

CHAPTER

53

FUSELAGE



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269	Oct 15/2015		298.7	Jun 15/2015		298.43	Jun 15/2015	
270	Oct 15/2015		298.8	Oct 15/2015		298.44	Oct 15/2015	
271	Jun 15/2015		298.9	Oct 15/2015		298.45	Oct 15/2015	
272	Oct 15/2015		298.10	Oct 15/2015		298.46	Oct 15/2015	
273	Oct 15/2015		298.11	Oct 15/2015		298.47	Oct 15/2015	
274	Jun 15/2015		298.12	Jun 15/2015		298.48	Jun 15/2015	
275	Oct 15/2015		298.13	Oct 15/2015		298.49	Oct 15/2015	
276	Oct 15/2015		298.14	Jun 15/2015		298.50	Oct 15/2015	
277	Jun 15/2015		298.15	Oct 15/2015		298.51	Oct 15/2015	
278	Oct 15/2015		298.16	Jun 15/2015		298.52	Oct 15/2015	
279	Oct 15/2015		298.17	Oct 15/2015		298.53	Oct 15/2015	
280	Oct 15/2015		298.18	Jun 15/2015		298.54	Oct 15/2015	
281	Jun 15/2015		298.19	Oct 15/2015		298.55	Oct 15/2015	
282	Oct 15/2015		298.20	Jun 15/2015		298.56	Jun 15/2015	
283	Jun 15/2015	R	298.21	Jun 15/2016		298.57	Oct 15/2015	
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286	Oct 15/2015		298.24	Oct 15/2015		298.60	Oct 15/2015	
287	Jun 15/2015		298.25	Oct 15/2015		298.61	Jun 15/2015	
288	Oct 15/2015		298.26	Jun 15/2015		298.62	Oct 15/2015	
289	Jun 15/2015		298.27	Oct 15/2015		298.63	Oct 15/2015	
290	Oct 15/2015		298.28	Oct 15/2015		298.64	Oct 15/2015	
291	Oct 15/2015		298.29	Jun 15/2015		298.65	Oct 15/2015	
292	Oct 15/2015		298.30	Oct 15/2015		298.66	Jun 15/2015	
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295	Oct 15/2015		298.33	Jun 15/2015		298.69	Jun 15/2015	
296	Oct 15/2015		298.34	Oct 15/2015		298.70	Oct 15/2015	
297	Oct 15/2015		298.35	Jun 15/2015		298.71	Jun 15/2015	
298	Jun 15/2015		298.36	Oct 15/2015		298.72	Oct 15/2015	
298.1	Jun 15/2015		298.37	Jun 15/2015		298.73	Jun 15/2015	
298.2	Oct 15/2015		298.38	Oct 15/2015		298.74	Oct 15/2015	
298.3	Oct 15/2015		298.39	Oct 15/2015		298.75	Oct 15/2015	
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298.5	Oct 15/2015		298.41	Oct 15/2015		298.77	Oct 15/2015	

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298.79	Oct 15/2015		204	Oct 15/2015		240	Oct 15/2015	
298.80	Oct 15/2015		205	Oct 15/2015		241	Oct 15/2015	
298.81	Jun 15/2015		206	Oct 15/2015		242	Oct 15/2014	
298.82	Oct 15/2015		207	Oct 15/2015		243	Oct 15/2015	
298.83	Oct 15/2015		208	Oct 15/2014		244	Oct 15/2015	
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298.85	Oct 15/2015		210	Oct 15/2015		246	BLANK	
298.86	Oct 15/2015		211	Oct 15/2015		53-12-11		
298.87	Feb 15/2016		212	Oct 15/2015		401	Oct 15/2015	
298.88	Feb 15/2016		213	Oct 15/2015		402	Oct 15/2014	
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402	Feb 15/2016		216	Oct 15/2014		402	Oct 15/2015	
403	Feb 15/2016		217	Oct 15/2015		403	Oct 15/2014	
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405	Oct 15/2015		219	Oct 15/2015		405	Oct 15/2015	
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407	Oct 15/2015		221	Oct 15/2014		407	Oct 15/2015	
408	Oct 15/2015		222	Oct 15/2014		408	BLANK	
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810	Oct 15/2015		201	Oct 15/2015		422	Oct 15/2014	
811	Oct 15/2015		202	Oct 15/2014		423	Oct 15/2015	
812	Oct 15/2015		203	Oct 15/2015		424	Oct 15/2014	
813	Oct 15/2015		204	BLANK		425	Oct 15/2014	
814	Oct 15/2015	53-51-01				426	Oct 15/2014	
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O 802	Jun 15/2016		603	Oct 15/2015		429	Oct 15/2015	
53-31-11			604	Feb 15/2015		430	BLANK	
401	Feb 15/2016		605	Oct 15/2015	53-51-21			
402	Oct 15/2015		606	BLANK	R	601	Jun 15/2016	
403	Oct 15/2015	53-51-11				602	Oct 15/2015	
404	Oct 15/2015		401	Feb 15/2015	R	603	Jun 15/2016	
405	Oct 15/2014		402	Oct 15/2014		604	Feb 15/2015	
406	BLANK	53-51-21				605	Oct 15/2015	
53-31-21			401	Oct 15/2014		606	Jun 15/2015	
401	Feb 15/2015		402	Oct 15/2014		607	Oct 15/2014	
R 402	Jun 15/2016		403	Oct 15/2015		608	BLANK	
403	Feb 15/2015		404	Oct 15/2015	53-51-37			
404	Oct 15/2014		405	Oct 15/2014		201	Oct 15/2014	
405	Oct 15/2015		406	Oct 15/2014		202	Oct 15/2014	
406	Oct 15/2015		407	Oct 15/2014		203	Oct 15/2015	
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401	Oct 15/2014		409	Oct 15/2014	53-52-00			
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404	Oct 15/2014		412	Oct 15/2015		203	Oct 15/2015	
405	Oct 15/2015		413	Oct 15/2015		204	Oct 15/2015	
406	Oct 15/2015		414	Oct 15/2014		205	Feb 15/2015	
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712	Feb 15/2016		405	Oct 15/2015				
713	Feb 15/2016		406	Jun 15/2015				
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715	Feb 15/2016		408	BLANK				
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<u>FUSELAGE - CORROSION PREVENTION</u>	53-00-37		201			AKS ALL
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EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-803			201			AKS ALL
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INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON) TASK 53-05-02-250-809			203			AKS ALL
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EXTERNAL - SPECIAL DETAILED: CROWN SKIN PANEL - FWD OF STA 259.5 TASK 53-05-02-250-814				206	AKS ALL
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INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE TASK 53-05-02-250-845				234	AKS ALL
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INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716 TASK 53-05-02-250-860				246	AKS ALL
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EXTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO STA 887 TASK 53-05-02-211-867				296	AKS ALL
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INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-974				298.4	AKS ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-950				298.5	AKS ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-130-809				298.5	AKS ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-951				298.6	AKS ALL
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EXTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-875				298.7	AKS ALL
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-250-953				298.8	AKS ALL
INTERNAL - DETAILED: WINDOW BELT STA 888 to 927 TASK 53-05-02-211-876				298.9	AKS ALL
EXTERNAL - DETAILED: WINDOW BELT STA 888 to 927 TASK 53-05-02-211-877				298.9	AKS ALL

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INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-250-A79				298.10	AKS ALL
INTERNAL - GENERAL VISUAL: PRESSURE DECK ATTACHMENTS TO REAR SPAR EXTENSION TASK 53-05-02-210-837				298.11	AKS ALL
EXTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727 TASK 53-05-02-250-A98				298.11	AKS ALL
INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE TASK 53-05-02-211-981				298.12	AKS ALL
INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-982				298.12	AKS ALL
FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES	53-05-03			201	AKS ALL
EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, FORWARD ACCESS DOOR CUTOUT TASK 53-05-03-210-801				201	AKS ALL
EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, EE COMPARTMENT DOOR CUTOUT TASK 53-05-03-210-802				203	AKS ALL
EXTERNAL - GENERAL VISUAL: NOSE WHEEL WELL TASK 53-05-03-210-804				205	AKS ALL
EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS TASK 53-05-03-211-801				207	AKS ALL

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EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS				209	AKS ALL
TASK 53-05-03-211-802					
EXTERNAL - GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL				211	AKS ALL
TASK 53-05-03-210-805					
INTERNAL - GENERAL VISUAL: FORWARD PRESSURE BULKHEAD				218	AKS ALL
TASK 53-05-03-210-806					
INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE WHEEL WELL				220	AKS ALL
TASK 53-05-03-210-807					
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE				222	AKS ALL
TASK 53-05-03-210-808					
INTERNAL - GENERAL VISUAL: AREA ABOVE AND OUTBOARD OF NOSE WHEEL WELL				224	AKS ALL
TASK 53-05-03-210-809					
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA				228	AKS ALL
TASK 53-05-03-210-810					
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA				234	AKS ALL
TASK 53-05-03-210-811					
INTERNAL - GENERAL VISUAL: ELECTRICAL AND ELECTRONICS COMPARTMENT				240	AKS ALL
TASK 53-05-03-210-812					
INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT				247	AKS ALL
TASK 53-05-03-210-813					
INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT FLOOR STRUCTURE				252	AKS ALL
TASK 53-05-03-210-814					
INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE				255	AKS ALL
TASK 53-05-03-210-815					

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INTERNAL - DETAILED: FORWARD CARGO DOOR CUTOUT TASK 53-05-03-211-803				258	AKS ALL
INTERNAL - GENERAL VISUAL: FORWARD BILGE TASK 53-05-03-210-816				260	AKS ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT TASK 53-05-03-210-817				263	AKS ALL
INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box) TASK 53-05-03-210-818				267	AKS ALL
INTERNAL - GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION TASK 53-05-03-210-819				271	AKS ALL
INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL TASK 53-05-03-210-820				274	AKS ALL
INTERNAL - GENERAL VISUAL: KEEL BEAM UNDER WING-TO-BODY FAIRING (under wing box) TASK 53-05-03-210-821				277	AKS ALL
INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL TASK 53-05-03-210-823				281	AKS ALL
INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT TASK 53-05-03-210-824				283	AKS ALL
INTERNAL - DETAILED: AFT CARGO DOOR CUTOUT TASK 53-05-03-211-804				287	AKS ALL
INTERNAL - GENERAL VISUAL: AFT BILGE TASK 53-05-03-210-825				289	AKS ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF CARGO COMPARTMENT TASK 53-05-03-210-826				294	AKS ALL

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INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well) TASK 53-05-03-210-827				298	AKS ALL
INTERNAL - GENERAL VISUAL: AREA UNDER WING-TO-BODY FAIRING (above wing) TASK 53-05-03-210-828				298.4	AKS ALL
EXTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT TASK 53-05-03-210-829				298.7	AKS ALL
EXTERNAL - DETAILED: FORWARD ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES TASK 53-05-03-211-805				298.12	AKS ALL
EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES TASK 53-05-03-211-806				298.14	AKS ALL
EXTERNAL - DETAILED: AFT ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES TASK 53-05-03-211-807				298.16	AKS ALL
EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES TASK 53-05-03-211-808				298.18	AKS ALL
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270 TASK 53-05-03-210-830				298.20	AKS ALL
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE TASK 53-05-03-210-831				298.23	AKS ALL
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 to 360 TASK 53-05-03-210-832				298.26	AKS ALL
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS TASK 53-05-03-211-809				298.29	AKS ALL

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INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOOUTS TASK 53-05-03-211-810				298.31	AKS ALL
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOOUTS TASK 53-05-03-211-811				298.33	AKS ALL
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOOUTS TASK 53-05-03-211-812				298.35	AKS ALL
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA TASK 53-05-03-210-833				298.37	AKS ALL
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA TASK 53-05-03-210-834				298.43	AKS ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA TASK 53-05-03-210-835				298.48	AKS ALL
INTERNAL - GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 to 663.75 TASK 53-05-03-210-836				298.52	AKS ALL
INTERNAL - GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 to 1016 TASK 53-05-03-210-837				298.56	AKS ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD TASK 53-05-03-210-838				298.61	AKS ALL
INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT TASK 53-05-03-210-839				298.66	AKS ALL
INTERNAL - GENERAL VISUAL: STA 1156 BULKHEAD TASK 53-05-03-210-840				298.69	AKS ALL

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INTERNAL - GENERAL VISUAL: FUSELAGE SKIN UNDER DORSAL FIN TASK 53-05-03-210-841				298.71	AKS ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING TASK 53-05-03-210-842				298.73	AKS ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING TASK 53-05-03-210-843				298.78	AKS ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING TASK 53-05-03-210-844				298.81	AKS ALL
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270 TASK 53-05-03-210-861				298.84	AKS ALL
INTERNAL - GENERAL VISUAL: CROWN SKIN PANEL TASK 53-05-03-210-862				298.87	AKS 012-999
PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION	53-11-01			401	AKS ALL
Remove the Scuff Plate TASK 53-11-01-000-801				401	AKS ALL
Install the Scuff Plate TASK 53-11-01-420-801				402	AKS ALL
CARGO DOOR SCUFF PLATE - REMOVAL/INSTALLATION	53-11-02			401	AKS ALL
Cargo Door Scuff Plate - Removal TASK 53-11-02-020-801				401	AKS ALL
Cargo Door Scuff Plate - Installation TASK 53-11-02-420-801				403	AKS ALL
FRAMES AND BULKHEADS CORROSION PREVENTION - MAINTENANCE PRACTICES	53-11-37			201	AKS ALL
Crown Frames, Stringers and Skin - Corrosion Prevention TASK 53-11-37-600-811				201	AKS ALL
Lower Lobe Structure - Corrosion Prevention TASK 53-11-37-600-812				206	AKS ALL

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Galley and Lavatory Areas - Corrosion Prevention TASK 53-11-37-600-804				214	AKS ALL
Main Gear Wheel Well and Keel Beam - Corrosion Prevention TASK 53-11-37-600-805				220	AKS ALL
Nose Gear Wheel Well - Corrosion Prevention TASK 53-11-37-600-806				228	AKS ALL
Door Openings - Corrosion Prevention TASK 53-11-37-600-808				234	AKS ALL
Upper Lobe Frames, Stringers and Skin - Corrosion Prevention TASK 53-11-37-600-810				241	AKS ALL
KEEL BEAM BLOWOUT PANEL - REMOVAL/INSTALLATION	53-12-11			401	AKS ALL
Keel Beam Blowout Panel Installation TASK 53-12-11-400-801				401	AKS ALL
NOSE WHEEL WELL ACCESS PANELS - REMOVAL/INSTALLATION	53-14-01			401	AKS ALL
Nose Wheel Well Access Panels - Removal TASK 53-14-01-020-801				401	AKS ALL
Nose Wheel Well Access Panels - Installation TASK 53-14-01-420-801				402	AKS ALL
PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION	53-21-00			401	AKS ALL
Passenger Cabin Floor Panel Removal TASK 53-21-00-000-801				401	AKS ALL
Passenger Cabin Floor Panel Installation TASK 53-21-00-400-801				402	AKS ALL
POLYURETHANE WATERSEAL - REPAIRS	53-21-00			801	AKS ALL
Repair the Polyurethane Waterseal TASK 53-21-00-300-801				801	AKS ALL
WATER BARRIER - REPAIRS	53-21-11			801	AKS ALL
Vinyl Water Barrier Repair TASK 53-21-11-300-801				801	AKS ALL

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Mylar Water Barrier Repair TASK 53-21-11-300-802					801	AKS ALL
<u>NOSE VORTEX GENERATORS - REMOVAL/INSTALLATION</u>			53-31-11		401	AKS ALL
Remove the Nose Vortex Generators TASK 53-31-11-000-801					401	AKS ALL
Install the Nose Vortex Generators TASK 53-31-11-400-801					404	AKS ALL
<u>VORTEX GENERATOR ASSEMBLY - REMOVAL/INSTALLATION</u>			53-31-21		401	AKS ALL
Vortex Generator Assembly Removal TASK 53-31-21-000-801					401	AKS ALL
Vortex Generator Installation TASK 53-31-21-400-801					402	AKS ALL
<u>STABILIZER TO BODY FRONT SPAR SLIDING SEAL - REMOVAL/INSTALLATION</u>	53-31-31	2			401	AKS ALL
Stabilizer-to-Body Upper Front Spar Sliding Seal Removal TASK 53-31-31-000-802		2			401	AKS ALL
Stabilizer-to-Body Upper Front Spar Sliding Seal Installation TASK 53-31-31-400-802		2			401	AKS ALL
Stabilizer-to-Body Lower Front Spar Sliding Seal Removal TASK 53-31-31-000-803		2			408	AKS ALL
Stabilizer-to-Body Lower Front Spar Sliding Seal Installation TASK 53-31-31-400-803		2			408	AKS ALL
<u>PASSENGER CABIN AND CARGO COMPARTMENT TRACKS - CLEANING/PAINTING</u>	53-42-11				701	AKS ALL
Clean the Passenger Cabin and Cargo Compartment Track TASK 53-42-11-100-801					701	AKS ALL

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FRONT SPAR TO REAR SPAR UNDERWING PANEL - INSPECTION/REPAIR	53-51-00				201	AKS ALL
Front Spar to Rear Spar Underwing Panel Inspection					201	AKS ALL
TASK 53-51-00-200-801						
Front Spar to Rear Spar Underwing Panel Repair					201	AKS ALL
TASK 53-51-00-300-801						
WING-TO-BODY FAIRING - INSPECTION/CHECK	53-51-01				601	AKS ALL
Wing-to-Body Fairing Electrical Resistance Check					601	AKS ALL
TASK 53-51-01-765-801						
WING-TO-BODY FAIRING BLOWOUT PANEL - REMOVAL/INSTALLATION	53-51-11				401	AKS ALL
Blowout Panel for the Wing-to-Body Fairing Removal					401	AKS ALL
TASK 53-51-11-000-801						
Blowout Panel for the Wing-to-Body Fairing Installation					401	AKS ALL
TASK 53-51-11-400-801						
WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION	53-51-21				401	AKS ALL
Forward Wing-To-Body Fairing Panel Removal					401	AKS ALL
TASK 53-51-21-000-803						
Forward Wing-To-Body Fairing Panel Installation					403	AKS ALL
TASK 53-51-21-400-803						
Center Wing-To-Body Fairing Panel Removal					409	AKS ALL
TASK 53-51-21-000-802						
Center Wing-To-Body Fairing Panel Installation					412	AKS ALL
TASK 53-51-21-400-802						
Aft Wing-To-Body Fairing Panel Removal					421	AKS ALL
TASK 53-51-21-000-801						
Aft Wing-To-Body Fairing Panel Installation					423	AKS ALL
TASK 53-51-21-400-801						

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<u>WING-TO-BODY FAIRING PANELS - INSPECTION/CHECK</u>	53-51-21		601			AKS ALL
Wing-To-Body Fairing Panel Maximum Electrical Resistance Check			601			AKS ALL
TASK 53-51-21-760-801						
Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection			606			AKS ALL
TASK 53-51-21-211-801						
<u>FILLET FAIRINGS CORROSION - MAITINENCE PRACTICES</u>	53-51-37		201			AKS ALL
Wing to Body Fairing Cavity - Corrosion Prevention			201			AKS ALL
TASK 53-51-37-600-801						
<u>NOSE RADOME - MAINTENANCE PRACTICES</u>	53-52-00		201			AKS ALL
Nose Radome - Open			201			AKS ALL
TASK 53-52-00-010-802						
Nose Radome - Close			204			AKS ALL
TASK 53-52-00-410-802						
Nose Radome Protective Boot Removal			205			AKS ALL
TASK 53-52-00-000-802						
Nose Radome Protective Boot Installation			205			AKS ALL
TASK 53-52-00-400-802						
<u>NOSE RADOME - REMOVAL/INSTALLATION</u>	53-52-00		401			AKS ALL
Nose Radome Removal			401			AKS ALL
TASK 53-52-00-000-801						
Nose Radome Installation			402			AKS ALL
TASK 53-52-00-400-801						
<u>NOSE RADOME - INSPECTION/CHECK</u>	53-52-00		601			AKS ALL
Do a Check of the Nose Radome			601			AKS ALL
TASK 53-52-00-200-801						
<u>NOSE RADOME - CLEANING/PAINTING</u>	53-52-00		701			AKS ALL
Nose Radome - Cleaning/Painting			701			AKS ALL
TASK 53-52-00-370-801						

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<u>LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES</u>		53-52-03		201	AKS ALL
Remove the Lightning Diverter Strips TASK 53-52-03-000-801				201	AKS ALL
Install the Lightning Diverter Strip TASK 53-52-03-400-801				201	AKS ALL
Lightning Diverter Strips - Test TASK 53-52-03-820-801				203	AKS ALL
<u>LIGHTNING DIVERTER STRIPS - REPAIRS</u>	53-52-03			801	AKS ALL
Lightning Diverter Strip Temporary Repair TASK 53-52-03-300-801				801	AKS ALL
<u>GLIDE SLOPE ANTENNA DIRECTOR BAR - REMOVAL/INSTALLATION</u>	53-52-31			401	AKS ALL
Glide Slope Director Bar Removal TASK 53-52-31-000-801				401	AKS ALL
Glide Slope Director Bar Installation TASK 53-52-31-400-801				401	AKS ALL
<u>TAILCONE - REMOVAL/INSTALLATION</u>	53-53-00			401	AKS ALL
Tailcone Removal TASK 53-53-00-000-801				401	AKS ALL
Tailcone Installation TASK 53-53-00-400-801				404	AKS ALL
<u>BROADBAND RADOME - REMOVAL/INSTALLATION</u>	53-54-00			401	AKS 012-999
Broadband Radome Removal TASK 53-54-00-000-801				401	AKS 012-999
Broadband Radome Installation TASK 53-54-00-400-801				405	AKS 012-999
<u>BROADBAND RADOME - INSPECTION/CHECK</u>	53-54-00			601	AKS 012-999
Broadband Radome Inspection TASK 53-54-00-211-801				601	AKS 012-999
<u>BROADBAND RADOME - REPAIRS</u>	53-54-00			801	AKS 012-999
Broadband Radome Blow-out Door Hinge Repair TASK 53-54-00-300-801				801	AKS 012-999

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Broadband Radome Blow-out Door Latch Repair TASK 53-54-00-300-802				801	AKS 012-999
Broadband Radome Blow-out Door Opening Edge Protector Repair TASK 53-54-00-300-803				802	AKS 012-999
Broadband Radome Blow-out Door Seal Repair TASK 53-54-00-300-804				803	AKS 012-999
Broadband Radome Exterior Coating Repair TASK 53-54-00-300-805				804	AKS 012-999
Broadband Radome Hoist Point Nutplate Repair TASK 53-54-00-300-806				806	AKS 012-999
Broadband Radome Leading Edge Protector Repair TASK 53-54-00-300-807				807	AKS 012-999
Broadband Radome Lightning Diverter Strip Repair TASK 53-54-00-300-808				808	AKS 012-999

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FUSELAGE - MAINTENANCE PRACTICES

1. General

- A. This procedure has this task:
- (1) Airworthiness Limitation Precautions.

TASK 53-00-00-912-801

2. Airworthiness Limitation Precautions

A. General

- (1) Critical Design Configuration Control Limitations (CDCCLs)
 - (a) All occurrences of CDCCLs found in this chapter of the AMM are identified by this note after each applicable CDCCL design feature:
 - 1) NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).
 - (b) Design features that are CDCCLs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. CDCCLs are a means of identifying certain design configuration features intended to preclude a fuel tank ignition source for the operational life of the airplane. CDCCLs are mandatory and cannot be changed or deleted without the approval of the FAA Oversight Office that is responsible for the airplane model Type Certificate. A critical fuel tank ignition source prevention feature may exist in the fuel system and its related installation or in systems that, if a failure condition were to develop, could interact with the fuel system in such a way that an unsafe condition would develop without this limitation. Strict adherence to configuration, methods, techniques, and practices as prescribed is required to ensure the CDCCL is complied with. Any use of parts, methods, techniques or practices not contained in the applicable CDCCL must be approved by the FAA Oversight Office that is responsible for the airplane model Type Certificate.
- (2) Airworthiness Limitation Instructions (ALIs)
 - (a) All occurrences of fuel tank system ALIs found in this chapter of the AMM are identified by this note after each applicable ALI inspection feature:
 - 1) NOTE: ALI - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on airworthiness limitation instructions (ALIs).
 - (b) Inspection features that are ALIs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. These ALIs identify inspection features related to fuel tank ignition source prevention which must be done to maintain the design level of safety for the operational life of the airplane. These inspection features are mandatory and cannot be changed or deleted without the approval of the FAA Oversight Office that is responsible for the airplane model Type Certificate. Strict adherence to methods, techniques and practices as prescribed is required to ensure the ALI is complied with. Any use of methods, techniques or practices not contained in these ALIs must be approved by the FAA Oversight Office that is responsible for the airplane model Type Certificate.

B. Location Zones

Zone	Area
100	Lower Half of Fuselage

EFFECTIVITY
AKS ALL

53-00-00

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(Continued)

Zone	Area
200	Upper Half of Fuselage
500	Left Wing
600	Right Wing

C. Critical Design Configuration Control Limitations (CDCCLs)

SUBTASK 53-00-00-910-001

WARNING: OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO MAINTENANCE THAT HAS AN EFFECT ON A CDCCL. IF YOU DO NOT OBEY THE PROCEDURES, IT CAN INCREASE THE RISK OF A SOURCE OF FUEL TANK IGNITION. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR IF THERE IS A FIRE OR EXPLOSION.

- (1) Make sure you follow the procedures for items identified as CDCCLs.

D. Airworthiness Limitation Instructions (ALIs)

SUBTASK 53-00-00-910-002

WARNING: OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO ANY MAINTENANCE THAT MAY AFFECT AN ALI. IF YOU DO NOT FOLLOW THE PROCEDURES, IT CAN INCREASE THE RISK OF A FUEL TANK IGNITION SOURCE.

- (1) Make sure you follow the procedures for items identified as ALIs.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-00-00

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FUSELAGE - CORROSION PREVENTION

1. General

Refer to the applicable section in the Table 201 for corrosion prevention instructions for the different areas of the fuselage.

Table 201/53-00-37-993-801 Specific Corrosion Problems - Fuselage

AREA	PROBLEM	INDEX
Crown Frames, Stringers and Skin	Corrosion of frames, stringers and interior skin surfaces.	53-11-37
Lower Lobe Structure	Corrosion of frames, stringers and interior skin surfaces. Corrosion of lower lobe doublers and lower lobe skins between BS 360 to 540 and BS 727 to 1016.	53-11-37
Galleys and Lavatories	Corrosion of structure under galleys and lavatories due to spillage. Corrosion of partition support on cabin floor between BS 1006 and 1030 because of soaked foam dams.	53-11-37 53-11-37
Main Wheel Well and Keel Beam	Corrosion on surfaces inside wheel well because of air contaminants and runway splash. Stress corrosion on inboard lug of main landing gear trunnion support beam and the BS 706 frame lug. Stress corrosion cracks on horizontal integral ribs on BS 685 and 706 frames. Stress corrosion cracks in keel beam lower tee chords. Stress corrosion of keel beam inboard splice tees.	53-11-37
Nose Gear Wheel Well	Corrosion on the surfaces inside the wheel well because of air contaminants and runway splash. Stress corrosion on lock support fittings. Stress corrosion cracking of the actuator support fittings.	53-11-37
Doorway Openings	Corrosion of the exterior surfaces. Corrosion on the structure around door openings.	53-11-37
Aft Pressure Bulkhead	Stress corrosion of aft airstair door stop fittings. Corrosion on the aft face of the bulkhead.	53-11-37
Upper Lobe Frames, Stringers and Skin	Corrosion on the lower 10 inches of the forward face of the bulkhead because of clogged drain hole. Cracks from fastener holes on Stringer 17 left and right.	53-11-37
Wing-To-Body Fairing Cavity	Broken attach bolt on BS 1088 bulkhead Pillow blankets that trapped moisture. Corrosion on the door and door hinge. Corrosion of the under fairing skin.	53-51-37

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FUSELAGE FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

TASK 53-05-02-250-801

1. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

SUBTASK 53-05-02-250-001

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 259.5 to STA 360.

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

———— END OF TASK ————

TASK 53-05-02-250-803

2. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

SUBTASK 53-05-02-250-003

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 259.5 to STA 360.

See Doc. D626A001-DTR, DTR check form 53-10-03-2, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

———— END OF TASK ————

TASK 53-05-02-250-805

3. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

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AKS ALL

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A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

SUBTASK 53-05-02-250-005

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringer S-14L (from STA 259.5 to STA 294.5, and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277, and from STA 344 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

————— END OF TASK ————

TASK 53-05-02-250-806

4. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

SUBTASK 53-05-02-250-006

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 259.5 to STA 294.5 and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277 and from STA 344 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

————— END OF TASK ————

TASK 53-05-02-210-839

5. INTERNAL - GENERAL VISUAL: LONGITUDINAL LAP SPLICE

A. Location Zones

Zone	Area
220	Subzone - Passenger Compartment - Body Station 259.50 to 360.00
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

SUBTASK 53-05-02-210-038

NOTE: Remove or displace interiors and insulation as required to perform this inspection.

