. Installation Test

SUBTASK 25-66-02-210-002

- (1) Do a check on the brackets [1] as follows:
 - (a) Make sure that the door is safe:
 - 1) Make sure that the door is closed and latched.

WARNING: MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE BRACKETS OF THE FLOOR-MOUNTED ESCAPE SLIDE. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN OPERATE WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- 2) Make sure that the girt bar is not engaged in the brackets [1].



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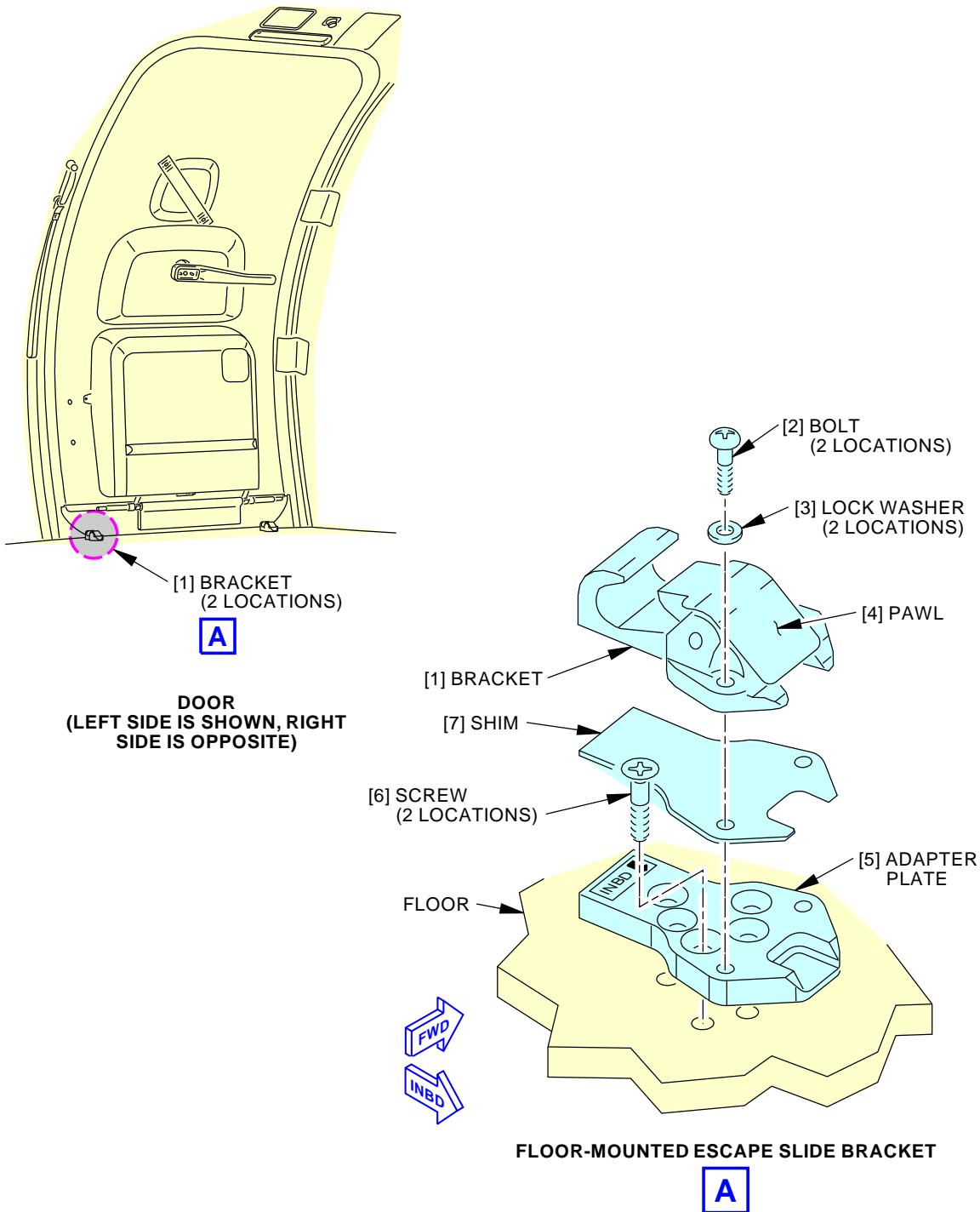
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- 3) Put the orange slide warning pennant across the window.
- (b) Remove the girt bar from the girt bar retainers on the cover.
- (c) Install the girt bar in the brackets [1].
- (d) Make sure that the brackets operate correctly.
- (e) Remove the girt bar from the brackets [1].
- (f) Install the girt bar in the girt bar retainer on the cover.
- (g) Remove the orange slide warning pennant from across the window.

———— END OF TASK ————

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**Floor-Mounted Escape Slide Bracket Installation
Figure 201/25-66-02-990-802**

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ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The removal of the E1/E5 moisture shroud,
 - (2) The installation of the E1/E5 moisture shroud,
 - (3) The removal of the E2/E3/E4 moisture shroud,
 - (4) The installation of the E2/E3/E4 moisture shroud,
 - (5) The removal of the E6 moisture shroud,
 - (6) The installation of the E6 moisture shroud.

TASK 25-71-00-000-801

2. E1/E5 Moisture Shroud Removal

(Figure 401)

A. References

Reference	Title
25-71-00-210-801	EE Center Moisture Shroud Visual Inspection (P/B 601)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Procedure

SUBTASK 25-71-00-010-001

- (1) Open the electronic compartment door for access.

SUBTASK 25-71-00-020-001

- (2) Remove the moisture shroud [1]:

NOTE: Removal of adjacent moisture shroud is necessary if you remove the forward center, forward right, or the aft right moisture shrouds.

- (a) Loosen the hose clamp [2] that attaches the drain tube [3] to the moisture shroud [1].
- (b) Disconnect the drain tube [3] from the moisture shroud [1].
- (c) Remove the screws [12] and washers [11].
- (d) Remove the plastic washer [10], if it is installed.
- (e) Remove the moisture shroud [1].

SUBTASK 25-71-00-220-001

- (3) If cracks or evidence of leakage is seen, do this task: EE Center Moisture Shroud Visual Inspection, TASK 25-71-00-210-801.

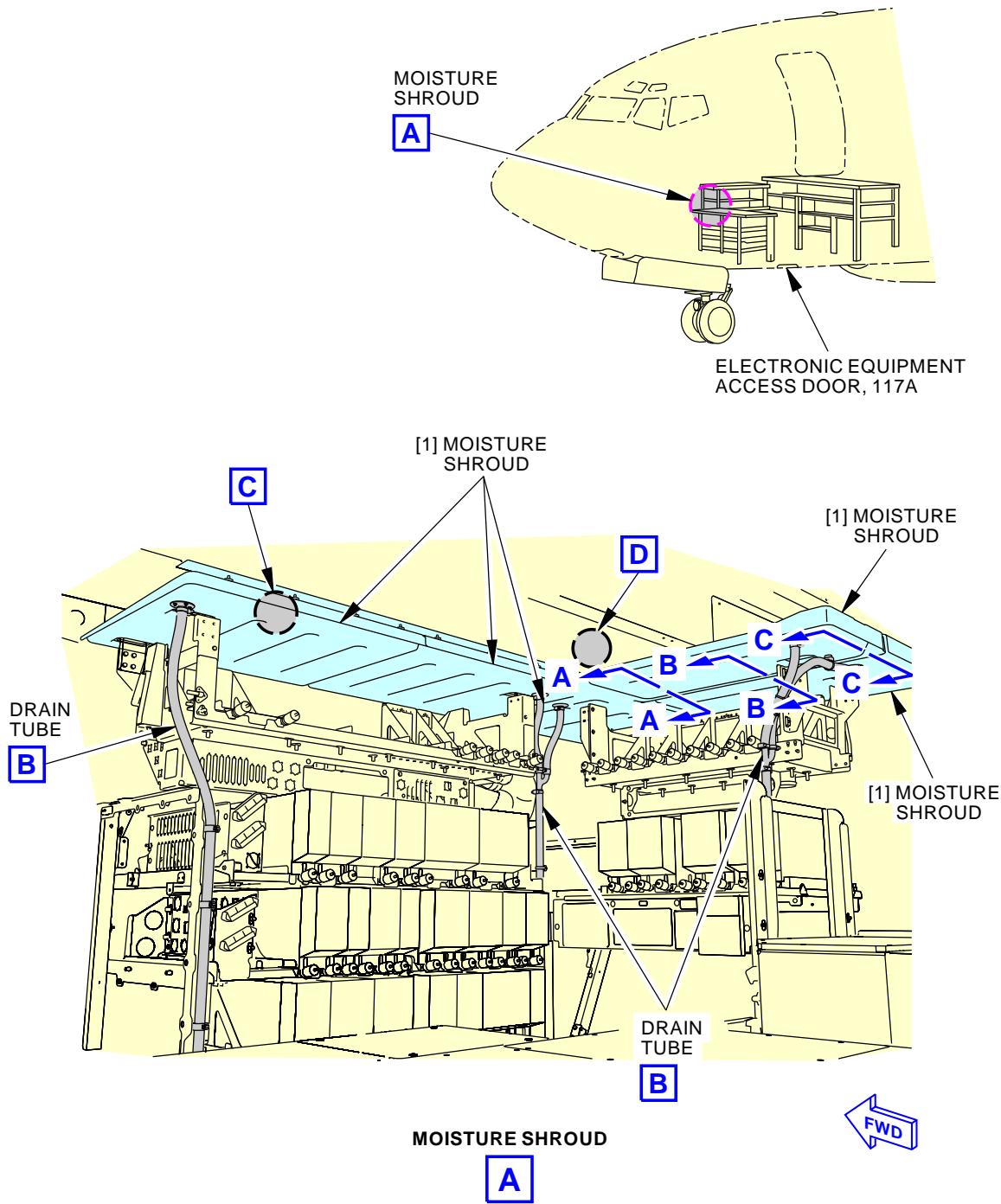
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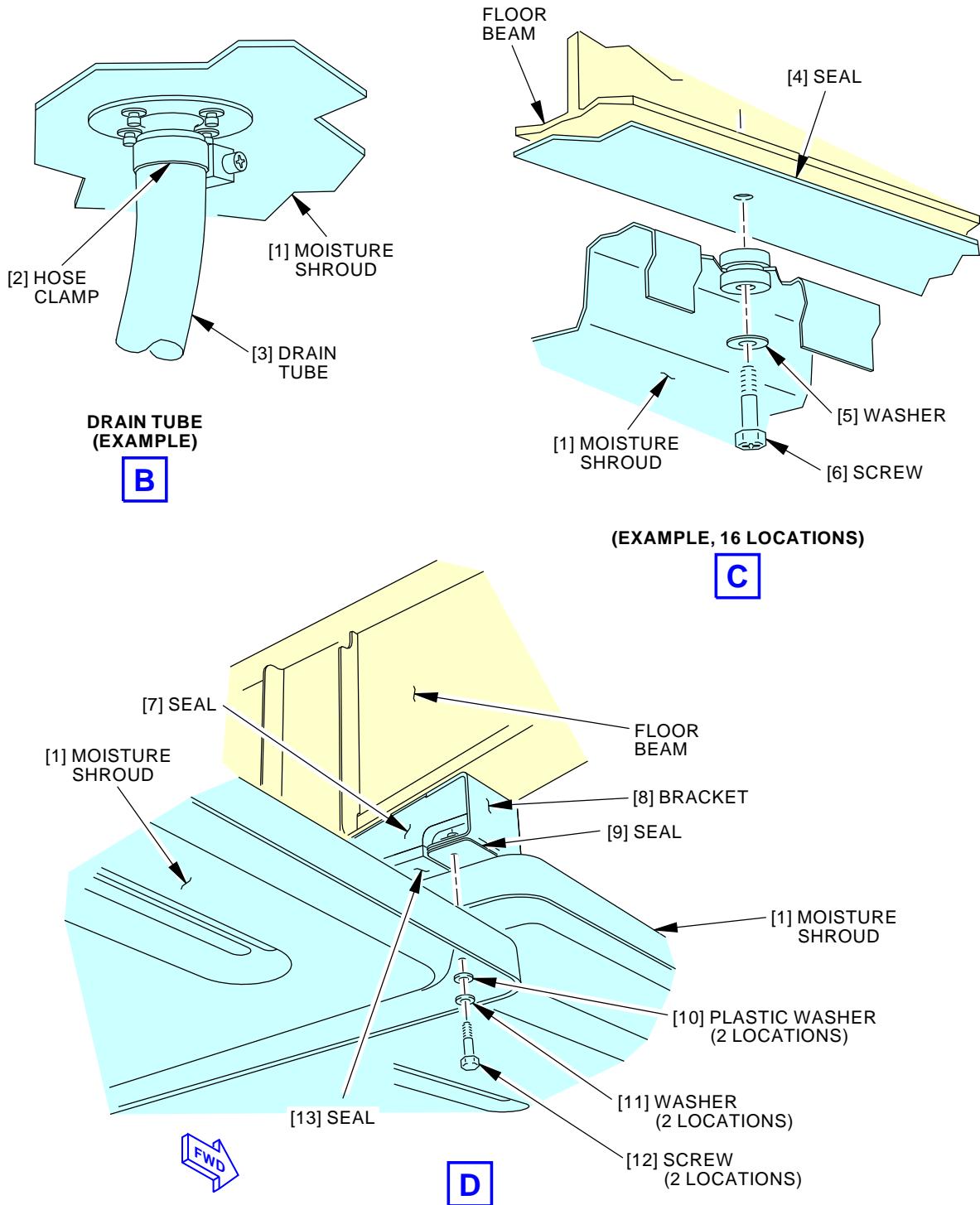
E1/E5 Moisture Shroud Installation
Figure 401/25-71-00-990-807 (Sheet 1 of 3)

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E1/E5 Moisture Shroud Installation
Figure 401/25-71-00-990-807 (Sheet 2 of 3)

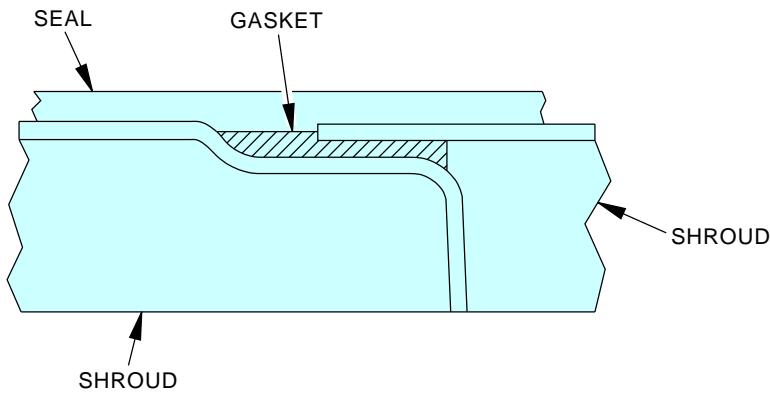
EFFECTIVITY
AKS ALL

25-71-00

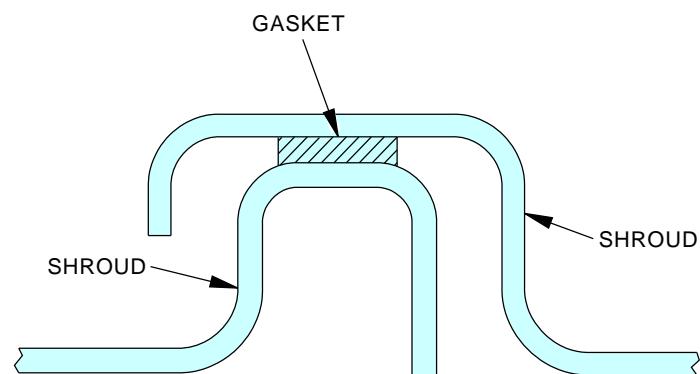
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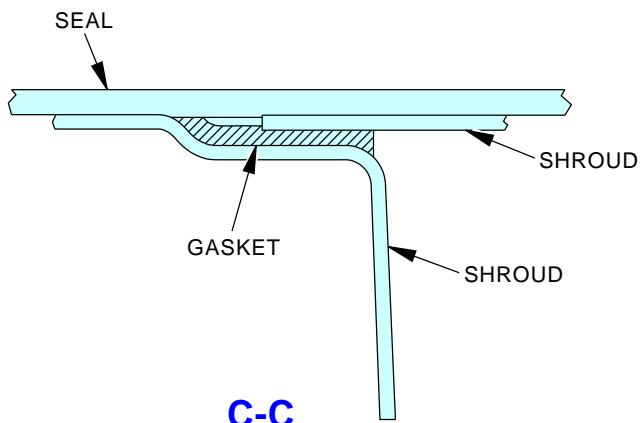
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



A-A



B-B



C-C

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E1/E5 Moisture Shroud Installation
Figure 401/25-71-00-990-807 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

25-71-00

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AIRCRAFT MAINTENANCE MANUAL

TASK 25-71-00-400-801

3. E1/E5 Moisture Shroud - Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G50825	Gasket - Polymer Gel	BMS8-397

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Procedure

SUBTASK 25-71-00-420-001

- (1) Install the E1/E5 moisture shroud [1]:

- (a) Put the moisture shroud [1] in its position.
- (b) Install the new gasket, G50825 along the top edge of the moisture shroud that is located directly over the E5 rack.
 - 1) Do these steps:
 - a) Remove the release film from the lower surface of 36 inches of the gasket.
 - b) Apply the gasket to the cleaned surface.
<1> Use firm hand pressure to minimize air entrapment.
 - c) Make sure that the lengthwise edges of the gasket are bonded to the moisture shroud.
 - d) Remove the remaining release film from the applied gasket.
 - e) Remove the release film from the lower surface of 36 inches of the gasket.
 - f) Apply the gasket to the previously applied gasket.
<1> Use firm hand pressure to minimize air entrapment.
 - g) Make sure that the lengthwise edges of the gasket are bonded to the previously applied gasket surface.
 - h) Remove the remaining release film.
 - i) Make sure that the butt joint is applied at a 90 degree angle to prevent water run over.
 - (c) Install the screws [12] and washers [11].
 - (d) If you removed it, install the plastic washer [10].
 - (e) Connect the drain tube [3] to the moisture shroud [1].
 - (f) Tighten the hose clamp [2] around the drain tube [3].

SUBTASK 25-71-00-410-001

- (2) Close the electronic compartment door.

———— END OF TASK ————



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TASK 25-71-00-000-802

4. E2/E3/E4 Moisture Shroud Removal

(Figure 402)

A. References

Reference	Title
25-71-00-210-801	EE Center Moisture Shroud Visual Inspection (P/B 601)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Procedure

SUBTASK 25-71-00-010-002

- (1) Remove the access panel on the aft side of the E2/E3/E4 equipment rack.

SUBTASK 25-71-00-020-002

- (2) Remove the moisture shroud [1].

- (a) Loosen the hose clamp [5] that attaches the drain tube [2] to the moisture shroud [].
- (b) Disconnect the drain tube [2] from the moisture shroud [1].
- (c) Remove the screws [4] and the washers [3].

NOTE: Remove the screws [4] and washers [3] for the forward part of the moisture shroud from the forward side of the E2/E3/E4 equipment rack.

- (d) Remove the moisture shroud [1].

SUBTASK 25-71-00-220-002

- (3) If cracks or evidence of leakage is seen, do this task: EE Center Moisture Shroud Visual Inspection, TASK 25-71-00-210-801.

———— END OF TASK ————

TASK 25-71-00-400-802

5. E2/E3/E4 Moisture Shroud Installation

(Figure 402)

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Procedure

SUBTASK 25-71-00-420-002

- (1) Install the moisture shroud [1].

- (a) Put the moisture shroud [1] in its position.
- (b) Install the screws [4] and the washers [3].

NOTE: Install the screws [4] and washers [3] for the forward part of the moisture shroud [] from the forward side of the E2/E3/E4 equipment rack.

- (c) Connect the drain tube [2] to the moisture shroud [1].
- (d) Tighten the hose clamp [5] around the drain tube [2].



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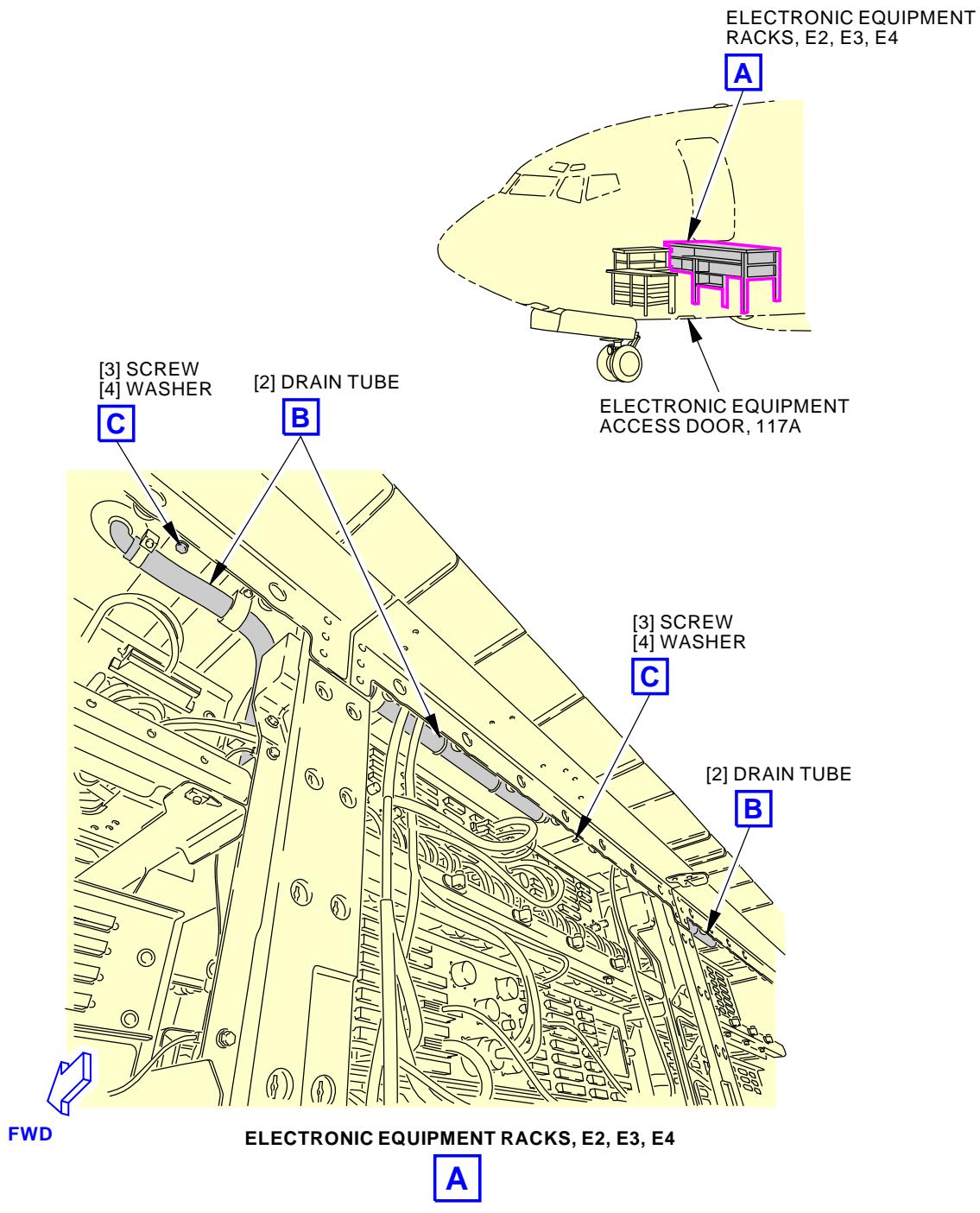
SUBTASK 25-71-00-410-002

- (2) Install the access panel on the aft side of the E2/E3/E4 equipment rack.

———— END OF TASK ——

EFFECTIVITY
AKS ALL

25-71-00



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E2, E3, E4 Moisture Shroud Installation
Figure 402/25-71-00-990-805 (Sheet 1 of 2)

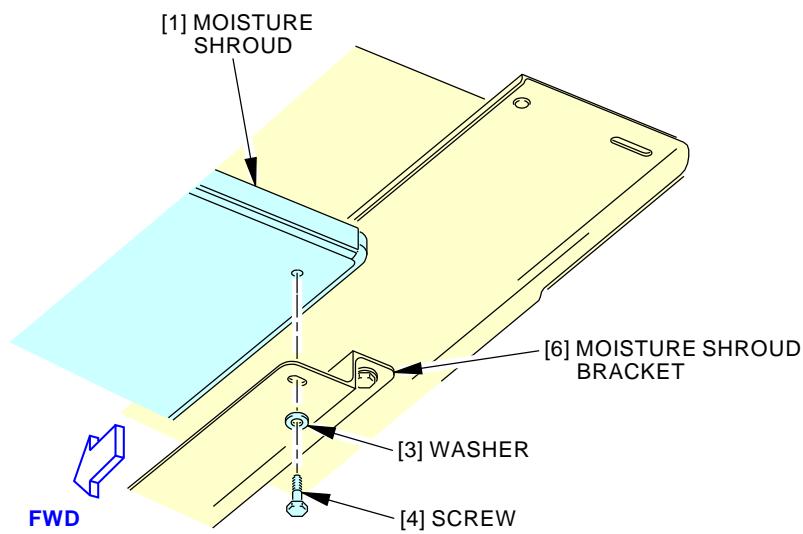
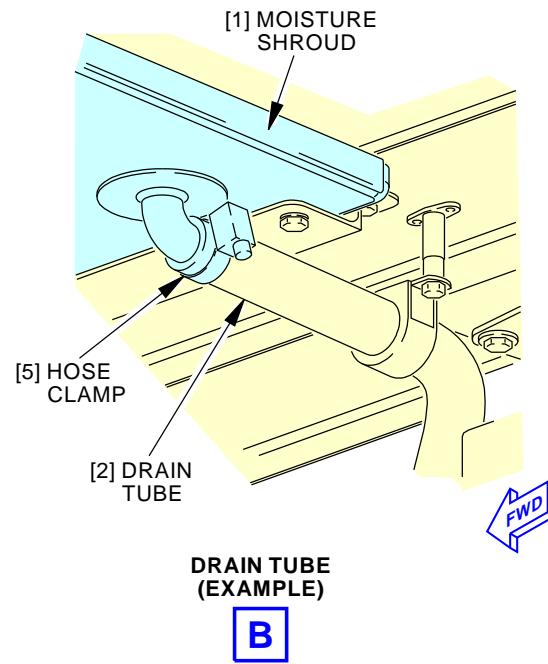
 EFFECTIVITY
 AKS ALL

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E2, E3, E4 Moisture Shroud Installation
Figure 402/25-71-00-990-805 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

25-71-00

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TASK 25-71-00-000-803

6. E6 Moisture Shroud Removal

(Figure 403)

A. References

Reference	Title
25-71-00-210-802	E6 Rack Moisture Shroud Visual Inspection (P/B 601)

B. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

C. Procedure

SUBTASK 25-71-00-020-003

- (1) Remove the moisture shroud [1]:
 - (a) Loosen the hose clamps [3] that attach the drain tubes [2] to the moisture shroud [1].
 - (b) Disconnect the drain tubes [2] from the moisture shroud [1].
 - (c) Remove the bolts [5] and the washers [4].
 - (d) Remove the bolts [6], washers [7], and the plastic washers [8].
 - (e) Remove the moisture shroud [1].

SUBTASK 25-71-00-220-003

- (2) If cracks or evidence of leakage is seen, do this task: E6 Rack Moisture Shroud Visual Inspection, TASK 25-71-00-210-802.

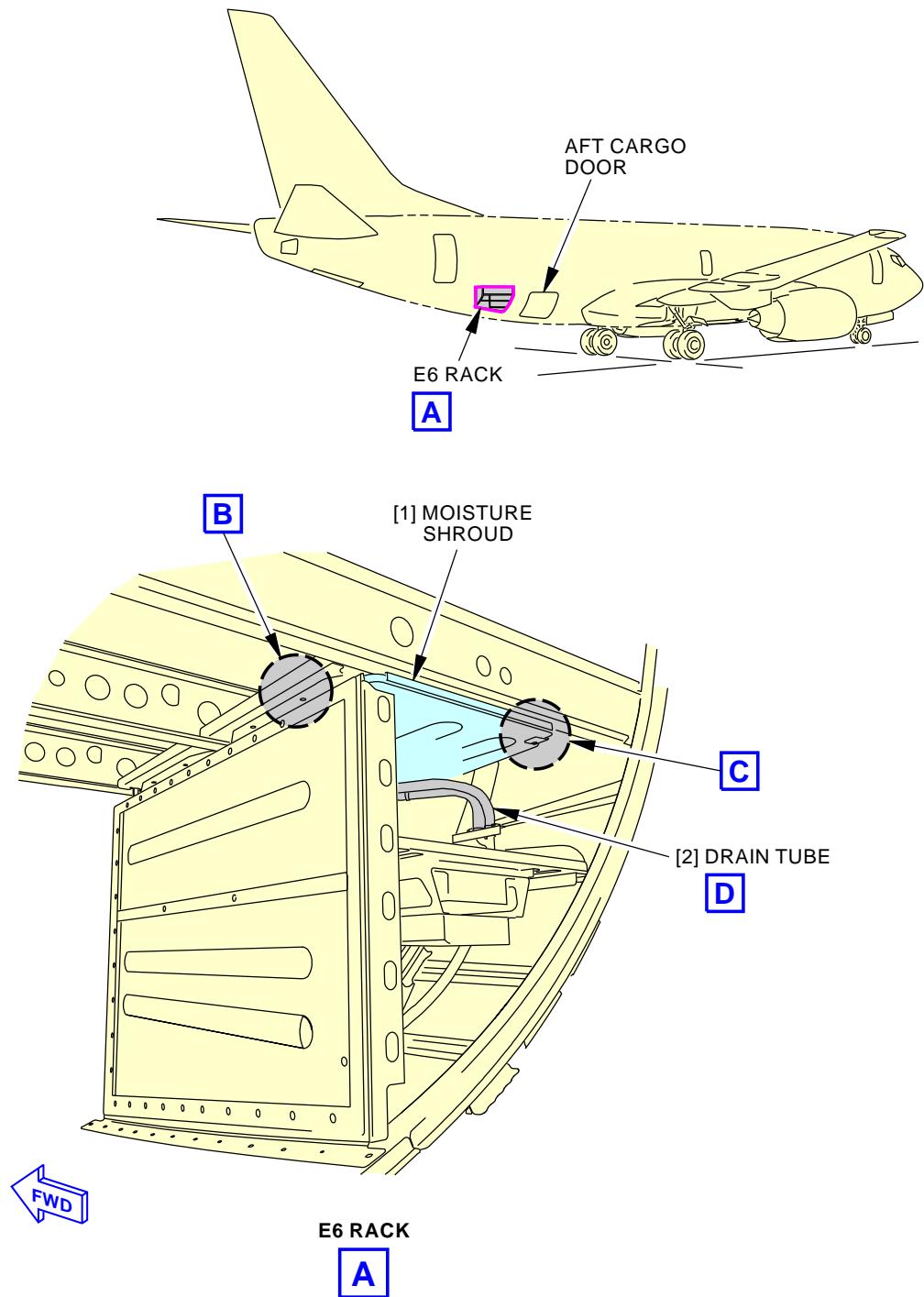
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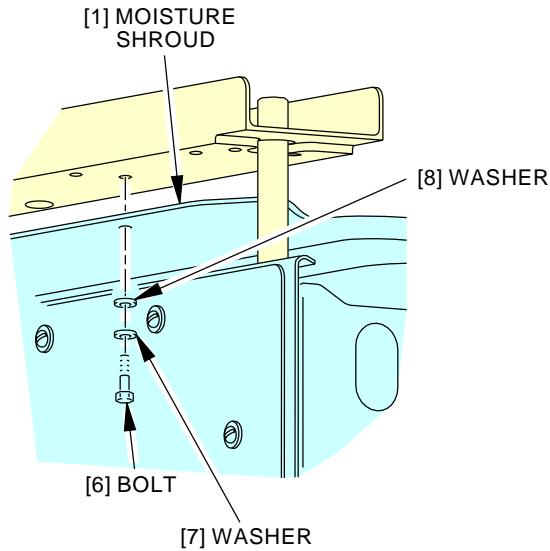
E6 Moisture Shroud Installation
Figure 403/25-71-00-990-808 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

25-71-00

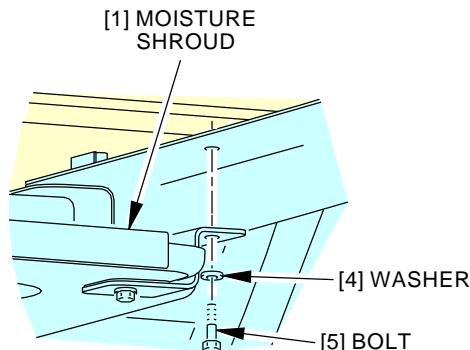
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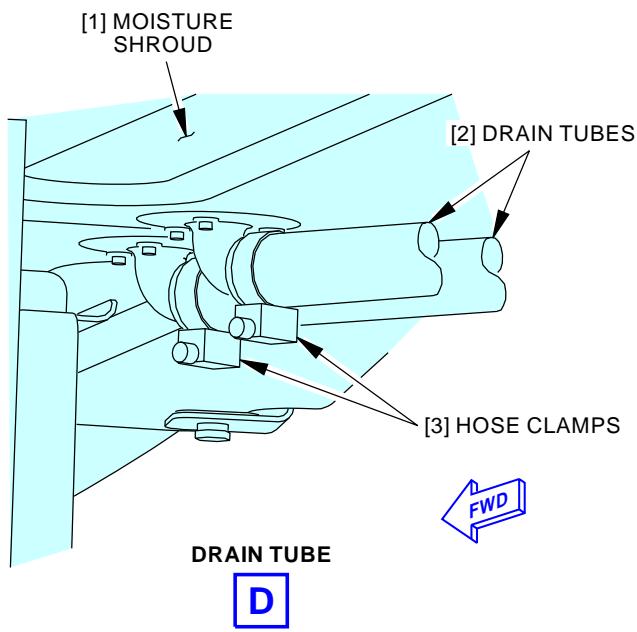
(EXAMPLE, 4 LOCATIONS)

B



(EXAMPLE, 4 LOCATIONS)

C



FWD

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E6 Moisture Shroud Installation
Figure 403/25-71-00-990-808 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 25-71-00-400-803

7. E6 Moisture Shroud - Installation

(Figure 403)

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

B. Procedure

SUBTASK 25-71-00-420-003

- (1) Install the E6 moisture shroud [1]:
 - (a) Put the moisture shroud [1] in its position.
 - (b) Install the bolts [6], washers [7], and the washers [8].
 - (c) Install the bolts [5] and the washers [6].
 - (d) Connect the drain tubes [2] to the moisture shroud [1].
 - (e) Tighten the hose clamps [3] around the drain tubes [2].

— END OF TASK —

EFFECTIVITY
AKS ALL

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ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) EE Center Moisture Shroud Visual Inspection.
 - (2) E6 Rack Moisture Shroud Visual Inspection, if applicable.

TASK 25-71-00-210-801

2. EE Center Moisture Shroud Visual Inspection

(Figure 601)

A. References

Reference	Title
25-71-00 P/B 401	ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION
25-71-00-000-801	E1/E5 Moisture Shroud Removal (P/B 401)
25-71-00-400-801	E1/E5 Moisture Shroud - Installation (P/B 401)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Procedure

SUBTASK 25-71-00-210-001

- (1) Examine the moisture shrouds (drip pans) that are above the electronic equipment racks in the electronic equipment compartment.
 - (a) Make sure they do not have obvious cracks, tears, or clogged drains.
 - (b) Make sure that they are not loose.

SUBTASK 25-71-00-210-005

- (2) Do a check for cracks around the fasteners and mounting holes of the moisture shroud.
 - (a) Replace the EE moisture shroud for a crack NOT in the direction toward an edge without a return lip that has a crack length more than 0.75 in. (1.90 cm). Do the applicable task in this procedure: ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION, PAGEBLOCK 25-71-00/401.
 - (b) Replace the EE moisture shroud for a crack in the direction toward an edge without a return lip that has a crack length more than one half of the distance between the hole and the edge of the flange. Do the applicable task in this procedure: ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION, PAGEBLOCK 25-71-00/401.

SUBTASK 25-71-00-210-007

- (3) Do a check of the polymer gel gasket that is between the moisture shrouds.
 - (a) Make sure that there are no cracks, tears, or holes that would allow moisture damage.
 - (b) Replace the gasket if it is necessary.
- 1) Do the applicable steps in this task: E1/E5 Moisture Shroud Removal, TASK 25-71-00-000-801

EFFECTIVITY
AKS ALL

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- 2) Do the applicable steps in this task: E1/E5 Moisture Shroud - Installation,
TASK 25-71-00-400-801

———— END OF TASK ——

———— EFFECTIVITY ——
AKS ALL

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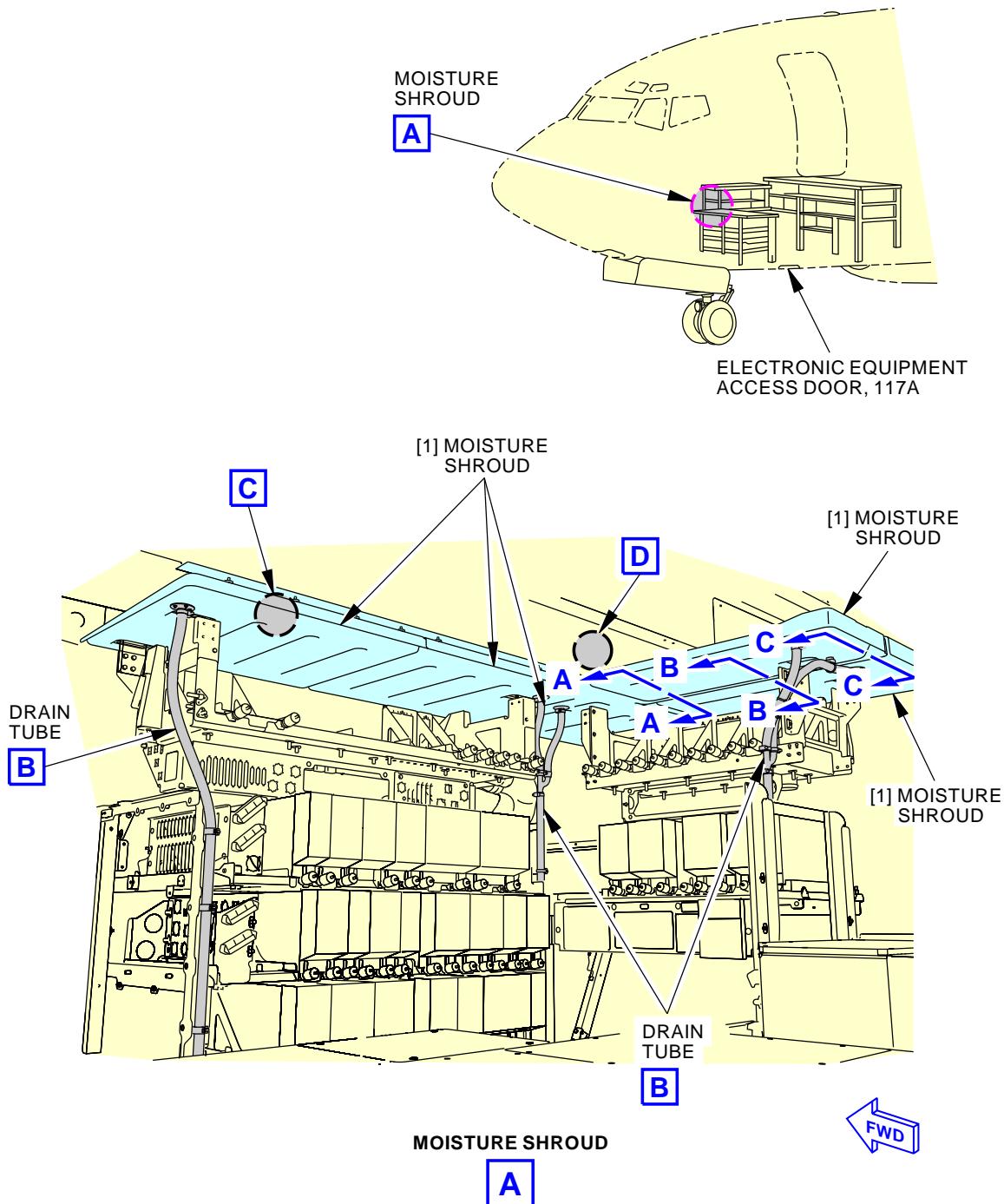
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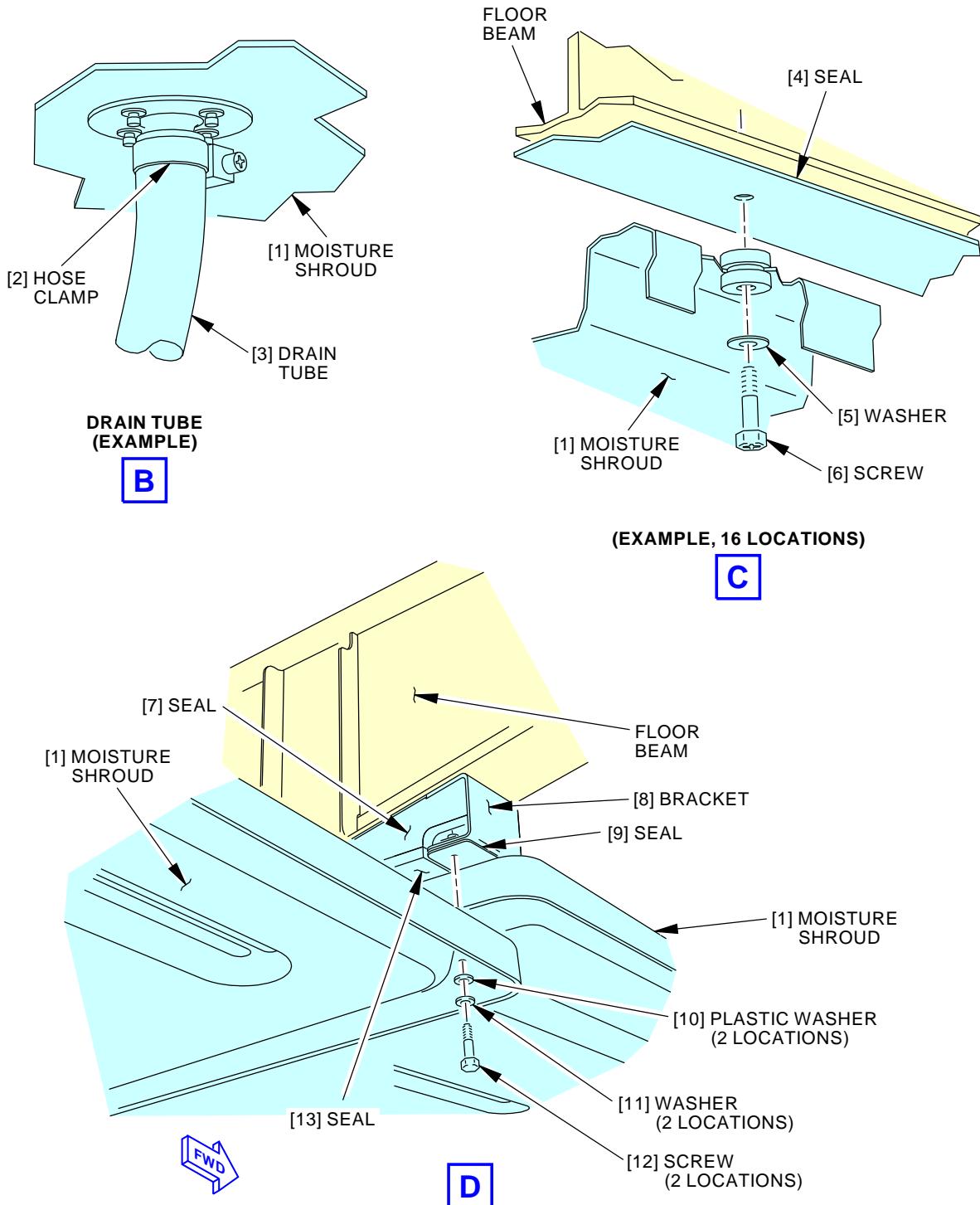


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E1/E5 Moisture Shroud Installation
Figure 601/25-71-00-990-809 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

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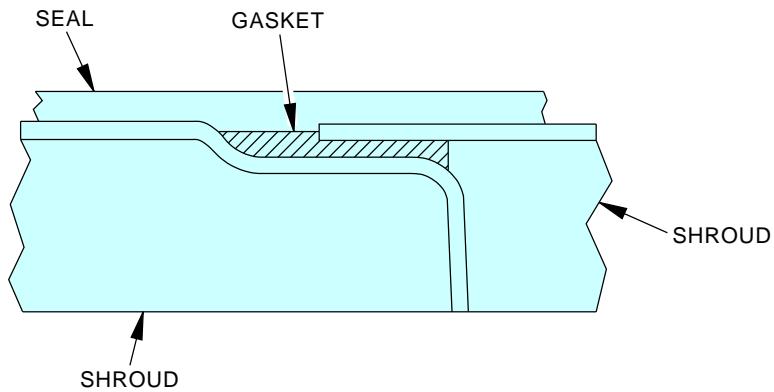
E1/E5 Moisture Shroud Installation
Figure 601/25-71-00-990-809 (Sheet 2 of 3)

EFFECTIVITY
 AKS ALL

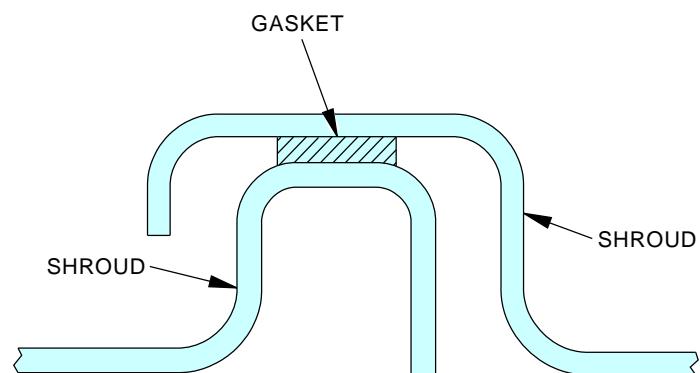
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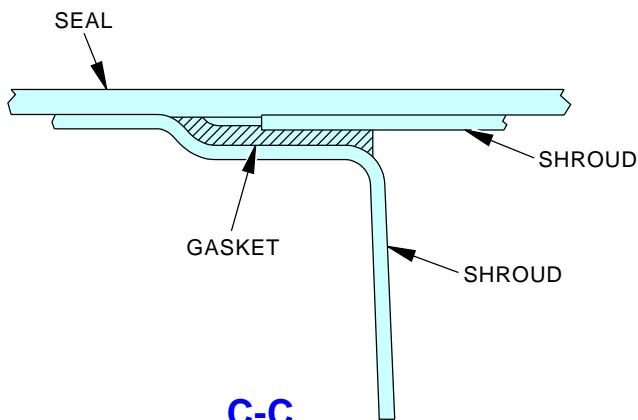
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A-A



B-B



C-C

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E1/E5 Moisture Shroud Installation
Figure 601/25-71-00-990-809 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

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TASK 25-71-00-210-802

3. E6 Rack Moisture Shroud Visual Inspection

(Figure 602)

A. References

Reference	Title
25-71-00 P/B 401	ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION

B. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

C. Procedure

SUBTASK 25-71-00-210-003

- (1) Examine the moisture shroud (drip pan) that is above the E6 electronic equipment rack in the aft cargo compartment, if applicable.
 - (a) Make sure it does not have obvious cracks, tears, or a clogged drain.
 - (b) Make sure it is not loose.