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- (1) Do a General Visual inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 259.5 to STA 294.5 and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277 and from STA 344 to STA 360).

See Doc. D626A001-DTR, DTR check form 53-10-03-4 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-807

| 6. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Inspection

SUBTASK 53-05-02-250-007

- (1) Do a Low Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringer S-24L (from STA 259.5 to STA 334) and at stringer S-24R (from STA 259.5 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-5 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

———— END OF TASK ————

TASK 53-05-02-250-809

| 7. INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-009

- (1) Do a High Frequency Eddy Current inspection of the AB post structure, from inside the aircraft, from the upper to lower sills and the post flanges aft of fastener locations.

See Doc D626A001-DTR, DTR check form 53-10-04-1a for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-75.

———— END OF TASK ————

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TASK 53-05-02-211-802

| 8. **EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-211-002

- (1) Do a Detailed inspection of the CD post, from outside the aircraft, along the entire post length on both the left and right sides.

See Doc D626A001-DTR, DTR check form 53-10-04-2a for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-803

| 9. **EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-211-003

- (1) Do a Detailed inspection of the EF post, from outside the aircraft, along the entire post length on both the left and right sides.

See Doc D626A001-DTR, DTR check form 53-10-04-3 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-811

| 10. **EXTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-011

- (1) Do a Low Frequency Eddy Current inspection on both rows of fasteners attaching the skin to the BD Sill, from outside the aircraft, between LBL 8 and LBL 26.5. Repeat the process between RBL 8 and RBL 26.5.

See Doc D626A001-DTR, DTR check form 53-10-04-4a for alternative inspections.

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-76.

————— END OF TASK ————

TASK 53-05-02-250-812

| 11. **INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Remove glareshield as required to perform the inspection.

SUBTASK 53-05-02-250-012

- (1) Do a High Frequency Eddy Current inspection on the flanges of the Point D Fitting, from the CD post inboard to the second fastener common to the BD sill, on both the left and right sides. See Doc D626A001-DTR, DTR check form 53-10-04-5 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-72.

————— END OF TASK ————

TASK 53-05-02-250-813

| 12. **INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Remove glareshield if/as required to perform inspection.

There are three (3) fasteners that join the angle, web and fitting.

There are four (4) fasteners that join the angle and the fitting.

SUBTASK 53-05-02-250-013

- (1) Do a High Frequency Eddy Current inspection of the Inconel angle around the (7) fasteners that join the angle to the B-D Sill Web and Point "D" Fitting. See Doc D626A001-DTR, DTR check form 53-10-04-6 for alternative inspections. The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-71.

————— END OF TASK ————

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TASK 53-05-02-250-814

| 13. EXTERNAL - SPECIAL DETAILED: CROWN SKIN PANEL - FWD OF STA 259.5

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-014

- (1) Do a Low Frequency Eddy Current inspection of the subsurface of the first row of fasteners, on the left and right side, of BL 0.0 between the cab window cutout and STA 259.5 panel splice.
See Doc D626A001-DTR, DTR check form 53-10-05-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-804

| 14. EXTERNAL - DETAILED: CUTOUT - ELECTRONIC EQUIPMENT DOOR

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Inspection

SUBTASK 53-05-02-211-004

- (1) Do a Detailed inspection of the skin at the edge of the E/E door cutout and around the two rows of fasteners adjacent to the edge. Inspection is performed along the entire perimeter of the E/E door cutout and bounded by Sta 323.7 and Sta 351.2, and RBL 15.47 and LBL 6.74.
See Doc D626A001-DTR, DTR check form 53-10-13-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-816

| 15. EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

SUBTASK 53-05-02-250-016

- (1) Do a High Frequency Eddy Current inspection on the two rows of fasteners common to the forward edge frame and skin at STA 303.9 from stringers S-11L and S-12L.
See Doc. D626A001-DTR, DTR check form 53-10-14-4 for alternative inspections.



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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-89.

————— END OF TASK ————

TASK 53-05-02-250-817

| 16. **EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

SUBTASK 53-05-02-250-017

- (1) Do a High Frequency Eddy Current inspection around the two rows of fasteners common to the forward edge frame and skin at STA 303.9 from stringers S-7L to S-11L and stringers S-12L to S-13L.

See Doc. D626A001-DTR, DTR check form 53-10-14-5 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-89.

————— END OF TASK ————

TASK 53-05-02-211-805

| 17. **INTERNAL - DETAILED: FWD ENTRY DOOR, FWD EDGE FRAME STOPS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

NOTE: Remove interior panels as required to perform inspection.

SUBTASK 53-05-02-211-005

- (1) Do a Detailed inspection around the fasteners in the inboard flange of the stop fittings from stringer S-7 thru S-16.

See Doc. D626A001-DTR, DTR check form 53-10-14-7 for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-806

| 18. **INTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right



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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-120

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-211-006

- (2) Do a Detailed inspection of the upper sill inner chord. (PSE 53-30-08-11).

See Doc. D626A001-DTR, DTR check form 53-60-08-11, for alternative inspections.

SUBTASK 53-05-02-410-118

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-818

| 19. INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

NOTE: Remove interior panels as required to perform inspection.

SUBTASK 53-05-02-250-018

- (1) Do a High Frequency Eddy Current inspection around the four fasteners on each stop strap at stringer S-7 thru S-14.

See Doc. D626A001-DTR, DTR check form 53-10-14-8 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-01.

———— END OF TASK ————

TASK 53-05-02-250-819

| 20. INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

NOTE: Remove interior panels as required to perform inspection



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SUBTASK 53-05-02-250-019

- (1) Do a High Frequency Eddy Current inspection around the first two (2) fasteners in the necked down section of the stop straps at S-15 and S-16.

See Doc. D626A001-DTR, DTR check form 53-10-14-9 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-01.

— END OF TASK —

TASK 53-05-02-211-807

| 21. **INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS**

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. **Inspection**

SUBTASK 53-05-02-211-007

NOTE: Open FWD Entry Door. Removal of interior panel is required to perform the inspection.

- (1) Do a Detailed inspection of the S-15 and S-16 tension straps at the fastener holes on either side of Sta 351.2 frame.

See Doc. D626A001-DTR, DTR check form 53-10-14-10 for alternative inspections.

— END OF TASK —

TASK 53-05-02-211-808

| 22. **INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS**

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. **Inspection**

NOTE: Open FWD Entry Door. Removal of interior panel is required to perform the inspection.

SUBTASK 53-05-02-211-008

- (1) Do a Detailed inspection of the Aft frame stops at the inner flange holes near Sta 348.2 from stringer S-7 to S-14.

See Doc. D626A001-DTR, DTR check form 53-10-14-11 for alternative inspections.

— END OF TASK —

TASK 53-05-02-250-820

| 23. **INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR CUTOUT**

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
117	Electrical and Electronics Compartment - Left



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(Continued)

Zone Area

221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
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B. Inspection

NOTE: Removal of scuff plate is required to perform the inspection.

SUBTASK 53-05-02-250-020

- (1) Do a High Frequency Eddy Current inspection of the skin around the fastener holes and along the edge of the cutout hidden by the scuff plates from STA 303 to STA 350.

See Doc. D626A001-DTR, DTR check form 53-10-14-12 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-43.

———— END OF TASK ——

TASK 53-05-02-250-821

| 24. INTERNAL - SPECIAL DETAILED: FORWARD GALLEY DOOR SURROUND STRUCTURE DOOR STOP BACKUP STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
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B. Inspection

NOTE: Remove interior panels as required to perform inspection. Door stops are numbered from the bottom up.

SUBTASK 53-05-02-250-021

- (1) Do a High Frequency Eddy Current inspection of the four (4) fastener at each stop location common to the intercostal tension strap at the forward edge frame at stops #1, #2, #5, #6.

See Doc. D626A001-DTR, DTR check form 53-10-15-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-98.

———— END OF TASK ——

TASK 53-05-02-250-822

| 25. EXTERNAL - SPECIAL DETAILED: CUTOUT - FWD GALLEY DOOR

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
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B. Inspection

SUBTASK 53-05-02-250-022

- (1) Do a High Frequency Eddy Current inspection around fasteners common to the skin and chords between stringers S-8R and S-14R at the forward and aft edge frames at STA 291.5 and STA 328.5.

See Doc. D626A001-DTR, DTR check form 53-10-15-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-55.

———— END OF TASK ————

TASK 53-05-02-250-823

| 26. INTERNAL - SPECIAL DETAILED: BULKHEAD, STA 294.5

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

C. Inspection

SUBTASK 53-05-02-010-046

- (1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Access through E/E Bay Aft of Nose Wheel Well.

SUBTASK 53-05-02-250-023

- (2) Do a High Frequency Eddy Current inspection around the fasteners in the WL 172 beam just outboard of LBL 17 and RBL 17 at the nose wheel well Aft bulkhead.

See Doc. D626A001-DTR, DTR check form 53-10-18-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-99.

SUBTASK 53-05-02-410-044

- (3) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

———— END OF TASK ————

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TASK 53-05-02-211-809

| 27. **INTERNAL - DETAILED: NOSE WHEEL WELL SIDE AND TOP PANELS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

C. Inspection

SUBTASK 53-05-02-010-014

- (1) Open this access panel on the Left side:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel

Open this access panel on the Right side:

Number	Name/Location
114BW	Forward Nose Wheel Well Panel

NOTE: Access through Left Aft Nose Wheel Well Panel.

Access through Right Aft Nose Wheel Well Panel.

SUBTASK 53-05-02-211-009

- (2) Do a Detailed inspection of the Aft access cutout forward vertical beam at Sta 260, from WL 170 to WL 184.

See Doc. D626A001-DTR, DTR check form 53-10-19-4, for alternative inspections.

SUBTASK 53-05-02-410-012

- (3) Close this access panel on the Left side:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel

Close this access panel on the Right side:

Number	Name/Location
114BW	Forward Nose Wheel Well Panel

———— END OF TASK ————

TASK 53-05-02-211-810

| 28. **INTERNAL - DETAILED: NOSE LANDING GEAR SUPPORT FITTINGS**

NOTE: This procedure is a scheduled maintenance task.



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A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

C. Inspection

SUBTASK 53-05-02-010-015

- (1) Open these access panels on the Left side:

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel

Open these access panels on the Right side:

Number	Name/Location
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

NOTE: For Direction 1, removal of Drag Brace is required.

SUBTASK 53-05-02-211-010

- (2) Do a Detailed inspection of the inboard and outboard drag brace fittings around the perimeter of the bushings at Sta 262, BL 16, WL 189.3.

See Doc. D626A001-DTR, DTR check form 53-10-20-2 for alternative inspections.

SUBTASK 53-05-02-410-013

- (3) Close these access panels on the Left side:

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel

Close these access panels on the Right side:

Number	Name/Location
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

———— END OF TASK ————

TASK 53-05-02-211-811

| 29. INTERNAL - DETAILED: NOSE LANDING GEAR TRUNNION SUPPORT FITTING

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

C. Inspection

SUBTASK 53-05-02-010-016

- (1) Open these access panels on the Left side:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

Open these access panels on the Right side:

Number	Name/Location
114BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

SUBTASK 53-05-02-211-011

- (2) Do a Detailed inspection of the inboard and outboard fitting segments of the Trunnion Support Fitting around the pin socket at BS 294.5, WL 156.1, and BL 16.

See Doc. D626A001-DTR, DTR check form 53-10-20-3 for alternative inspections.

SUBTASK 53-05-02-410-014

- (3) Close these access panels on the Left side:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

Close these access panels on the Right side:

Number	Name/Location
114BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

— END OF TASK —

TASK 53-05-02-211-812

| 30. INTERNAL - DETAILED: AIR STAIR DOOR CUTOUT

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left



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B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

C. Inspection

SUBTASK 53-05-02-010-017

- (1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Opening of Air Stair Door is required to perform this inspection.

SUBTASK 53-05-02-211-012

- (2) Do a Detailed inspection of the upper and lower outer sill chords from Sta 303.8 to Sta 348.
See Doc. D626A001-DTR, DTR check form 53-10-21-1 for alternative inspections.

SUBTASK 53-05-02-410-015

- (3) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

———— END OF TASK ————

TASK 53-05-02-210-840

31. EXTERNAL - GENERAL VISUAL: AIR STAIR DOOR CUTOUT

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

B. Inspection

SUBTASK 53-05-02-210-039

- (1) Do a General Visual inspection of the skin around three rows of fasteners above and blow the air stair door cutout from STA 303.8 to STA 348.
See Doc. D626A001-DTR, DTR check form 53-10-21-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-824

32. INTERNAL - SPECIAL DETAILED: AIR STAIR DOOR CUTOUT

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door
117BL	Forward Airstair Door



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C. Inspection

SUBTASK 53-05-02-010-175

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
117BL	Forward Airstair Door

NOTE: Opening of Air Stair Door is required to perform this inspection.

SUBTASK 53-05-02-250-024

- (2) Do a Low Frequency Eddy Current inspection of the forward and aft edge frame webs around the fasteners common to the corner clips at STA 303.9 and STA 351.2.

See Doc. D626A001-DTR, DTR check form 53-10-21-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-27.

SUBTASK 53-05-02-410-166

- (3) Close these doors:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
117BL	Forward Airstair Door

———— END OF TASK ————

TASK 53-05-02-210-841

33. INTERNAL - GENERAL VISUAL: AIR STAIR DOOR CUTOUT

A. Location Zones

<u>Zone</u>	<u>Area</u>
117	Electrical and Electronics Compartment - Left

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
117BL	Forward Airstair Door

C. Inspection

SUBTASK 53-05-02-210-040

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
117BL	Forward Airstair Door

SUBTASK 53-05-02-210-041

NOTE: Pulling back of insulation and plastic covering from EE Bay are required.

- (2) Do a General Visual inspection of the AFT frame inner chord flange at STA 303.9 and STA 351.2.

See Doc. D626A001-DTR, DTR check form 53-10-21-4 for alternative inspections.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-211-813

| **34. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540**

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. Inspection

SUBTASK 53-05-02-211-013

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from Sta 360 to Sta 540, except at the lap splices and antennas.

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-814

| **35. INTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540**

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. Inspection

NOTE: Removal of external antenna fairings and base plates are required.

SUBTASK 53-05-02-211-014

- (1) Do a Detailed inspection of the exterior surface of the skin under the TCAS Antenna at Sta 385, the ATC Antenna at Sta 430, and the GPS Antenna at Sta 500A.

See Doc D626A001-DTR, DTR check form 53-30-01-4 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-815

| **36. INTERNAL - DETAILED: SATCOM AERO-H ANTENNA INSTALLATION**

NOTE: This procedure is a scheduled maintenance task.

A. General

B. 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

C. Inspection

NOTE: Removal of antenna is required.



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SUBTASK 53-05-02-211-015

- (1) Do a Detailed inspection of the skin near the fastener locations around the antenna cutout, stringers, and antenna nutplates on both the left and right sides of the aircraft at Sta 500 between stringers S-6 and S-7.

See Doc D626A001-DTR, DTR check form 53-30-01-5 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-210-801

| 37. **EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right
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. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

C. Inspection

SUBTASK 53-05-02-010-009

- (1) Open these access panels on the Left side:

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side
195BL	Wing To Body Fairing - Left Side
195CL	Wing To Body Fairing - Left Side

Open these access panels on the Right side:

Number	Name/Location
191AR	Forward Wing To Body Fairing Panel - Upper
195AR	Wing To Body Fairing - Right Side
195BR	Wing To Body Fairing - Right Side
195CR	Wing To Body Fairings - Right Side

NOTE: Remove or displace aft wing to body fairings as required.



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SUBTASK 53-05-02-210-001

- (2) Do a General Visual inspection of the skin from Sta 360 to Sta 540 between stringers S-14 to S-17.

See Doc D626A001-DTR, DTR check form 53-30-02-1 for alternative inspections.

SUBTASK 53-05-02-410-007

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side
195BL	Wing To Body Fairing - Left Side
195CL	Wing To Body Fairing - Left Side

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
191AR	Forward Wing To Body Fairing Panel - Upper
195AR	Wing To Body Fairing - Right Side
195BR	Wing To Body Fairing - Right Side
195CR	Wing To Body Fairings - Right Side

———— END OF TASK ————

TASK 53-05-02-211-816

| 38. EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
191	Lower Wing-To-Body Fairing - Forward of Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side

C. Inspection

SUBTASK 53-05-02-010-018

- (1) Open this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
191AR	Forward Wing To Body Fairing Panel - Upper
195AR	Wing To Body Fairing - Right Side

EFFECTIVITY
AKS ALL

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NOTE: Remove or displace wing to body fairings as required to perform this inspection.

SUBTASK 53-05-02-211-016

- (2) Do a Detailed inspection of the fuselage skin panels under the Wing to Body Fairing from Sta 360 to Sta 540.

See Doc D626A001-DTR, DTR check form 53-30-02-4 for alternative inspections.

SUBTASK 53-05-02-410-016

- (3) Close these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
195AL	Wing To Body Fairing - Left Side

Close these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
195AR	Wing To Body Fairing - Right Side

———— END OF TASK ————

TASK 53-05-02-250-826

| 39. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC

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. Inspection

SUBTASK 53-05-02-250-026

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 360 to STA 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

———— END OF TASK ————

TASK 53-05-02-250-828

| 40. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE

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



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B. Inspection

SUBTASK 53-05-02-250-028

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 360 to STA 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-3, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

————— END OF TASK ————

TASK 53-05-02-211-817

| 41. INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE

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. Inspection

NOTE: Removal or displacement of interior sidewall panels and insulation blankets are required.

SUBTASK 53-05-02-211-017

- (1) Do a Detailed inspection of the lower skin along the lower fastener row at stringers S-10L and S-10R from Sta 360 to Sta 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-4, for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-819

| 42. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE

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. Inspection

SUBTASK 53-05-02-211-019

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringers S-14L and S-14R from Sta 360 to Sta 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-5, for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-250-830

| 43. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.



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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. Inspection

SUBTASK 53-05-02-250-030

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-14L and S-14R from STA 360 to STA 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-6, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

———— END OF TASK ————

TASK 53-05-02-250-832

| 44. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Remove Wing to Body Fairing as required to perform this inspection.

SUBTASK 53-05-02-250-032

- (1) Do a Low Frequency Eddy Current inspection of the upper (inner) skin along the upper fastener row at stringers S-24L and S-24R from STA 360 to STA 540, except at the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-30-04-7, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

———— END OF TASK ————

TASK 53-05-02-211-821

| 45. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

EFFECTIVITY
AKS ALL

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Zone	Area
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Remove Wing to Body Fairing as required to perform this inspection.

SUBTASK 53-05-02-211-021

- (1) Do a Detailed inspection of the lower (outer) skin along the lower fastener row at stringers S-24L and S-24R from Sta 360 to Sta 540, except at the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-30-04-8, for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-833

| 46. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT STA 440 AND 492.4

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-048

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

NOTE: Perform inspection with door open. Remove or displace cargo liners as required to perform this inspection.

SUBTASK 53-05-02-250-033

- (2) Do a High Frequency Eddy Current inspection of the outboard portion of the frame web for damage between stringers S-17R and S-26R, except at the door stops and sill locations.

See Doc D626A001-DTR, DTR check form 53-30-08-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-23.



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SUBTASK 53-05-02-410-046

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-130-801

| 47. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT STA 440 AND 492.4**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-003

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

NOTE: Perform inspection with door open. Remove or displace cargo liners as required.

SUBTASK 53-05-02-130-001

- (2) Do an Ultrasonic inspection of the outboard portion of the frame web for damage under all door stop fittings and sill clips

See Doc D626A001-DTR, DTR check form 53-30-08-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 53-10-06.

SUBTASK 53-05-02-410-001

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-834

| 48. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right



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Zone Area

124 Forward Cargo Compartment - Right

B. Access Panels

Number Name/Location

821 Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-049

- (1) Open this access panel:

Number Name/Location

821 Forward Cargo Door

NOTE: Perform inspection with door open. Remove sealer at door stops as required.

SUBTASK 53-05-02-250-034

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chords between stringers S-18R and S-26R.

See Doc D626A001-DTR, DTR check form 53-30-08-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-90.

SUBTASK 53-05-02-410-047

- (3) Close this access panel:

Number Name/Location

821 Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-835

| 49. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

122 Forward Cargo Compartment - Right

B. Access Panels

Number Name/Location

821 Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-050

- (1) Open this access panel:

Number Name/Location

821 Forward Cargo Door

NOTE: Remove cargo liners as required to perform the inspection.



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SUBTASK 53-05-02-250-035

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chords between stringers S-17R and S-18R.

See Doc D626A001-DTR, DTR check form 53-30-08-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-87.

SUBTASK 53-05-02-410-048

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-836

| 50. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-051

- (1) Open this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

NOTE: Remove cargo liners as required to perform the inspection.

SUBTASK 53-05-02-250-036

- (2) Do a Low Frequency Eddy Current inspection of the forward and aft edge frame inner chords at stringer S-18R.

See Doc D626A001-DTR, DTR check form 53-30-08-5 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-80.

SUBTASK 53-05-02-410-049

- (3) Close this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-250-837

| 51. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-052

- (1) Open this access door:

Number	Name/Location
821	Forward Cargo Door

SUBTASK 53-05-02-250-037

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for two inches on each side of stringer S-24R at STA 440 and STA 492.4.

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-91.

SUBTASK 53-05-02-410-050

- (3) Close this access door:

Number	Name/Location
821	Forward Cargo Door

— END OF TASK —

TASK 53-05-02-130-802

| 52. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door



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C. Inspection

SUBTASK 53-05-02-010-004

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-130-002

- (2) Do an Ultrasonic inspection of the bearstrap for hidden damage under the stop backup fitting at stringer S-24R at Sta 440 and Sta 492.4.

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 53-10-07.

SUBTASK 53-05-02-410-002

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-838

| 53. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-053

- (1) Open this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-038

- (2) Do a High Frequency Eddy Current inspection of the outer chord around the fasteners common to the chord and bearstrap.

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-48.



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SUBTASK 53-05-02-410-051

- (3) Close this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-839

| 54. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-054

- (1) Open this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-039

- (2) Do a High Frequency Eddy Current inspection of the bearstrap along the upper edge of the forward cargo door.

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-48.

SUBTASK 53-05-02-410-052

- (3) Close this access door:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-840

| 55. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right



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B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-055

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

NOTE: Removal of forward cargo door scuff plate is required to perform this inspection.

SUBTASK 53-05-02-250-040

- (2) Do a Low Frequency Eddy Current inspection around the fasteners common to the web at the lower main sill chords between STA 421 and 438 (for -600) and STA 461 and STA 478 (for -700/-800).

See Doc. D626A001-DTR, DTR check form 53-30-08-12, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-33.

SUBTASK 53-05-02-410-053

- (3) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

— END OF TASK —

TASK 53-05-02-250-841

| 56. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-056

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

NOTE: Remove cargo liners as required

SUBTASK 53-05-02-250-041

- (2) Do a High Frequency Eddy Current inspection of the intercostal web for cracks adjacent to rivets and fastener holes (five locations at the forward and aft edge frames) common to the backup fitting and intercostal.



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See Doc D626A001-DTR, DTR check form 53-30-09-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-11-02.

SUBTASK 53-05-02-410-054

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-842

| 57. **INTERNAL - SPECIAL DETAILED: WING TO BODY LOWER DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

C. Inspection

SUBTASK 53-05-02-010-057

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

SUBTASK 53-05-02-010-058

- (2) Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

NOTE: Removal of wing to body fairings is required.

SUBTASK 53-05-02-250-042

- (3) Do a High Frequency Eddy Current inspection around all fasteners in the angle (9 inches forward and 12 inches aft) of the wing to body intersection (STA 536) between STA 518 to STA 555, above stringer 24.

EFFECTIVITY
AKS ALL

D633A101-AKS

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See Doc D626A001-DTR, DTR check form 53-30-11-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-47.

SUBTASK 53-05-02-410-055

- (4) Close these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

SUBTASK 53-05-02-410-056

- (5) Close these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

———— END OF TASK ————

TASK 53-05-02-250-843

| 58. **INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

C. Inspection

SUBTASK 53-05-02-010-059

- (1) Open these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

EFFECTIVITY
AKS ALL

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Open these access panels on the Right side:

Number Name/Location

- | | |
|-------|---|
| 191AR | Forward Wing To Body Fairing Panel - Upper |
| 191FR | Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet |

NOTE: Removal of wing to body fairings, duct located aft of STA 536 and sealant along edge of angle to body contour and lower wing skin is required.

SUBTASK 53-05-02-250-043

- (2) Do a High Frequency Eddy Current inspection, eight inches FWD and AFT of STA 536 along the edge of the inboard angle adjacent to the fuselage (FWD of STA 536) and the lower wing skin (AFT of STA 536).

See Doc D626A001-DTR, DTR check form 53-30-11-02 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-47.

SUBTASK 53-05-02-410-058

- (3) Close these access panels on the Left side:

Number Name/Location

- | | |
|-------|---|
| 191AL | Forward Wing To Body Fairing Panel - Upper |
| 191FL | Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet |

Close these access panels on the Right side:

Number Name/Location

- | | |
|-------|---|
| 191AR | Forward Wing To Body Fairing Panel - Upper |
| 191FR | Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet |

———— END OF TASK ————

TASK 53-05-02-250-844

| 59. INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

EFFECTIVITY
AKS ALL

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C. Inspection

SUBTASK 53-05-02-010-061

- (1) Open these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

Open these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

NOTE: Removal of wing to body fairings, duct located aft of STA 536 and sealant along edge of angle to body contour and lower wing skin is required.

SUBTASK 53-05-02-250-044

- (2) Do a High Frequency Eddy Current inspection, eight inches FWD and AFT of STA 536 along the inboard angle at the angle to fuselage interface (FWD of STA 536) and the angle to lower wing skin interface (AFT of STA 536).

See Doc D626A001-DTR, DTR check form 53-30-11-02 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-47.

SUBTASK 53-05-02-410-059

- (3) Close these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

Close these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

———— END OF TASK ————

TASK 53-05-02-250-845

| 60. INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right

EFFECTIVITY AKS ALL

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(Continued)

Zone Area

191	Lower Wing-To-Body Fairing - Forward of Wing Box
-----	--

B. Access Panels

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

C. Inspection

SUBTASK 53-05-02-010-064

- (1) Open these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

Open these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

NOTE: Removal of wing to body fairings and duct located aft of STA 536 is required.

SUBTASK 53-05-02-250-045

- (2) Do a High Frequency Eddy Current inspection around the fasteners in the inboard and outboard angles eight inches forward and aft of STA 536.

See Doc. D626A001-DTR, DTR check form 53-30-11-03, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-47.

SUBTASK 53-05-02-410-061

- (3) Close these access panels on the Left side:

Number Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

SUBTASK 53-05-02-410-062

- (4) Close these access panels on the Right side:

Number Name/Location

191AR	Forward Wing To Body Fairing Panel - Upper
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

———— END OF TASK ————



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TASK 53-05-02-250-847

| **61. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE**

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-047

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 540 to STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-03-3, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-41.

———— END OF TASK ————

TASK 53-05-02-211-822

| **62. INTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727**

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls and insulation blankets is required.

SUBTASK 53-05-02-211-022

- (1) Do a Detailed inspection of the stringers S-11 and S-13 from STA 540 to 727.

See Doc. D626A001-DTR, DTR check form 53-40-04-1, for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-823

| **63. EXTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727**

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

EFFECTIVITY
AKS ALL

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Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-023

- (1) Do a Detailed inspection of the skin from stringers S-11 to S-13 between the windows from STA 540 to STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-04-2 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-211-824

| 64. INTERNAL - DETAILED: STRINGER SPLICE, STA 663

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall panels and insulation blankets.

SUBTASK 53-05-02-211-024

- (1) Do a Detailed inspection of the stringers S-11 to S-13 at a distance of 10 inches forward and aft of STA 663.

See Doc. D626A001-DTR, DTR check form 53-40-07-2 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-211-825

| 65. INTERNAL - DETAILED: KEEL BEAM CHORDS, STIFFENERS AND SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well

B. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door



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C. Inspection

SUBTASK 53-05-02-010-019

- (1) Open this access panel on the Left side:

Number Name/Location

192CL ECS Access Door

Open this access panel on the Right side:

Number Name/Location

192CR ECS Access Door

SUBTASK 53-05-02-211-025

- (2) Do a Detailed inspection of the keel beam side panel webs from STA 540 to STA 663.