SUBTASK 25-71-00-210-006

- (2) Do a check for cracks around the fasteners and mounting holes of the moisture shroud.
 - (a) Replace the E6 moisture shroud for a crack NOT in the direction toward an edge without a return lip that has a crack length more than 0.75 in. (1.90 cm). Do the applicable task in this procedure: ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION, PAGEBLOCK 25-71-00/401.
 - (b) Replace the E6 moisture shroud for a crack in the direction toward an edge without a return lip that has a crack length more than one half of the distance between the hole and the edge of the flange. Do the applicable task in this procedure: ELECTRICAL EQUIPMENT RACK MOISTURE SHROUD - REMOVAL/INSTALLATION, PAGEBLOCK 25-71-00/401.

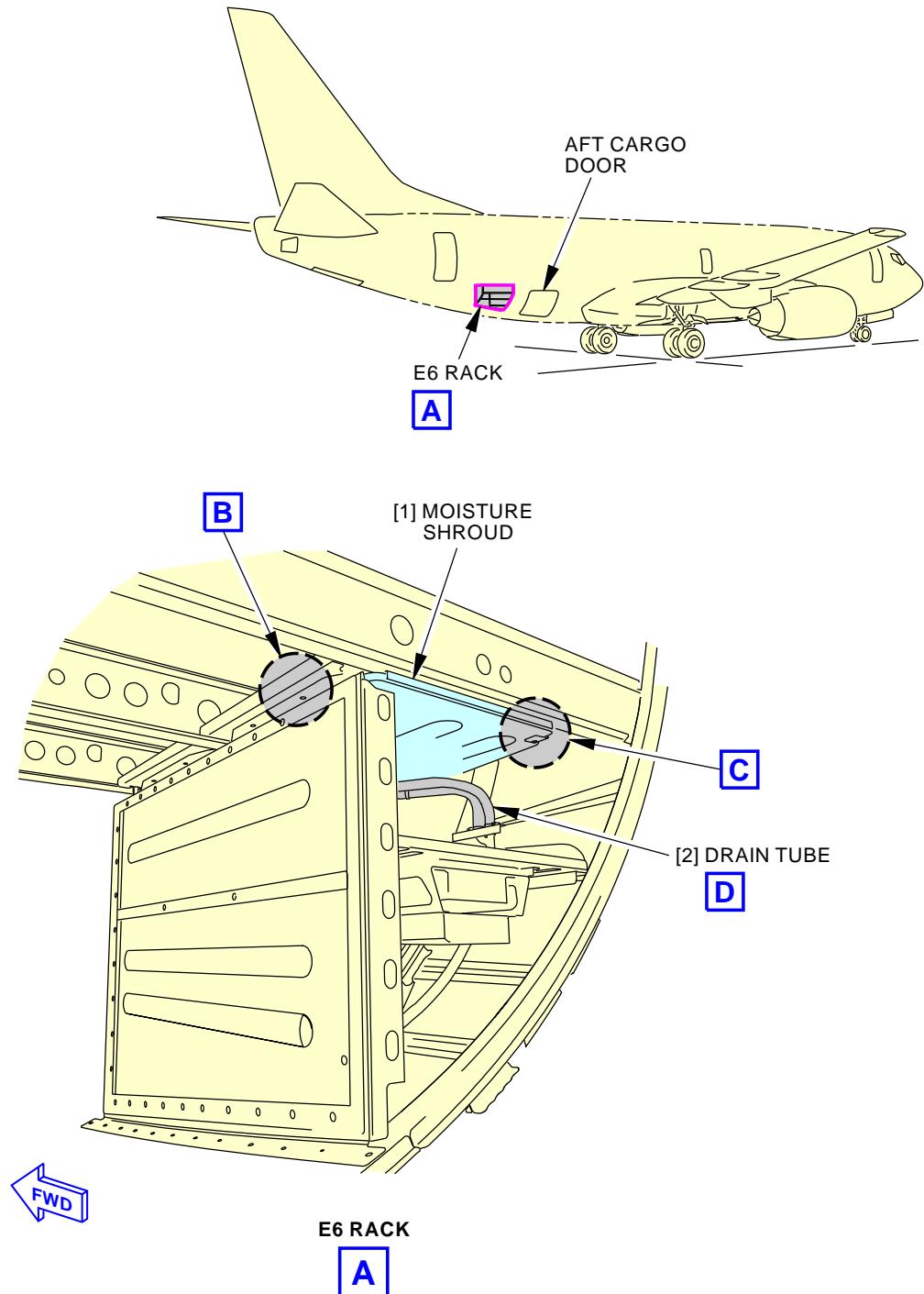
———— END OF TASK ————



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E6 Moisture Shroud Installation
Figure 602/25-71-00-990-811 (Sheet 1 of 2)

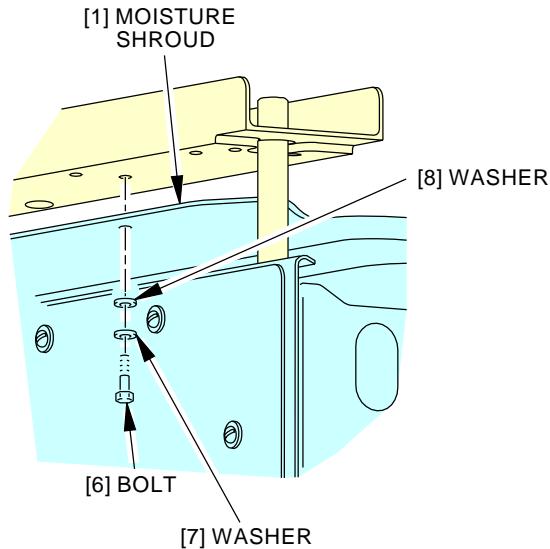
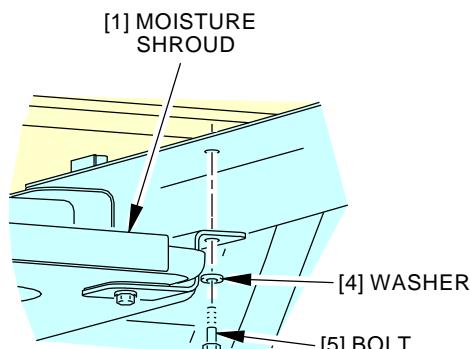
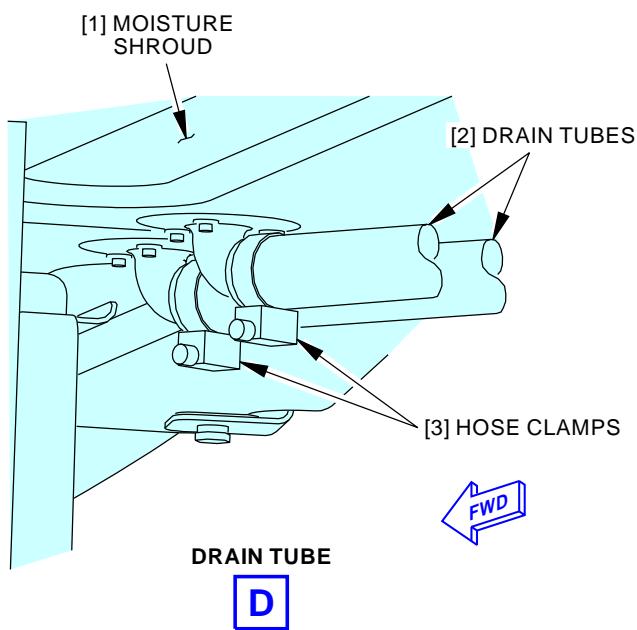
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B

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E6 Moisture Shroud Installation
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INSULATION BLANKET - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Insulation Blanket Removal.
 - (2) Insulation Blanket Installation.

TASK 25-80-00-000-801

2. **Insulation Blanket Removal**

A. **Location Zones**

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

B. **Remove the Insulation Blanket**

SUBTASK 25-80-00-010-001

- (1) Remove the applicable panels and parts from the airplane interior for access to the insulation blankets that you want to remove.

SUBTASK 25-80-00-930-001

- (2) Put a tag on the blankets to help you install them in the correct positions, where necessary.

SUBTASK 25-80-00-020-001

- (3) Remove the disks from the index pins.

SUBTASK 25-80-00-020-002

- (4) Roll the clamps off of the insulation blankets.

SUBTASK 25-80-00-020-003

- (5) Remove the insulation blankets, moisture control blankets or capstrips.

———— END OF TASK ————

TASK 25-80-00-400-801

3. **Insulation Blanket Installation**

(Figure 401)

A. **References**

Reference	Title
SOPM 20-41-05	Application of Corrosion Inhibiting Compounds

B. **Consumable Materials**

Reference	Description	Specification
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26
C00915	Compound - Organic Corrosion Inhibiting, Advanced	BMS3-29
D50299	Tape - Advanced Insulation Blanket	BMS5-157 Grade A Composition MPVF
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50330	Fabric - Insulation Covering, Flame Propagation Resistant	BMS8-377



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(Continued)

Reference	Description	Specification
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50521	Tape - Advanced Insulation	BMS5-157 Type IV Class 1 Grade A Form 1 MPVF
G50522	Tape - Advanced Insulation	BMS5-157 Type III Class 1 Grade A Form 1 MPVF
G50523	Tape - Advanced Insulation	BMS5-157 Type II Class I Grade A Form 1 PVF

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

D. Check for Insulation Blanket Contamination

SUBTASK 25-80-00-110-001

WARNING: LET THE CORROSION-INHIBITING COMPOUNDS (CIC) BECOME FULLY DRY. IF CIC GETS ON THE INSULATION BLANKET, THE INSULATION BLANKET WILL BECOME LESS FLAME-RESISTANT. THIS INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) To prevent CIC contamination of insulation blankets, let the corrosion-inhibiting compounds fully dry before you install the insulation blankets.
 - (a) Let the corrosion-inhibiting compounds dry longer than the minimum times listed below if you have one of these conditions:
 - 1) Low temperature.
 - 2) High humidity.
 - 3) Thick layer of corrosion-inhibiting compounds.
 - (b) Ventilate areas treated with CIC such as corrosion inhibiting compound, G00009, with good air flow for a minimum of one hour.
 - (c) Ventilate areas treated with CIC such as compound, C00755 or compound, C00915, with good air flow for a minimum of four hours.

SUBTASK 25-80-00-110-016

- (2) If the insulation blanket is contaminated do the following steps as necessary:

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (a) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), refer to:SOPM 20-41-05.

SUBTASK 25-80-00-160-016

- (3) If there are dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner or a non-metallic soft brush to remove the contamination.

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SUBTASK 25-80-00-210-004

- (4) Make sure that the insulation blanket has no rips, tears or holes.

SUBTASK 25-80-00-160-015

- (5) Make sure the area is clean before you install the insulation blanket.

E. Install the Insulation Blanket

SUBTASK 25-80-00-420-003

- (1) If you replace an insulation blanket or a capstrip, install an insulation blanket or a capstrip that complies with FAR 25.856.

- (a) Use the tape, D50299 and hook and loop tape, G50333, where necessary.

NOTE: The tape, D50299 and hook/loop tape, G50333 are FAR 25.856 compliant.

- (b) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

- (c) Replace the part of the hook and loop tape that is installed on the airplane structure where the replacement insulation blanket attaches with hook and loop tape, G50333, if it is necessary.

SUBTASK 25-80-00-420-001

- (2) Do these steps to install the insulation blanket to the airplane structure:

- (a) Put a membrane material around the frame if it is necessary.

- (b) Put the side of the insulation blanket with the clamp indicator inboard.

- (c) Align the holes in the insulation blanket with the index pins.

- 1) Put the insulation blanket in its position.

- 2) Install the disks on the index pins.

- (d) Wrap the insulation blanket correctly around the airplane structure.

- 1) Put the blanket tab around the airplane structure.

- 2) Put the capstrip over the blanket tab.

SUBTASK 25-80-00-420-002

CAUTION: DO NOT USE FORCE TO PUSH THE CLAMP STRAIGHT ON THE AIRPLANE STRUCTURE. USE A ROLLING MOVEMENT WITH TWO HANDS TO INSTALL THE CLAMPS. IF YOU USE FORCE TO PUSH THE CLAMP STRAIGHT ON THE AIRPLANE STRUCTURE, YOU WILL CAUSE PERMANENT DAMAGE TO THE CLAMP AND TEAR THE INSULATION BLANKET.

- (3) Attach the blanket with clips, tapes, pins, and disk fasteners as applicable. Refer to the illustration for examples of the installation details (Figure 401).

- (a) Look for clamp indicator on the insulation blanket.

- (b) When you install the clamps, make sure they are the minimum distance from the adjacent hoses, wires, or ducts:

Table 401/25-80-00-993-801

Separation Requirements	
Hoses, Wires, Ducts, or other Systems	Minimum Distance from Clamp (Inch)
Supported (at the stand off)	0.25 Inch (6 mm)
Unsupported	0.5 Inch (13 mm)

EFFECTIVITY
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- (c) Make sure the openings in the intercostals are not blocked by the insulation blanket.
- (d) Make sure the passenger compartment sidewall blanket is centered on the window opening.
 - 1) Do not put the blanket behind the window clips.
- (e) Make sure you cannot see structure after you install the insulation blanket.
- (f) Make sure you cannot see the bilge and sill trays in the cargo compartments.
- (g) Make sure the hook and loop tape is fully engaged.
- (h) Make sure the tapes match.

SUBTASK 25-80-00-420-004

- (4) Do these steps to install the insulation blanket on the overwing exit upper liner:
 - (a) Use double-sided tape, tape, G50523, on the back of the insulation blanket if necessary.
 - (b) Put the side of the insulation blanket with the tape inside the overwing exit upper liner.
NOTE: Place the wire bundles through the open slot in the insulation blanket.
 - (c) Install the disk on the index pins.
 - 1) Install the foam disk with the adhesive side facing the insulation blanket.
 - (d) Align the insulation blanket around the light.
 - (e) Put the index pins through the insulation blanket.
 - (f) Install the disks on the index pins.
 - 1) Install the foam disks with the adhesive side facing the insulation blanket.
 - 2) Install the retaining disks.
 - (g) Make sure the insulation blanket is secure.
 - 1) Secure the insulation blanket in place around the liner edges.
 - 2) Firmly press on the insulation blanket in areas where tape attach to the panel.

SUBTASK 25-80-00-210-001

- (5) Make sure moisture penetration through to the inboard side of the insulation blanket is minimized.
 - (a) Make sure all the insulation blanket are correctly overlapped to keep out any condensation that can flow between insulation blankets into the inboard side of the insulation blanket.
 - (b) Re-install any moisture control blankets at longitudinal (intercostal) structural locations.
 - (c) Make sure the moisture deflector on the overwing exit insulation blanket extends past the bottom edge of the liner.
NOTE: Overlap the lower blanket with the top overwing exit insulation blanket so moisture can be deflected to drain holes in the structure.

AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS

- (d) For insulation blanket with fabric, G50330 cover material, use the tape, D50299 and hook and loop tape, G50333, where necessary to reduce any gaps between blankets, or between blankets and structure.

AKS ALL

- (e) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

EFFECTIVITY	AKS ALL
	D633A101-AKS

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SUBTASK 25-80-00-390-001

- (6) For replacement insulation blanket, push on the insulation blanket to remove the air that is inside the insulation blanket through the vent hole(s).
 - (a) Peel off the attached release liner on the circle tape and seal the vent hole(s).

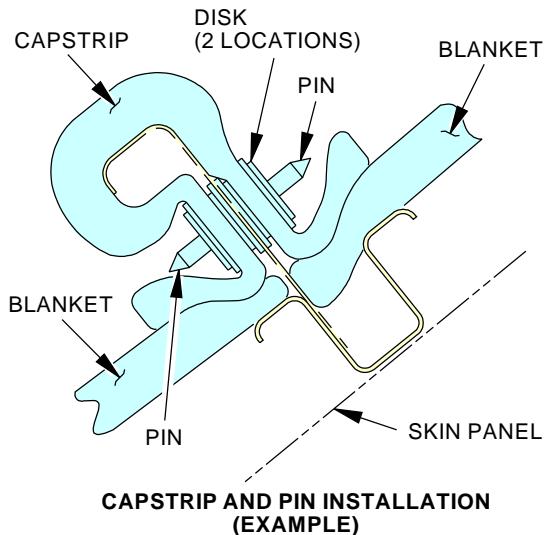
SUBTASK 25-80-00-010-002

- (7) Install the panels and parts that you removed from the airplane interior.

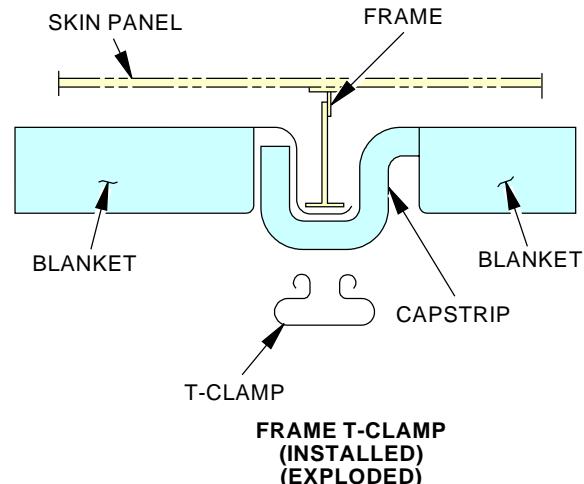
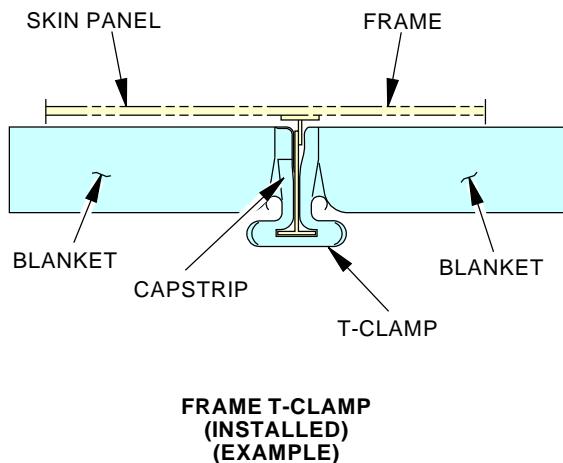
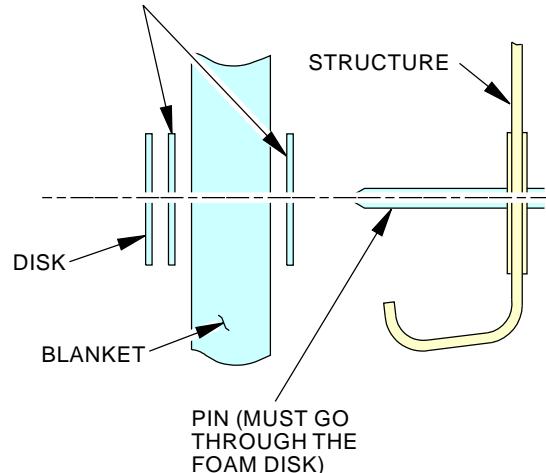
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EFFECTIVITY
AKS ALL

25-80-00



THE ADHESIVE SIDE OF
THE FOAM DISK GOES
AGAINST THE INSULATION



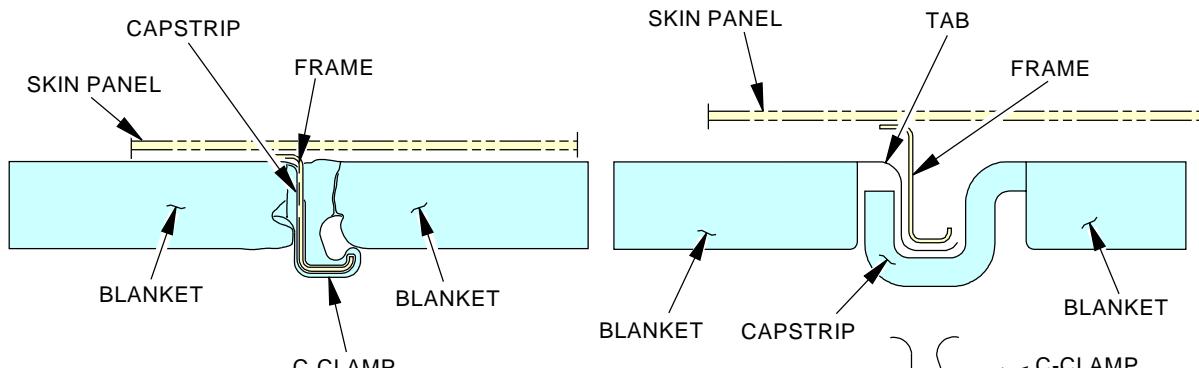
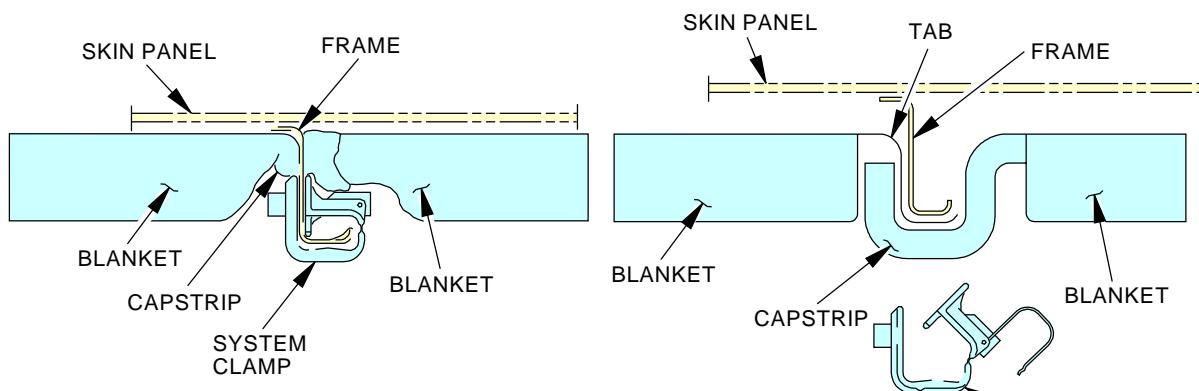
G79054 S0006567948_V2

Insulation Blanket Installation

Figure 401/25-80-00-990-801 (Sheet 1 of 9)