See Doc. D626A001-DTR, DTR check form 53-40-08-1 for alternative inspections.

SUBTASK 53-05-02-410-017

- (3) Close this access panel on the Left side:

Number Name/Location

192CL ECS Access Door

Close this access panel on the Right side:

Number Name/Location

192CR ECS Access Door

———— END OF TASK ————

TASK 53-05-02-250-848

| 66. **INTERNAL - SPECIAL DETAILED: STIFFENER ATTACHMENT TO FLOOR BEAM, STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

B. Inspection

NOTE: Removal and/or displacement of aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-048

- (1) Do a High Frequency Eddy Current inspection of the fastener row connecting the pressure bulkhead stiffener to the stiffener attachment fitting that joins the stiffener to the floor beam (at five locations) around the fastener/collar on the outboard side at LBL and RBL 45 and WL 202.6.

See Doc. D626A001-DTR, DTR check form 53-40-10-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-849

| 67. **INTERNAL - SPECIAL DETAILED: STRINGER 18 STRAP SIDE OF BODY**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

C. Inspection

SUBTASK 53-05-02-010-137

- (1) Open this access panel on the Left side:

Number	Name/Location
195CL	Wing To Body Fairing - Left Side

Open this access panel on the Right side:

Number	Name/Location
195CR	Wing To Body Fairings - Right Side

SUBTASK 53-05-02-250-049

- (2) Do a Low Frequency Eddy Current inspection of the skin under the strap at stringer S-18 between the fasteners common to the strap and skin from STA 717 to STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-11-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-49.

SUBTASK 53-05-02-410-127

- (3) Close this access panel on the Left side:

Number	Name/Location
195CL	Wing To Body Fairing - Left Side

Close this access panel on the Right side:

Number	Name/Location
195CR	Wing To Body Fairings - Right Side

— END OF TASK —

TASK 53-05-02-250-850

| 68. **INTERNAL - SPECIAL DETAILED: STRINGER 18A CHORD AND LINKS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
142	Aft Cargo Compartment - Right

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B. Inspection

SUBTASK 53-05-02-250-050

- (1) Do a High Frequency Eddy Current inspection around the bushings on each lug, three lugs per assembly, on the upper and lower surface at STA 663.

See Doc. D626A001-DTR, DTR check form 53-40-12-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-30.

————— END OF TASK ————

TASK 53-05-02-250-851

| 69. INTERNAL - SPECIAL DETAILED: FRAME SPLICE AT STA 540

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. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required.

SUBTASK 53-05-02-250-051

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at all fasteners common to the inner chord and to the inner splice plate between stringers S-8 and S-9.

See Doc. D626A001-DTR, DTR check form 53-40-14-1 for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-826

| 70. EXTERNAL - DETAILED: BS 540 BULKHEAD

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. Inspection

SUBTASK 53-05-02-211-026

- (1) Do a Detailed inspection of the skin panels at the outer chord from stringers S-9L to S-9R, on each side of splice 540, for cracks at the frame to skin fastener holes.

See Doc. D626A001-DTR, DTR check form 53-40-14-4 for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-827

| 71. EXTERNAL - DETAILED: BS 663 BULKHEAD

NOTE: This procedure is a scheduled maintenance task.



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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. Inspection

SUBTASK 53-05-02-211-027

- (1) Do a Detailed inspection of the skin on each side of STA 663, from stringers S-8 to S-11, on both the left and right sides.

See Doc. D626A001-DTR, DTR check form 53-40-15-1 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-852

| 72. INTERNAL - SPECIAL DETAILED: BS 663 BULKHEAD

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. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required.

SUBTASK 53-05-02-250-052

- (1) Do a High Frequency Eddy Current inspection of the bulkhead inner chord from stringers S-10 and S-17 on both the left and right hand sides.

See Doc. D626A001-DTR, DTR check form 53-40-15-3 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-211-828

| 73. INTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-142

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-211-028

- (2) Do a Detailed inspection of the upper sill inner chord.

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See Doc. D626A001-DTR, DTR check form 53-60-08-11, for alternative inspections.

SUBTASK 53-05-02-410-134

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-853

| 74. **INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-053

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at STA 727 between stringers S-17 and S-21 on both the left and right hand sides.

See Doc. D626A001-DTR, DTR check form 53-40-16-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-25.

———— END OF TASK ————

TASK 53-05-02-250-854

| 75. **INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-054

- (1) Do a High Frequency Eddy Current inspection of the fail safe angle from inside the aft cargo bay at frame 727, from stringers S-21L to S-27L and stringers S-21R to S-27R.

See Doc. D626A001-DTR, DTR check form 53-40-16-1a for alternative inspections.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-130-804

| 76. **INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required.

SUBTASK 53-05-02-130-004

- (1) Do an Ultrasonic inspection of the six fasteners through the inner chord and web at STA 727 and WL 201.

See Doc. D626A001-DTR, DTR check form 53-40-16-2a for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 53-10-09.

———— END OF TASK ————

TASK 53-05-02-211-830

| 77. **INTERNAL - DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB, STA 727**

A. Inspection

SUBTASK 53-05-02-211-030

- (1) Do the inspection.

———— END OF TASK ————

TASK 53-05-02-211-832

| 78. **INTERNAL - DETAILED: AFT WHEEL WELL BULKHEAD AND PRESSURE WEB, STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

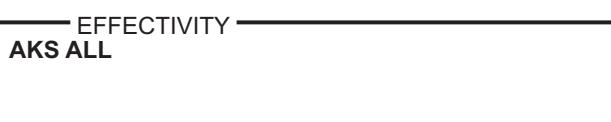
NOTE: Remove and/or displace passenger cabin ceiling panels and insulation as required to perform the inspection.

SUBTASK 53-05-02-211-032

- (1) Do a Detailed inspection of the frame inner chord and web between stringers S-9L and S-9R at STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-16-5 for alternative inspections.

———— END OF TASK ————



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TASK 53-05-02-250-855

| 79. **INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD FRAME, STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin ceiling panels and insulation as required to perform the inspection.

SUBTASK 53-05-02-250-055

- (1) Do a High Frequency Eddy Current inspection of the visible portion of the frame web above the splice angle on the forward side of the frame between stringers S-9 and S-10 on both sides of the aircraft at STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-16-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-92.

————— END OF TASK ————

TASK 53-05-02-250-856

| 80. **INTERNAL - SPECIAL DETAILED: SIDE STRUT SUPPORT FRAME, STA 706**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-056

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord and fail-safe angle (around the fasteners common to the fail-safe angle), the forward frame web (around the fasteners common to the fail-safe angle), and the frame outer chord (around the fasteners common to the skin) between stringers S-10 and S-13.

See Doc. D626A001-DTR, DTR check form 53-40-17-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-19.

————— END OF TASK ————

TASK 53-05-02-210-802

| 81. **INTERNAL - GENERAL VISUAL: MAIN LANDING GEAR SUPPORT FRAME, STA 695**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

NOTE: Remove or displace passenger cabin sidewall air grilles, floor panels and insulation blankets as required.

SUBTASK 53-05-02-210-002

- (1) Do a General Visual inspection of the upper fastener through the web.

See Doc. D626A001-DTR, DTR check form 53-40-18-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-857

| 82. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall panels, sidewall air grilles, and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-057

- (1) Do a High Frequency Eddy Current inspection of the frame web around the fasteners common to the stringer clip at stringer S-16 and the forward and aft flanges of the frame inner chord from 6 inches above and below stringer S-16.

See Doc. D626A001-DTR, DTR check form 53-40-19-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-40-05.

———— END OF TASK ————

TASK 53-05-02-250-858

| 83. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

EFFECTIVITY AKS ALL

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Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall air grilles, floor panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-058

- (1) Do a High Frequency Eddy Current inspection of the stub beam upper chord around the two fasteners common to the crease beam inner chord.

See Doc. D626A001-DTR, DTR check form 53-40-19-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-14.

———— END OF TASK ——

TASK 53-05-02-250-859

| 84. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall air grilles, floor panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-059

- (1) Do a High Frequency Eddy Current inspection on the web of the stub beam around the fasteners common to the floor clip.

See Doc. D626A001-DTR, DTR check form 53-40-19-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-09.

———— END OF TASK ——

TASK 53-05-02-250-860

| 85. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left

EFFECTIVITY
AKS ALL

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Zone	Area
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall air grilles, floor panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-060

- (1) Do a High Frequency Eddy Current inspection on the upper side of the upper flange on both the forward and aft sides from BL 45.5 to BL 64.6 on both the right and left sides.

See Doc. D626A001-DTR, DTR check form 53-40-19-3a for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-09.

———— END OF TASK ————

TASK 53-05-02-211-833

| 86. INTERNAL - DETAILED: WHEEL WELL FRAME, STA 685

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls, sidewall air grilles, and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-211-033

- (1) Do a Detailed inspection of the frame inner chord from stringers S-13 to S-15.

See Doc. D626A001-DTR, DTR check form 53-40-21-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-861

| 87. INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME, STA 685

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

EFFECTIVITY
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B. Inspection

SUBTASK 53-05-02-250-061

NOTE: Remove and/or displace passenger cabin sidewalls, sidewall air grilles, and insulation blankets as required to perform the inspection.

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord flange and around accessible fasteners common to the inner chord and stringer clips from stringers S-17 to S-14. See Doc. D626A001-DTR, DTR check form 53-40-21-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-17.

———— END OF TASK ————

TASK 53-05-02-250-862

| 88. INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME AT STA 685

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - 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

B. Inspection

SUBTASK 53-05-02-250-062

NOTE: Remove and/or displace passenger cabin floor panels as required to perform the inspection.

- (1) Do a High Frequency Eddy Current inspection of the stub beam upper chord from two inches inside the skin to a distance of twelve inches inboard and around any fasteners through the upper web and chord in this area.

See Doc. D626A001-DTR, DTR check form 53-40-21-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-06.

———— END OF TASK ————

TASK 53-05-02-250-867

| 89. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
832	Left Forward Emergency Exit
842	Right Forward Emergency Exit



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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit
842	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-080

- (1) Open this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit

Open this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
842	Emergency Exit

SUBTASK 53-05-02-250-067

- (2) Do a Low Frequency Eddy Current inspection of the doublers around the fasteners common to the STA 578 cutout forward edge frame outer chord from stringers S-10 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections. NOTE:

NOTE: This inspection must be work in conjunction with either fatigue task 53-682-01 or 53-682-03 to meet DTR requirements.

SUBTASK 53-05-02-410-078

- (3) Close this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit

Close this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
842	Emergency Exit

————— END OF TASK ————

TASK 53-05-02-250-868

| 90. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
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. Access Panels

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit
842	Emergency Exit



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C. Inspection

SUBTASK 53-05-02-010-081

- (1) Open this access panel on the Left side:

Number Name/Location

832 Emergency Exit

Open this access panel on the Right side:

Number Name/Location

842 Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection.

SUBTASK 53-05-02-250-068

- (2) Do a High Frequency Eddy Current inspection on the edges of the doublers from stringers S-11 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-15.

NOTE: This inspection may be optional. See DTR 53-40-22-3 for inspection requirements.

SUBTASK 53-05-02-410-079

- (3) Close this access panel on the Left side:

Number Name/Location

832 Emergency Exit

Close this access panel on the Right side:

Number Name/Location

842 Emergency Exit

———— END OF TASK ————

TASK 53-05-02-250-869

| 91. **INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD**

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. Access Panels

Number Name/Location

832 Emergency Exit

842 Emergency Exit



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C. Inspection

SUBTASK 53-05-02-010-082

- (1) Open this access panel on the Left side:

Number Name/Location

832 Emergency Exit

Open this access panel on the Right side:

Number Name/Location

842 Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection. Seal removal or displacement is required to perform the inspection.

SUBTASK 53-05-02-250-069

- (2) Do a High Frequency Eddy Current inspection of the inner doubler from stringers S-11 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-15.

NOTE: This inspection may be optional. See DTR 53-40-22-3 for inspection requirements.

SUBTASK 53-05-02-410-080

- (3) Close this access panel on the Left side:

Number Name/Location

832 Emergency Exit

Close this access panel on the Right side:

Number Name/Location

842 Emergency Exit

———— END OF TASK ————

TASK 53-05-02-250-874

| 92. **INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS**

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. Access Panels

Number Name/Location

832 Emergency Exit
833 Emergency Exit
842 Emergency Exit
843 Emergency Exit



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C. Inspection

SUBTASK 53-05-02-010-085

- (1) Open these access panels on the Left side:

Number Name/Location

832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number Name/Location

842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform the inspection.

SUBTASK 53-05-02-250-074

- (2) Do a High Frequency Eddy Current inspection on the edges of the doublers, on the upper edge, at stringer S-11(from STA 578 to STA 601 and from STA 616 to STA 639).

See Doc. D626A001-DTR, DTR check form 53-40-22-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-15.

NOTE: Doors with external doublers at the upper forward corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-083

- (3) Close these access panels on the Left side:

Number Name/Location

832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number Name/Location

842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

TASK 53-05-02-250-875

| 93. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS

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. Access Panels

Number Name/Location

832	Emergency Exit
833	Emergency Exit



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(Continued)

<u>Number</u>	<u>Name/Location</u>
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-087

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit
833	Emergency Exit

Open this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform this inspection. Remove or displace passenger cabin sidewall lining if/as required to perform this inspection.

SUBTASK 53-05-02-250-075

- (2) Do a High Frequency Eddy Current inspection of the inner doubler between the seal retainer and the frames and sills, on the upper edge, at stringer S-11 (from STA 578 to STA 601 and from STA 616 to STA 639).

See Doc. D626A001-DTR, DTR check form 53-40-22-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-15.

NOTE: Doors with external doublers at the upper forward corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-085

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

TASK 53-05-02-130-805

| 94. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left

EFFECTIVITY
AKS ALL

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(Continued)

Zone Area

232 Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right

B. Access Panels

Number Name/Location

832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-005

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform the inspection. Remove or displace passenger cabin sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-130-005

- (2) Do an Ultrasonic inspection of the edge frames outer chord under the stop backup fittings at stringers S-11 and S-12.

See Doc. D626A001-DTR, DTR check form 53-40-22-7 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 53-10-10.

SUBTASK 53-05-02-410-003

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

TASK 53-05-02-250-878

| 95. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-089

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform the inspection.

SUBTASK 53-05-02-250-078

- (2) Do a High Frequency Eddy Current inspection on the edges of the cutout doublers at all four lower corners (intersection of lower sill and edge frames) at stringer S-14 (from STA 578 to STA 607 and from STA 616 to STA 639).

See Doc. D626A001-DTR, DTR check form 53-40-22-9 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-15.

NOTE: Doors with external doublers at the lower door corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-087

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————



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TASK 53-05-02-250-880

| 96. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSY AND FRAME OUTER CHORD

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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-091

- (1) Open this access panel on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

SUBTASK 53-05-02-250-080

- (2) Do a Low Frequency Eddy Current inspection of the doublers around the fasteners common to the edge frame at STA 578 (from stringers S-13 to S-15) and at STAs 601, 616 and 639 (from stringers S-10 to S-15).

See Doc. D626A001-DTR, DTR check form 53-40-22-11 for alternative inspections.

NOTE: Doors with external doublers at the lower door corners refer to DTR 53-40-22-22 for area covered by doubler.

SUBTASK 53-05-02-410-089

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-210-803

| 97. INTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT

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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-010

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit Door must be open to perform the inspection. Remove or displace passenger cabin sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-210-003

- (2) Do a General Visual inspection on the width and thickness of the lower sill inner splice strap and around the five fasteners at STAs 578, 601, 616 and 639.

NOTE: Fastener location is three FWD and two AFT at STAs 578/616 and two FWD and three AFT at STAs 601/639.

See Doc. D626A001-DTR, DTR check form 53-40-22-13 for alternative inspections.

SUBTASK 53-05-02-410-008

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-211-835

| **98. INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS**

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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-021

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit Door must be open to perform the inspection.

SUBTASK 53-05-02-211-035

- (2) Do a Detailed inspection of the door stops attached to the forward and aft edge frames, six fittings per door.

See Doc. D626A001-DTR, DTR check form 53-40-23-1 for alternative inspections.

SUBTASK 53-05-02-410-019

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

TASK 53-05-02-211-836

| **99. INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-022

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection. Removal of passenger cabin sidewall lining between Emergency Exit Doors is required to perform the inspection.

SUBTASK 53-05-02-211-036

- (2) Do a Detailed inspection of the door stop intercostals (three locations) between STA 601 to STA 616.

See Doc. D626A001-DTR, DTR check form 53-40-23-2 for alternative inspections.

SUBTASK 53-05-02-410-020

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

— END OF TASK —

TASK 53-05-02-250-884

| 100. INTERNAL - SPECIAL DETAILED: OVERWING EXIT DOOR STOPS AND FITTINGS

NOTE: This procedure is a scheduled maintenance task.



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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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-095

- (1) Open these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Removal of passenger cabin sidewall lining between Emergency Exit Doors is required to perform the inspection.

SUBTASK 53-05-02-250-084

- (2) Do a High Frequency Eddy Current inspection of the window frame edge inboard of the fasteners common to the door stop backup fitting attachment at stringers S-11 and S-12.

See Doc. D626A001-DTR, DTR check form 53-40-23-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-24.

SUBTASK 53-05-02-410-093

- (3) Close these access panels on the Left side:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-211-837

| 101. **INTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO 887**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal of ADT Antenna, fairing and base plate as required to expose the skin to perform the inspection.

SUBTASK 53-05-02-211-037

- (1) Do a Detailed inspection of the crown skin panel at the ADF Antenna cutout (STA 727+9, RBL 5) and the SATCOM Antenna cutout (STA 747, stringer S-1).

See Doc. D626A001-DTR, DTR check form 53-60-01-4 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-885

| 102. **INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL)**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-250-085

- (1) Do a Low Frequency Eddy Current inspection of the skin for hidden cracks between the adaptor plate and stringers S-1 and S-2L.

See Doc. D626A001-DTR, DTR check form 53-60-01-5 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-838

| 103. **INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL)**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

EFFECTIVITY
AKS ALL

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B. Inspection

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-211-038

- (1) Do a Detailed inspection of the skin under the antenna adaptor plate from stringers S-1 to S-2L at STA 767.

See Doc. D626A001-DTR, DTR check form 53-60-01-5 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-886

| 104. INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection

SUBTASK 53-05-02-250-086

- (1) Do a Low Frequency Eddy Current inspection of the skin for hidden cracks between the adaptor plate and stringers S-1 and S-2L.

See Doc. D626A001-DTR, DTR check form 53-60-01-6 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-211-839

| 105. INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-211-039

- (1) Do a Detailed inspection of the skin under the antenna adaptor plate from stringers S-1 to S-2L at STA 767.

See Doc. D626A001-DTR, DTR check form 53-60-01-6 for alternative inspections.

———— END OF TASK ——

EFFECTIVITY
AKS ALL

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TASK 53-05-02-250-887

| 106. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-250-087

- (1) Do a Low Frequency Eddy Current inspection of the upper (inner) skin along the upper fastener row at stringers S-23L and S-23R from STA 727 to STA 887, except at the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-60-04-7, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

———— END OF TASK ————

TASK 53-05-02-211-840

| 107. INTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall window assemblies and insulation blankets as required.

SUBTASK 53-05-02-211-040

- (1) Do a Detailed inspection of the window frames around each window from STA 727 to STA 888.
See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-841

| 108. EXTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888

NOTE: This procedure is a scheduled maintenance task.

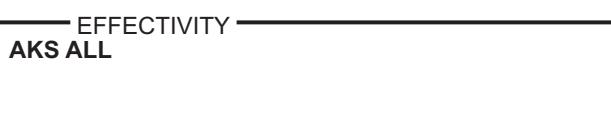
A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-041

- (1) Do a Detailed inspection of the window frames around each window from STA 727 to STA 888.



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See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-888

| 109. **INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-096

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

NOTE: Cargo Door must be open to perform the inspection.

SUBTASK 53-05-02-250-088

- (2) Do a High Frequency Eddy Current inspection of the frame inner chord between the web and failsafe strap from stringers S-18R to S-26R.

See Doc D626A001-DTR, DTR check form 53-60-08-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-88.

SUBTASK 53-05-02-410-094

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ——

TASK 53-05-02-250-889

| 110. **INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

EFFECTIVITY
AKS ALL

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C. Inspection

SUBTASK 53-05-02-010-097

- (1) Open this access panel:

Number Name/Location

822 Aft Cargo Door

NOTE: Cargo Door must be open to perform the inspection. Remove or displace aft cargo sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-089

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chord fail-safe straps between stringers S-17R and S-18R.

See Doc D626A001-DTR, DTR check form 53-60-08-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-88.

SUBTASK 53-05-02-410-095

- (3) Close this access panel:

Number Name/Location

822 Aft Cargo Door

————— END OF TASK ————

TASK 53-05-02-250-890

| 111. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

142 Aft Cargo Compartment - Right

144 Area Below Aft Cargo Compartment - Right

B. Access Panels

Number Name/Location

822 Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-098

- (1) Open this access panel:

Number Name/Location

822 Aft Cargo Door

NOTE: Remove or displace aft cargo sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-090

- (2) Do a Low Frequency Eddy Current inspection of the forward and aft edge frame inner chords at stringer S-18R.

See Doc D626A001-DTR, DTR check form 53-60-08-3 for alternative inspections.

EFFECTIVITY
AKS ALL

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-81.

SUBTASK 53-05-02-410-096

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-891

| 112. **INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-099

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

NOTE: Aft cargo door must be open to perform the inspection.

SUBTASK 53-05-02-250-091

- (2) Do a High Frequency Eddy Current inspection of the outboard portion of the web on the outer chord between stringers S-16R and S-26R at STA 794.37 and STA 847 (except at door stops and sills location).

See Doc D626A001-DTR, DTR check form 53-60-08-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-22.

SUBTASK 53-05-02-410-097

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-02



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TASK 53-05-02-130-806

| 113. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-006

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

NOTE: Aft cargo door must be open to perform the inspection. Remove or displace aft cargo lining as required to perform the inspection.

SUBTASK 53-05-02-130-006

- (2) Do an Ultrasonic inspection of the outboard portion of the frame web under the door stop fittings and sill clips at STA 794.37 and STA 847.

See Doc D626A001-DTR, DTR check form 53-60-08-5 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 53-10-08.

SUBTASK 53-05-02-410-004

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

— END OF TASK —

TASK 53-05-02-250-892

| 114. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door



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C. Inspection

SUBTASK 53-05-02-010-100

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-092

- (2) Do a High Frequency Eddy Current inspection of the exposed edge of the bearstrap at both the forward and aft edge of the door at STA 794.4 and STA 847 from stringers S-18R to S-25R. See Doc D626A001-DTR, DTR check form 53-60-08-8 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-21.

SUBTASK 53-05-02-410-098

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-211-842

| 115. **EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-023

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

NOTE: Scuff plate removal required.

SUBTASK 53-05-02-211-042

- (2) Do a Detailed inspection of the skin at all four corners (upper/lower/FWD/AFT) of the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-021

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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TASK 53-05-02-210-804

| 116. **INTERNAL - GENERAL VISUAL: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-011

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Corner casting removal is required.

SUBTASK 53-05-02-210-004

- (2) Do a General Visual inspection of the bearstrap at all four corners (upper/lower/fwd/aft) of the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-009

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-893

| 117. **INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-101

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door



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NOTE: Aft cargo door must be open to perform the inspection. Remove or displace aft cargo sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-250-093

- (2) Do a High Frequency Eddy Current inspection of the intercostal web for cracks adjacent to the rivet and fastener holes. Five door stops locations on both the forward and aft edge frames.
See Doc. D626A001-DTR, DTR check form 53-60-09-3, for alternative inspections.
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-82.

SUBTASK 53-05-02-410-099

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-894

| 118. **EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-094

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 887 to STA 1016.
See Doc. D626A001-DTR, DTR check form 53-70-03-2, for alternative inspections.
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

———— END OF TASK ————

TASK 53-05-02-211-845

| 119. **EXTERNAL - DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-045

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringer S-14L (from STA 888 to STA 947, and from STA 1006 to STA 1016) and at stringer S-14R (from STA 888 to STA 947, and from STA 996 to STA 1016).

EFFECTIVITY
AKS ALL

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See Doc D626A001-DTR, DTR check form 53-70-03-3 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-895

| 120. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-095

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 888 to STA 947 and from STA 1006 to STA 1016) and at stringer S-14R (from STA 888 to STA 947 and from STA 996 to STA 1016).

See Doc D626A001-DTR, DTR check form 53-70-03-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

———— END OF TASK ——

TASK 53-05-02-250-896

| 121. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Inspection

NOTE: Remove or displace interior sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-250-096

- (1) Do a High Frequency Eddy Current inspection of the four fastener locations at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-35.

———— END OF TASK ——

TASK 53-05-02-250-897

| 122. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform the inspection.

SUBTASK 53-05-02-250-097

- (1) Do a High Frequency Eddy Current inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doublers at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-36.

———— END OF TASK ————

TASK 53-05-02-210-842

**123. INTERNAL - GENERAL VISUAL: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP
INTERCOSTALS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Inspection

SUBTASK 53-05-02-210-042

NOTE: Remove or displace interior sidewall and door lining as required to perform the inspection.

- (1) Do a General Visual inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doublers at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-4 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-846

124. EXTERNAL - DETAILED: CUTOUT, AFT ENTRY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

Number	Name/Location
834	Aft Entry Door

EFFECTIVITY
AKS ALL

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C. Inspection

SUBTASK 53-05-02-010-025

- (1) Open this access panel:

Number Name/Location

834 Aft Entry Door

NOTE: Remove or displace interior sidewall and door lining as required to do the inspection.

SUBTASK 53-05-02-211-046

- (2) Do a Detailed inspection on the perimeter of the cutout and around the fasteners common to the edge frames and upper sill outer chords.

See Doc D626A001-DTR, DTR check form 53-70-07-5 for alternative inspections.

SUBTASK 53-05-02-410-023

- (3) Close this access panel:

Number Name/Location

834 Aft Entry Door

———— END OF TASK ————

TASK 53-05-02-211-847

| 125. **EXTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

145 Aft Cargo Compartment Equipment Bay - Left

241 Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

Number Name/Location

834 Aft Entry Door

C. Inspection

SUBTASK 53-05-02-010-026

- (1) Open this access panel:

Number Name/Location

834 Aft Entry Door

SUBTASK 53-05-02-211-047

- (2) Do a Detailed inspection of the skin around the edges of the scuff plates.

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

SUBTASK 53-05-02-410-024

- (3) Close this access panel:

Number Name/Location

834 Aft Entry Door

———— END OF TASK ————



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TASK 53-05-02-250-898

| **126. EXTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
145	Aft Cargo Compartment Equipment Bay - Left
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

C. Inspection

SUBTASK 53-05-02-010-103

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Remove scuff plate.

SUBTASK 53-05-02-250-098

- (2) Do a High Frequency Eddy Current inspection of the skin around the fastener holes hidden by the scuff plate.

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-34.

SUBTASK 53-05-02-410-101

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

———— END OF TASK ————

TASK 53-05-02-211-848

| **127. INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door



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C. Inspection

SUBTASK 53-05-02-010-027

- (1) Open this access panel:

Number Name/Location

834 Aft Entry Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to do the inspection.

SUBTASK 53-05-02-211-048

- (2) Do a Detailed inspection of the inner chord and web along the upper main sill from STA 951 to STA 1006.

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-167

- (3) Close this access panel:

Number Name/Location

834 Aft Entry Door

———— END OF TASK ————

TASK 53-05-02-250-899

| 128. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP
BACKUP STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

242 Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number Name/Location

844 Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-102

- (1) Open this access panel:

Number Name/Location

844 Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-099

- (2) Do a Low Frequency Eddy Current inspection on the four fastener locations at the #1, #2, #5 and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-83.



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SUBTASK 53-05-02-410-100

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————

TASK 53-05-02-250-900

| 129. **INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-104

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-100

- (2) Do a High Frequency Eddy Current inspection on the four fastener locations at the #1, #2, #5 and #6 stop locations. For door stop #5, there are two locations in the strap hidden by the bracket.

See Doc D626A001-DTR, DTR check form 53-70-08-3 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-83.

SUBTASK 53-05-02-410-102

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————

TASK 53-05-02-250-901

| 130. **INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

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A. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-105

- (1) Open this access panel:

Number Name/Location

844	Aft Galley Service Door
-----	-------------------------

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-101

- (2) Do a High Frequency Eddy Current inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doubler at the #1, #2, #5, and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-84.

SUBTASK 53-05-02-410-103

- (3) Close this access panel:

Number Name/Location

844	Aft Galley Service Door
-----	-------------------------

— END OF TASK —

TASK 53-05-02-210-843

**131. INTERNAL - GENERAL VISUAL: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP
INTERCOSTALS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-410-171

- (1) Open this access panel:

Number Name/Location

844	Aft Galley Service Door
-----	-------------------------



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NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-210-043

- (2) Do a General Visual inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doubler at the #1, #2, #5, and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-4 for alternative inspections.

SUBTASK 53-05-02-410-172

- (3) Close this access panel:

Number Name/Location

844 Aft Galley Service Door

———— END OF TASK ————

TASK 53-05-02-211-849

| 132. EXTERNAL - DETAILED: CUTOUT, AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-028

- (1) Open this access panel:

Number Name/Location

844 Aft Galley Service Door

SUBTASK 53-05-02-211-049

- (2) Do a Detailed inspection of the perimeter of the cutout and around the fasteners common to the edge frames and upper sill outer chords.

See Doc D626A001-DTR, DTR check form 53-70-08-5 for alternative inspections.

SUBTASK 53-05-02-410-026

- (3) Close this access panel:

Number Name/Location

844 Aft Galley Service Door

———— END OF TASK ————

TASK 53-05-02-211-850

| 133. INTERNAL - DETAILED: BULKHEAD STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left

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AKS ALL

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<u>Zone</u>	<u>Area</u>
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-029

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-211-050

- (2) Do a Detailed inspection of the pressure dome webs between the stiffeners and tear straps.
See Doc D626A001-DTR, DTR check form 53-80-01-2 for alternative inspections.

SUBTASK 53-05-02-410-027

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

— END OF TASK —

TASK 53-05-02-211-851

| 134. INTERNAL - DETAILED: BULKHEAD STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-030

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-211-051

- (2) Do a Detailed inspection of the pressure dome web lap splices along the fastener rows adjacent to the radial stiffeners.

See Doc D626A001-DTR, DTR check form 53-80-01-3 for alternative inspections.

EFFECTIVITY
AKS ALL

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SUBTASK 53-05-02-410-028

- (3) Close this access panel:

Number Name/Location

311BL Stabilizer Trim Access Door

———— END OF TASK ————

TASK 53-05-02-250-902

| 135. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - 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
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin and aft cargo interiors as required to perform the inspection.

SUBTASK 53-05-02-250-102

- (1) Do a High Frequency Eddy Current inspection of the forward side of the pressure dome web along the aft fastener row attaching the web to the pressure chord. Inspect at the edge of each stiffener/clip and around the two fasteners on each side of the stiffener.

See Doc D626A001-DTR, DTR check form 53-80-01-4 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-11.

———— END OF TASK ————

TASK 53-05-02-250-903

| 136. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

EFFECTIVITY
AKS ALL

53-05-02

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SUBTASK 53-05-02-250-103

- (1) Do a High Frequency Eddy Current inspection of the pressure dome webs along the aft fastener row attaching the web to the pressure chord and between the stiffener locations from stringers S-5L to S-7L and S-5R to S-9R.

See Doc D626A001-DTR, DTR check form 53-80-01-5A for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-38.

————— END OF TASK ————

TASK 53-05-02-250-904

| 137. **INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - 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
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors if/as required to perform this inspection.

SUBTASK 53-05-02-250-104

- (1) Do a High Frequency Eddy Current inspection of the pressure dome webs along the aft fastener row attaching the web to the pressure chord and between the stiffener locations outside of stringers S-5L to S-7L and S-5R to S-9R.

See Doc D626A001-DTR, DTR check form 53-80-01-5B for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-250-905

| 138. **INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - 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
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.



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SUBTASK 53-05-02-250-105

- (1) Do a Low Frequency Eddy Current inspection around the fasteners common to the pressure chord splices between stringers S-2 and S-3 and S-16 and S-17A.

See Doc D626A001-DTR, DTR check form 53-80-01-6 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-906

| 139. **INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - 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
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-106

- (1) Do a Low Frequency Eddy Current inspection on the forward side of the pressure dome web around the fasteners common to the lap splice and the stiffeners.

See Doc D626A001-DTR, DTR check form 53-80-01-7 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-250-907

| 140. **INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-107

- (1) Do a High Frequency Eddy Current inspection on the forward side of the pressure dome web around the fasteners common to the tear strap.

See Doc D626A001-DTR, DTR check form 53-80-01-8 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-97.

———— END OF TASK ——

EFFECTIVITY
AKS ALL

53-05-02



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TASK 53-05-02-250-908

| **141. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-141

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-250-108

- (2) Do a Low Frequency Eddy Current inspection on the aft side of the pressure dome web at the intersection of the tear straps and lap splice next to the stiffeners.

See Doc D626A001-DTR, DTR check form 53-80-01-9 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-08.

SUBTASK 53-05-02-410-132

- (3) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

— END OF TASK —

TASK 53-05-02-250-909

| **142. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-109

- (1) Do a High Frequency Eddy Current inspection on the forward side of the pressure dome webs at the junction of the radial stiffeners/lap splices and the tear straps.

See Doc D626A001-DTR, DTR check form 53-80-01-11 for alternative inspections.



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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-07.

————— END OF TASK ————

TASK 53-05-02-250-910

| **143. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-110

- (1) Do a Low Frequency Eddy Current inspection on the forward side of the pressure dome web around the fasteners common to the doubler, Y-Chord and the tear strap between stringers S-1 and S-3.

See Doc D626A001-DTR, DTR check form 53-80-01-13 for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-888

| **144. INTERNAL - DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-071

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-211-088

- (2) Do a Detailed inspection of the aft side of STA 1016 bulkhead web for oil cans.

NOTE: Refer to Structural Repair Manual, Section 53-80-08, for definition of oil can.

No DTR form available for PSE 53-80-01-14.



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SUBTASK 53-05-02-410-069

- (3) Close this access panel:

Number Name/Location

311BL Stabilizer Trim Access Door

———— END OF TASK ————

TASK 53-05-02-211-852

| 145. INTERNAL - DETAILED: VERTICAL FIN FRONT SPAR FITTING BULKHEAD ATTACHMENT - STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
321	Vertical Fin - Dorsal Fin

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-211-052

- (1) Do a Detailed inspection of the fittings on both sides of the bulkhead at STA 1016.

See Doc D626A001-DTR, DTR check form 53-80-02-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-912

| 146. INTERNAL - SPECIAL DETAILED: VERTICAL FIN FRONT SPAR FITTINGS - STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
322	Vertical Fin - Removable Fin Leading Edge

B. Access Panels

Number Name/Location

323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

C. Inspection

SUBTASK 53-05-02-010-174

- (1) Open these access panels:

Number Name/Location

323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

SUBTASK 53-05-02-250-112

- (2) Do a High Frequency Eddy Current inspection of the exposed forward and aft surfaces of the fitting lugs. Bolt removal is not required.

EFFECTIVITY
AKS ALL

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See Doc D626A001-DTR, DTR check form 53-80-02-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-78.

SUBTASK 53-05-02-410-165

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

———— END OF TASK ————

TASK 53-05-02-250-913

| 147. INTERNAL - SPECIAL DETAILED: STRINGER SPLICE FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-144

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

NOTE: Remove or displace passenger cabin interior as required to perform the inspection.

SUBTASK 53-05-02-250-113

- (2) Do a High Frequency Eddy Current inspection of the stringer splice fittings from stringer S-9L to S-9R at the first two fastener locations forward and aft of the STA 1016 bulkhead.

See Doc D626A001-DTR, DTR check form 53-80-03-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-79.

SUBTASK 53-05-02-410-135

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-02

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TASK 53-05-02-250-914

| 148. INTERNAL - SPECIAL DETAILED: JACKSCREW FITTING LUGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-106

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

NOTE: Remove access panel as required. Remove/disconnect the jackscrew from the fitting and move aside for access to the lugs.

SUBTASK 53-05-02-250-114

- (2) Do a High Frequency Eddy Current inspection of both primary jackscrew fitting lugs on both sides around the bushing at the STA 1088 bulkhead.

See Doc D626A001-DTR, DTR check form 53-80-05-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-95.

SUBTASK 53-05-02-410-104

- (3) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

———— END OF TASK ————

TASK 53-05-02-130-807

| 149. INTERNAL - SPECIAL DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
323	Vertical Fin - Front Spar To Rear Spar



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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-007

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

NOTE: Access fittings inside the tailcone on the forward and aft side of the STA 1088 Bulkhead. The top of the fittings are sandwiched between the splice angles and the bulkhead.

SUBTASK 53-05-02-130-007

- (2) Do an Ultrasonic inspection of the top two fasteners in the outboard primary fittings common to the STA 1088 bulkhead.

See Doc D626A001-DTR, DTR check form 53-80-06-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 53-80-01.

SUBTASK 53-05-02-410-005

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

— END OF TASK —

TASK 53-05-02-211-853

| 150. INTERNAL - DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
323	Vertical Fin - Front Spar To Rear Spar

B. Inspection

NOTE: Remove vertical fin including primary and fail-safe bolts.

SUBTASK 53-05-02-211-053

- (1) Do a Detailed inspection of the four primary fitting lugs, from the inside of the lugs, at STA 1088.

See Doc D626A001-DTR, DTR check form 53-80-06-2 for alternative inspections.

— END OF TASK —

EFFECTIVITY
AKS ALL

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TASK 53-05-02-250-915

| 151. **INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1156**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

B. Access Panels

Number	Name/Location
318BR	Tailcone Access Door

C. Inspection

SUBTASK 53-05-02-010-107

- (1) Open this access panel:

Number	Name/Location
318BR	Tailcone Access Door

SUBTASK 53-05-02-250-115

- (2) Do a High Frequency Eddy Current inspection on the edge of the outer chord and the web above and below the stab pivot line.

See Doc D626A001-DTR, DTR check form 53-80-07-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-85.

SUBTASK 53-05-02-410-105

- (3) Close this access panel:

Number	Name/Location
318BR	Tailcone Access Door

———— END OF TASK ————

TASK 53-05-02-250-916

| 152. **INTERNAL - SPECIAL DETAILED: INTEGRATED BULKHEAD STA 1156**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

B. Access Panels

Number	Name/Location
318BR	Tailcone Access Door

EFFECTIVITY
AKS ALL

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C. Inspection

SUBTASK 53-05-02-010-108

- (1) Open this access panel:

Number Name/Location

318BR Tailcone Access Door

NOTE: Enter aircraft through the tail cone access panel.

SUBTASK 53-05-02-250-116

- (2) Do a High Frequency Eddy Current inspection of the web inboard along the failsafe strap from the top of the stabilizer attach fitting down 16 inches vertically.

See Doc D626A001-DTR, DTR check form 53-80-07-2 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-33.

SUBTASK 53-05-02-410-106

- (3) Close this access panel:

Number Name/Location

318BR Tailcone Access Door

———— END OF TASK ————

TASK 53-05-02-250-917

| 153. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT FITTING

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

B. Inspection

NOTE: Remove sliding seals for access.

SUBTASK 53-05-02-250-117

- (1) Do a High Frequency Eddy Current inspection of the pivot fitting beams around the pivot pins at the STA 1156 hinge beam.

See Doc D626A001-DTR, DTR check form 53-80-08-1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-86.

———— END OF TASK ————

TASK 53-05-02-230-801

| 154. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT PINS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left

EFFECTIVITY
AKS ALL

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Zone	Area
314	Stabilizer Torsion Box Compartment - Right

B. Inspection

NOTE: Removal and separation of pivot pins is required to perform the inspection.

SUBTASK 53-05-02-230-001

- (1) Do a Dye Penetrant of both the inner and outer pivot pins at STA 1156.

See Doc D626A001-DTR, DTR check form 53-80-08-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-854

| 155. EXTERNAL - DETAILED: SECTION 48 SKIN PANELS, STA 1088 TO STA 1156

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

B. Inspection

SUBTASK 53-05-02-211-054

- (1) Do a Detailed inspection of the skin panels around the STA 1138 cutout.

See Doc D626A001-DTR, DTR check form 53-80-10-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-862

| 156. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 259.5 TO STA 360

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

SUBTASK 53-05-02-211-062

- (1) Do a detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from Sta 259.5 to Sta 360, except at the lap splices and antennas. (53-10-08-1).

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-931

| 157. INTERNAL - SPECIAL DETAILED: FWD GALLEY DOOR CUTOUT

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
AKS ALL

53-05-02



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A. Location Zones

Zone	Area
118	Electrical and Electronics Compartment - Right
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

NOTE: Removal of scuff plate is required to perform the inspection.

SUBTASK 53-05-02-250-131

- (1) Do a High Frequency Eddy Current inspection of the skin around the fastener holes and along the edge of the cutout hidden by the scuff plates from STA 303 to STA 350. (53-10-15).

See Doc. D626A001-DTR, DTR check form 53-10-14-12 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-43.

———— END OF TASK ——

TASK 53-05-02-250-932

| 158. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC

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. Inspection

SUBTASK 53-05-02-250-132

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 360 to STA 540 (PSE 53-30-04-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

———— END OF TASK ——

TASK 53-05-02-211-863

| 159. INTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540

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. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall window assemblies and insulation blankets is required.



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SUBTASK 53-05-02-211-063

- (1) Do a Detailed inspection of the window frames around each window from Sta 360 to Sta 540.
(PSE 53-30-05).

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-864

| 160. **EXTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540**

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. Inspection

SUBTASK 53-05-02-211-064

- (1) Do a Detailed inspection of the window frames around each window from Sta 360 to Sta 540.
(PSE 53-30-05).

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-934

| 161. **INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-112

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

SUBTASK 53-05-02-250-134

- (2) Do a High Frequency Eddy Current inspection of the exposed edge of the bearstrap at both the forward and aft edge of the door at STA 440 and STA 492.4 from stringers S-18R to S-25R.
(PSE 53-30-08).

See Doc D626A001-DTR, DTR check form 53-60-08-8 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-21.

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SUBTASK 53-05-02-410-110

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-211-865

| 162. **EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-121

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

NOTE: Forward cargo door must be open to perform this inspection. Scuff plate removal required.

SUBTASK 53-05-02-211-065

- (2) Do a Detailed inspection of the skin around the entire edge of the scuff plates at all four corners (upper/lower/fwd/aft) of the cargo door. (PSE 53-30-08-9).

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-119

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-210-808

| 163. **INTERNAL - GENERAL VISUAL: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right



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B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-013

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

NOTE: Corner casting removal is required.

SUBTASK 53-05-02-210-008

- (2) Do a General Visual inspection of the bearstrap at all four corners (upper/lower/fwd/aft) of the cargo door cutout. (PSE 53-30-08-9).

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-011

- (3) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

———— END OF TASK ————

TASK 53-05-02-211-866

| 164. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 540 TO STA 727

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-066

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 540 to STA 727, except at the lap splices and antennas. (53-40-01-1).

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-935

| 165. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

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



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Zone Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-135

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 540 to STA 727. (PSE 53-40-03-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

———— END OF TASK ————

TASK 53-05-02-250-937

| 166. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-137

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 540 to STA 727. (53-40-03-2).

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

———— END OF TASK ————

TASK 53-05-02-211-867

| 167. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO STA 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove Dorsal Fin as required to perform the inspection.



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SUBTASK 53-05-02-211-067

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 727 to STA 887, except at the lap splices and antennas. (PSE 53-60-01-2).
See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-210-805

| 168. **EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

C. Inspection

SUBTASK 53-05-02-010-012

- (1) Open these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

NOTE: Remove or displace wing to body fairings as required to perform the inspection.

SUBTASK 53-05-02-210-005

- (2) Do a General Visual inspection of the skin from STA 727 to STA 887 between stringers S-14 to S-17. (PSE 53-60-02-1).

See Doc D626A001-DTR, DTR check form 53-30-02-1 for alternative inspections.

SUBTASK 53-05-02-410-010

- (3) Close these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

———— END OF TASK ——

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TASK 53-05-02-211-868

| 169. EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

B. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

C. Inspection

SUBTASK 53-05-02-010-037

- (1) Open these access panels on the Left side:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel

Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

NOTE: Remove or displace wing to body fairings as required to perform this inspection.

SUBTASK 53-05-02-211-068

- (2) Do a Detailed inspection of the fuselage skin panels under the Wing to Body Fairing from STA 727 to STA 887. (53-60-02-4).

See Doc D626A001-DTR, DTR check form 53-30-02-4 for alternative inspections.

SUBTASK 53-05-02-410-035

- (3) Close these access panels on the Left side:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel

Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

———— END OF TASK ————

EFFECTIVITY
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TASK 53-05-02-250-940

| 170. **EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-140

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 727 to STA 887. (PSE 53-60-04-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

———— END OF TASK ————

TASK 53-05-02-250-942

| 171. **EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-142

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 727 to STA 887. (PSE 53-60-04-2).

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-50.

———— END OF TASK ————

TASK 53-05-02-250-944

| 172. **EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right



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B. Inspection

SUBTASK 53-05-02-250-144

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 727 to STA 887. (PSE 53-60-04-3)

See Doc. D626A001-DTR, DTR check form 53-30-04-3, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

————— END OF TASK ————

TASK 53-05-02-211-869

| 173. INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal or displacement of interior sidewall panels and insulation blankets are required.

SUBTASK 53-05-02-211-069

- (1) Do a Detailed inspection of the lower skin along the lower fastener row at stringers S-10L and S-10R from STA 727 to STA 887. (PSE 53-60-04-4)

See Doc. D626A001-DTR, DTR check form 53-30-04-4, for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-211-871

| 174. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-071

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringers S-14L and S-14R from STA 727 to STA 887. (PSE 53-60-04-5)

See Doc. D626A001-DTR, DTR check form 53-30-04-5, for alternative inspections.

————— END OF TASK ————

TASK 53-05-02-250-946

| 175. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-146

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-14L and S-14R from STA 727 to STA 887. (PSE 53-60-04-6).

See Doc. D626A001-DTR, DTR check form 53-30-04-6, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-30-50.

————— END OF TASK ————

TASK 53-05-02-250-948

| **176. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-113

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Removal of aft cargo door scuff plate is required to perform the inspection.

SUBTASK 53-05-02-250-148

- (2) Do a Low Frequency Eddy Current inspection around the fasteners common to the web at the lower main sill chords between STA 807 and STA 827. (PSE 53-60-08).

See Doc. D626A001-DTR, DTR check form 53-30-08-12, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-33.

SUBTASK 53-05-02-410-111

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— END OF TASK ————



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TASK 53-05-02-250-949

| 177. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-115

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Remove or displace aft cargo door lining as required to perform the inspection.

SUBTASK 53-05-02-250-149

- (2) Do a High Frequency Eddy Current inspection of the upper sill outer chord around the fasteners common to the chord and bearstrap. (PSE 53-60-08).

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

SUBTASK 53-05-02-410-113

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-974

| 178. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-117

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Remove or displace aft cargo door lining as required to perform the inspection.

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SUBTASK 53-05-02-250-174

- (2) Do a High Frequency Eddy Current inspection of the bearstrap along the upper edge of the aft cargo door. (53-60-08).

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

SUBTASK 53-05-02-410-115

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-950

| 179. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-114

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-150

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for two inches on each side of stringer S-24R at STA 794.4 and STA 847. (PSE 53-60-08)

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

SUBTASK 53-05-02-410-112

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-130-809

| 180. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right



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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-008

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-130-009

- (2) Do an Ultrasonic inspection of the bearstrap for hidden damage under the stop backup fitting at stringer S-24R at STA 794.4 and STA 847. (PSE 53-60-08).

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

SUBTASK 53-05-02-410-006

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— END OF TASK ————

TASK 53-05-02-250-951

| 181. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-151

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 887 to STA 1016. (PSE 53-70-03-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-30-41.

———— END OF TASK ————

TASK 53-05-02-211-873

| 182. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 887 TO STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right



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B. Inspection

NOTE: Remove Dorsal Fin as required to perform the inspection.

SUBTASK 53-05-02-211-073

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 887 to STA 1016, except at the lap splices and antennas. (PSE 53-70-04-1).
See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ——

TASK 53-05-02-211-874

| 183. INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-038

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required.

SUBTASK 53-05-02-211-074

- (2) Do a Detailed inspection of the inner chord and web along the upper main sill from STA 951 to STA 1006. (PSE 53-70-08).

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-036

- (3) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

———— END OF TASK ——

TASK 53-05-02-211-875

| 184. EXTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
146	Aft Cargo Compartment Equipment Bay - Right
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right



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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-039

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

SUBTASK 53-05-02-211-075

- (2) Do a Detailed inspection of the skin around the edges of the scuff plates. (PSE 53-70-08-6).

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

SUBTASK 53-05-02-410-037

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

— END OF TASK —

TASK 53-05-02-250-953

| 185. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
146	Aft Cargo Compartment Equipment Bay - Right
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-116

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Remove scuff plate.

SUBTASK 53-05-02-250-153

- (2) Do a High Frequency Eddy Current inspection on the skin around the fastener holes hidden by the scuff plate. (PSE 53-70-08-6).

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspection

SUBTASK 53-05-02-410-114

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

— END OF TASK —

EFFECTIVITY
AKS ALL

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TASK 53-05-02-211-876

| 186. INTERNAL - DETAILED: WINDOW BELT STA 888 to 927

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall window assemblies and insulation blankets as required.

SUBTASK 53-05-02-211-076

- (1) Do a Detailed inspection of the window frames around each window from STA 888 to STA 927.
(PSE 53-70-09)

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-211-877

| 187. EXTERNAL - DETAILED: WINDOW BELT STA 888 to 927

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-077

- (1) Do a Detailed inspection of the window frames around each window from STA 888 to STA 927.
(PSE 53-70-09)

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-997

| 188. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
834	Aft Entry Door



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C. Inspection

SUBTASK 53-05-02-010-172

- (1) Open this access panel:

Number Name/Location

834 Aft Entry Door

NOTE: Remove scuff plates as required for access to the outer chord.

SUBTASK 53-05-02-250-197

- (2) Do a High Frequency Eddy Current inspection of the first five fasteners on the upper flange of the lower main sill outer chord, aft of the edge frame.

See Doc D626A001-DTR, DTR check form 53-70-07-12 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-20.

SUBTASK 53-05-02-410-163

- (3) Close this access panel:

Number Name/Location

834 Aft Entry Door

———— END OF TASK ————

TASK 53-05-02-250-A79

| 189. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone Area

242 Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number Name/Location

844 Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-173

- (1) Open this access panel:

Number Name/Location

844 Aft Galley Service Door

NOTE: Remove scuff plates as required for access to the outer chord.

SUBTASK 53-05-02-250-279

- (2) Do a High Frequency Eddy Current inspection on the first five fasteners on the upper flange of the lower main sill outer chord, aft of the edge frame. (53-70-08-12).

See Doc D626A001-DTR, DTR check form 53-70-07-12 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 53-11-20.

EFFECTIVITY
AKS ALL

53-05-02



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SUBTASK 53-05-02-410-164

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————

TASK 53-05-02-210-837

| 190. **INTERNAL - GENERAL VISUAL: PRESSURE DECK ATTACHMENTS TO REAR SPAR EXTENSION**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

B. Inspection

SUBTASK 53-05-02-210-037

- (1) Do a General Visual inspection of the angle between the rear spar extension and the pressure deck from the AFT or FWD side, including the bend radius.

NOTE: Either the AFT or FWD side inspection may be performed.

See Doc. D626A001-DTR, DTR check form 53-40-24-1 for alternative inspections.

———— END OF TASK ————

TASK 53-05-02-250-A98

| 191. **EXTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right
193	Lower Wing-To-Body Fairing - Wheel Well

B. Inspection

SUBTASK 53-05-02-250-303

- (1) Do a High Frequency Eddy Current inspection of the chord at frame 727 from stringers S-21L to S-27L and stringers S-21R to S-27R.

See Doc. D626A001-DTR, DTR check form 53-40-16-1b for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 53-10-93.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-02



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TASK 53-05-02-211-981

| 192. INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. **Access Panels**

Number	Name/Location
834	Aft Entry Door

C. **Inspection**

SUBTASK 53-05-02-010-176

- (1) Open this access panel:

Number	Name/Location
834	Aft Entry Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

D. **Procedure**

SUBTASK 53-05-02-211-181

- (1) Do a Detailed inspection of the inner chord strap near the edge frames from STA 951 to STA 1006.

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-168

- (2) Close this access panel:

Number	Name/Location
834	Aft Entry Door

———— END OF TASK ————

TASK 53-05-02-211-982

| 193. INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. **Access Panels**

Number	Name/Location
844	Aft Galley Service Door

C. **Inspection**

SUBTASK 53-05-02-010-177

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door



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NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-211-183

- (2) Do a Detailed inspection of the inner chord strap near the edge frames from STA 951 to STA 1006. (PSE 53-70-08).

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-170

- (3) Close this access panel:

Number Name/Location

844 Aft Galley Service Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-02



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FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 53-05-03-210-801

1. **EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, FORWARD ACCESS DOOR CUTOUT**
(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
112A	Forward Access Door

C. Inspection

SUBTASK 53-05-03-010-001

- (1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

NOTE: Open forward access door.

SUBTASK 53-05-03-210-001

- (2) Do a General Visual inspection of the door cutout at forward access door.

SUBTASK 53-05-03-910-001

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 53-05-03-410-001

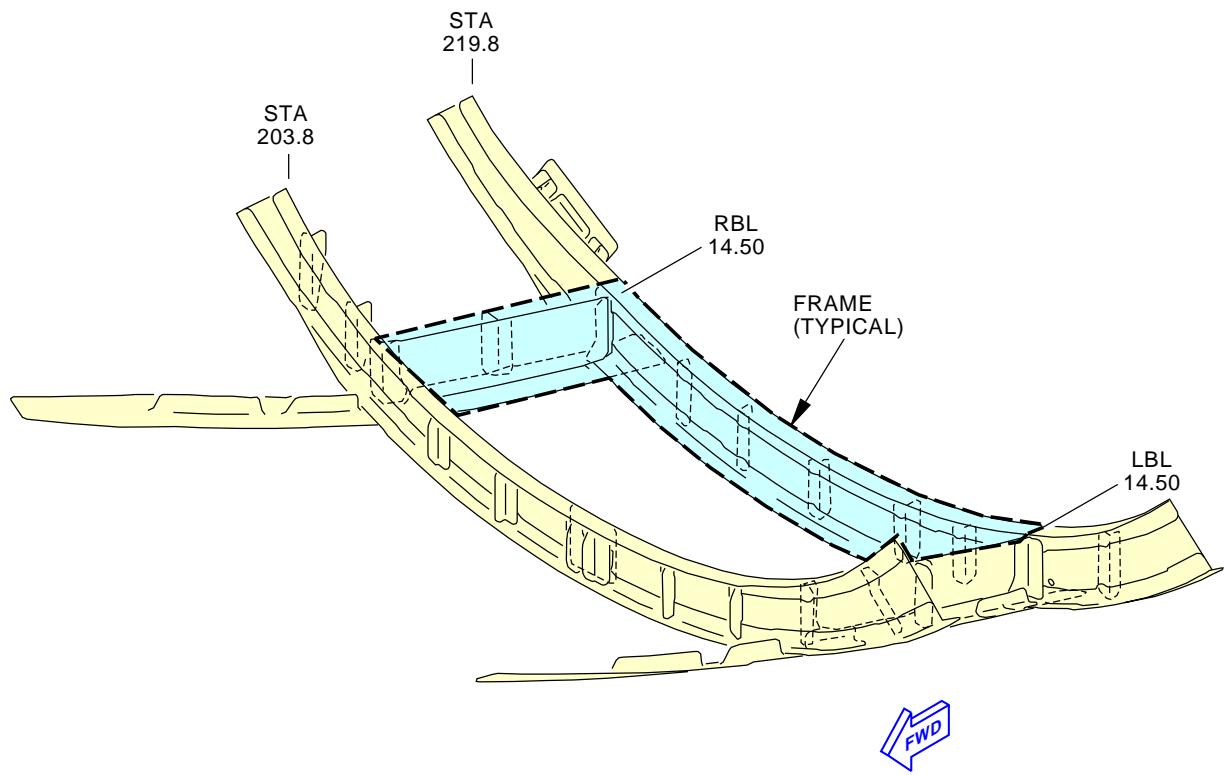
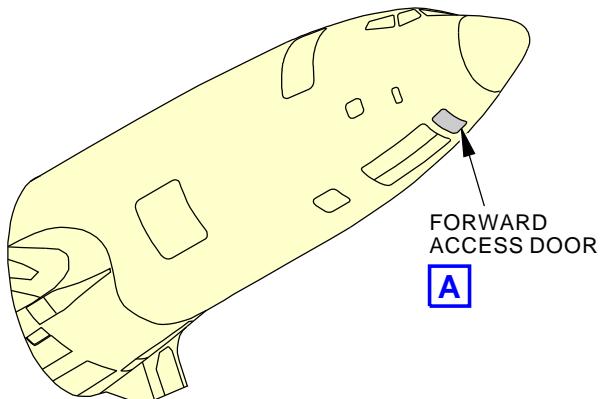
- (4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

———— END OF TASK ————



53-05-03



FORWARD ACCESS DOOR FRAME

A

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External - Forward Access Door Cutout Frame
Figure 201/53-05-03-990-801

EFFECTIVITY
AKS ALL

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TASK 53-05-03-210-802

2. **EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, EE COMPARTMENT DOOR CUTOUT**
(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

C. Inspection

SUBTASK 53-05-03-010-002

- (1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Open EE compartment door.