EFFECTIVITY
AKS ALL

25-80-00

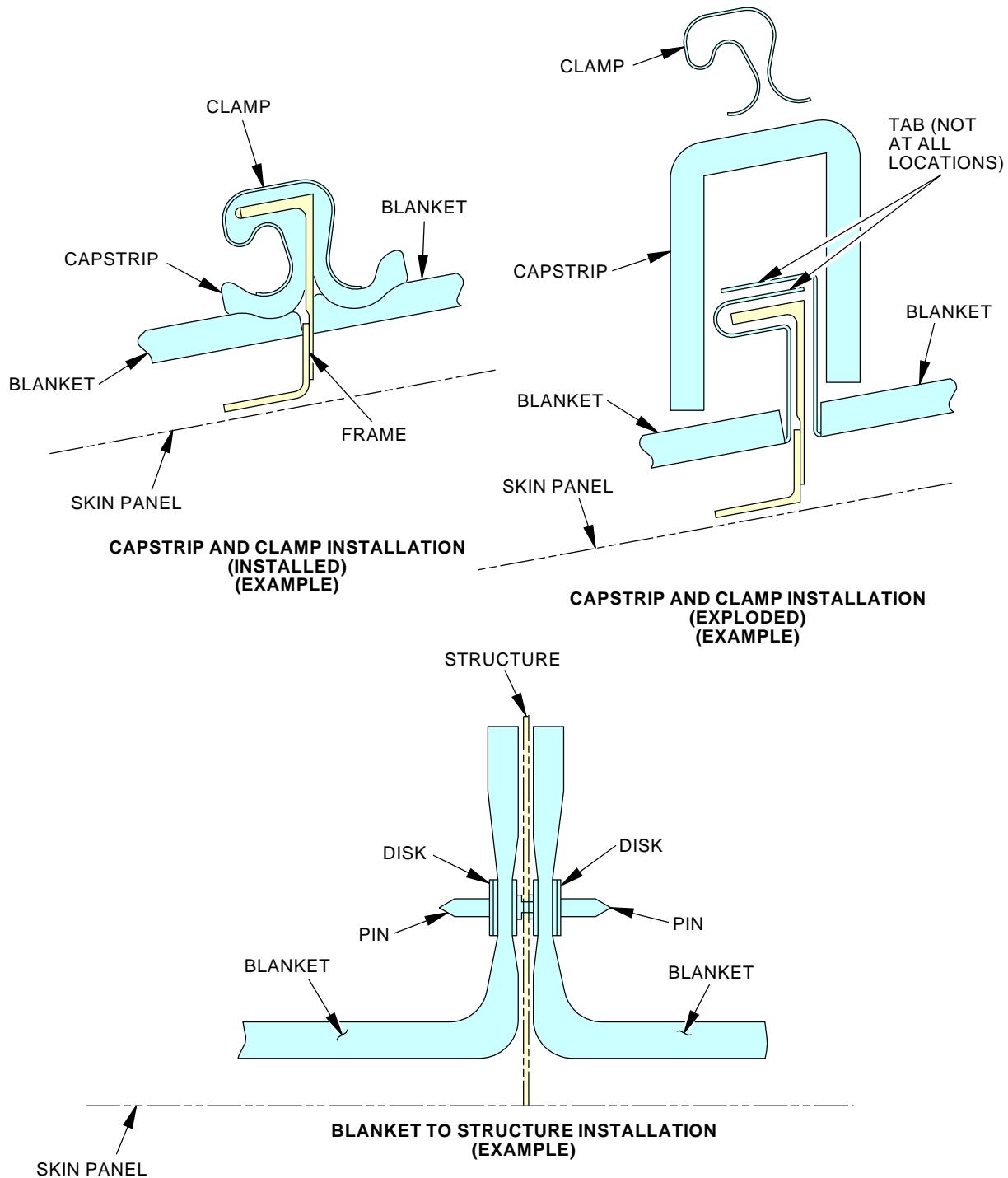

**FRAME C-CLAMP
(INSTALLED)
(EXAMPLE)**
**FRAME C-CLAMP
(EXPLODED)
(EXAMPLE)**

**FRAME E-CLAMP
(INSTALLED)
(EXAMPLE)**
**FRAME E-CLAMP
(EXPLODED)
(EXAMPLE)**

G79055 S0006567949_V2

Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 2 of 9)

EFFECTIVITY
AKS ALL

25-80-00



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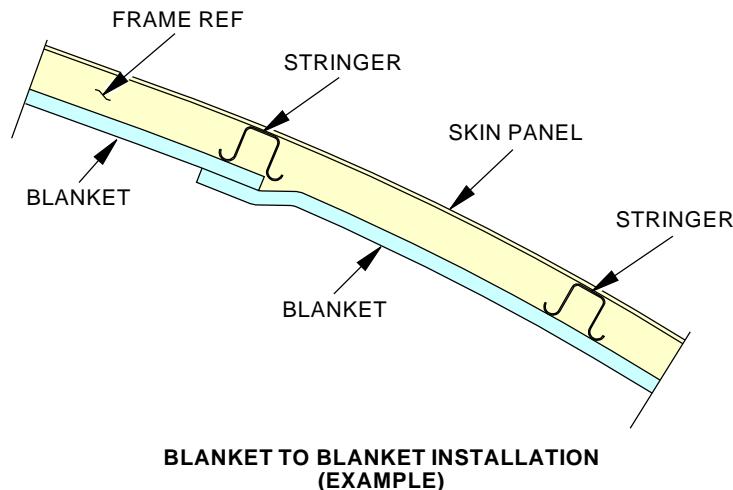
Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 3 of 9)

EFFECTIVITY
AKS ALL

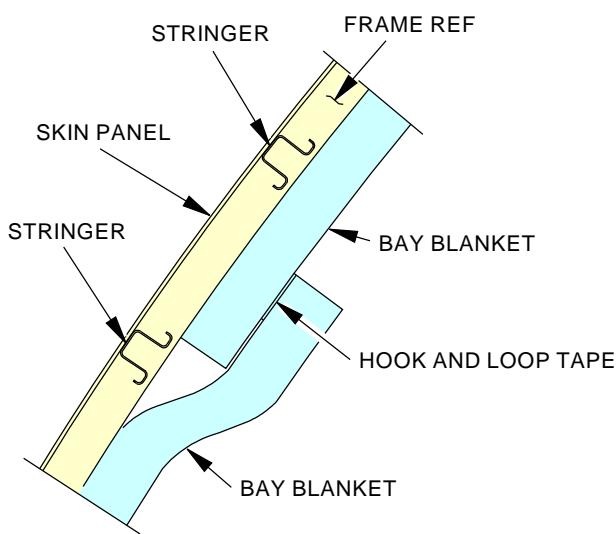
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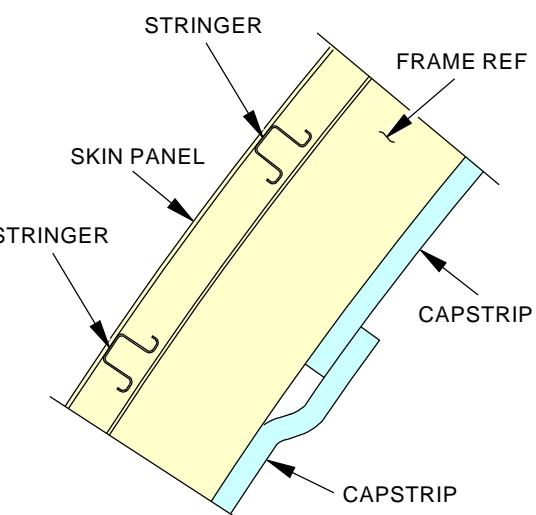
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BLANKET TO BLANKET INSTALLATION
(EXAMPLE)



BLANKET OVERLAP
(EXAMPLE)



CAPSTRIP OVERLAP
(EXAMPLE)

G79057 S0006567951_V3

Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 4 of 9)

EFFECTIVITY
AKS ALL

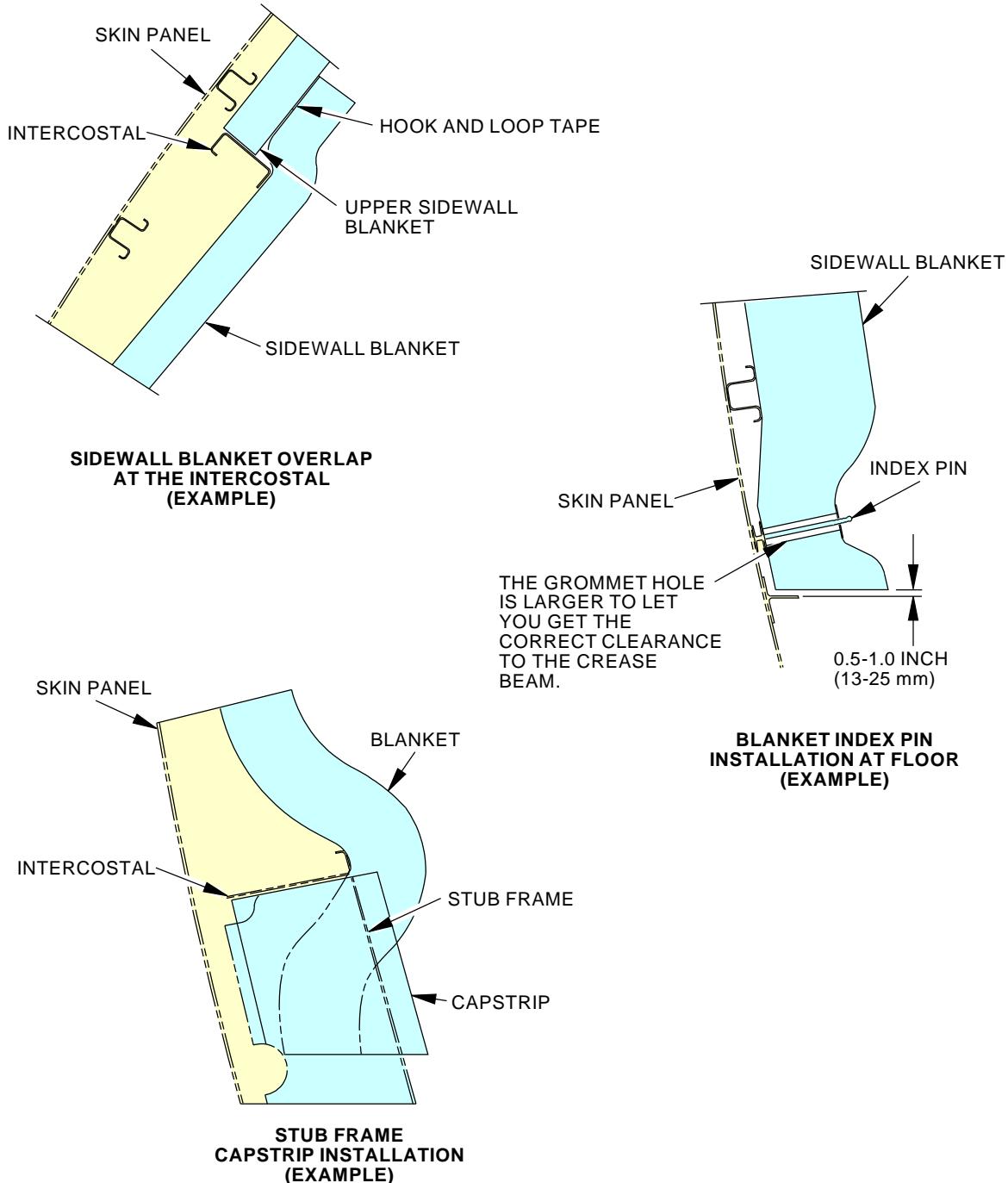
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Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 5 of 9)

EFFECTIVITY
AKS ALL

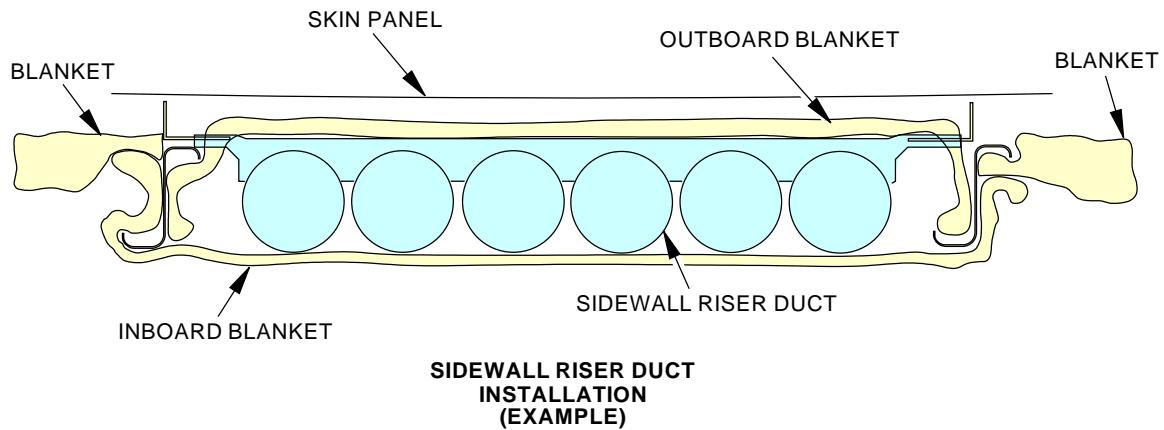
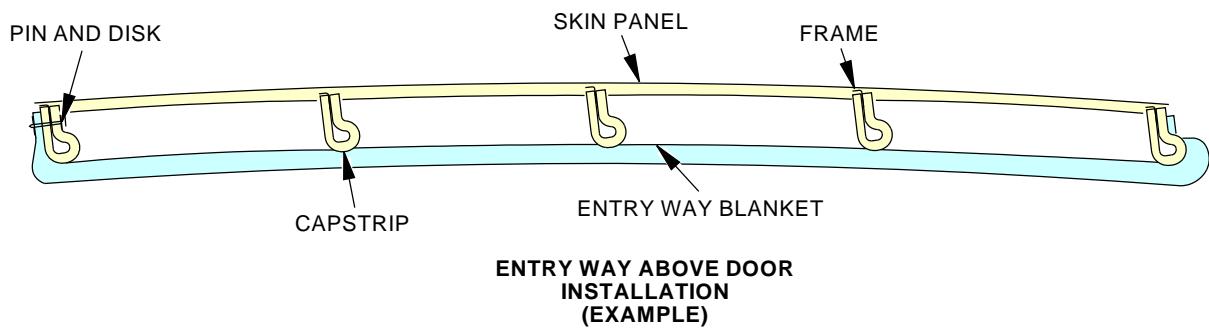
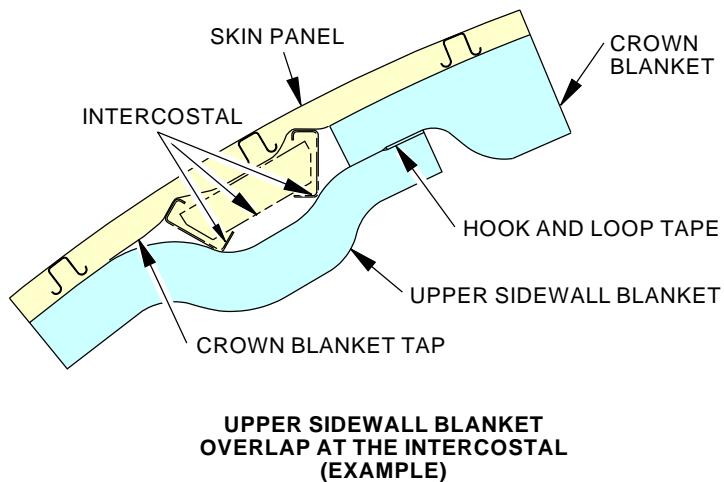
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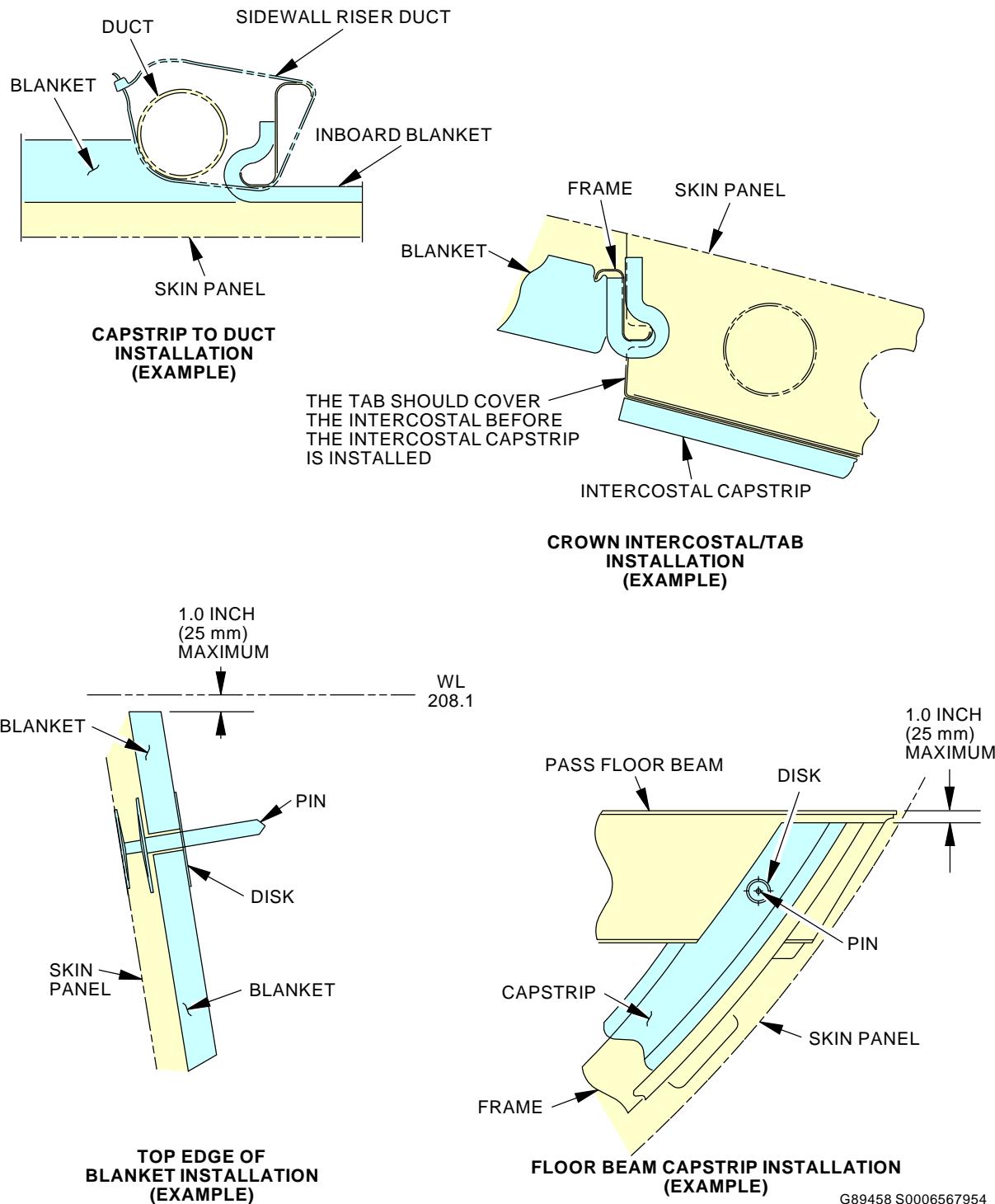
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Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 6 of 9)

EFFECTIVITY
AKS ALL

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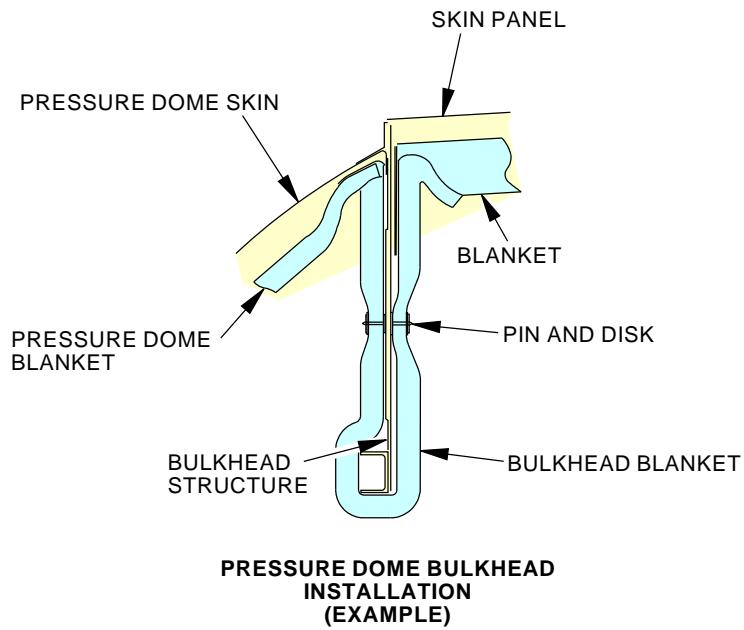
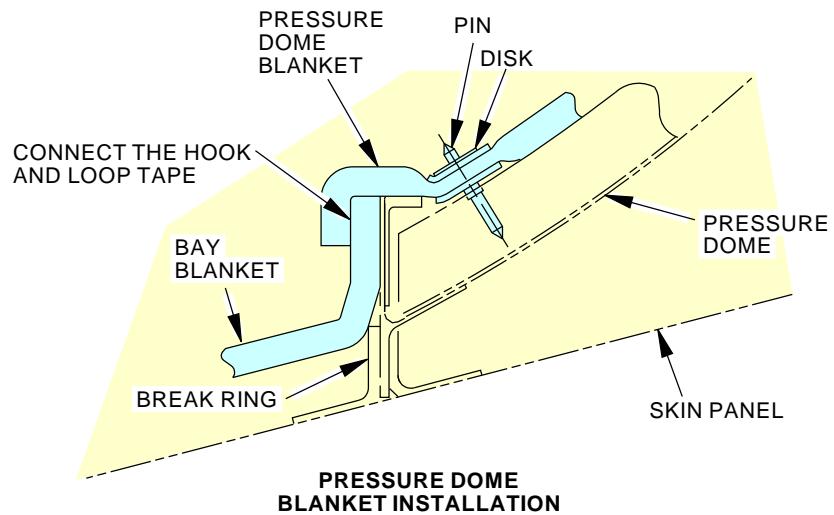
Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 7 of 9)

EFFECTIVITY
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G89547 S0006567955_V3

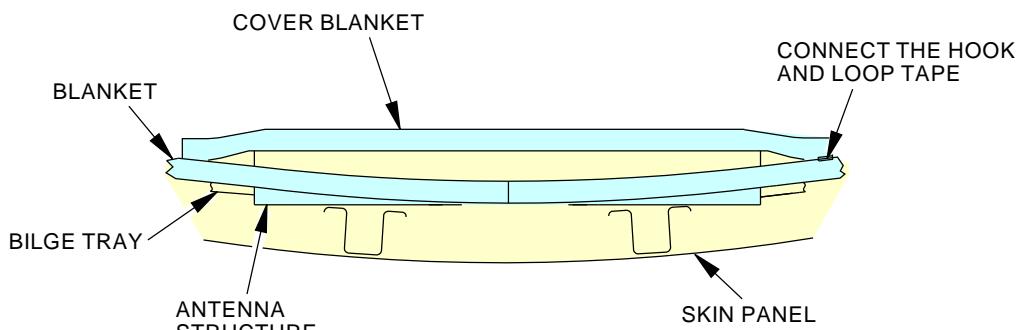
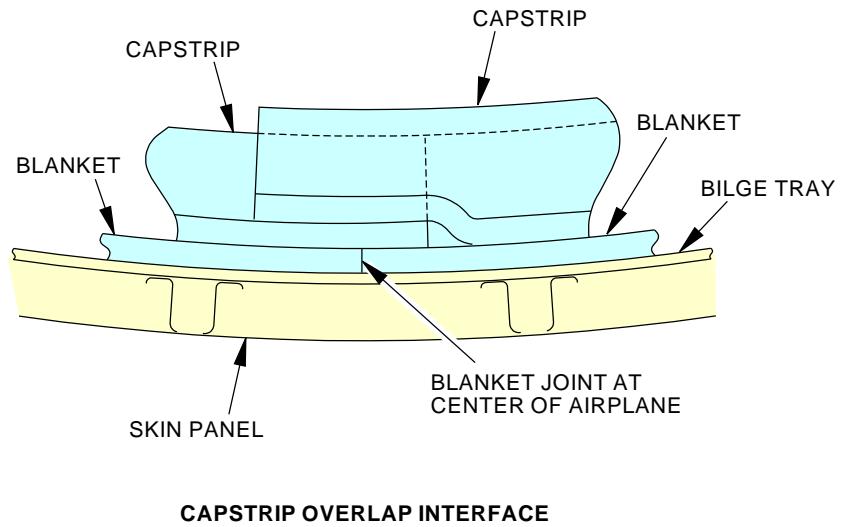
Insulation Blanket Installation
Figure 401/25-80-00-990-801 (Sheet 8 of 9)

EFFECTIVITY
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ANTENNA BLANKET INSTALLATION

G89594 S0006567956_V3

Insulation Blanket Installation
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INSULATION BLANKET - MAINTENANCE PRACTICES

1. General

- A. This procedure gives Boeing recommendations when operators install electronic equipment in the primary passenger cabin that requires changes to the fuselage insulation blankets.
- B. The fuselage insulation blankets primary function is to provide thermal and acoustic performance to keep the main passenger cabin warm and quiet during flight. Also, the fuselage insulation system provides a moisture barrier to keep condensation in the passenger cabin to a minimum.
 - (1) All open holes, tears or damage to the insulation blanket cover films degrade the moisture barrier and airplane Cabin Moisture Management.
- C. Boeing has four recommended tasks for maintenance of the fuselage insulation blankets:
NOTE: These tasks come from inspections of post-delivery installations on several in-service airplanes.
 - (1) Crown Antenna Installation – Insulation Blanket Access
 - (2) Crown Hardware Installation – Insulation Blanket Protection
 - (3) Cover Film Repairs
 - (4) Cargo Bilge Antenna Installation – Insulation Blanket Access

TASK 25-80-00-400-802

2. Crown Antenna Installation - Insulation Blanket Access

(Figure 201, Figure 202, and Figure 203)

A. General

- (1) The typical crown antenna cable installation is through the crown insulation blankets. Do not permit an open hole or cutout in the crown insulation blanket. A hole or opening lets in warm, moist cabin air. This causes increased condensation and moisture into the passenger cabin, referred to as "rain in the plane".

B. Consumable Materials

Reference	Description	Specification
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50334	Felt - Needled, Flame Propagation Resistant	BMS8-373
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

D. Procedure – Access Provision

NOTE: The access is in the crown insulation blanket directly below the antenna installation.

SUBTASK 25-80-00-360-001

- (1) Cut a slit in the insulation blanket from directly below the location of the antenna.
 - (a) Make sure that this slit is not more than 6-inches in length. This depends on the necessary opening.



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- (2) Make a box edge around the slit in the crown insulation blanket (Figure 201).
 - (a) Use the grommet, BACG20AJ.
 - (b) Grommet BACG20AJ01R16H is recommended for a 6-inch slit.
 - (c) Grommet BACG20AJ01N16H is recommended for a 4-inch slit.

SUBTASK 25-80-00-360-002

- (3) Attach a strip of tape, G50333, on one side of the slit (Figure 202).
 - (a) 1-inch width is recommended for hook tape.

SUBTASK 25-80-00-360-003

- (4) Make a flap on the other side of the slit with insulation tape, G50789. Make sure that the loop tape, G50333 aligns with the hook tape used on the other side of the slit (Figure 202).
 - (a) 2-inch width is recommended for insulation tape
 - (b) 1-inch width is recommended for loop tape.

SUBTASK 25-80-00-360-004

- (5) Attach the tape, G50789 of the new flap on one side of the slit to make sure that the loop tape and hook tape give a tight fit of the slit (Figure 202).
 - (a) When the attachment to the crown insulation blanket is complete:
 - 1) Cut a slit down the middle of the new flap to make two different flaps.
 - (b) Each flap will bring closure on the two sides of the antenna cable when it travels through the crown insulation blanket.

SUBTASK 25-80-00-360-005

- (6) Make a water absorbent felt, G50334 cover for the slit in the insulation blanket (Figure 203).
 - (a) The dimension of the cover will depend on the length of the slit.
 - 1) The width of the cover must be a minimum of 4-inches.
 - 2) The length of the cover must extend a minimum of 2-inches at each end of the slit.
 - (b) Sew the loop tape, G50333 around the perimeter of the cover.
 - 1) 1-inch width is recommended for loop tape
 - 2) A double seam stitch is recommended.

SUBTASK 25-80-00-360-006

- (7) Attach hook tape, G50333 to the crown insulation blanket to align the loop tape on the water absorbent cover (Figure 202).
 - (a) The location of the tape must center the cover around the slit in the crown insulation blanket.

SUBTASK 25-80-00-360-007

- (8) Cut an opening in the water absorbent cover so that the antenna cable can move through the cover (Figure 203).
 - (a) The opening should be sufficient to let the antenna cable move through the cover.

E. Procedure – Additional Moisture Provisions

SUBTASK 25-80-00-360-008

- (1) When you complete the antenna cable installation:
 - (a) Attach the moisture absorbing felt, G50334 around the cable on the inboard side of the crown installation blanket.
 - 1) If the cable uses a straight connector, use a 411A4904-15 felt.

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- 2) If the cable uses an L-connector (90-degree), use a 411A4904-10 felt.
- 3) Put the felt on the inboard side of the crown insulation blanket.

NOTE: It should be touching the felt cover.

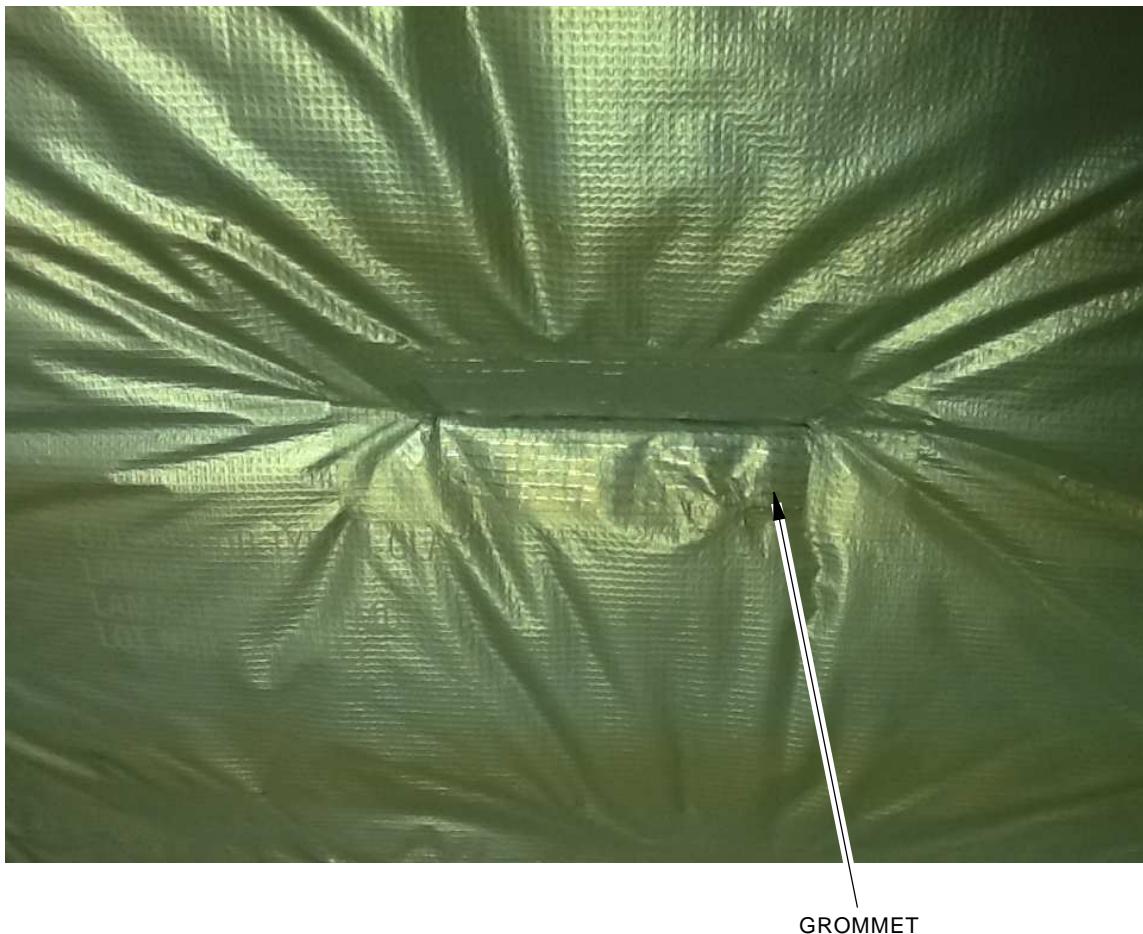
———— END OF TASK ————

EFFECTIVITY
AKS ALL

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2328998 S0000529423_V2

Slit With Grommet Installed
Figure 201/25-80-00-990-805

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25-80-00

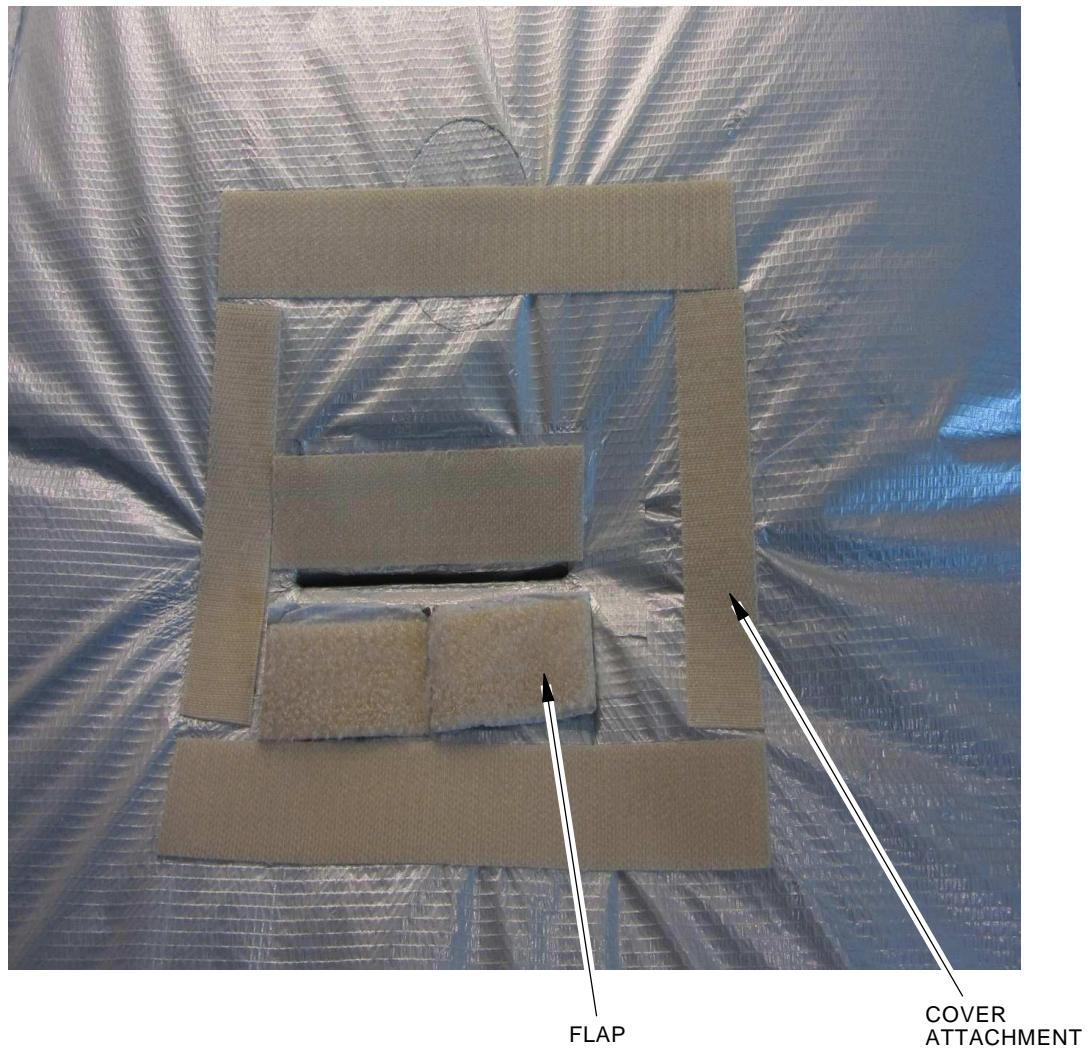
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2329000 S0000529424_V2

Flap For Slit and Cover attachment
Figure 202/25-80-00-990-806

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2329003 S0000529426_V2

Cover For Antenna Access
Figure 203/25-80-00-990-807

EFFECTIVITY
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TASK 25-80-00-400-803

3. Crown Hardware Installation - Insulation Blanket Protection

A. General

- (1) Locations where there is hardware installed must have coverage with the fuselage insulation blanket. Do not compromise the moisture barrier function.
- (2) Holes in the fuselage insulation blanket without correct foam disks can cause damage to the inboard and outboard cover films.
- (3) Damaged cover films will let moisture into the insulation blanket and will cause moisture to release into the passenger cabin (i.e. – “rain in the plane”).

B. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

C. Procedure – Fuselage Blanket Penetration

SUBTASK 25-80-00-360-009

- (1) Find all screws in the crown of the airplane or in the pressurized cabin that go through the fuselage insulation blanket.
 - (a) Install the BACW10DZ3 adhesive foam disks on the two sides of the insulation blanket.
 - (b) Tighten screws to 22.5 ± 2.5 in-lb (2.54 ± 0.28 N·m).

———— END OF TASK ————

TASK 25-80-00-300-802

4. Cover Film Repairs

A. General

- (1) You must repair all damage to the inboard or outboard cover film of the insulation blanket during their modifications to keep them serviceable.

B. References

Reference	Title
25-80-00 P/B 801	INSULATION - REPAIRS

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

D. Procedure – Insulation Blanket Repairs

SUBTASK 25-80-00-360-010

- (1) Do this task to repair damage to the insulation blanket or cover films: INSULATION - REPAIRS, PAGEBLOCK 25-80-00/801.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 25-80-00-400-804

5. Cargo Bilge Antenna Installation - Insulation Blanket Access

A. General

- (1) The primary problem for installation of antennas on the lower fuselage delivered after September 2009 is:

- (a) Holes in the fuselage insulation blankets.

NOTE: These insulation blankets meet the requirements of Federal Aviation Regulation (FAR) 25.856(b) and 121.312(e)(3)

NOTE: For more information, see Boeing Service Letter 737-SL-25-135-A.

- (2) The guidelines in AC25-856-2A, Page 8, Section 7.c.(2) read that penetration is unavoidable, but you must minimize the damage.
- (3) If a cable must go through the fuselage insulation blanket, the dimension of the hole must be as small as possible.

B. Consumable Materials

Reference	Description	Specification
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

D. Procedure – Insulation Blanket Antenna Cable Penetration

SUBTASK 25-80-00-360-011

- (1) Find the location of the cable penetration.

NOTE: Use the lightening holes when possible to bring the cable from the outboard to the inboard side of the fuselage insulation blanket.

SUBTASK 25-80-00-360-012

- (2) Cut the holes for the cable penetration.

SUBTASK 25-80-00-360-013

- (3) When the cable is set, use the tape, G50789 to seal the edges of the hole.

———— END OF TASK ————



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INSULATION - REPAIRS

1. General

A. This procedure has these tasks:

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- (1) Repair the Insulation Blanket with BMS8-377 Cover Material.
- (2) Repair the Insulation Blanket with BMS8-370 Cover Material.

AKS ALL

- (3) Repair the Insulation Blanket with BMS8-396 Cover Material
- (4) Repair the Insulation Blanket with BMS8-380 Cover Material
- (5) Insulation Blanket Manufacturing.

AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS

TASK 25-80-00-340-803

2. Repair the Insulation Blanket with BMS8-377 Cover Material

(Figure 801)

A. General

- (1) This procedure has instructions to repair insulation blanket with BMS8-377 cover material.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-11573	Installation Tool - Garment Tag Part #: 954885 Supplier: 16956
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. Consumable Materials

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
D50299	Tape - Advanced Insulation Blanket	BMS5-157 Grade A Composition MPVF
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G50330	Fabric - Insulation Covering, Flame Propagation Resistant	BMS8-377



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**AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
(Continued)**

(Continued)

Reference	Description	Specification
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50442	Fastener - Garment Tag, Nylon (Avery Dennison Standard T-End Swiftach)	
G50521	Tape - Advanced Insulation	BMS5-157 Type IV Class 1 Grade A Form 1 MPVF
G50522	Tape - Advanced Insulation	BMS5-157 Type III Class 1 Grade A Form 1 MPVF
G50523	Tape - Advanced Insulation	BMS5-157 Type II Class I Grade A Form 1 PVF

E. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-212-003

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801.
 - 2) Insulation Blanket Installation, TASK 25-80-00-400-801.
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-160-009

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-160-010

- (3) If there are dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a soft-bristle non-metallic brush, STD-126 to remove the contamination.

SUBTASK 25-80-00-160-011

- (4) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket with BMS8-377 Cover Material

NOTE: BMS8-377 cover material is a thin opaque gray plastic film with an open weave scrim on one side and has a grid-like appearance.



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**AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
(Continued)**

SUBTASK 25-80-00-340-055

- (1) To repair a grommet hole in the insulation blanket, do these steps:
 - (a) Make two round tape patches from tape, D50299 (BMS5-157) with a 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the grommet hole.
 - 1) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
 - (b) Make a fiberglass plug from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - (c) Put the fiberglass plug into the grommet hole.
 - (d) Put the round tape patches over the grommet hole on both sides of the insulation blanket.
 - 1) Make sure the tape patch overlaps the edge of the grommet hole by a minimum of 0.75 in. (19.05 mm).
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-088

- (2) To remove a line of stitching do these steps:
 - (a) Remove the thread from the line of stitching.
 - (b) Cover the affected area with tape, D50299.

SUBTASK 25-80-00-340-089

- (3) To replace snaps with hook and loop tape, do these steps:
 - (a) Remove the snaps.

NOTE: Be careful to do as little damage as is possible to the blanket material.
 - (b) Cover all of the snap holes with tape, D50299.
 - (c) Cover both sides of the blanket if it is necessary.
 - (d) Install the tape, G50333.

NOTE: Apply the tape using normal fabrication methods.

SUBTASK 25-80-00-340-056

- (4) To repair a tear in the insulation blanket, do these steps:
 - (a) Clean the area with a cotton wiper, G00034 wet with solvent, B00184.
 - (b) Dry the area with a clean cotton wiper, G00034.
 - (c) Make a tape patch from tape, D50299 (BMS5-157) that is 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) larger than the tear on all sides.
 - 1) Make sure the corners on the tape patch are rounded.
 - 2) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
 - (d) Put the tape patch over the tear.
 - 1) Make sure the tape patch overlaps the damaged area by 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) on all sides.
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

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AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
(Continued)

SUBTASK 25-80-00-340-057

- (5) To repair damage that is larger than a tear in the insulation blanket cover, do these steps:
- (a) Cut a rectangle out of the damaged blanket cover which fully removes the damaged area.
 - 1) Keep the rectangle cutout as template to make a new replacement cover patch.
 - (b) Use the rectangle cutout template to make a rectangle cover patch that is similar in shape and size as the template from fabric, G50330 (BMS8-377).
 - (c) If there is damage to the fiberglass batting insulation, G00086 (BMS8-48) inside the blanket cover, do these steps:
 - 1) If the damaged area is only on the first layer of the fiberglass batting, do these steps:
 - a) Cut a rectangle out of the damaged fiberglass batting to fully remove the damaged area on the first layer of the fiberglass batting, and leave behind a rectangular void in the blanket.
 - b) Cut a ply of replacement fiberglass patch from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - <1> Make sure that the patch extends a minimum of 2 in. (51 mm) past the edges of the rectangular void.
 - c) Put the replacement fiberglass patch over the center of the rectangular void and under the blanket cover.
 - 2) If the damaged area is on multiple layers of the fiberglass batting, do these steps:
 - a) Cut out the damaged fiberglass batting to fully remove the damaged area.
 - b) Interleave new plies of fiberglass batting from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket, as necessary
 - (d) Put the rectangle cover patch over the cutout on the insulation blanket cover.
 - (e) Make a tape patch from tape, D50299 (BMS5-157) that is a minimum of 1 in. (25 mm) larger than all sides of the rectangle cutout.
 - 1) Make sure the corners on the tape patch are rounded.
 - (f) Put the tape patches over the joints to keep the rectangle cover patch in place on all sides.
 - 1) Make sure the tape patch overlaps the joint by a minimum of 1 in. (25 mm) on all sides.
 - (g) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.
 - (h) Use the garment tag installer, COM-11573 to install the external garment tag fastener, G50442, spaced at 6 in. (152 mm) into the overlapped fiberglass repair area to keep the fiberglass batting in position between the covers.
 - 1) Cut a 1 in. (25 mm) diameter circle of tape from tape, D50299 (BMS5-157) for use as reinforcement tape.
 - 2) Put the reinforcement tape over the area where the external garment tag fastener, G50442 is to be stapled through on both sides of the blanket.

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(Continued)

- 3) Use the garment tag installer, COM-11573 to staple the external garment tag fastener, G50442 through all layers of the insulation blanket, which includes the reinforcement tapes.
- 4) Cut a 2 in. (51 mm) diameter circle of tape from tape, D50299 (BMS5-157) for use as covering tape.
- 5) Put the covering tape over the external garment tag fastener, G50442 and reinforcement tape onto the insulation cover on both sides of the insulation blanket.
- 6) Push on the tape to make sure there is a good bond with the insulation blanket cover.
 - (i) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

SUBTASK 25-80-00-340-058

- (6) To replace a damaged hook/loop tape on the insulation blanket cover, do these steps:
 - (a) Carefully removed the damaged part of the hook/loop tape from the insulation blanket cover.
 - (b) Clean and dry the adhesive surface left by the removal of the damaged hook/loop tape.
 - (c) Put a piece of tape, D50299 (BMS5-157) over the area left by the removal of the damaged hook/loop tape on both sides of the insulation blanket assembly, if it is necessary.
 - 1) Make sure the tape is larger than the damaged area on the insulation cover by a minimum of 1 in. (25 mm) on all sides.
 - 2) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
 - (d) Install the replacement hook/loop tape, G50333 (BMS8-372) at the correct location on the insulation blanket cover.

— END OF TASK —

TASK 25-80-00-340-805

3. **Repair the Insulation Blanket with BMS8-370 Cover Material**
(Figure 801)

A. General

- (1) This procedure has instructions to repair insulation blanket with BMS8-370 cover material.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

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**AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
(Continued)**

D. Consumable Materials

Reference	Description	Specification
A00153	Adhesive - Low Odor, Synthetic Rubber Cement	BMS5-30
G50328	Fabric - Advance Polymer Coated, Flame Propagation Resistant	BMS8-370
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	

E. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-212-008

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801.
 - 2) Insulation Blanket Installation, TASK 25-80-00-400-801.
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-160-012

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-160-013

- (3) If there are dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a soft-bristle non-metallic brush, STD-126 to remove the contamination.

SUBTASK 25-80-00-160-014

- (4) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket with BMS8-370 Cover Material

NOTE: BMS8-370 cover material has a smooth and silky surface, typically white in appearance. It is used in only a few areas of the airplane.

SUBTASK 25-80-00-340-060

- (1) Do these steps if there is damage on the insulation blanket cover:
 - (a) Identify the perimeter around the damaged area on the insulation blanket for a cover patch area that is larger than the damaged area by 1 in. (25 mm) to 1.5 in. (38.1 mm) on all sides.