SUBTASK 53-05-03-210-002

- (2) Do a General Visual inspection of the door cutout at EE Compartment door.

SUBTASK 53-05-03-910-002

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 53-05-03-410-002

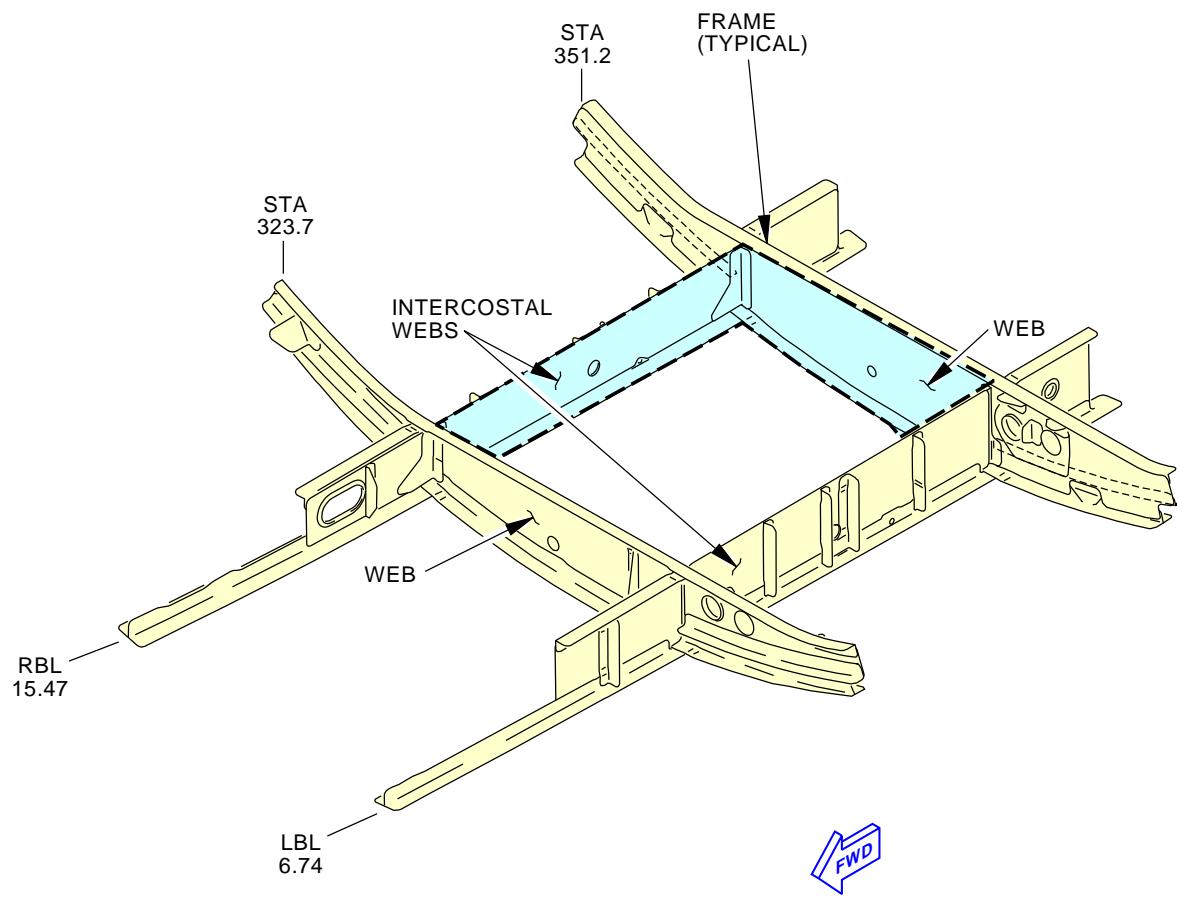
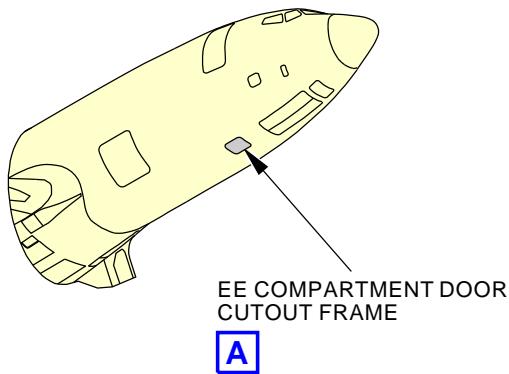
- (4) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

———— END OF TASK ————



53-05-03



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External - EE Compartment Door Cutout Frame
Figure 202/53-05-03-990-802

EFFECTIVITY
AKS ALL

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TASK 53-05-03-210-804

3. EXTERNAL - GENERAL VISUAL: NOSE WHEEL WELL

(Figure 203)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

B. Inspection

SUBTASK 53-05-03-210-004

- (1) Do a General Visual inspection of the nose landing gear wheel well, including canted bulkhead (Sta 224.8 to 227.8), Sta 294.5 bulkhead, side and top panels, trunnion support fitting, actuator support fitting, and drag brace fitting.

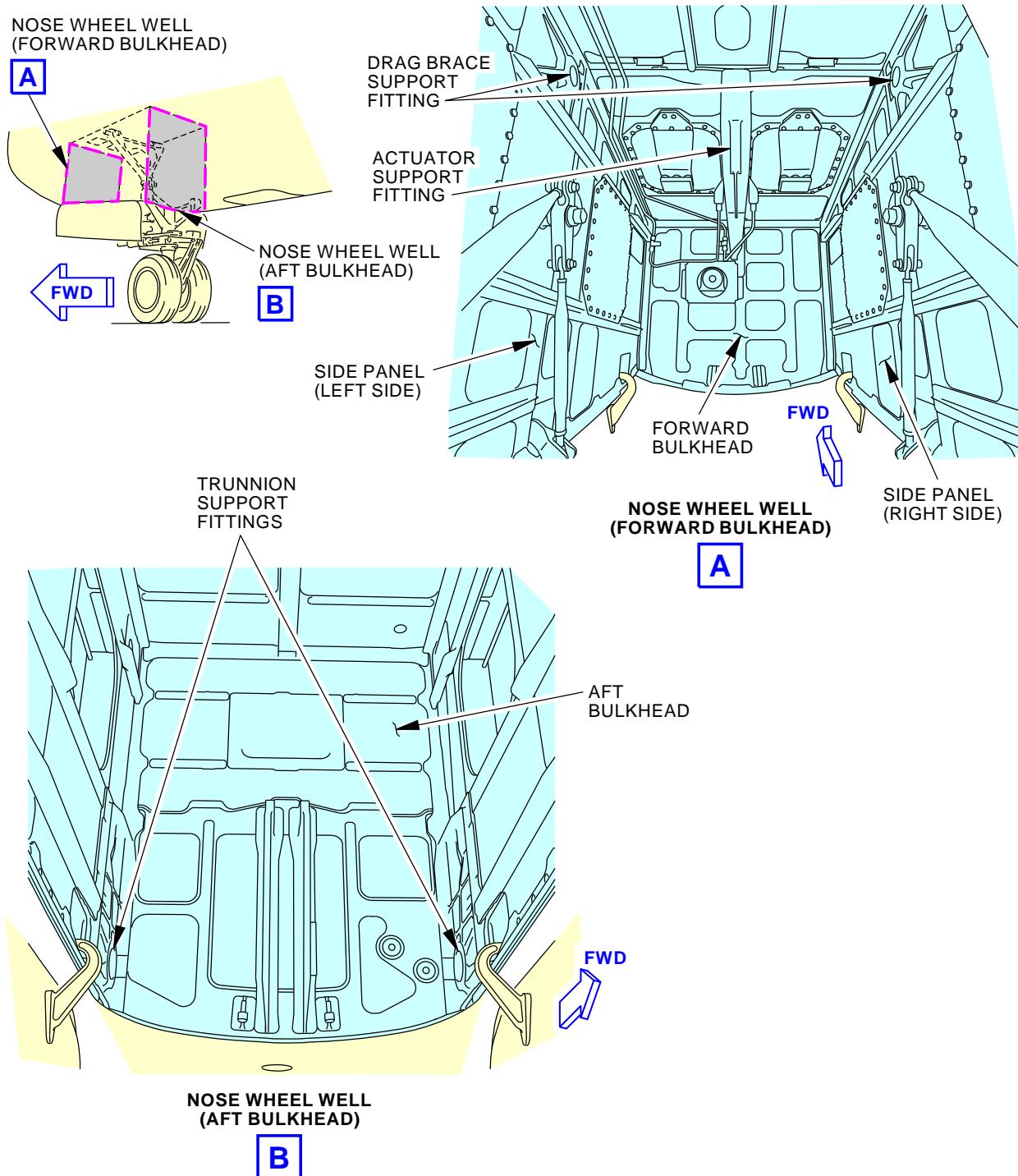
SUBTASK 53-05-03-910-004

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03



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Nose Landing Gear Wheel Well

Figure 203/53-05-03-990-831

EFFECTIVITY
AKS ALL

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TASK 53-05-03-211-801

4. EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS

(Figure 204)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-03-010-055

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

SUBTASK 53-05-03-211-001

- (2) Do a Detailed inspection of the forward cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-005

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-055

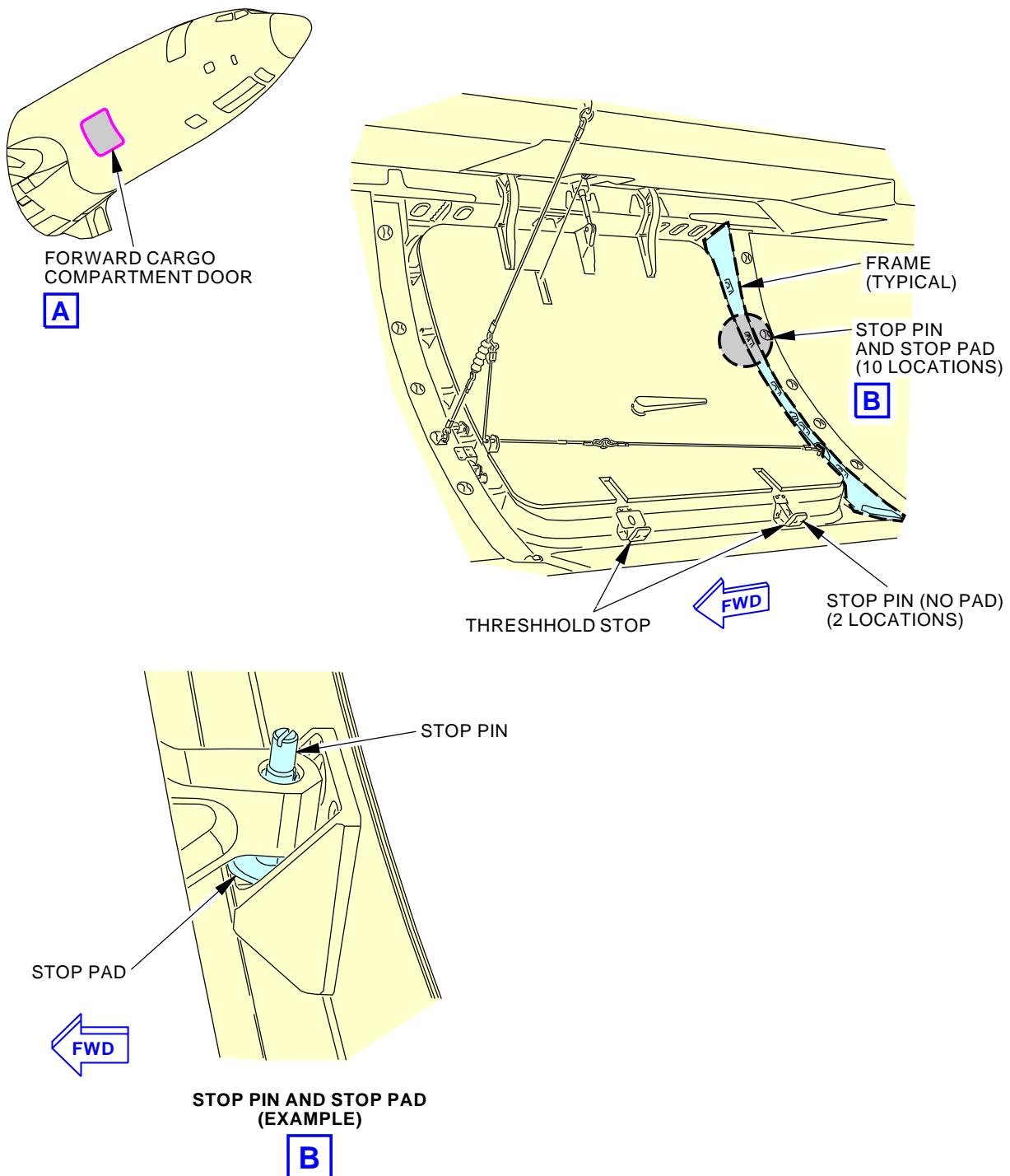
- (4) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

———— END OF TASK ————



53-05-03



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External - Forward Cargo Door Surround Structure Fitting and Stops
Figure 204/53-05-03-990-804

EFFECTIVITY
AKS ALL

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TASK 53-05-03-211-802

5. **EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS**
(Figure 205)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-03-010-056

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-03-211-002

- (2) Do a Detailed inspection of the aft cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-006

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-056

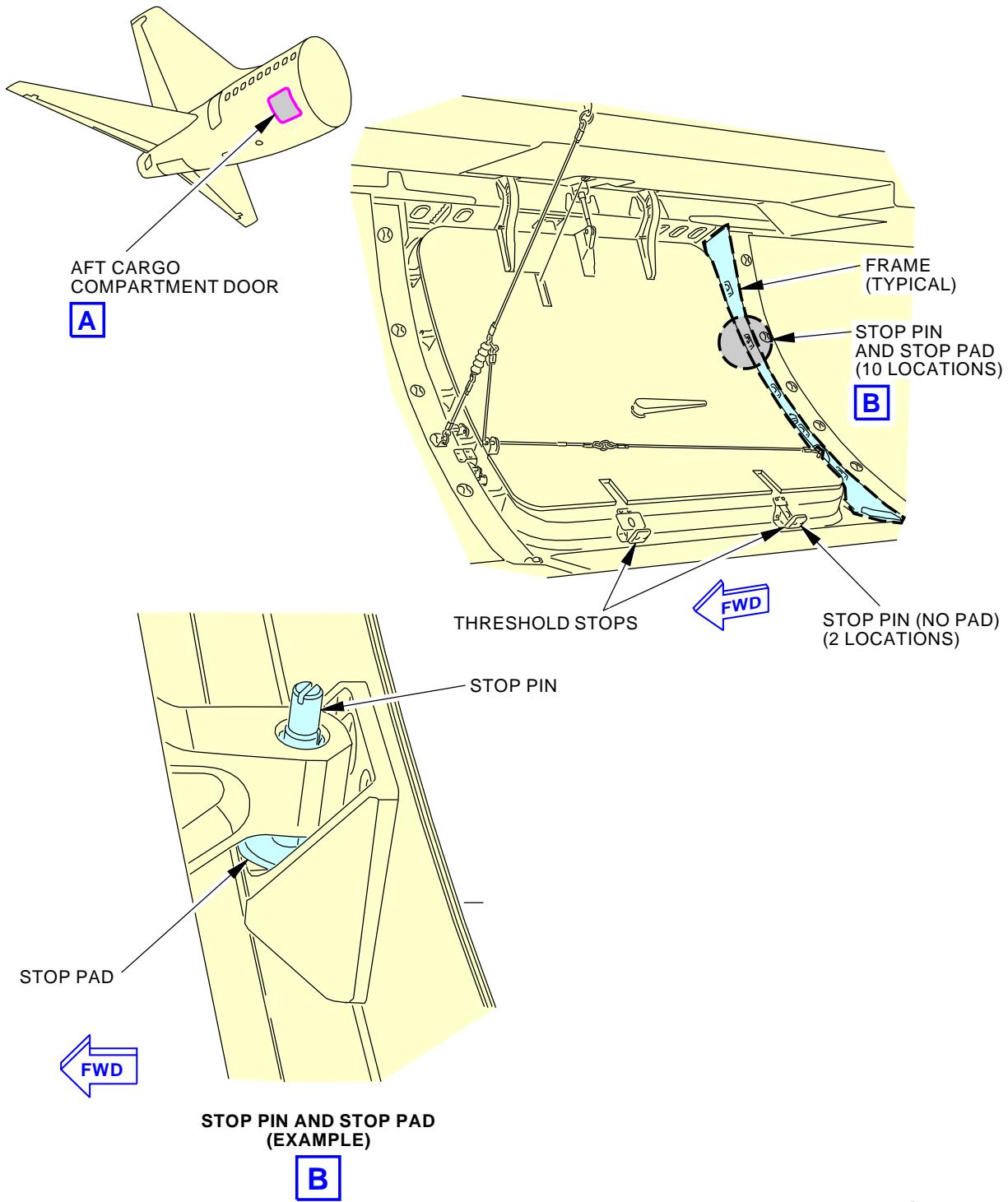
- (4) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

———— END OF TASK ————



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External - Aft Cargo Door Surround Structure Fittings and Stops
Figure 205/53-05-03-990-805

EFFECTIVITY
AKS ALL

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TASK 53-05-03-210-805

6. EXTERNAL - GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL

(Figure 206,Figure 207,Figure 208)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

B. Inspection

SUBTASK 53-05-03-210-005

- (1) Do a General Visual inspection of the main landing gear wheel well, including:
 1. Pressure deck web and stiffeners, including attachment to wing center section rear spar at Sta 663.
 2. Bulkhead at STA 663.
 3. Bulkhead and pressure web at STA 727.
 4. Keel beam chords, webs, stiffeners and splice, keel beam/rear spar attachment angles.
 5. Stringer 18A web, chord and links.
 6. Side strut support frame at STA 706.
 7. Main landing gear support frame at STA 695 and 716.
 8. Wheel well frame at STA 685.
 9. Flap track support fittings.

SUBTASK 53-05-03-910-007

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

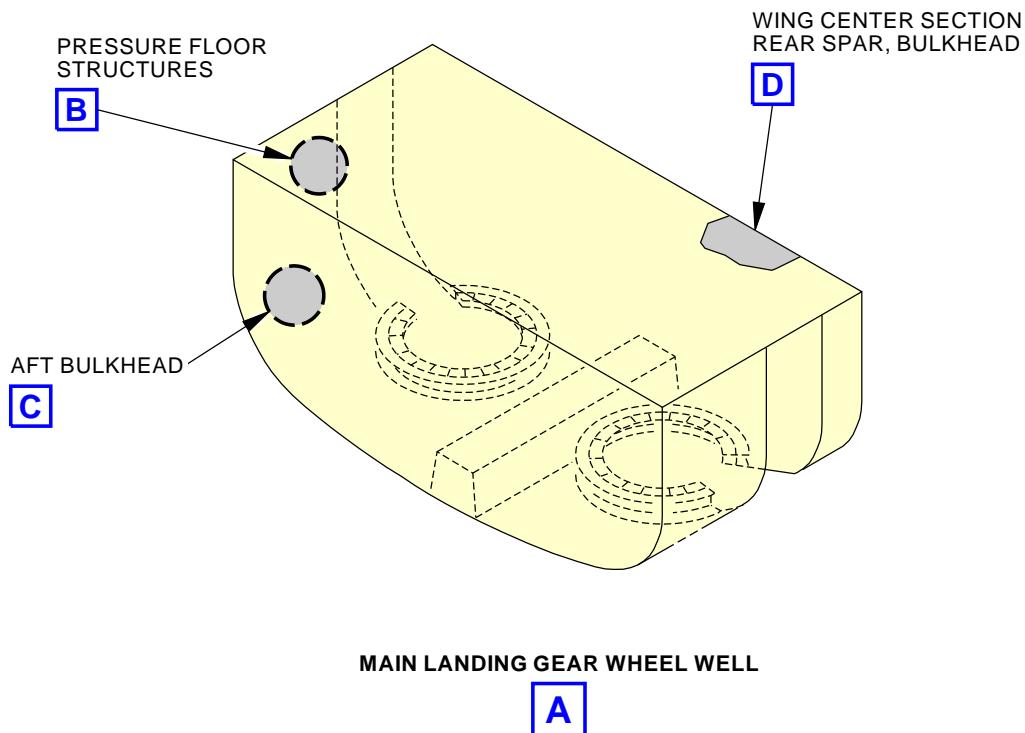
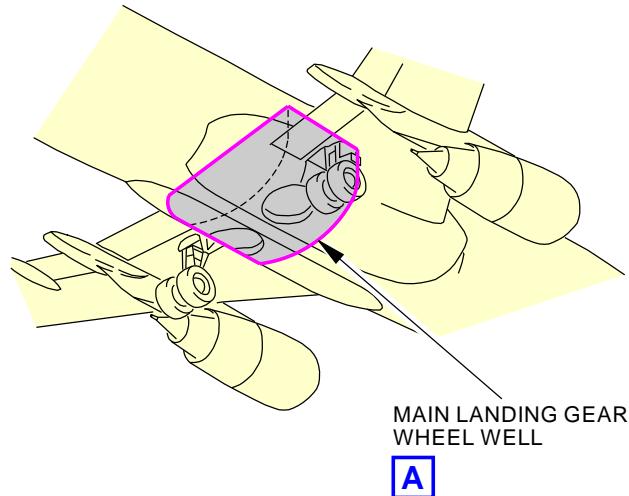
———— END OF TASK ————



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EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-835 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

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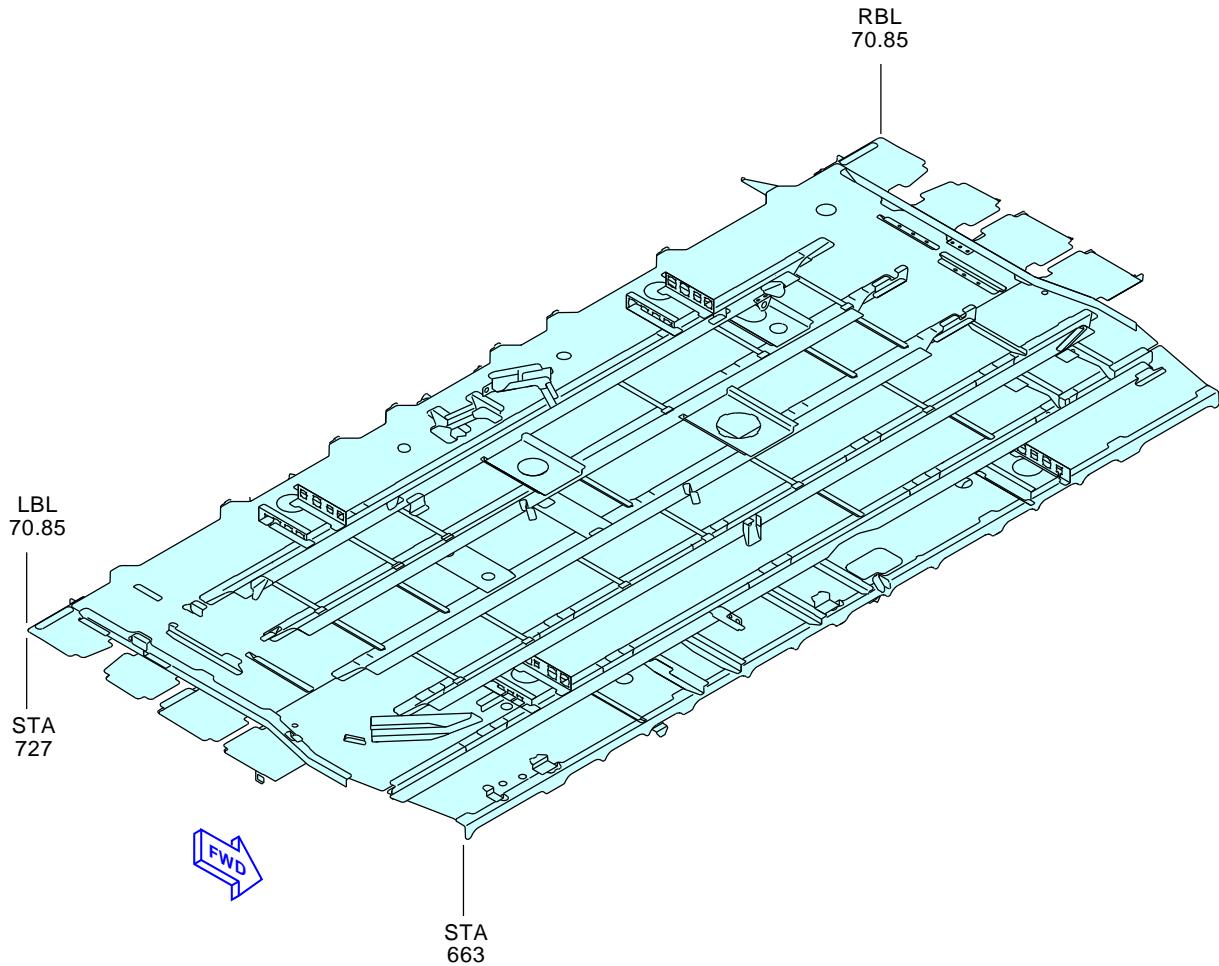
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PRESSURE FLOOR STRUCTURES
(BOTTOM VIEW LOOKING UP)

B

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EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-835 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

53-05-03

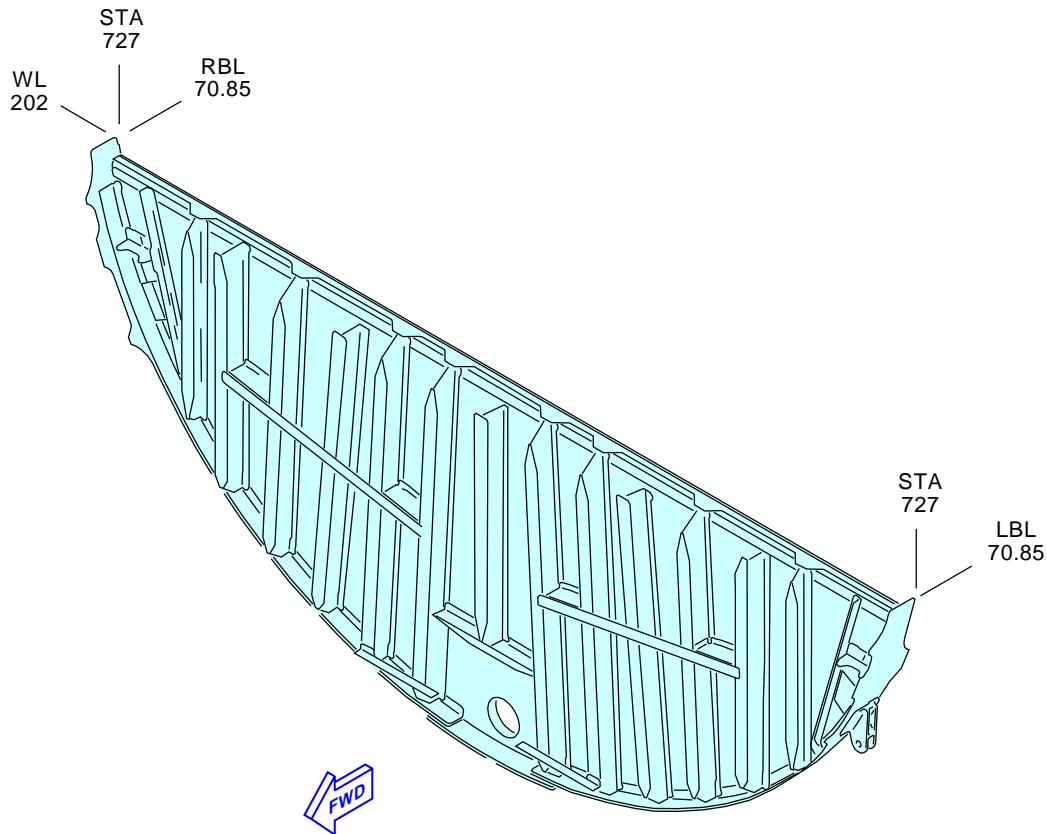
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AFT BULKHEAD
(STA 727)

C

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EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-835 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

53-05-03

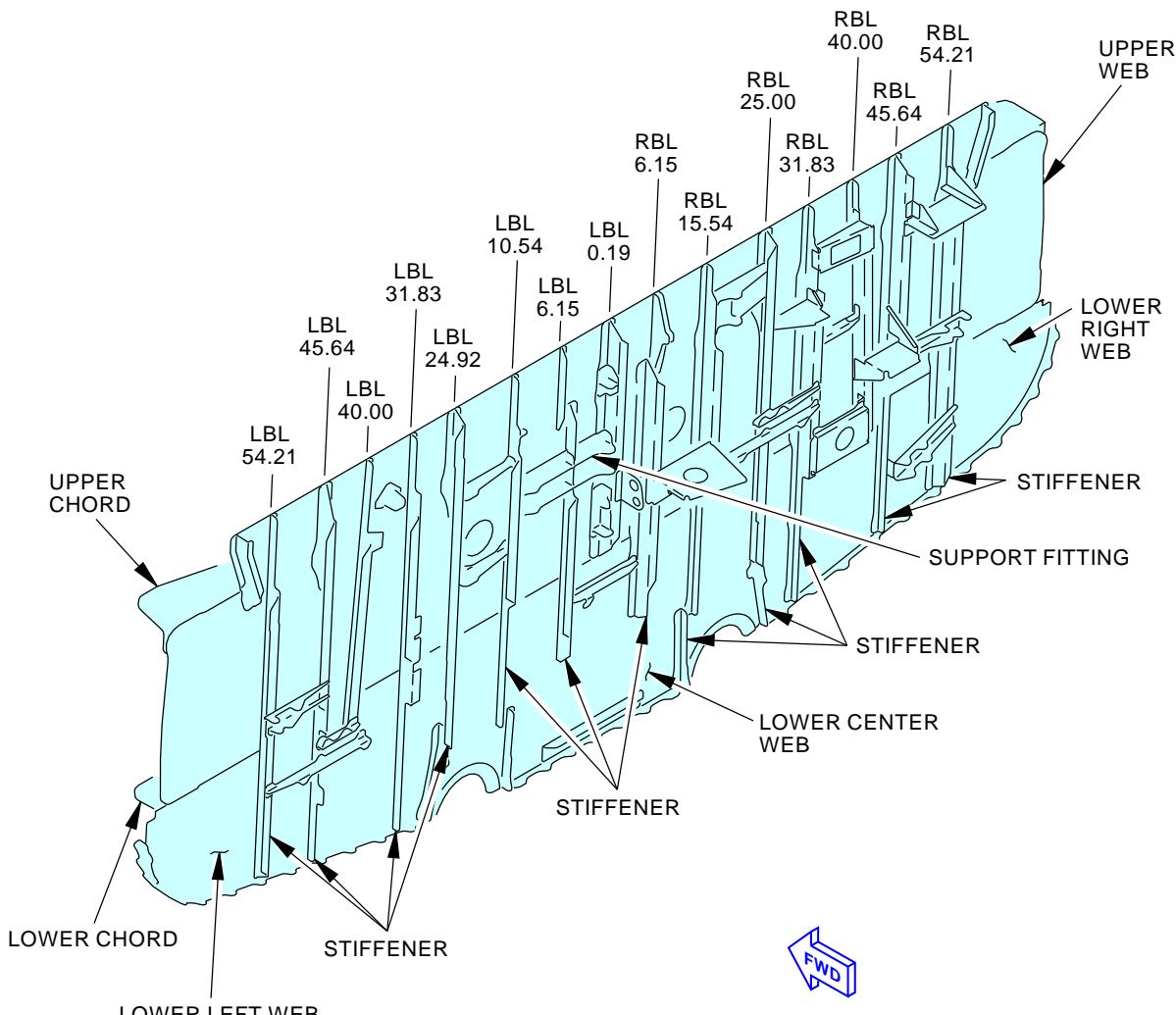
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WING CENTER SECTION
REAR SPAR, BULKHEAD
(STA 663)

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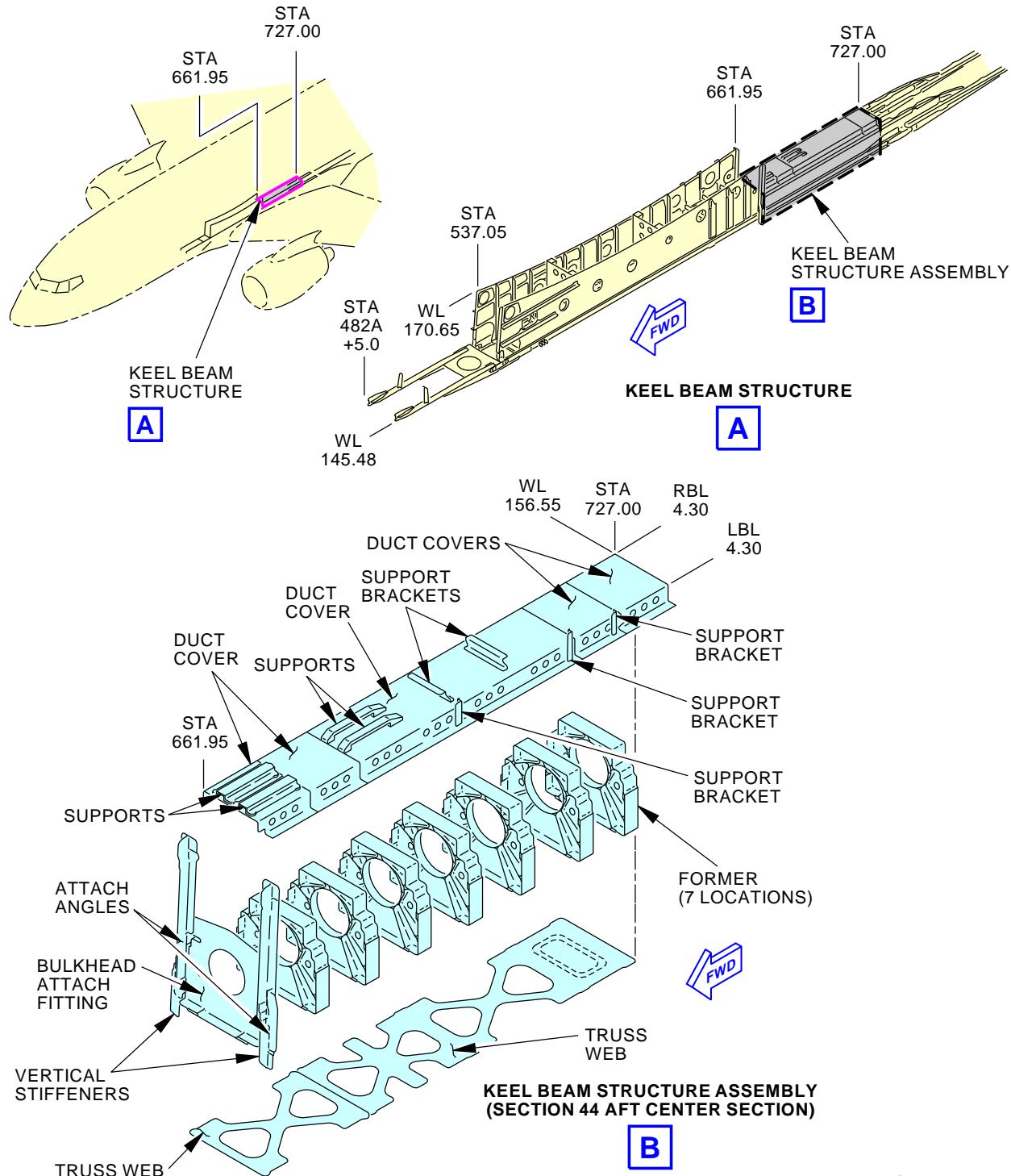
EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-835 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

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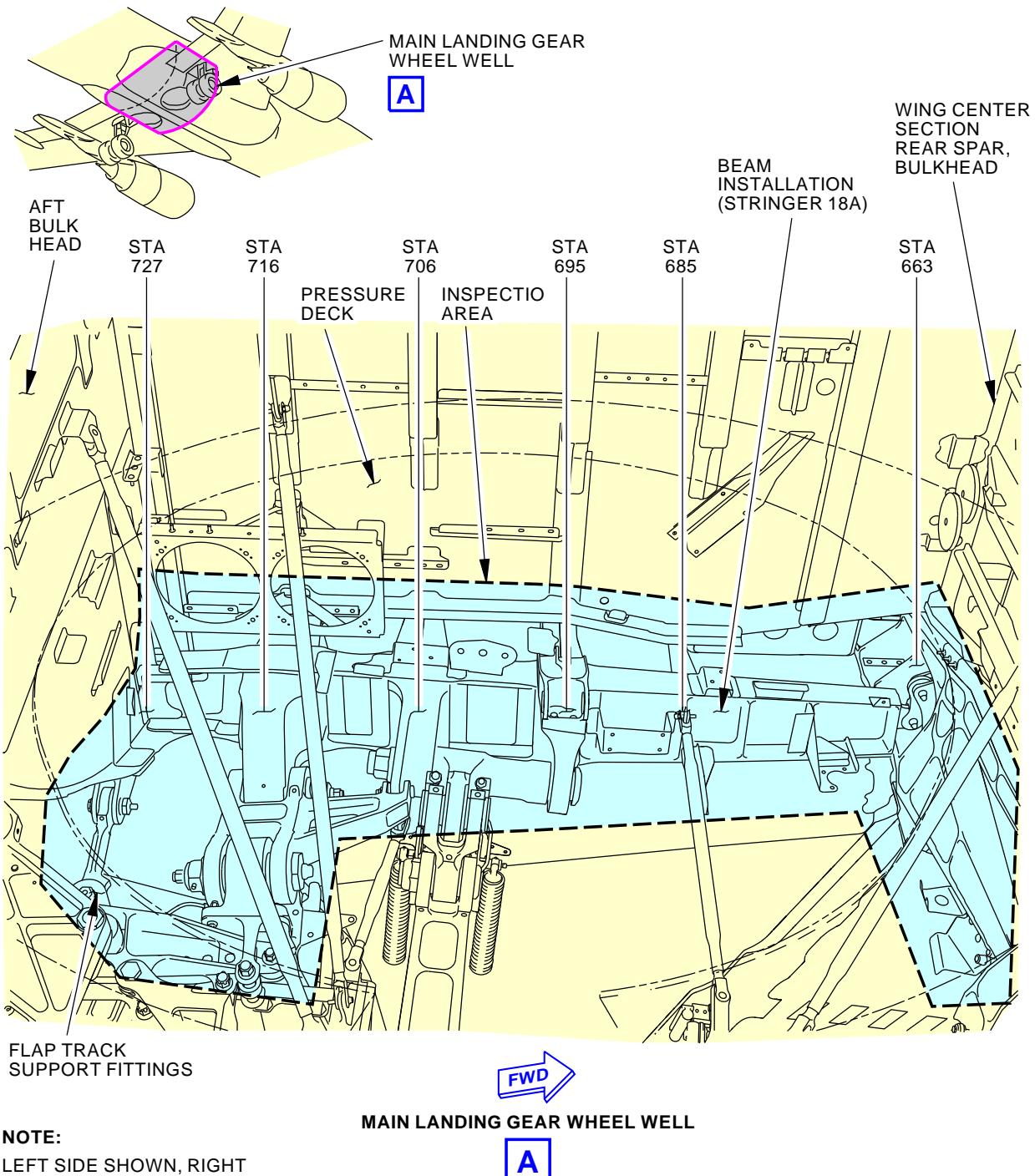
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EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 207/53-05-03-990-836

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



D80805 S0000164953_V2

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 208/53-05-03-990-837

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-806

7. INTERNAL - GENERAL VISUAL: FORWARD PRESSURE BULKHEAD

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
111	Radome

B. Access Panels

Number	Name/Location
111	Radome

C. Inspection

SUBTASK 53-05-03-010-004

- (1) Open this access panel:

Number	Name/Location
111	Radome

NOTE: Open nose radome.

SUBTASK 53-05-03-210-006

- (2) Do a General Visual inspection of the forward side of STA 178 bulkhead.

SUBTASK 53-05-03-910-008

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-004

- (4) Close this access panel:

Number	Name/Location
111	Radome

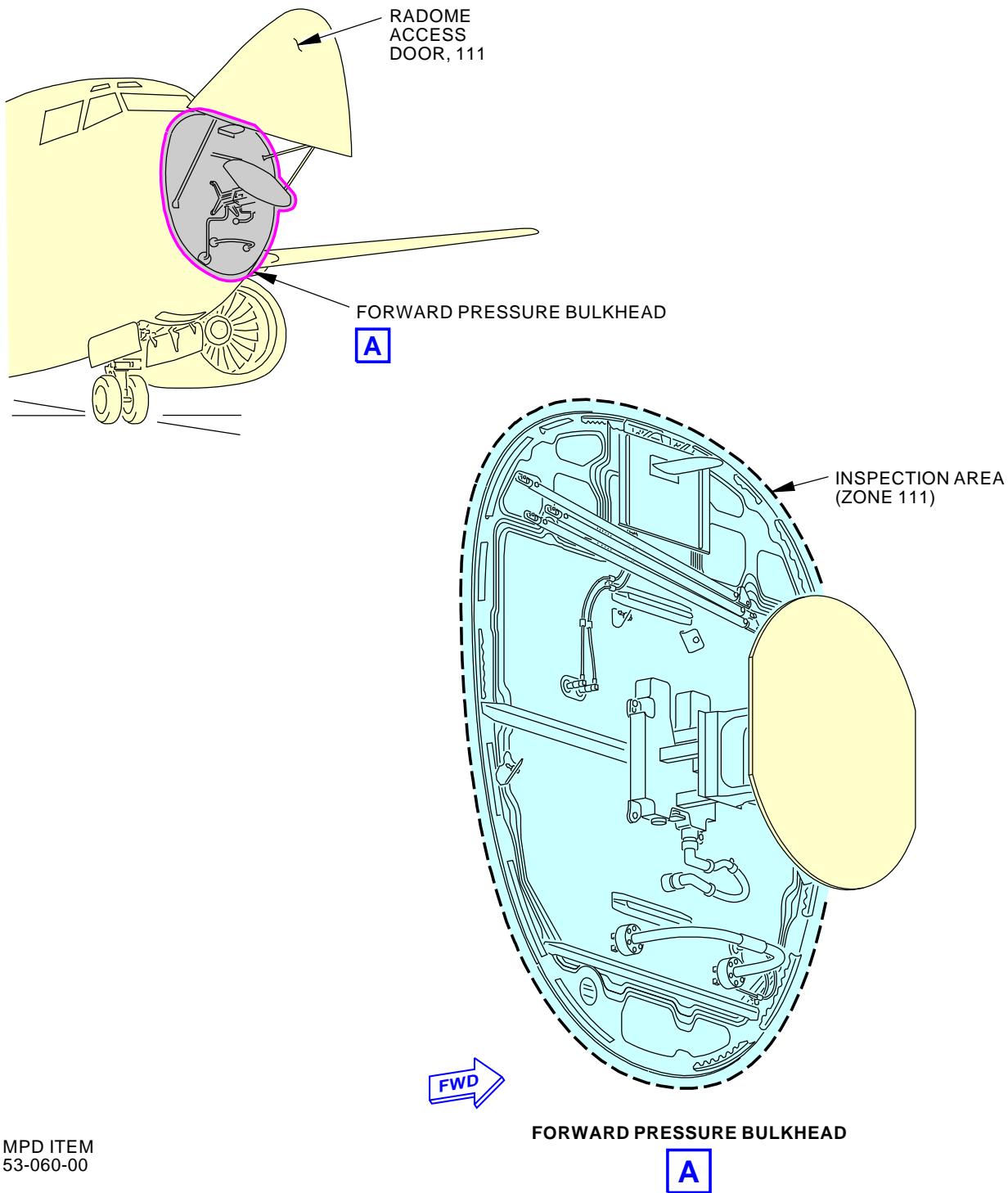
———— END OF TASK ————



53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



Forward Pressure Bulkhead, Sta. 178
Figure 209/53-05-03-990-894

EFFECTIVITY	AKS ALL
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D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-807

8. INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE WHEEL WELL

(Figure 210)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

C. Inspection

SUBTASK 53-05-03-010-005

- (1) Open these access panels:

Number	Name/Location
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

NOTE: Remove weather radar RT mount. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-007

- (2) Do a General Visual inspection of the fuselage lower lobe from STA 178 bulkhead to canted bulkhead (STA 224.8 to 227.8), including bulkheads, skin panels (skins, frames, stringers), longitudinal lap splices, forward access door cutout, and nose wheel well cutout.

SUBTASK 53-05-03-910-009

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-005

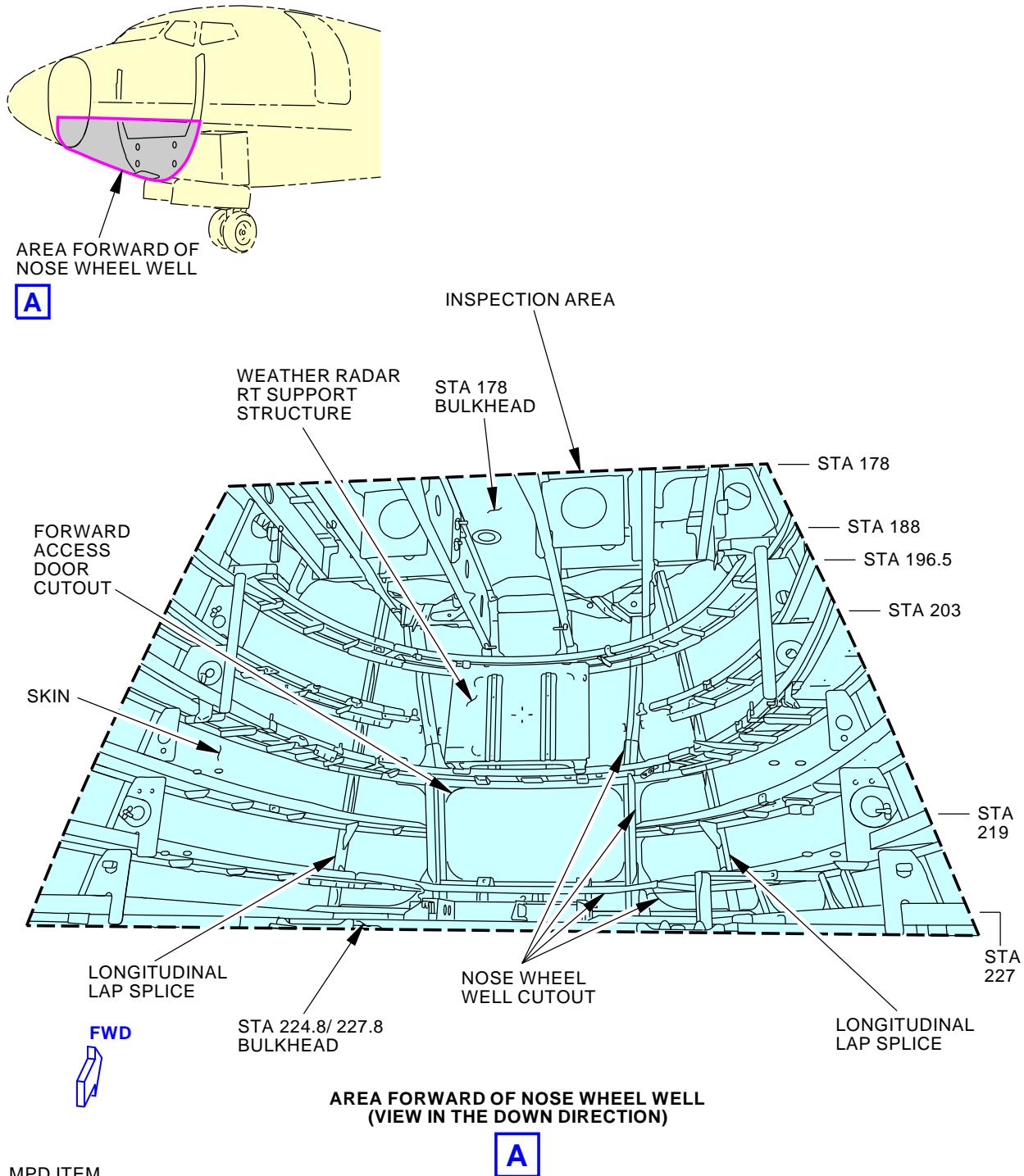
- (4) Close these access panels:

Number	Name/Location
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

———— END OF TASK ————



53-05-03



MPD ITEM
53-070-00

2069529 S0000429375_V2

Forward of Nose Landing Gear Wheel Well General Visual (Internal)
Figure 210/53-05-03-990-845

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-808

9. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
112A	Forward Access Door

C. Inspection

SUBTASK 53-05-03-010-006

- (1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

NOTE: Access through forward access door.

SUBTASK 53-05-03-210-008

- (2) Do a General Visual inspection of the flight compartment floor structure from lower lobe.

SUBTASK 53-05-03-910-010

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-006

- (4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

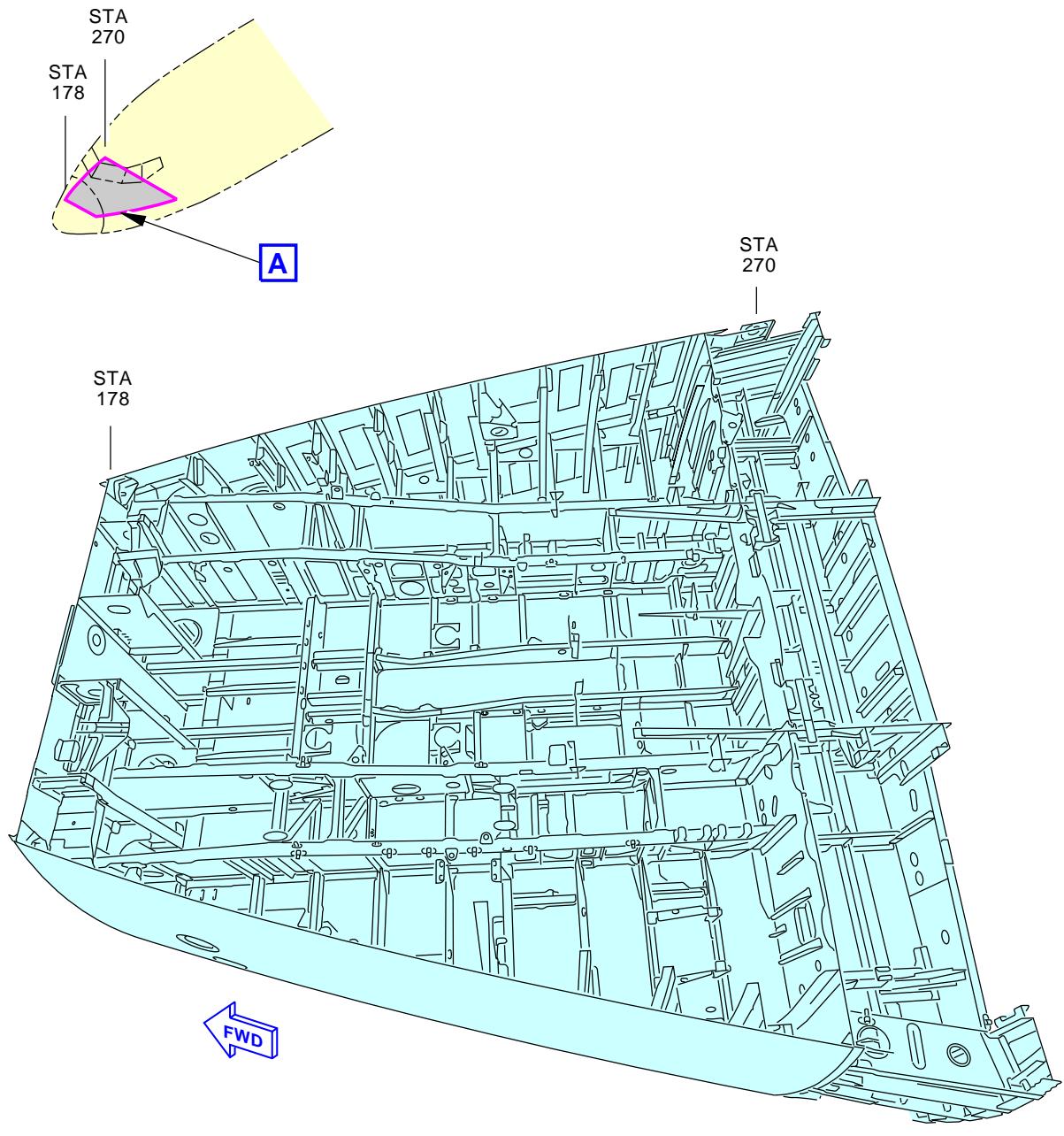
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53-05-03



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(VIEW IN THE UP DIRECTION)



MPD ITEM
53-080-00

D63217 S0000162565_V3

Flight Deck Floor Structure
Figure 211/53-05-03-990-830

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-809

10. INTERNAL - GENERAL VISUAL: AREA ABOVE AND OUTBOARD OF NOSE WHEEL WELL

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
S1101	Area Above And Outboard of Nose Wheel Well Inspection

C. Inspection

SUBTASK 53-05-03-010-007

- (1) Open these access panels:

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Access through nose wheel well side and top access panels, and through access panel in crew floor. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-009

- (2) Do a General Visual inspection of the fuselage lower lobe from canted bulkhead (Sta 224.8 to 227.8) to Sta 294, including:
1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at Sta 259.5.
 2. Nose wheel well cutout surround structure, nose wheel well side and top panels.
 3. Trunnion support fitting, actuator support fitting and drag brace fitting.