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(Continued)

- (b) If the cover patch area that is identified on the damaged insulation blanket can fit into a 3 in. (76 mm) by 3 in. (76 mm) square, do these steps:
- 1) Make a cover patch from fabric, G50328 (BMS8-370) that is larger than the damaged area by 1 in. (25 mm) to 1.5 in. (38.1 mm) on all sides.
 - a) Make sure the corners on the cover patch are rounded.
 - 2) Lightly abrade the entire adhesive side of the cover patch and the area to be covered by the cover patch, with 180 grit abrasive paper, G50381 or finer paper to remove any gloss.
 - 3) Apply adhesive, A00153 (BMS5-30) on the entire bonding surface of the cover patch area or insulation blanket cover.
 - 4) Put the adhesive side of the cover patch over the damaged area of the insulation blanket cover.
 - 5) Make sure there is an overlap of 1 in. (25 mm) to 1.5 in. (38.1 mm) between the damaged area and the edge of the cover patch on all sides.
 - 6) Wipe off any adhesive, A00153 (BMS5-30) that is not necessary.
 - 7) Push on the cover patch to make sure there is a good bond with the insulation blanket cover.
- (c) If the cover patch area that is identified on the damaged insulation blanket is larger than a 3 in. (76 mm) by 3 in. (76 mm) square repeat the steps in (b) except that adhesive, A00153 shall be applied up to 1 in. (25 mm) wide around the periphery of the patch.

— END OF TASK —

AKS ALL

TASK 25-80-00-340-809

4. Repair the Insulation Blanket that has BMS 8-396 Fire Resistant Material

A. General

- (1) This procedure has instructions to repair insulation blankets that have the BMS 8-396 fire resistant material.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. Consumable Materials

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

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(Continued)

Reference	Description	Specification
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G02470	Foam - Flexible Polyimide	BMS8-300 Type I
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50779	Material - Insulation Flame Penetration Resistant, Barrier Covering	BMS8-396
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

E. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-340-065

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801
 - 2) Insulation Blanket Installation, TASK 25-80-00-400-801
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-340-066

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-340-067

- (3) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a non-metallic soft-bristle non-metallic brush, STD-126 to remove the contamination.

SUBTASK 25-80-00-340-068

- (4) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket that has the BMS 8-396 Fire Resistant Barrier

NOTE: BMS8-396 cover material is a laminate of reinforced polymer films in combination with a paper fire-blocker. The film has a scrim on one or both sides and has a opaque gray or pale yellow color with a grid like appearance.

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SUBTASK 25-80-00-340-069

- (1) To repair a grommet hole in the insulation blanket, do these steps:
 - (a) Make two round tape patches from tape, G50789 (BMS5-157) that are a minimum of 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the grommet hole.
 - (b) Make a fiberglass plug from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - (c) Put the fiberglass plug into the grommet hole.
 - (d) Put the round tape patches over the grommet hole on both sides of the insulation blanket.
 - 1) Make sure the tape patch overlaps the edge of the grommet hole by a minimum of 0.75 in. (19.05 mm).
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-070

- (2) To remove a line of stitching do these steps:
 - (a) Remove the thread from the line of stitching.
 - (b) Cover the affected area with tape, G50789.

SUBTASK 25-80-00-340-071

- (3) To replace snaps with hook and loop tape, do these steps:
 - (a) Remove the snaps.

NOTE: Be careful to do as little damage as is possible to the blanket material.
 - (b) Cover all of the snap holes with tape, G50789.
 - (c) Cover both sides of the blanket if it is necessary.
 - (d) Install the tape, G50333.

NOTE: Apply the tape using normal fabrication methods.

SUBTASK 25-80-00-340-072

- (4) To repair a tear in the insulation material, G50779, do these steps:
 - (a) Clean the area with a cotton wiper, G00034 wet with solvent, B00184.
 - (b) Dry the area with a cotton wiper, G00034
 - (c) Make a round tape patch from tape, G50789 (BMS5-157) that is a minimum of 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) larger than the tear.
 - 1) Make sure the corners on the tape patch are rounded.
 - (d) Put the tape patch over the tear.
 - 1) Make sure the tape patch overlaps the damaged area by 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) on all sides.
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-073

- (5) To repair damage that is larger than a tear in the insulation blanket cover, do these steps:
 - (a) Leave the damaged cover in place, if possible. Do not remove it from the covering. Measure the damaged area.
 - 1) Use the measurement as a template to make a new rectangle replacement cover patch.



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- (b) Use the measurement to make a rectangle cover patch that is similar in shape and size as the damage on insulation material, G50779 (BMS8-396).
- (c) If there is damage to the fiberglass batting insulation, G00086 (BMS8-48) or to the foam insulation, G02470 (BMS8-300) inside the blanket cover, do these steps:
 - 1) If the damaged area is only on the first layer of the fiberglass batting or foam, do these steps:
 - a) Cut a rectangle out of the damaged fiberglass batting or foam to fully remove the damaged area, and leave behind a rectangular void in the blanket.
 - b) Cut a ply of replacement fiberglass patch from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - c) Make sure that the patch extends a minimum of 2 in. (51 mm) past the edges of the rectangular void.
 - d) Make a foam plug from foam insulation, G02470 (BMS8-300), that is equivalent in type and grade of the damaged insulation blanket.
 - e) Put the replacement fiberglass patch or foam plug over the center of the rectangular void and under the blanket cover.
 - 2) If the damaged area is on multiple layers of the fiberglass batting or a combination of foam and batting, do these steps:
 - a) Cut out the damaged fiberglass batting to fully remove the damaged area.
 - b) Interleave new plies of fiberglass batting insulation, G00086 (BMS8-48) or foam insulation, G02470 (BMS8-300), or combination that is equivalent in type/class/grade as those used in the insulation blanket, as necessary.
 - (d) Put the rectangle cover patch over the cutout on the insulation blanket cover.
 - (e) Make a tape patch from tape, G50789 (BMS5-157) that is a minimum of 1 in. (25 mm) larger than all sides of the rectangle cutout.
 - 1) Make sure the corners on the tape patch are rounded.
 - (f) Put the tape patches over the joints to keep the rectangle cover patch in place on all sides.
 - 1) Make sure the tape patch overlaps the joint by a minimum of 1 in. (25 mm) on all sides.
 - (g) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.
 - (h) Install external garment tags, spaced at 6 in. (152 mm) onto the overlapped fiberglass repair area to keep the fiberglass batting in position between the covers.
 - 1) Cut a 1 in. (25 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as reinforcement tape.
 - 2) Put the reinforcement tape over the area where the external garment tag is to be stapled through on both sides of the blanket.
 - 3) Staple the external garment tag through all layers of the insulation blanket, which includes the reinforcement tapes.
 - 4) Cut a 2 in. (51 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as covering tape.
 - 5) Put the covering tape over the external garment tag and reinforcement tape onto the insulation cover on both sides of the insulation blanket.

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- 6) Push on the tape to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-074

- (6) To repair delamination of the cover material, do these steps:

- NOTE: There is no limitation to the delamination repair area. Apply the tape patch to any damaged area.
- Make sure that the damage is limited to the outermost film only.
 - Make a tape patch from tape, G50789 that is a minimum of 1 in. (25 mm) to 1.5 in. (38.1 mm) beyond the damaged area in all directions.
 - Apply the tape to the damaged area

————— END OF TASK ————

TASK 25-80-00-340-808

5. Repair the Insulation Blanket that has BMS8-380 Cover Material

A. General

- This procedure has instructions to repair insulation blankets that have the BMS 8-380 fire resistant barrier.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. Consumable Materials

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50606	Cover - Insulation, Polyetherketoneketone (PEKK) - Flame Propagation Resistant	BMS8-380 Type 2 Class 2
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

E. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

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F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-340-076

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801.
 - 2) Insulation Blanket Installation, TASK 25-80-00-400-801.
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-340-077

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-340-078

- (3) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a non-metallic soft-bristle non-metallic brush, STD-126 to remove contamination.

SUBTASK 25-80-00-340-079

- (4) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket that has the BMS 8-380 Cover Material

NOTE: BMS8-380 cover material is a thin opaque gray plastic film with an open weave scrim on one side and has a grid-like appearance.

SUBTASK 25-80-00-340-080

- (1) To repair a grommet hole in the insulation blanket, do these steps:
 - (a) Make two round tape patches from tape, G50789 (BMS5-157) that are a minimum 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the grommet hole.
 - (b) Make a fiberglass plug from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - (c) Put the fiberglass plug into the grommet hole.
 - (d) Put the round tape patches over the grommet hole on both sides of the insulation blanket.
 - 1) Make sure the tape patch overlaps the edge of the grommet hole by a minimum of 0.75 in. (19.05 mm).
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-081

- (2) To remove a line of stitching do these steps:
 - (a) Remove the thread from the line of stitching.
 - (b) Cover the affected area with tape, G50789.



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SUBTASK 25-80-00-340-082

- (3) To replace snaps with hook and loop tape, do these steps:

- (a) Remove the snaps.

NOTE: Be careful to do as little damage as is possible to the blanket material.

- (b) Cover all of the snap holes with tape, G50789.

- (c) Cover both sides of the blanket if it is necessary.

- (d) Install the tape, G50333.

NOTE: Apply the tape using normal fabrication methods.

SUBTASK 25-80-00-340-083

- (4) To repair a tear in the insulation cover, G50606, do these steps:

- (a) Clean the area with a cotton wiper, G00034 wet with solvent, B00184.

- (b) Dry the area with a cotton wiper, G00034.

- (c) Make a round tape patch from tape, G50789 (BMS5-157) that is a minimum of 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) larger than the tear on all sides.

- 1) Make sure the corners on the tape patch are rounded.

- (d) Put the tape patch over the tear.

- 1) Make sure the tape patch overlaps the damaged area by 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) on all sides.

- (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-084

- (5) To repair damage that is larger than a tear in the insulation blanket cover, do these steps:

- (a) Cut a rectangle out of the damaged blanket cover which fully removes the damaged area.

- 1) Keep the rectangle cutout as template to make a new replacement cover patch.

- (b) Use the rectangle cutout template to make a rectangle cover patch that is similar in shape and size as the template from insulation cover, G50606 (BMS8-380).

- (c) If there is damage to the fiberglass batting insulation, G00086 (BMS8-48) inside the blanket cover, do these steps:

- 1) If the damaged area is only on the first layer of the fiberglass batting, do these steps:

- a) Cut a rectangle out of the damaged fiberglass batting to fully remove the damaged area on the first layer of the fiberglass batting, and leave behind a rectangular void in the blanket.

- b) Cut a ply of replacement fiberglass patch from fiberglass batting insulation, G00086 (BMS8-48) that extends a minimum of 2 in. (51 mm) past the edges of the rectangular void.

- c) Put the replacement fiberglass patch over the center of the rectangular void and under the blanket cover.

- 2) If the damaged area is on multiple layers of the fiberglass batting, do these steps:

- a) Cut out the damaged fiberglass batting to fully remove the damaged area.

- b) Interleave new plies of fiberglass batting from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket, as necessary.

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- (d) Put the rectangle cover patch over the cutout on the insulation blanket cover.
- (e) Make a tape patch from tape, G50789 (BMS5-157) that is a minimum of 1 in. (25 mm) larger than all sides of the rectangle cutout.
 - 1) Make sure the corners on the tape patch are rounded.
- (f) Put the tape patches over the joints to keep the rectangle cover patch in place on all sides.
 - 1) Make sure the tape patch overlaps the joint by a minimum of 1 in. (25 mm) on all sides.
- (g) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.
- (h) Install external garment tags, spaced at 6 in. (152 mm) onto the overlapped fiberglass repair area to keep the fiberglass batting in position between the covers.
 - 1) Cut a 1 in. (25 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as reinforcement tape.
 - 2) Put the reinforcement tape over the area where the external garment tag is to be stapled through on both sides of the blanket.
 - 3) Staple the external garment tag through all layers of the insulation blanket, which includes the reinforcement tapes.
 - 4) Cut a 2 in. (51 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as covering tape.
 - 5) Put the covering tape over the external garment tag and reinforcement tape onto the insulation cover on both sides of the insulation blanket.
 - 6) Push on the tape to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-340-085

- (6) To replace damaged hook/loop tape, G50333 (BMS8-372) on the insulation blanket cover, do these steps:
 - (a) Carefully removed the damaged part of the hook/loop tape, G50333 from the insulation blanket cover.
 - (b) Clean and dry the adhesive surface left by the removal of the damaged hook/loop tape, G50333.
 - (c) Put a piece of tape, G50789 (BMS5-157) over the area left by the removal of the damaged hook/loop tape, G50333 on both sides of the insulation blanket assembly, if it is necessary.
 - 1) Make sure the tape is larger than the damaged area on the insulation cover by a minimum of 1 in. (25 mm) on all sides.
 - (d) Install the replacement hook/loop tape, tape, G50333 (BMS8-372) at the correct location on the insulation blanket cover

———— END OF TASK ————

EFFECTIVITY
AKS ALL

25-80-00



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TASK 25-80-00-300-801

6. Insulation Blanket Manufacturing

(Figure 802)

A. General

- (1) This procedure has instructions to make new a insulation blanket.
- (2) The new insulation blanket can either be cut from the assembly of various component materials, or from a semi-finished insulation blanket strip, that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.
- (3) The damaged insulation blanket can be used as a template to make a new insulation blanket.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-11573	Installation Tool - Garment Tag Part #: 954885 Supplier: 16956

C. Consumable Materials

Reference	Description	Specification
D50299	Tape - Advanced Insulation Blanket	BMS5-157 Grade A Composition MPVF
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G02470	Foam - Flexible Polyimide	BMS8-300 Type I
G50328	Fabric - Advance Polymer Coated, Flame Propagation Resistant	BMS8-370
G50329	Fabric - High Mass Coated, Flame Propagation Resistant	BMS8-374
G50330	Fabric - Insulation Covering, Flame Propagation Resistant	BMS8-377
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50334	Felt - Needled, Flame Propagation Resistant	BMS8-373
G50341	Thread - Kevlar Sewing (T40), Strip Machine Thread (T60)	A-A-55220 Bonded Tex 40, Tex 60
G50408	Foam - Flexible Polyvinylidene Fluoride	BMS8-371
G50442	Fastener - Garment Tag, Nylon (Avery Dennison Standard T-End Swiftach)	
G50521	Tape - Advanced Insulation	BMS5-157 Type IV Class 1 Grade A Form 1 MPVF
G50522	Tape - Advanced Insulation	BMS5-157 Type III Class 1 Grade A Form 1 MPVF
G50523	Tape - Advanced Insulation	BMS5-157 Type II Class 1 Grade A Form 1 PVF

EFFECTIVITY	AKS ALL
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(Continued)

Reference	Description	Specification
G50606	Cover - Insulation, Polyetherketoneketone (PEKK) - Flame Propagation Resistant	BMS8-380 Type 2 Class 2
G50779	Material - Insulation Flame Penetration Resistant, Barrier Covering	BMS8-396
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Make a New Insulation Blanket

NOTE: The new insulation blanket can either be cut from the assembly of various component materials, or from a semi-finished insulation blanket strip, that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.

NOTE: Insulation cover, insulation material, G50779 (BMS8-396) must be continuous when used as inboard or outboard covering.

SUBTASK 25-80-00-340-039

- (1) To cut out a new insulation blanket from component materials, do these steps:
 - (a) Use the damaged insulation blanket as a template to outline its shape.
 - (b) Cut the applicable insulation cover (or combination of covers):
 - 1) fabric, G50330 (BMS8-377).
 - 2) fabric, G50328 (BMS8-370).
 - 3) fabric, G50329 (BMS8-374).
 - 4) felt, G50334 (BMS8-373).
 - 5) insulation cover, G50606 (BMS8-380)
 - 6) insulation material, G50779 (BMS8-396)
 - (c) Cut the fiberglass batting insulation, G00086 (BMS8-48) or the foam insulation, G02470 (BMS8-300).
 - 1) Make sure to use fiberglass batting insulation, G00086 (BMS8-48) or foam insulation, G02470 (BMS8-300) that are equivalent in type/class/grade as those in the template.
 - 2) Interleave the fiberglass batting insulation, G00086 (BMS8-48) and foam insulation, G02470 (BMS8-300), if it is necessary to extend the blanket.
 - (d) Put the fiberglass batting insulation, G00086 (BMS8-48) and foam insulation, G02470 (BMS8-300) in between the applicable inboard and outboard insulation covers.

SUBTASK 25-80-00-340-040

- (2) To cut a new insulation blanket from a semi-finished insulation blanket strip, do these steps:
 - (a) Make sure to use a semi-finished insulation blanket strip that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.



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- (b) Use the damaged insulation blanket as a template to outline its shape on the semi-finished insulation blanket strip.
- (c) Cut the semi-finished insulation blanket strip to the same shape as the template outline.
- (d) Interleave the fiberglass batting insulation, G00086 (BMS8-48) and foam insulation, G02470 (BMS8-300) as applicable, if it is necessary to extend the blanket.

SUBTASK 25-80-00-340-041

- (3) Do these steps to install external garment tag fastener, G50442 to connect the layers of insulation blanket materials:

NOTE: The garment tag is a commercially available plastic fastener that is stapled through all layers of the insulation blanket and fastened to keep the fiberglass batting inside the insulation blanket in the same position in relation to the blanket covers.

- (a) Use only tape, D50299 (BMS5-157) with fabric, G50330 (BMS8-377).
- (b) Use only tape, G50789 (BMS5-157) with insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396).
- (c) Cut a 1.00 in. (25.40 mm) diameter circle of tape, D50299 (BMS5-157) or tape, G50789 (BMS5-157) for use as reinforcement tape.
- (d) Put the reinforcement tape over the area where the external garment tag fastener, G50442 is to be stapled through on both sides of the blanket.
- (e) Use the garment tag installer, COM-11573 to staple the external garment tag fastener, G50442 through all layers of the insulation blanket, which includes the reinforcement tapes.

- 1) Make sure to use a garment tag fastener, G50442 of the correct length in relation to the nominal thickness of the insulation blanket, see Table 801.

Table 801 - Insulation Blanket Garment Tag Sizes

Nominal Thickness of Insulation Blanket *[1]	Garment Tag Length
4.01 in. (101.85 mm) to 7.01 in. (178.05 mm)	3.00 in. (76.20 mm)
2.01 in. (51.05 mm) to 4.00 in. (101.60 mm)	2.00 in. (50.80 mm)
1.26 in. (32.00 mm) to 2.00 in. (50.80 mm)	1.00 in. (25.40 mm)
0.51 in. (12.95 mm) to 1.25 in. (31.75 mm)	0.50 in. (12.70 mm)
0.38 in. (9.65 mm) to 0.50 in. (12.70 mm)	0.25 in. (6.35 mm)

* This is the total nominal thickness of all layers of raw material used in blankets.

*[1] This is the total nominal thickness of all layers of raw material used in blankets.

- (f) Cut a 2.00 in. (50.80 mm) diameter circle of tape, D50299 (BMS5-157) or tape, G50789 (BMS5-157) for use as covering tape.
- (g) Put the covering tape over the external garment tag fastener, G50442 and reinforcement tape, onto the insulation cover on both sides of the blanket.
- (h) Push on the tape to make sure there is a good bond with the blanket cover.
- (i) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

SUBTASK 25-80-00-340-042

- (4) Do the applicable steps to close the edges and cutouts of the insulation blanket:
 - (a) Method 1: Sew the edges.

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- 1) Fold the cover fabric over the edge of the blanket or wrap a strip of cover fabric over the edge of the blanket as applicable to bind the edge on the blanket.
 - 2) Stitch the edge with kevlar sewing thread, G50341 at 4 to 6 stitches per each inch.
 - 3) Make sure the stitches go through the edge binding on both sides of the insulation blanket.
 - 4) Seal the stitching on the blanket with the applicable tape, D50299 (BMS5-157), or tape, G50789 (BMS5-157).
- (b) Method 2: Tape the edges.

NOTE: Applicable for BMS8-377, BMS8-380 and BMS8-396 materials only.

- 1) Use tape, D50299 (BMS5-157) for fabric, G50330 (BMS8-377) and tape, G50789 (BMS5-157) for insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396) that is sufficiently wide to overlap the top and bottom of the blanket by a minimum of 0.75 in. (19.05 mm).
- 2) Make the edge the same height as the template.
- 3) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523 for the BMS8-377 fabric.

- (c) Method 3: Heat-seal the edges.

NOTE: Not all types of fabric can be heat sealed. Fabric that can be heat sealed may be heavier than fabric that cannot be heat sealed. Make sure you use the correct type of fabric. Blanket edges can be heat sealed using a thermal or ultra sonic equipment.

- 1) Hold the top and bottom covers together and heat-seal the edges of the blanket.
- 2) The width of the heat seal must be 0.25 in. (6.35 mm) to 0.5 in. (12.7 mm).

SUBTASK 25-80-00-340-043

- (5) Install hook/loop tape, G50333 (BMS8-372), where applicable.

SUBTASK 25-80-00-340-044

- (6) Install water diverter on the insulation blanket with foam, G50408 (BMS8-371) or equivalent, where applicable.

SUBTASK 25-80-00-340-045

- (7) To make a grommet through a hole in the insulation blanket with cover fabric, G50330 (BMS8-377), use tape, D50299 (BMS5-157) only, or fabric, G50330 (BMS8-377) with tape, D50299 (BMS5-157) to bond it to the insulation blanket.

SUBTASK 25-80-00-340-086

- (8) To make a grommet through a hole in the insulation blanket with insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396) use tape, G50789 or insulation cover, G50606 (BMS8-380) with tape, G50789 (BMS5-157) to bond it to the insulation blanket.

SUBTASK 25-80-00-340-046

- (9) Do these steps to install vents in the insulation blanket cover fabric, G50330 (BMS8-377):
 - (a) Make sure you install the vent so that it opens in the same direction as on the template.
 - (b) Cut a hole approximately 1 in. (25 mm) in diameter in the cover fabric.
 - (c) Cut a 2 in. (51 mm) circle of tape from tape, D50299 (BMS5-157).
 - (d) Remove the release liner from a small part of the circle tape, D50299 (BMS5-157).
 - (e) Attach the circletape, D50299 (BMS5-157) over the hole in the blanket.

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- (f) You can use these (BMS5-157) tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

SUBTASK 25-80-00-340-087

- (10) Do these steps to install vents in the insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396):
- Make sure you install the vent so that it opens in the same direction as on the template.
 - Cut a hole approximately 1 in. (25 mm) in diameter in the cover fabric.
 - Cut a 2 in. (51 mm) circle of tape from tape, G50789 (BMS5-157).
 - Remove the release liner from a small part of the circle tape, G50789 (BMS5-157).
 - Attach the circle tape, G50789 (BMS5-157) over the hole in the blanket.

SUBTASK 25-80-00-340-047

- (11) Do these steps to quilt the blanket, where applicable:
- Quilt through all layers of the insulation blanket, from cover to cover with kevlar sewing thread, G50341 at 4 to 6 stitches per inch.
 - Make sure the grid size of the quilting is a minimum 1 in. (25 mm) by 1 in. (25 mm) square or larger.
 - Apply the applicable strips of tape over the quilting:
 - tape, D50299 (BMS5-157) for fabric, G50330 (BMS8-377).
 - tape, G50789 (BMS5-157) for insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396)
 - Overlap the strips of tape over both sides of the quilting at 0.75 in. (19.05 mm) intervals.

SUBTASK 25-80-00-340-048

- (12) To add drain holes to the insulation blanket, cut 0.5 in. (12.7 mm) diameter drain holes at the bottom edge of the blanket on the inboard side at 2 in. (51 mm) intervals, where applicable.

SUBTASK 25-80-00-340-049

- (13) Add these part information on the inboard side of the completed insulation blanket cover:
- Part Number.
 - Supplier Name.
 - Date of Manufacture.

SUBTASK 25-80-00-340-050

CAUTION: DO NOT COMPRESS THE INSULATION BLANKET BY MORE THAN 50 PERCENT. THIS DECREASES THE THERMAL AND ACOUSTIC PROPERTIES. IF YOU COMPRESS IT TOO MUCH, DAMAGE TO THE INSULATION BLANKET WILL OCCUR.

- (14) Put the insulation blanket in a neat stack on a shelf or in a bag for shipping.