SUBTASK 53-05-03-910-011

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-007

- (4) Close these access panels:

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
S1101	Area Above And Outboard of Nose Wheel Well Inspection

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

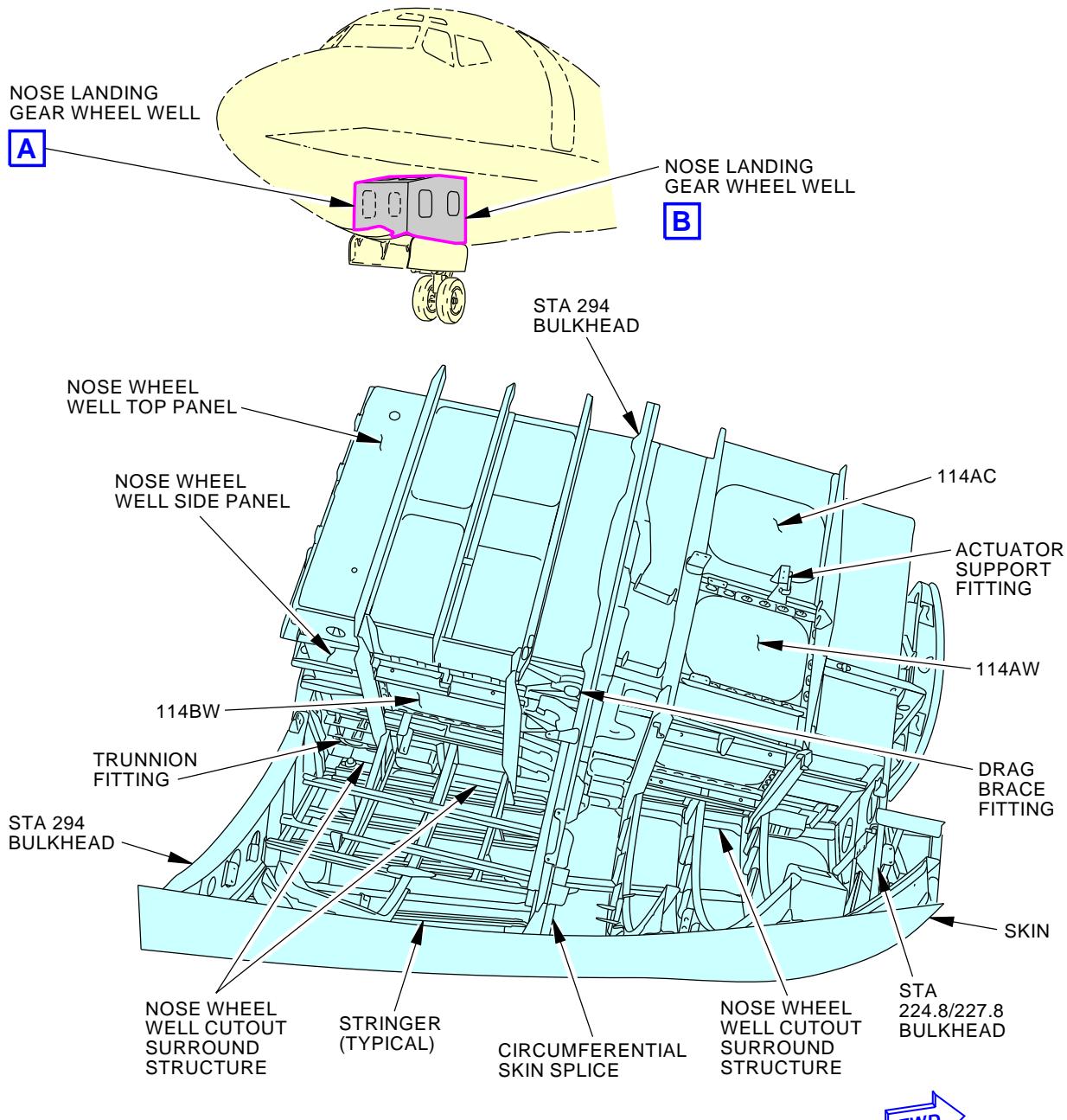
———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03

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D633A101-AKS



**NOSE LANDING GEAR WHEEL WELL
(RIGHT SIDE, VIEW IN THE INBOARD DIRECTION)**

A

MPD ITEM
53-090-00

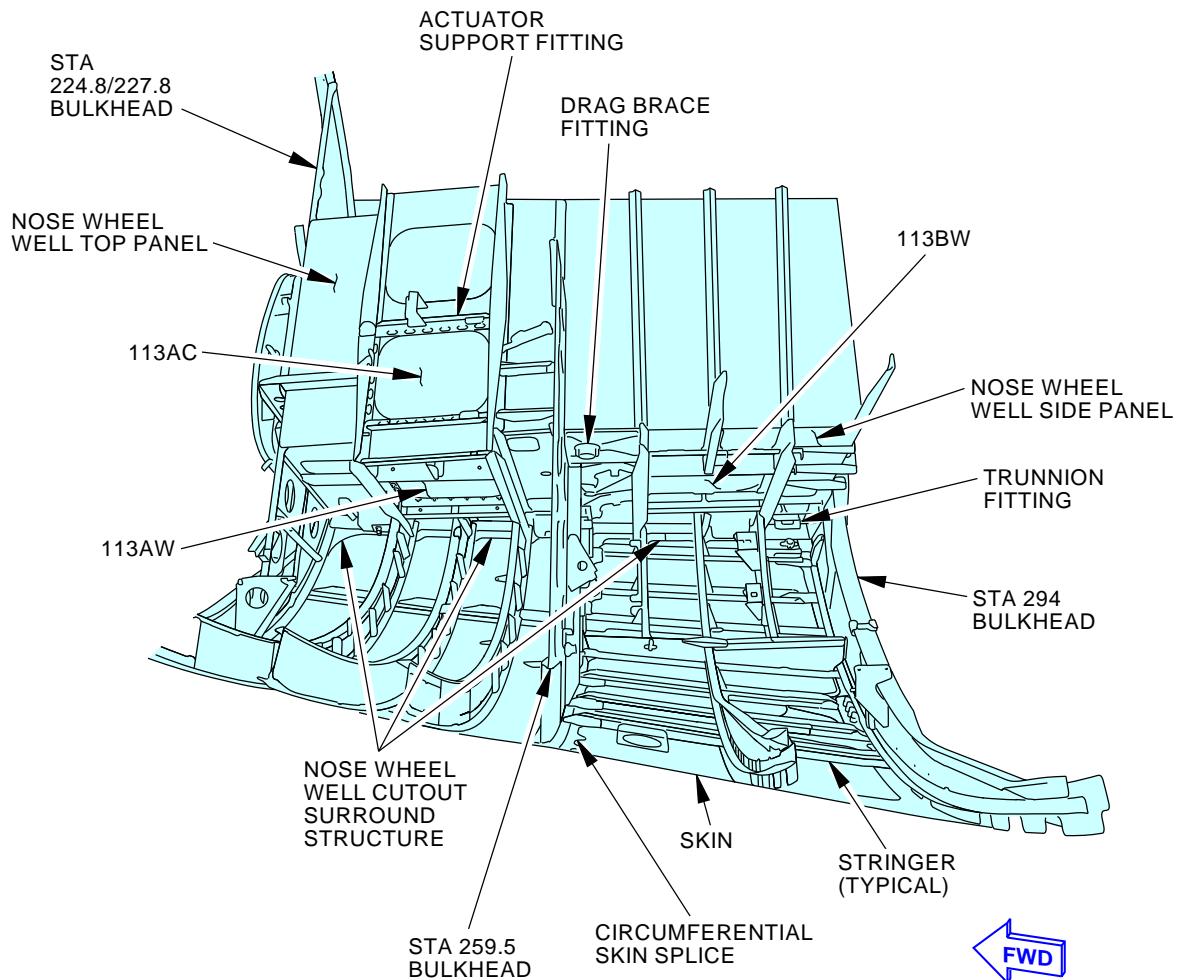
2069612 S0000429415_V2

**Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)
Figure 212/53-05-03-990-844 (Sheet 1 of 2)**

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



MPD ITEM
53-090-00

2070792 S0000429416_V2

Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)
Figure 212/53-05-03-990-844 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-810

11. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA
(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
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

B. Access Panels

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

C. Inspection

SUBTASK 53-05-03-010-008

- (1) Open these access panels:

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required. Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstairs compartment (if installed).

SUBTASK 53-05-03-210-010

- (2) Do a General Visual inspection of the passenger compartment floor structure in dry areas (away from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-012

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-008

- (4) Close these access panels:

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

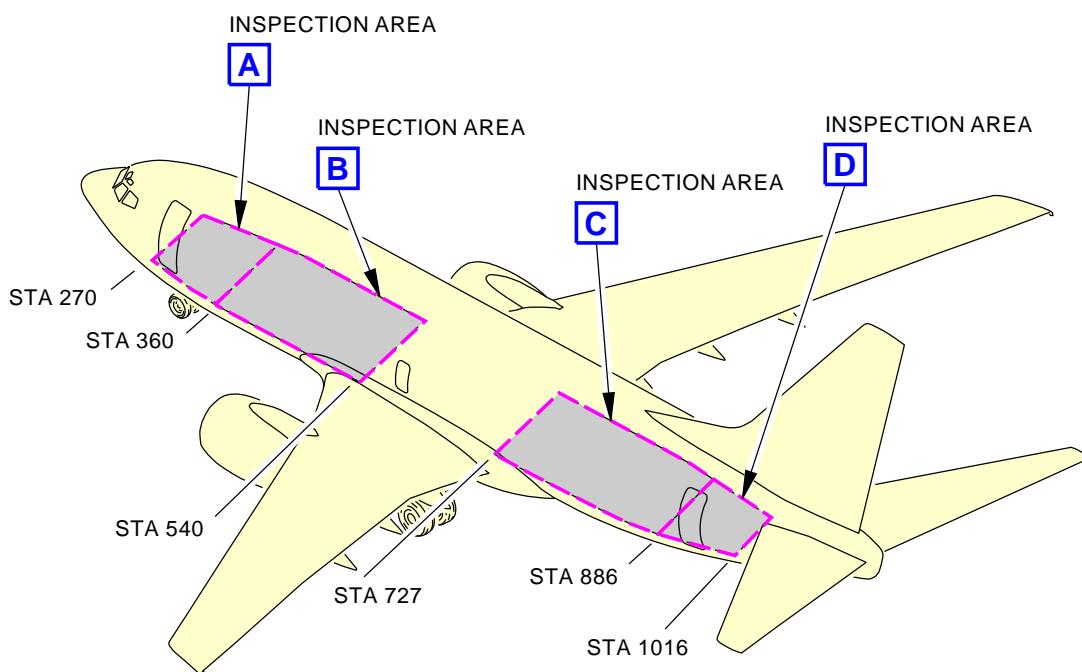
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EFFECTIVITY
AKS ALL

53-05-03



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MPD ITEM
53-100-00

2089311 S0000440307_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-849 (Sheet 1 of 5)

EFFECTIVITY
AKS ALL

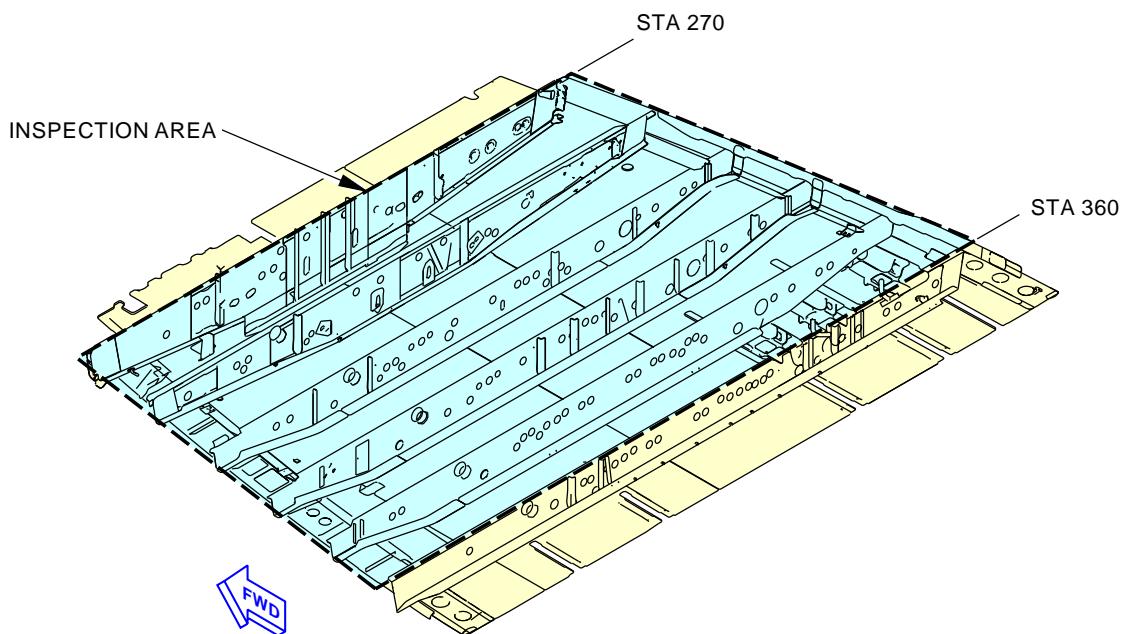
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53-05-03

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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

A

MPD ITEM
53-100-00

2089843 S0000440308_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-849 (Sheet 2 of 5)

EFFECTIVITY
AKS ALL

53-05-03

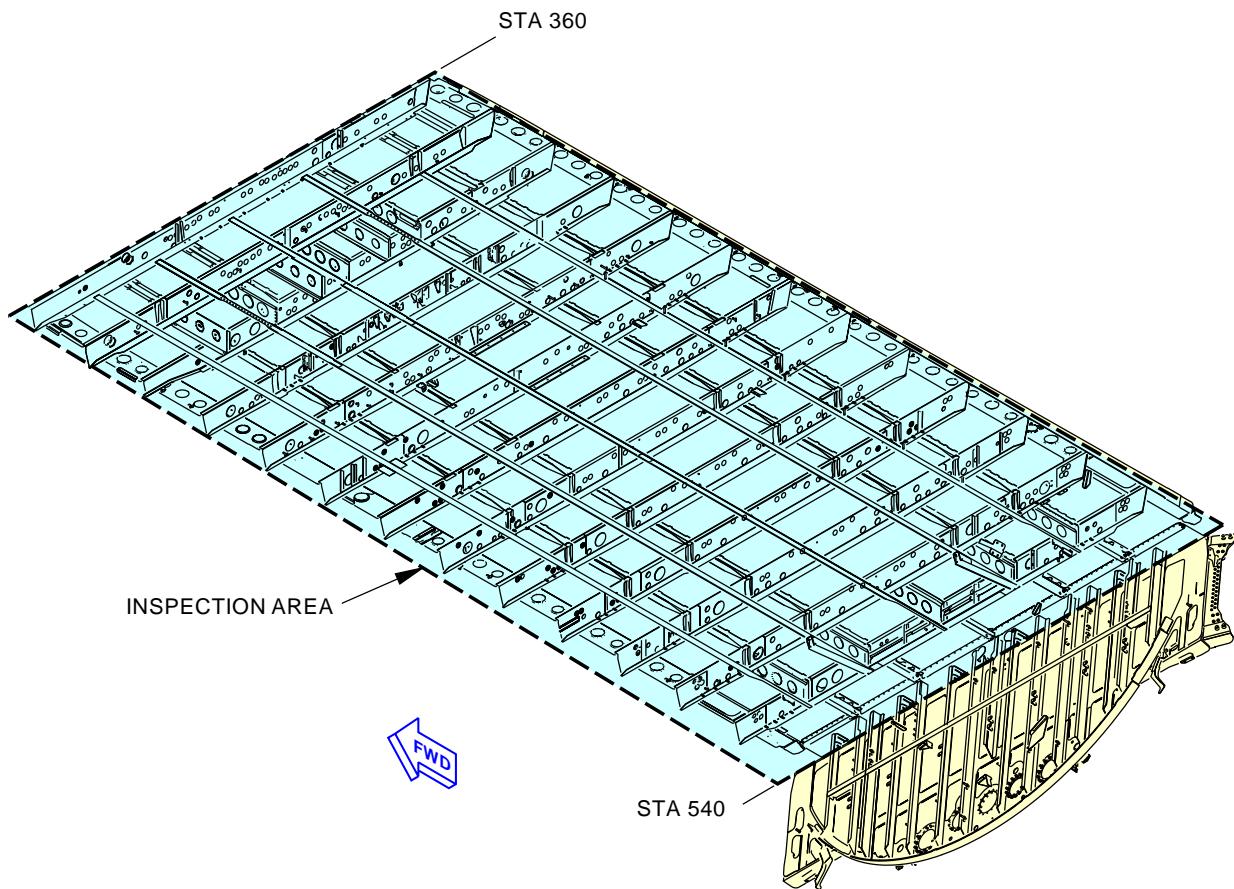
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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

B

MPD ITEM
53-100-00

2089847 S0000440309_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-849 (Sheet 3 of 5)

EFFECTIVITY
AKS ALL

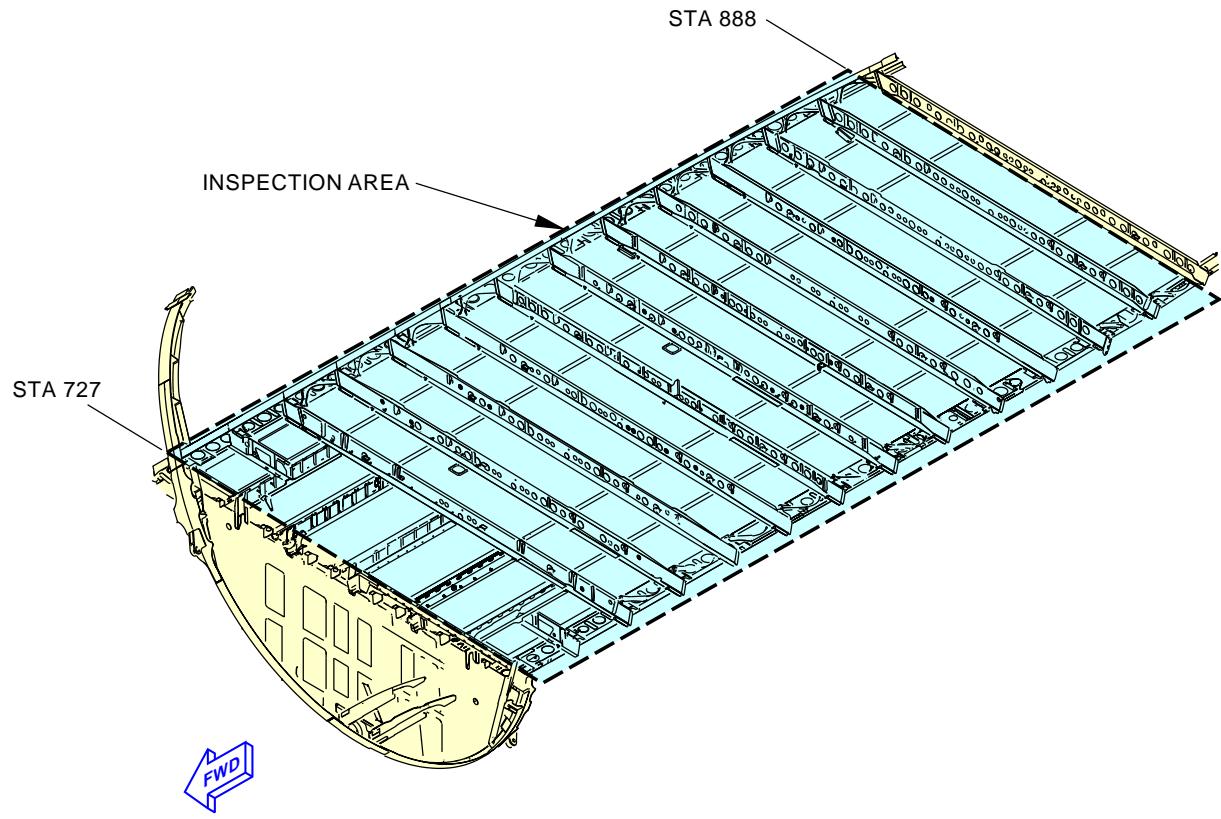
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53-05-03

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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

C

MPD ITEM
53-100-00

2089855 S0000440310_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-849 (Sheet 4 of 5)

EFFECTIVITY
AKS ALL

53-05-03

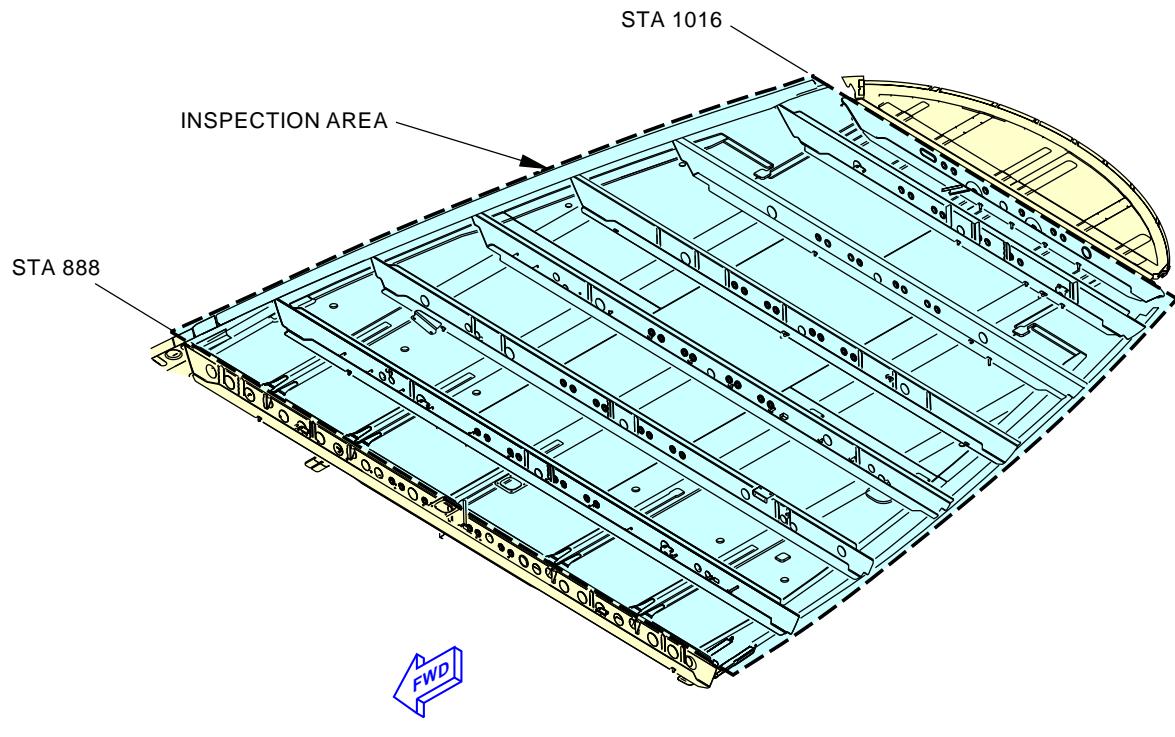
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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

D

MPD ITEM
53-100-00

2089863 S0000440311_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-849 (Sheet 5 of 5)

EFFECTIVITY

AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-811

12. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA
(Figure 214)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
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

B. Access Panels

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

C. Inspection

SUBTASK 53-05-03-010-009

- (1) Open these access panels:

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required. Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstair compartment (if installed. 117BL).

SUBTASK 53-05-03-210-011

- (2) Do a General Visual inspection of the passenger compartment floor structure in wet areas (within approximately 20 inches from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-013

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-009

- (4) Close these access panels:

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

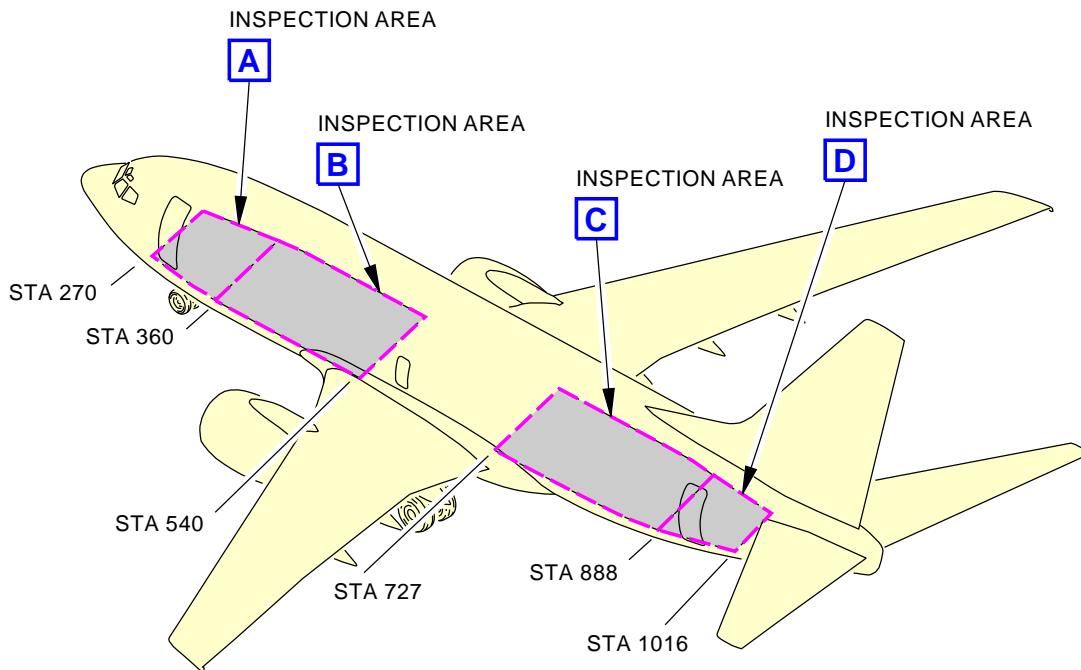
— END OF TASK —

EFFECTIVITY
AKS ALL

53-05-03



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MPD ITEM
53-110-00

2123126 S0000457776_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-869 (Sheet 1 of 5)

EFFECTIVITY
AKS ALL

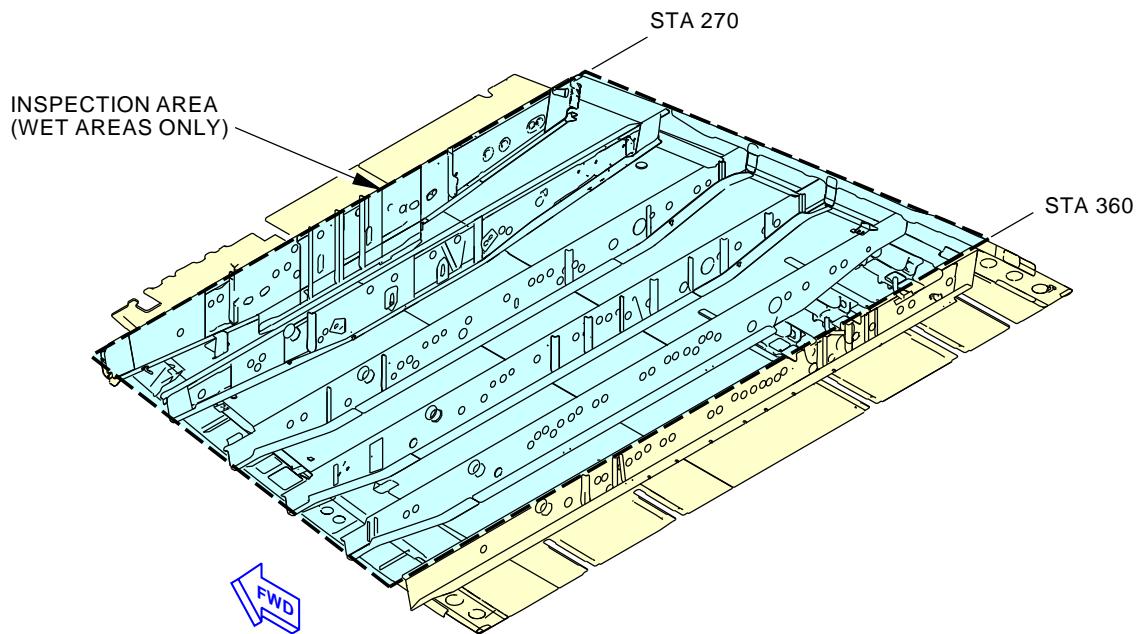
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53-05-03

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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

A

MPD ITEM
53-110-00

2123135 S0000457777_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-869 (Sheet 2 of 5)

EFFECTIVITY
AKS ALL

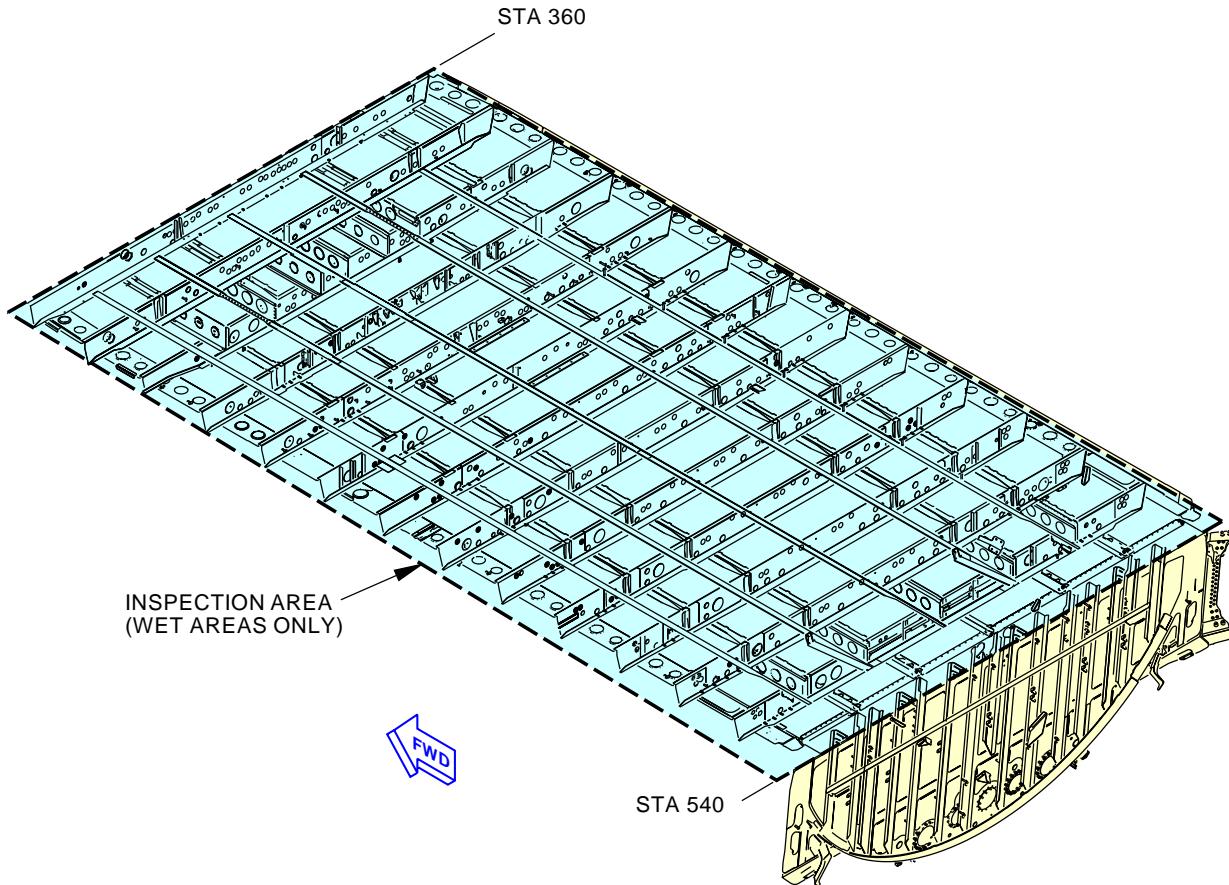
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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