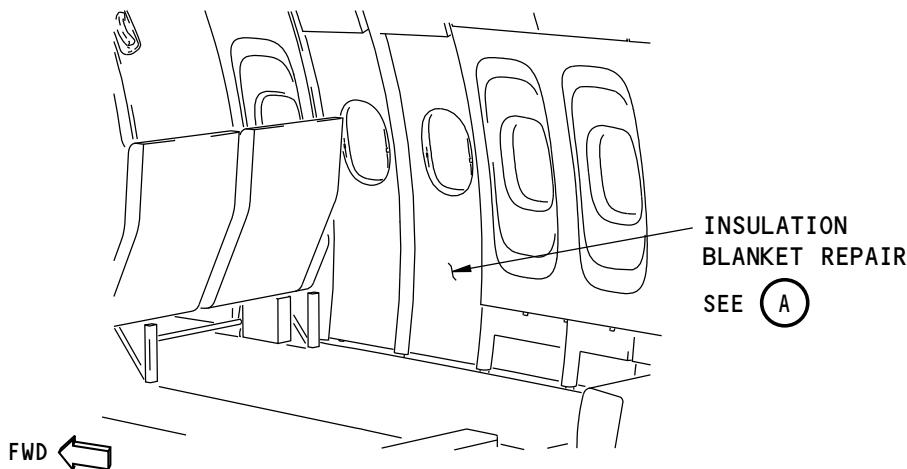
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EFFECTIVITY
AKS ALL

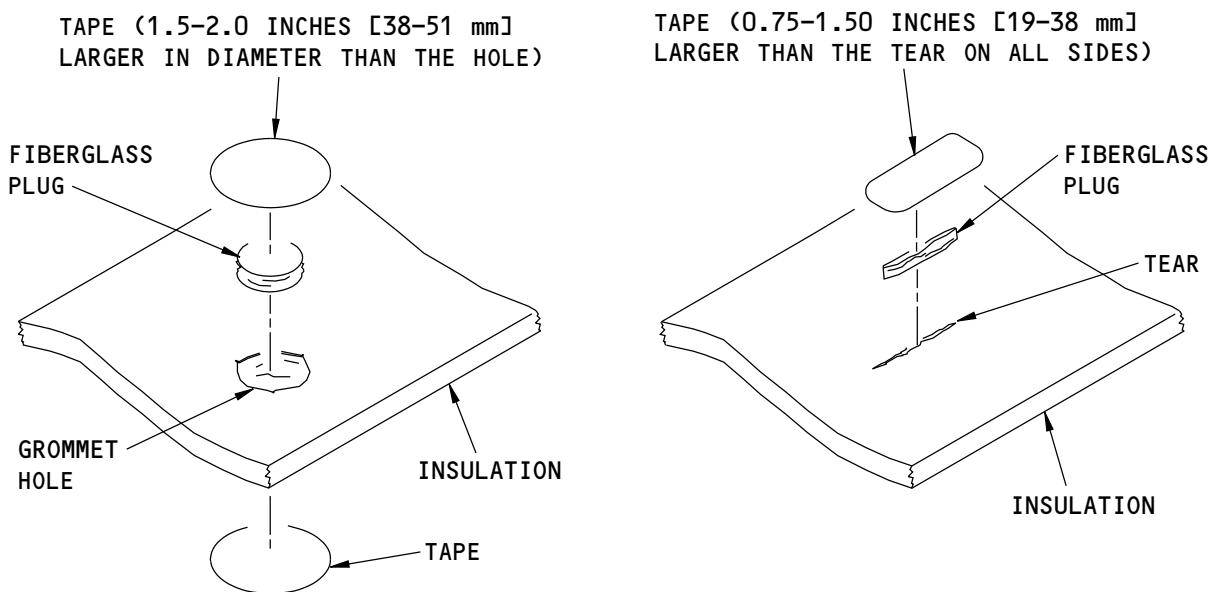
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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT SIDEWALL
(LINER REMOVED)



INSULATION BLANKET REPAIR
(EXAMPLE)

A

C85266 S0006411609_V3

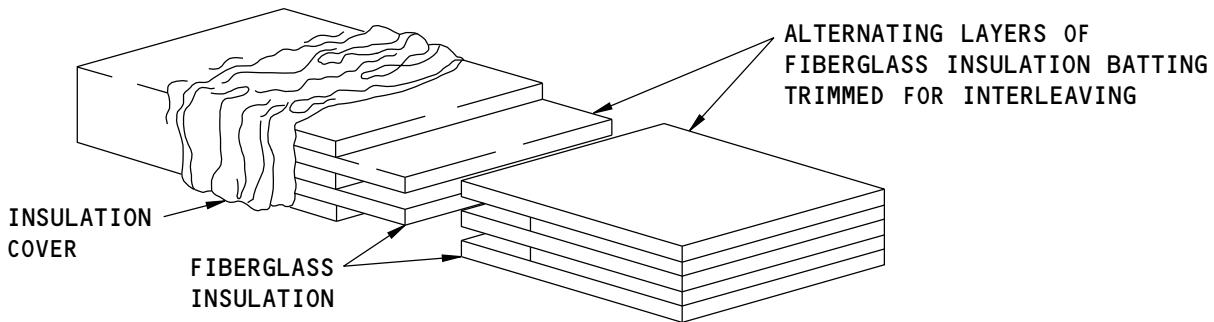
Insulation Blanket Repair
Figure 801/25-80-00-990-804 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

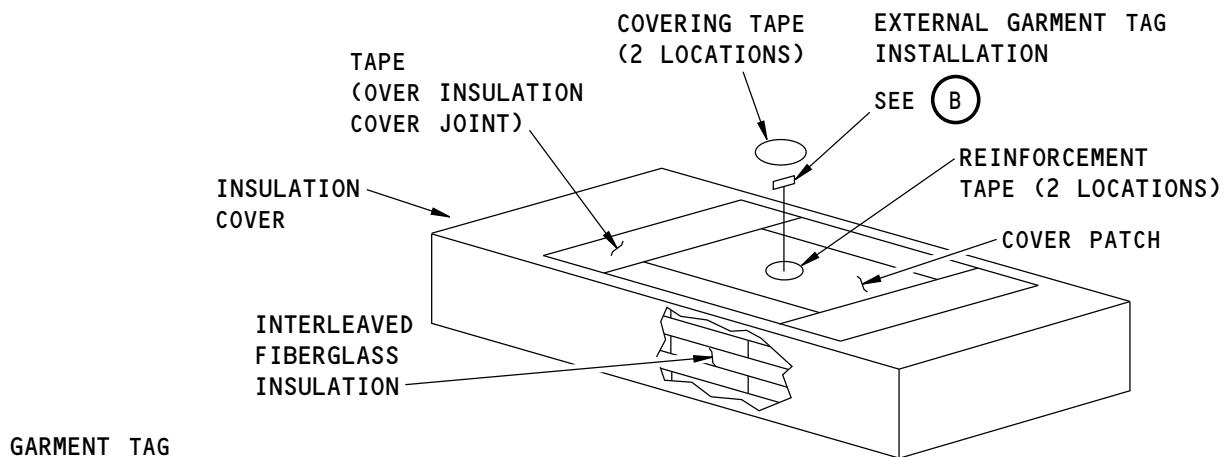
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

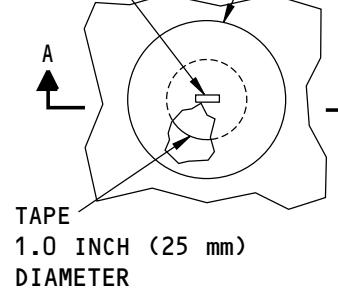


PROCEDURE TO INTERLEAVE FIBERGLASS INSULATION BATTING



GARMENT TAG
(INSERT FROM
INBOARD SIDE
OF BLANKET)

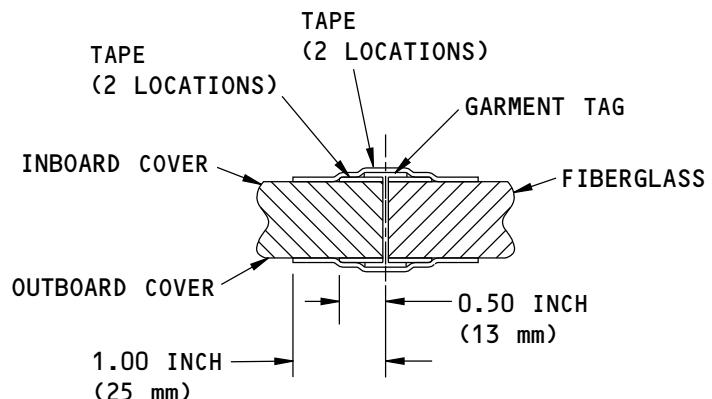
TAPE
2.0 INCH (51 mm)
DIAMETER



EXTERNAL GARMENT TAG
INSTALLATION
(EXAMPLE)



ATTACHMENT OF INTERLEAVED PARTS



J91571 S0000186016_V1

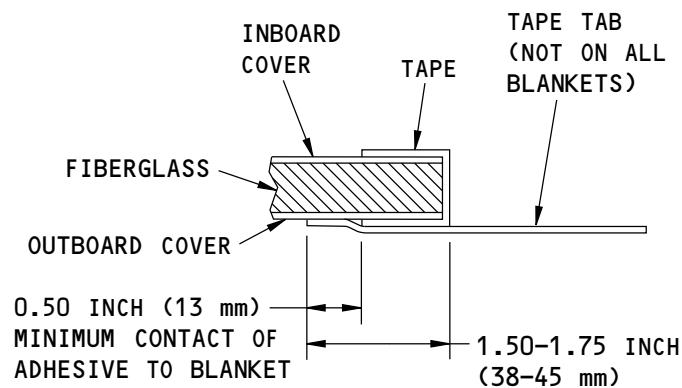
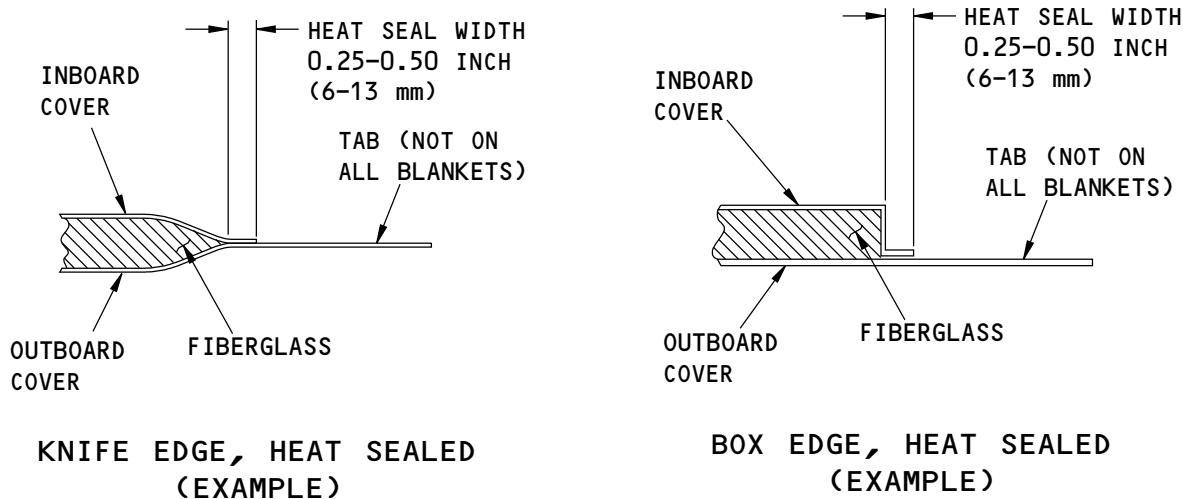
Insulation Blanket Repair
Figure 801/25-80-00-990-804 (Sheet 2 of 2)

EFFECTIVITY
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25-80-00



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AIRCRAFT MAINTENANCE MANUAL



BOX EDGE, TAPE
(EXAMPLE)

J61246 S0000172518_V3

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 1 of 10)

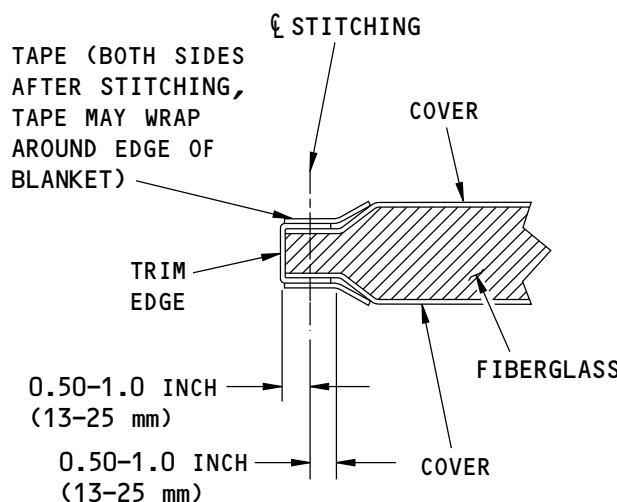
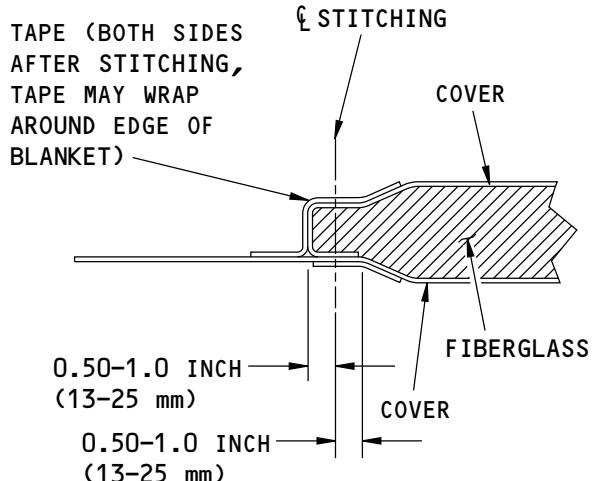
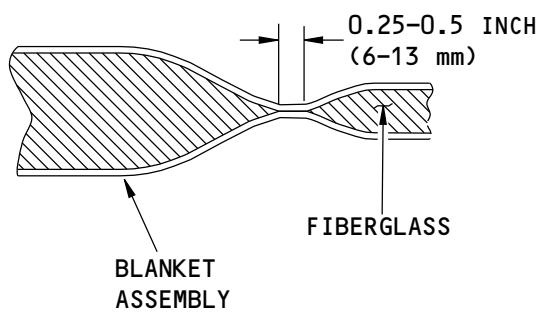
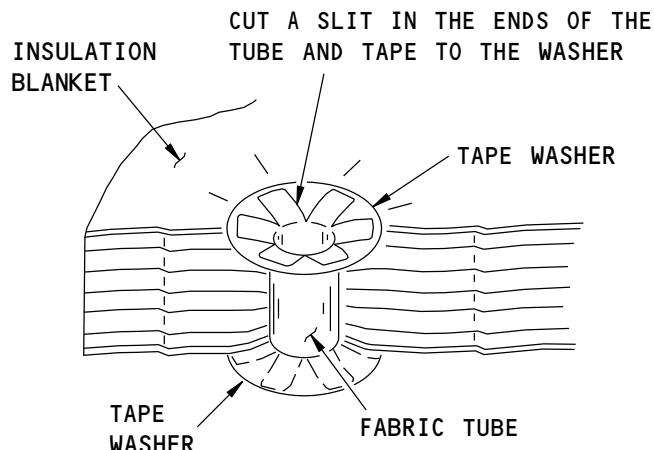
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AKS ALL

25-80-00

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**EDGE BINDING WITHOUT A TAB,
SEWN EDGE**

**EDGE BINDING WITH A TAB,
SEWN EDGE**

**HEATSEAL SEAM LINE
(EXAMPLE)**

**GROMMET INSTALLATION ON
INSULATION BLANKETS**

J61304 S0000172519_V2

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 2 of 10)**

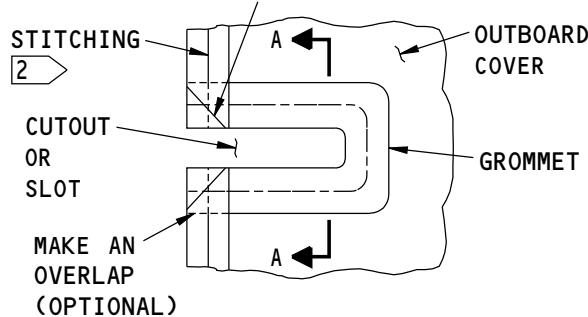
 EFFECTIVITY
AKS ALL

25-80-00

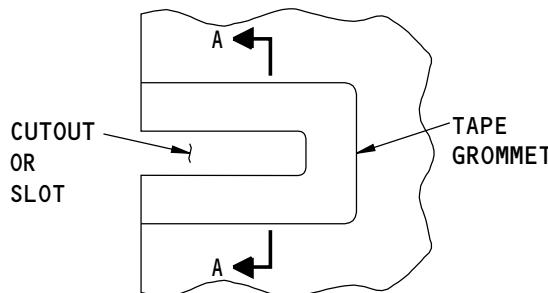


737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

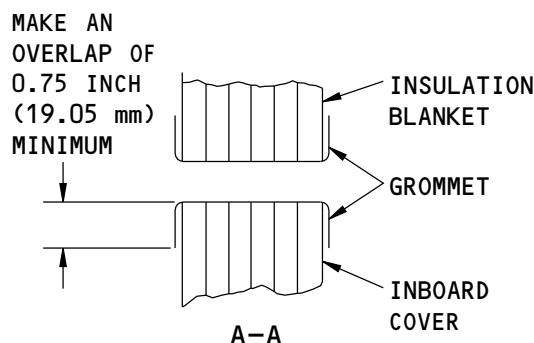
FOLD BACK THE EDGE
OF THE TRIM
APPROXIMATELY
45° AND STITCH AS SHOWN



TRIM EDGE STITCHED
CUTOUT OR SLOT



TRIM EDGE TAPE
CUTOUT OR SLOT [3]



[2] USE KEVLAR SEWING THREAD TO
MAKE 5 ±1 STITCHES FOR EACH INCH

[3] USE TAPE TO MAKE GROMMET

J61278 S0000172520_V1

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 3 of 10)

EFFECTIVITY
AKS ALL

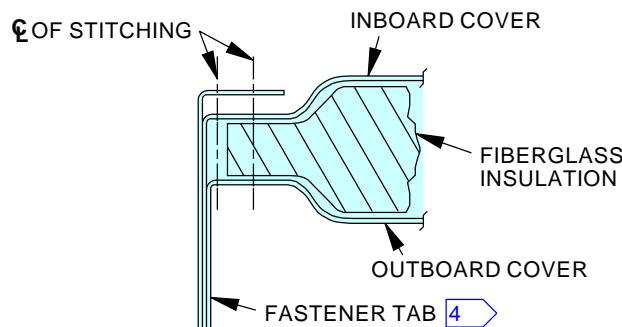
25-80-00



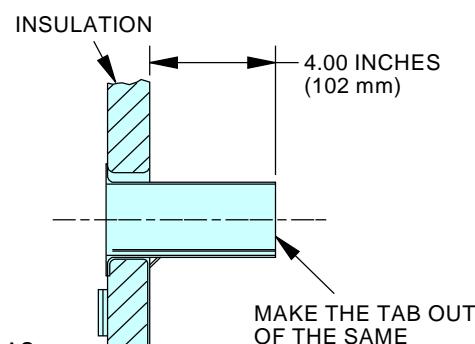
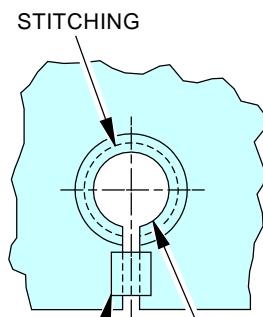
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



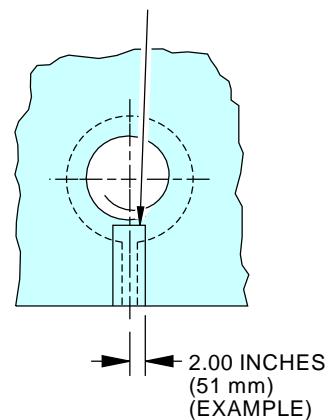
EXAMPLE PROCEDURE TO ATTACH
THE BLANKET ASSEMBLIES TO THE AIRPLANE STRUCTURE OR
TO OTHER BLANKET ASSEMBLIES WITH HOOK/LOOP TAPE



TRIM-EDGE WITH A TAB



SEAL THE GAP IN THE
COVER WITH TAPE
AFTER YOU INSTALL
THE BLANKET



BLANKET OPENINGS FOR SYSTEM (TUBING, ETC)

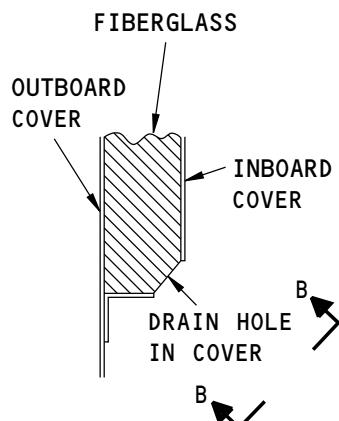
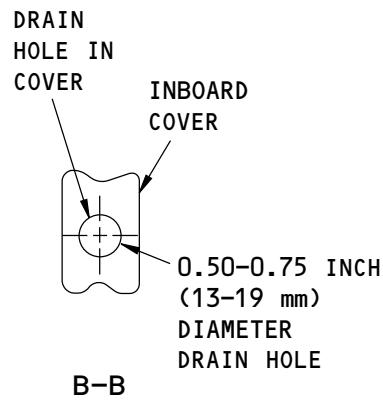
4 MAKE THE FASTENER TAB FROM THE INBOARD AND
OUTBOARD COVER, PLUS ONE LAYER OF COVER FABRIC.

J61261 S0000172521_V3

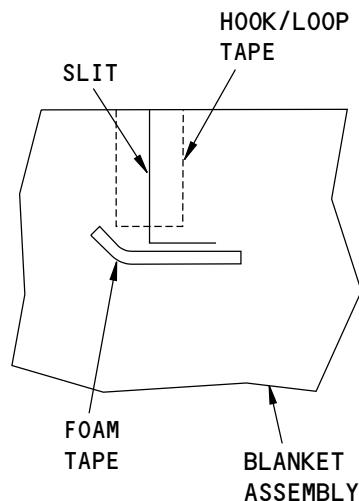
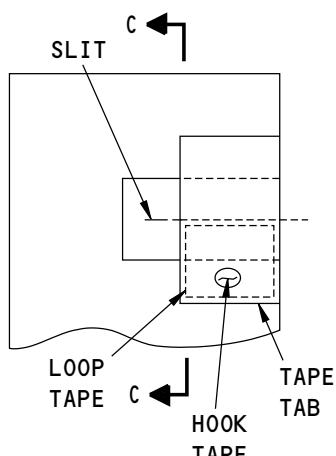
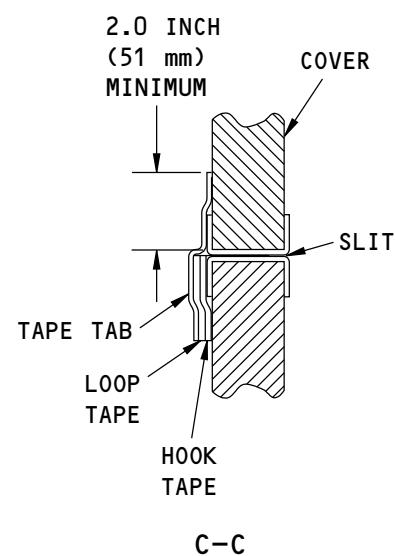
Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 4 of 10)

EFFECTIVITY
AKS ALL

25-80-00


**BOX EDGE DRAIN
(EXAMPLE)**


B-B


**FOAM TAPE WATER DIVERTER
(FOAM TAPE LOCATED ON OUTBOARD
SIDE OF CAPSTRIP)
(EXAMPLE)**

**CLOSURE FOR SLITS
(EXAMPLE)**

**NOMEX ATTACHMENT
(EXAMPLE)**

J61353 S0000172522_V2

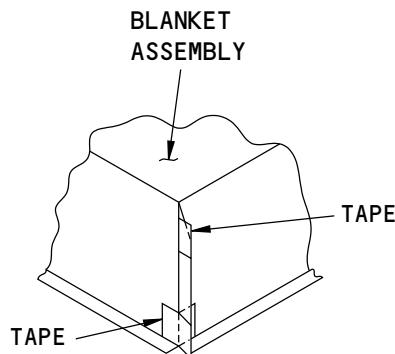
Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 5 of 10)

EFFECTIVITY
AKS ALL

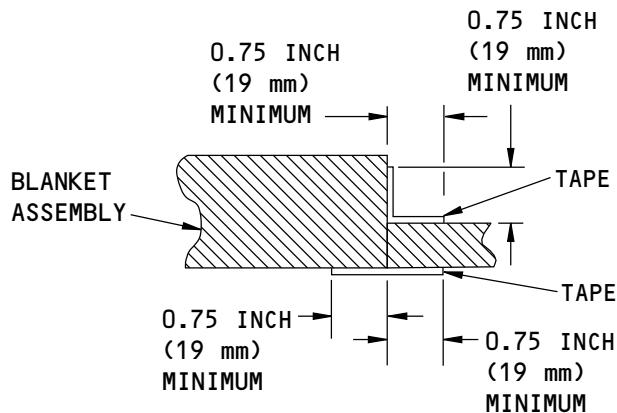
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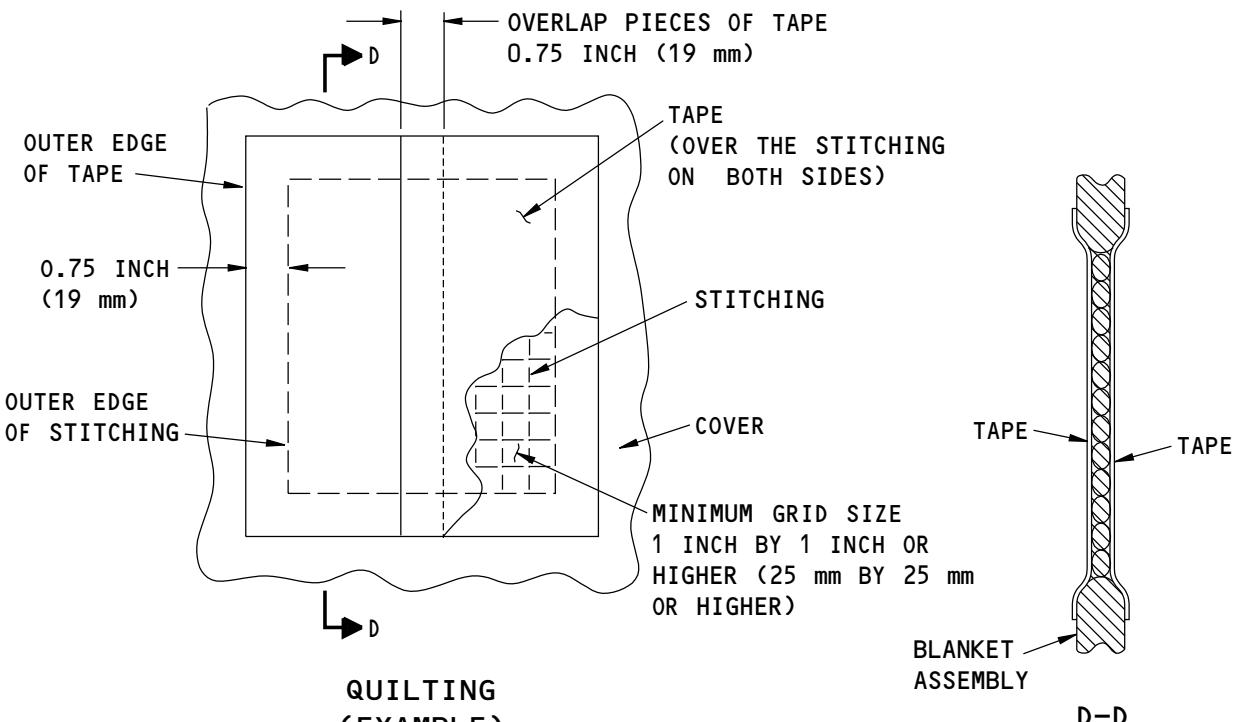
**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**



**REINFORCED CORNER
OF BOXED BLANKET
(EXAMPLE)**



**BLANKET ATTACHMENT
(EXAMPLE)**



J61359 S0000172523_V2

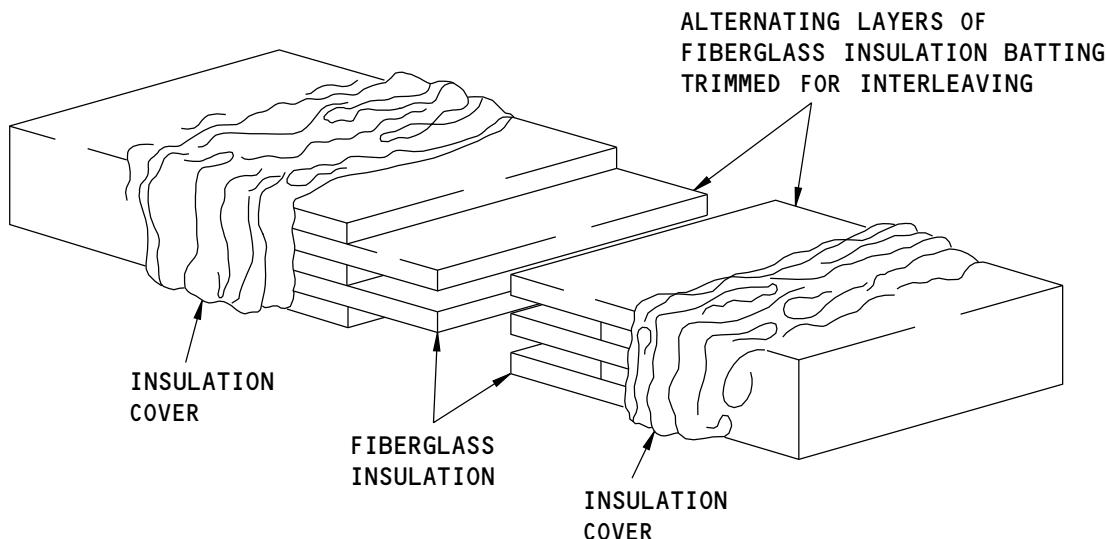
**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 6 of 10)**

EFFECTIVITY
AKS ALL

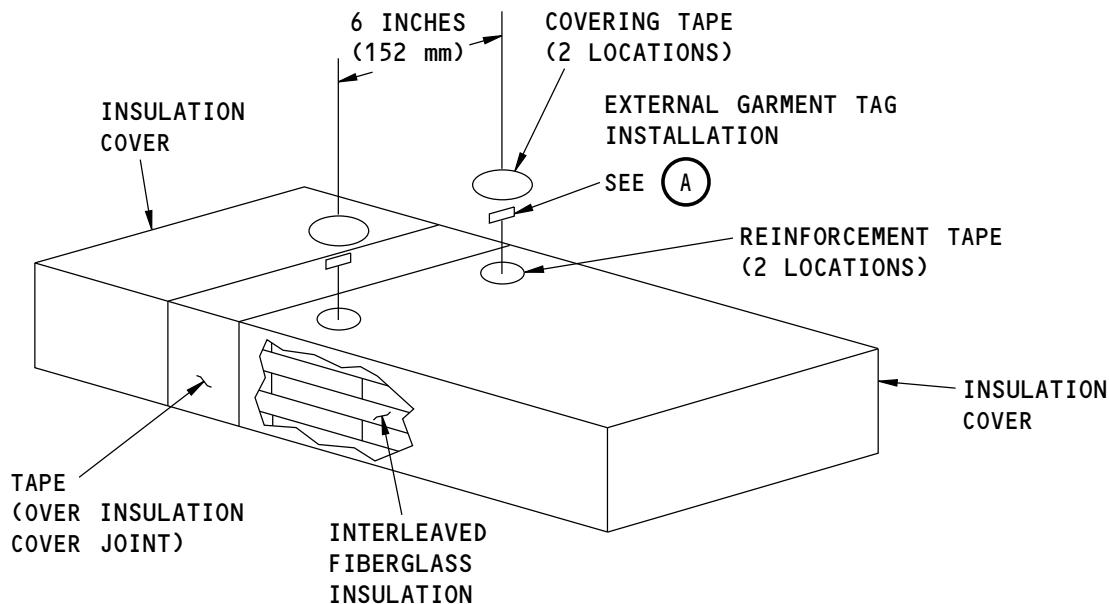
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AIRCRAFT MAINTENANCE MANUAL



PROCEDURE TO INTERLEAVE FIBERGLASS INSULATION BATTING



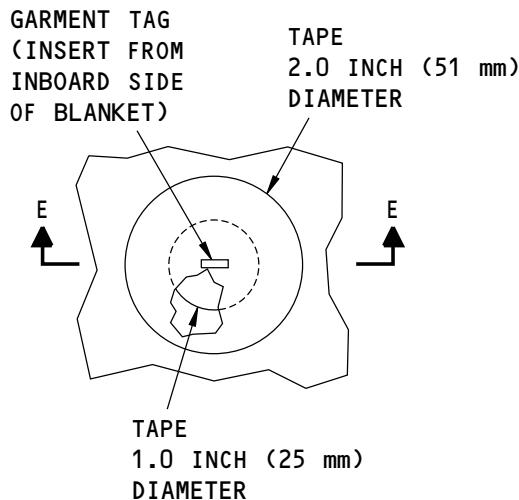
ATTACHMENT OF INTERLEAVED PARTS

J61386 S0000172524_V2

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 7 of 10)

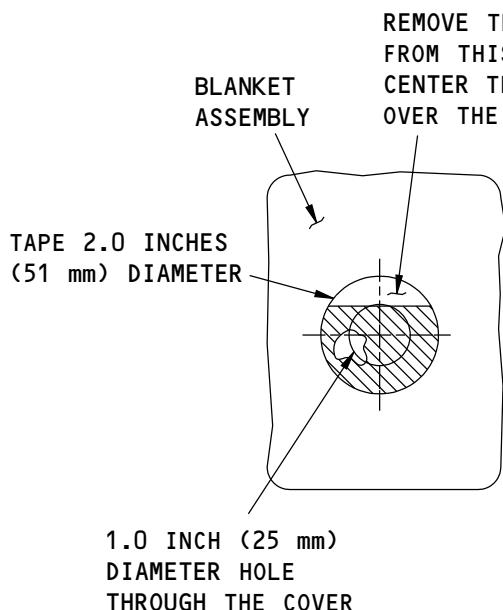
EFFECTIVITY
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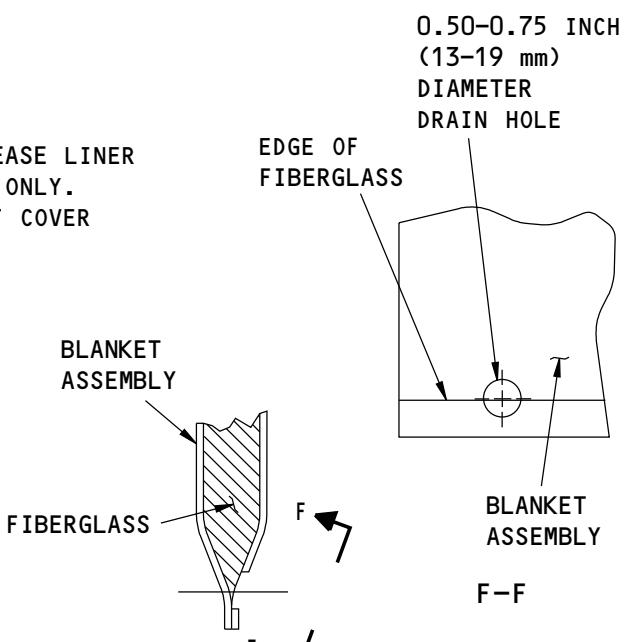
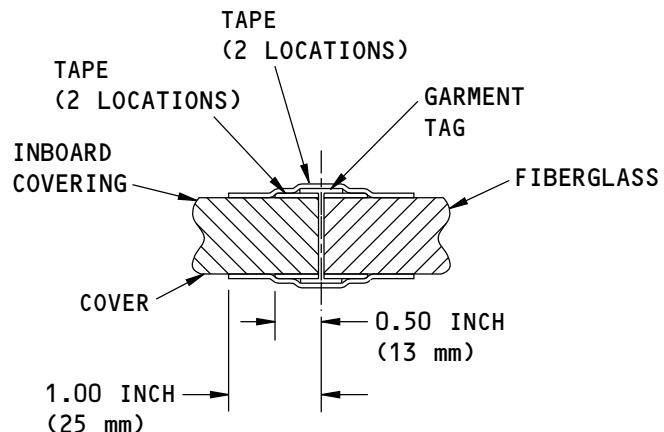


**EXTERNAL GARMENT
TAG INSTALLATION
(EXAMPLE)**

(A)



**VENT INSTALLATION
(EXAMPLE)**



J61388 S0000172525_V2

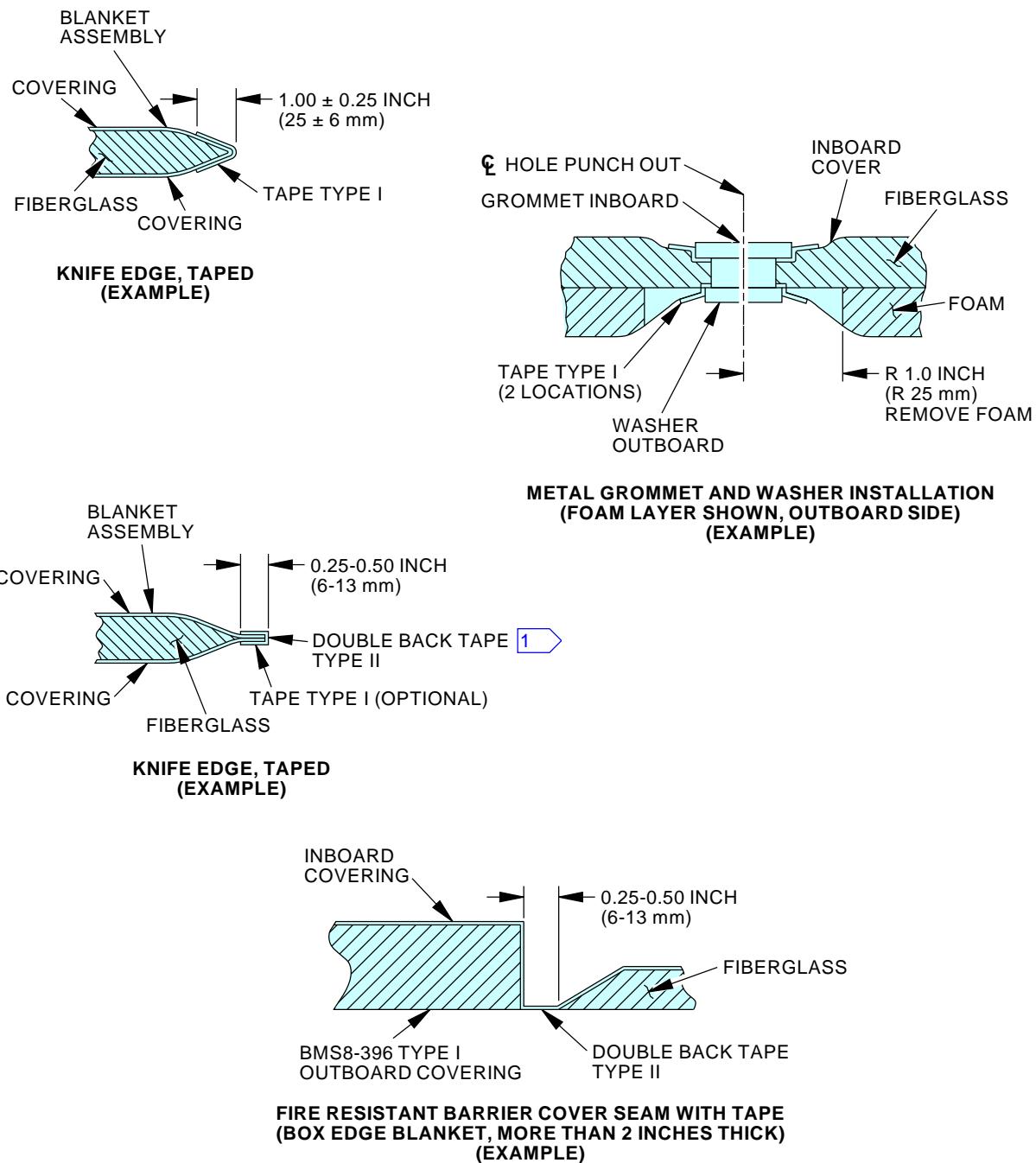
**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 8 of 10)**

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[1] USE DOUBLE BACK TAPE TO ATTACH INBOARD AND OUTBOARD COVER TOGETHER

1929600 S0000364240_V2

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 9 of 10)

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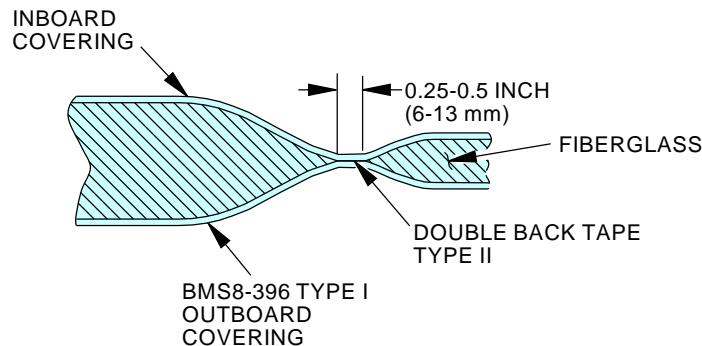
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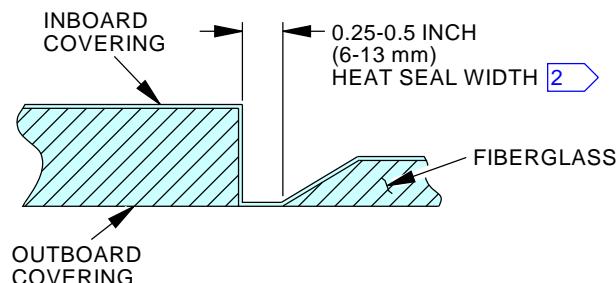
Page 830
Oct 15/2015



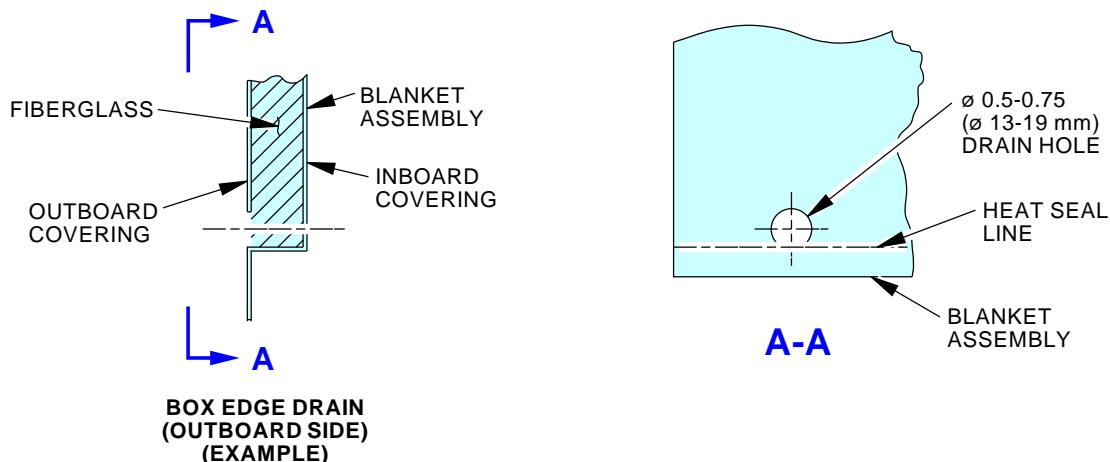
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FIRE RESISTANT BARRIER COVER SEAM WITH TAPE
(KNIFE EDGE BLANKET, 2 INCHES THICK OR LESS)
(EXAMPLE)



HEAT SEAL SEAM LINE
(EXAMPLE)



BOX EDGE DRAIN
(OUTBOARD SIDE)
(EXAMPLE)

[2] USE ONLY THERMAL HEAT SEAL FOR FIRE RESISTANT BARRIER COVERING (BMS8-396).

1929770 S0000364242_V2

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-803 (Sheet 10 of 10)

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TASK 25-80-00-340-806

7. Repair of Cargo Door Insulation Blankets

A. General

- (1) This procedure has instructions to make repairs to cargo door insulation blankets.
- (2) The area to repair must be less than 25 percent of the total area of the inboard cover material.
- (3) Make sure the patch overlaps the joint by a minimum of 1.0 inch (25 mm) on all sides

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. Consumable Materials

Reference	Description	Specification
A00153	Adhesive - Low Odor, Synthetic Rubber Cement	BMS5-30
G50328	Fabric - Advance Polymer Coated, Flame Propagation Resistant	BMS8-370
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	

E. Location Zones

Zone	Area
100	Lower Half of Fuselage

AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS

F. Repairs To BMS8-343 Type III

SUBTASK 25-80-00-212-010

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801
 - 2) Insulation Blanket Installation, TASK 25-80-00-400-801
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-160-019

WARNING: DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

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AIRCRAFT MAINTENANCE MANUAL

**AKS ALL; AIRPLANES WITH FAR 25.856(a) COMPLIANT THERMAL/ACOUSTIC INSULATION MATERIALS
(Continued)**

- (3) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a soft-bristle non-metallic brush, STD-126 to remove the contamination.

SUBTASK 25-80-00-160-020

- (4) Make sure the repair area is clean and dry.

SUBTASK 25-80-00-340-064

- (5) Do these steps if there is damage on the insulation blanket cover:
 - (a) Identify the perimeter around the damaged area on the insulation blanket for a cover patch area that is larger than the damaged area by 1 in. (25 mm) to 1.5 in. (38.1 mm) on all sides.
 - (b) If the cover patch area that is identified on the damaged insulation blanket can fit into a 3 in. (76 mm) by 3 in. (76 mm) square, do these steps:
 - 1) Make a cover patch from fabric, G50328 (BMS8-370) that is larger than the damaged area by 1 in. (25 mm) to 1.5 in. (38.1 mm) on all sides.
 - a) Make sure the corners on the cover patch are rounded.
 - 2) Lightly abrade the entire adhesive side of the cover patch and the area to be covered by the cover patch, with 180 grit abrasive paper, G50381 or finer paper to remove any gloss.
 - 3) Apply adhesive, A00153 (BMS5-30) on the entire bonding surface of the cover patch area or insulation blanket cover.
 - 4) Put the adhesive side of the cover patch over the damaged area of the insulation blanket cover.
 - 5) Make sure there is an overlap of 1 in. (25 mm) to 1.5 in. (38.1 mm) between the damaged area and the edge of the cover patch on all sides.
 - 6) Wipe off any adhesive, A00153 (BMS5-30) that is not necessary.
 - 7) Push on the cover patch to make sure there is a good bond with the insulation blanket cover.
 - (c) If the cover patch area that is identified on the damaged insulation blanket is larger than a 3 in. (76 mm) by 3 in. (76 mm) square repeat the steps in (b) except that adhesive, A00153 (BMS5-30) shall be applied up to 1 in. (25 mm) wide around the periphery of the patch.

———— END OF TASK ————

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25-80-00