B

MPD ITEM
53-110-00

2123138 S0000457778_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-869 (Sheet 3 of 5)

EFFECTIVITY
AKS ALL

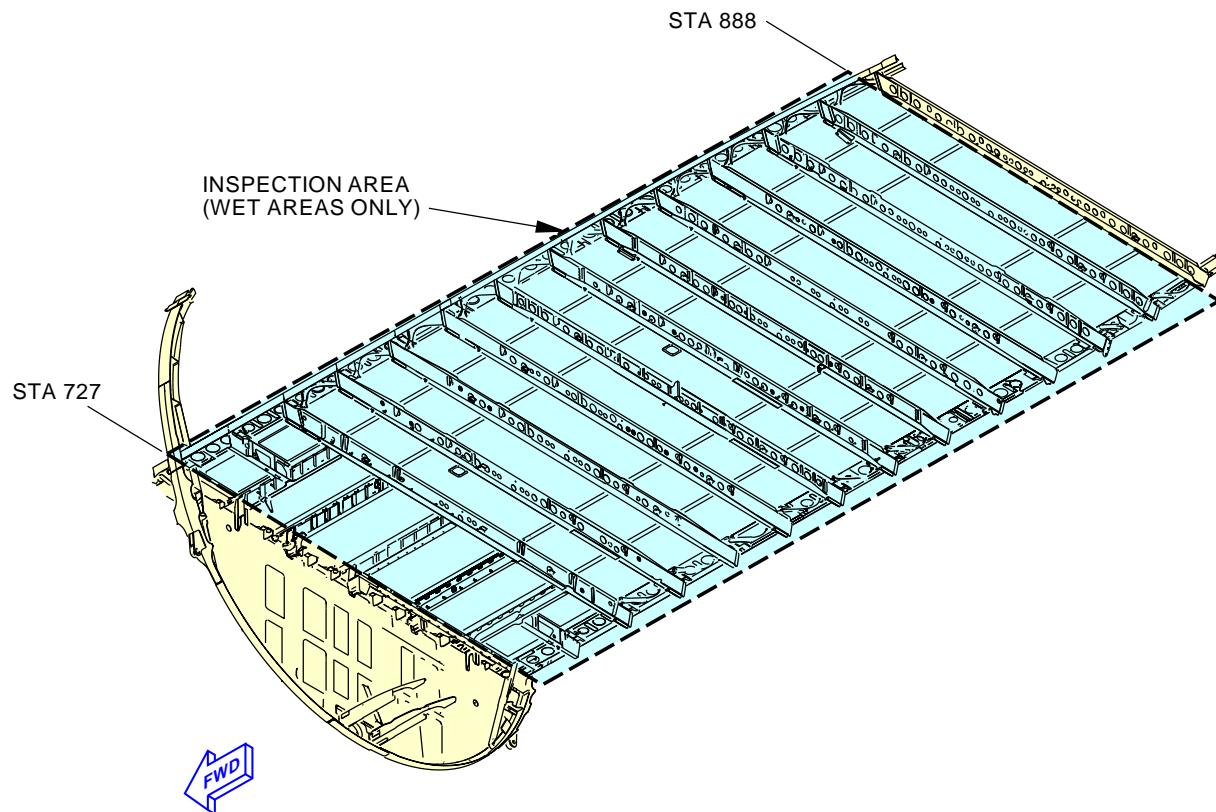
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53-05-03

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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

C

MPD ITEM
53-110-00

2123141 S0000457779_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-869 (Sheet 4 of 5)

EFFECTIVITY
AKS ALL

53-05-03

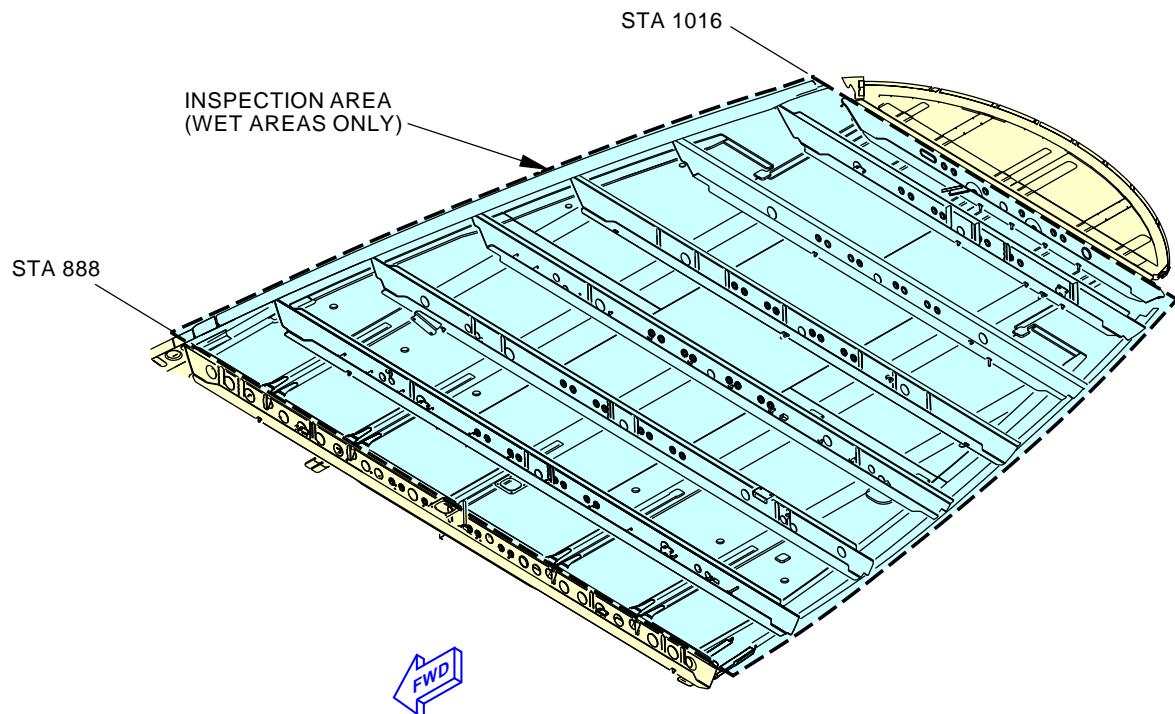
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PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

D

MPD ITEM
53-110-00

2123145 S0000457780_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-869 (Sheet 5 of 5)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-812

13. INTERNAL - GENERAL VISUAL: ELECTRICAL AND ELECTRONICS COMPARTMENT

(Figure 215)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-010

- (1) Open these access panels:

Number	Name/Location
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

NOTE: Remove LRUs and racks, do not remove permanently installed structure.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-012

- (2) Do a General Visual inspection of the EE compartment (STA 294.5 to 396 (STA 400 for 737-700C)), including:

1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at STA 294.5.
2. EE compartment door and airstairs door cutout surround structure.
3. Forward entry and galley door cutout surround structure (portion in lower lobe).

SUBTASK 53-05-03-910-014

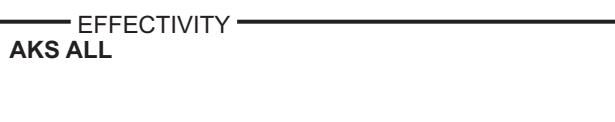
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-010

- (4) Close these access panels:

Number	Name/Location
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

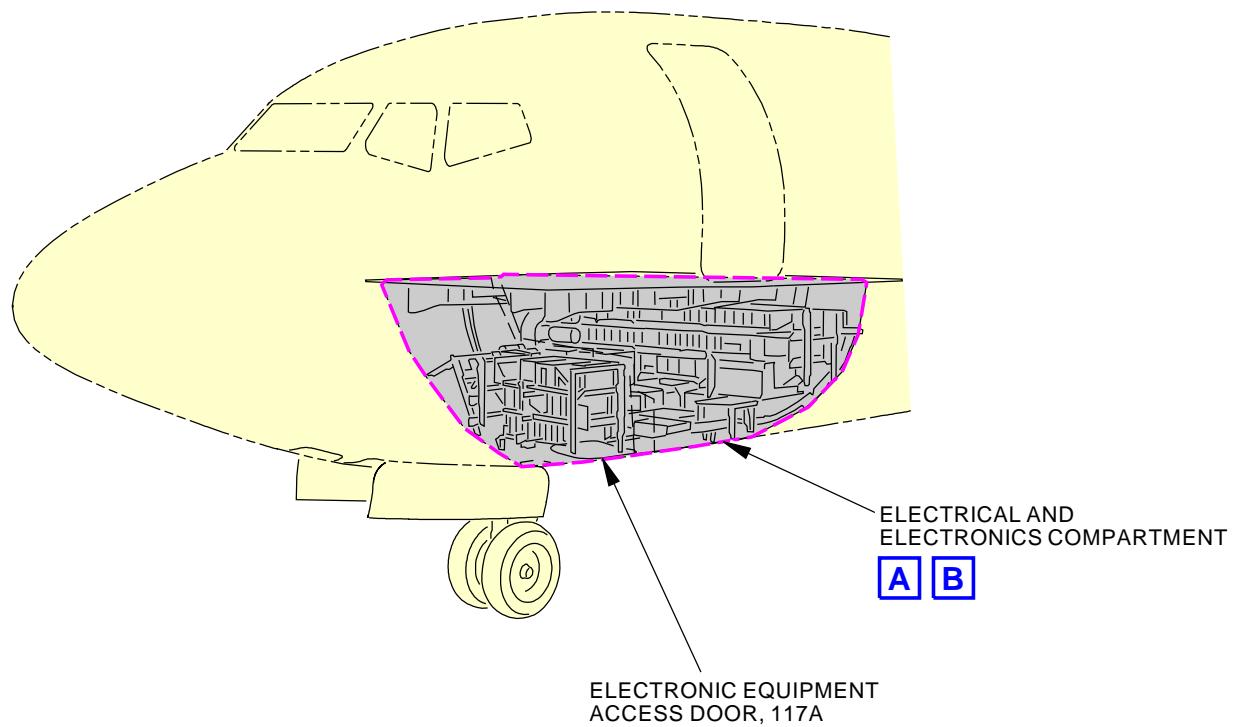
———— END OF TASK ————



53-05-03



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MPD ITEM
53-120-00

2084073 S0000437120_V2

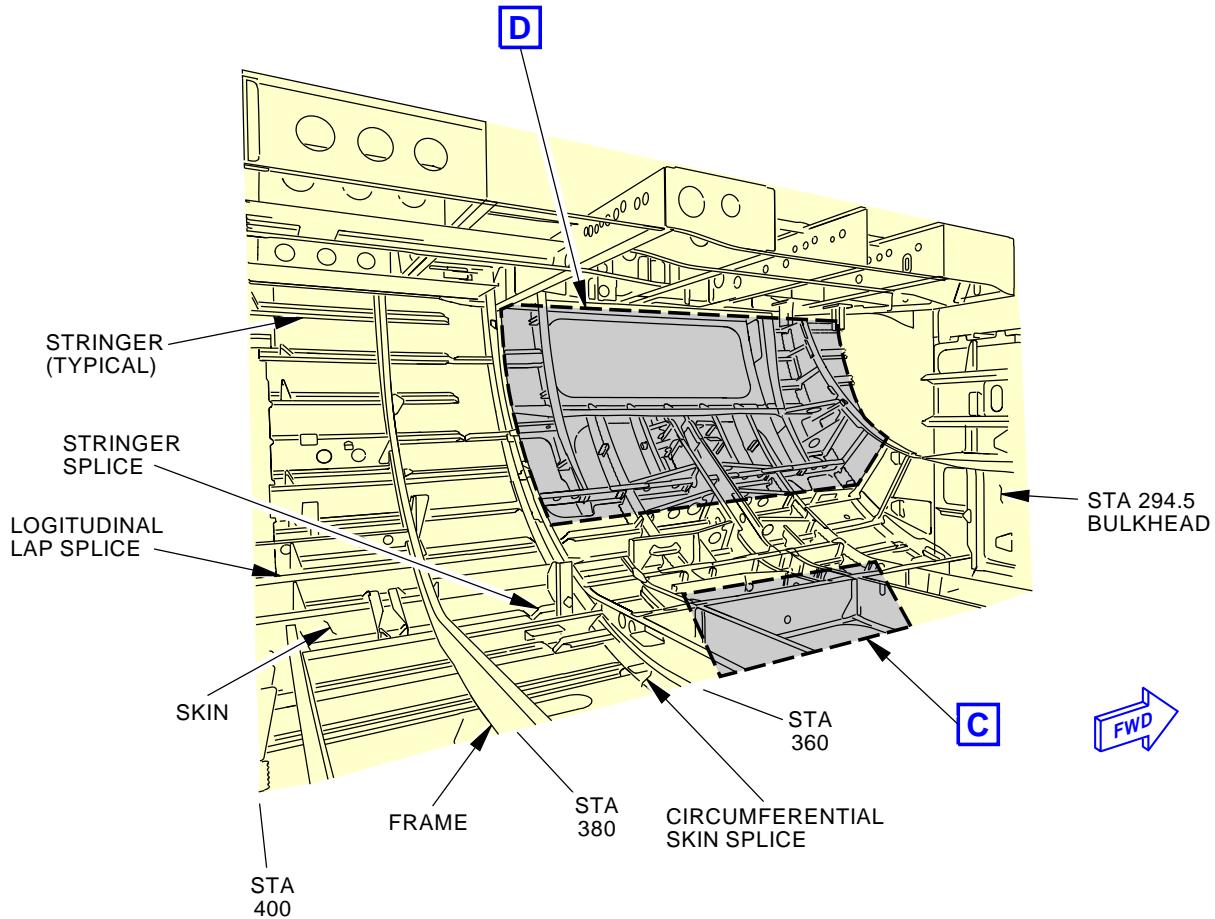
Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 1 of 6)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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ELECTRICAL AND ELECTRONIC COMPARTMENT
(LEFT SIDE)

A

MPD ITEM
53-120-00

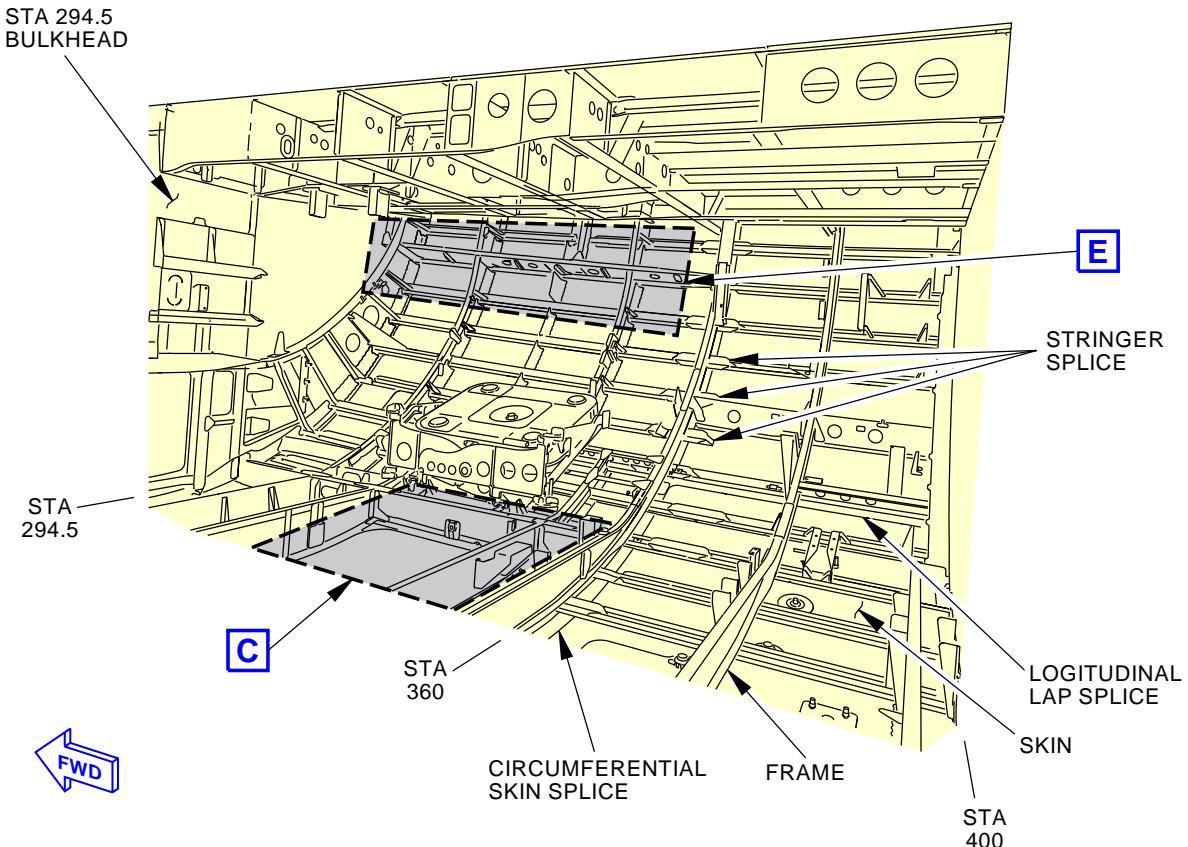
2083911 S0000437121_V2

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 2 of 6)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



**ELECTRICAL AND ELECTRONIC COMPARTMENT
(RIGHT SIDE)**

B

MPD ITEM
53-120-00

2081267 S0000437122_V2

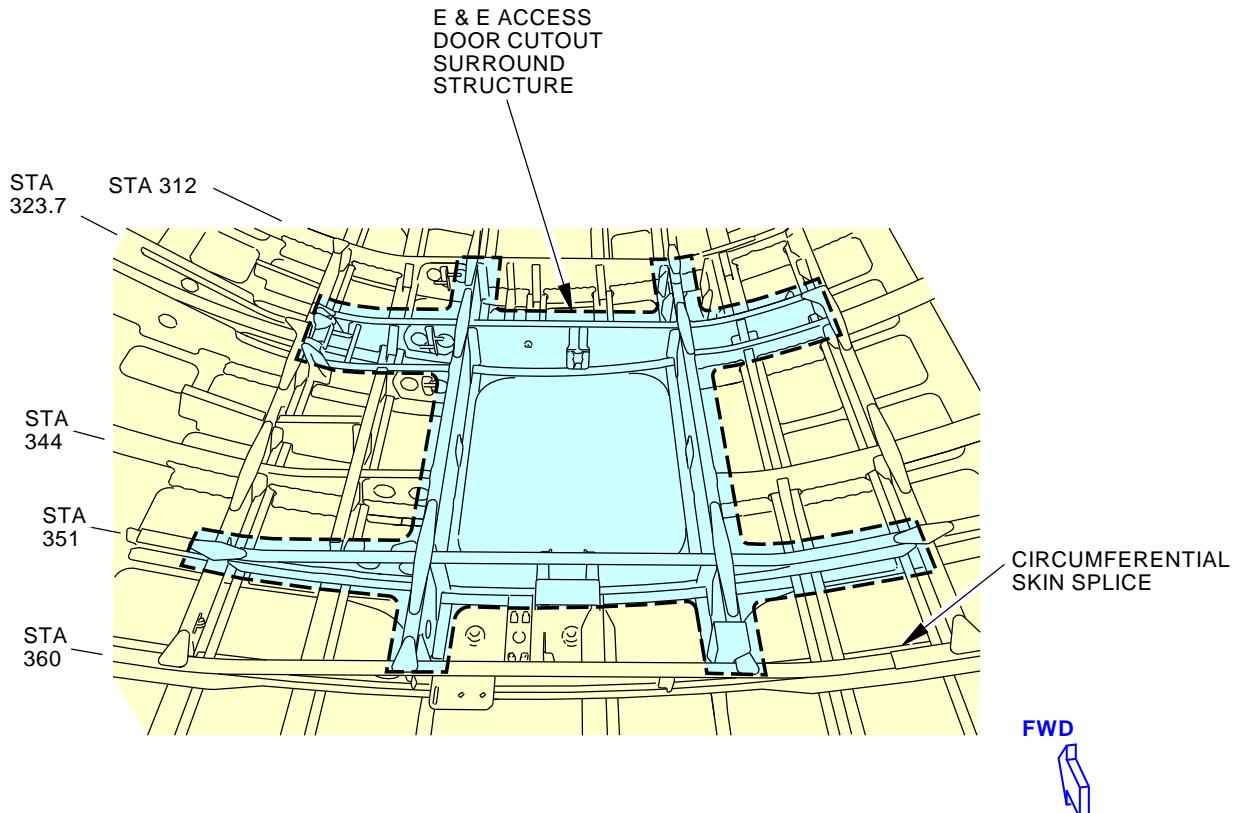
**Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 3 of 6)**

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL



ELECTRICAL AND ELECTRONIC COMPARTMENT
ACCESS DOOR CUTOUT SURROUND STRUCTURE

C

MPD ITEM
53-120-00

2084481 S0000437123_V2

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 4 of 6)

EFFECTIVITY
AKS ALL

D633A101-AKS

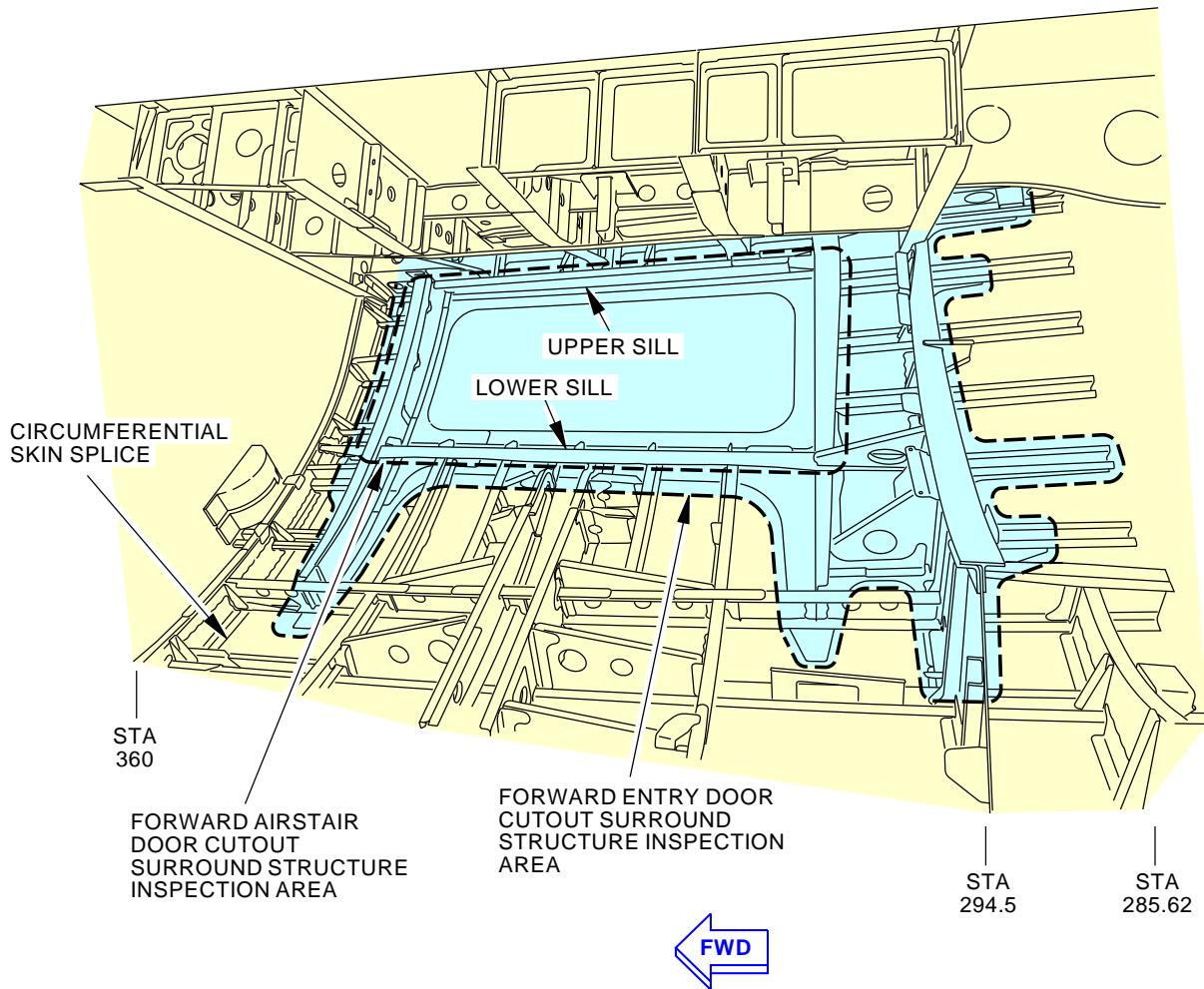
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FORWARD AIRSTAIR DOOR AND FORWARD ENTRY DOOR CUTOUT
AND SURROUND STRUCTURE

D

MPD ITEM
53-120-00

2088473 S0000437124_V3

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 5 of 6)

EFFECTIVITY
AKS ALL

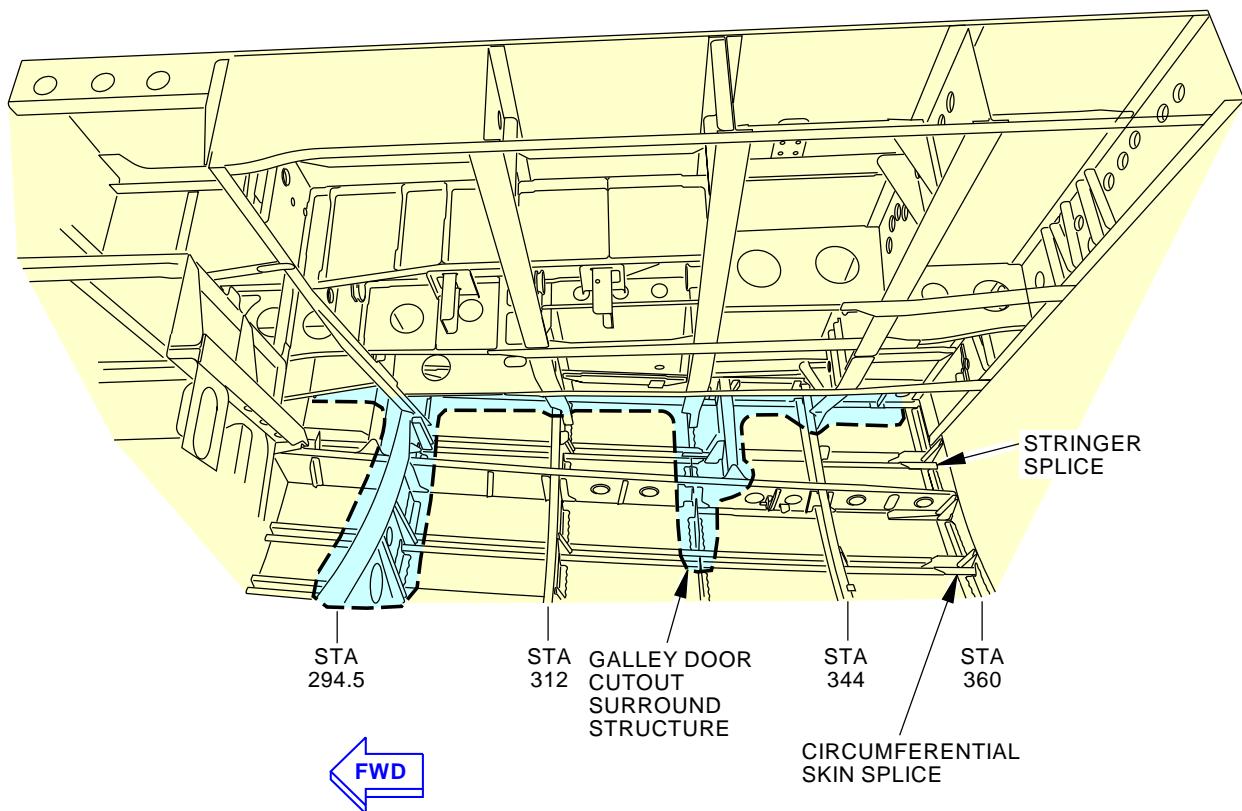
D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL



GALLEY DOOR CUTOUT SURROUND STRUCTURE

E

MPD ITEM
53-120-00

2086454 S0000437125_V2

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-843 (Sheet 6 of 6)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-813

14. INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT

(Figure 216)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
S1201	Forward Cargo Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-011

- (1) Open this access panel:

Number	Name/Location
S1201	Forward Cargo Compartment Inspection

NOTE: Remove sidewalls and ceiling panels. Remove/displace insulation blankets as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-013

- (2) Do a General Visual inspection of the forward cargo compartment skin panels including skins, frames, and stringers (note: inspection includes the circumferential skin and stringer splice at STA 500E for the -900 models).

SUBTASK 53-05-03-910-015

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-011

- (4) Close this access panel:

Number	Name/Location
S1201	Forward Cargo Compartment Inspection

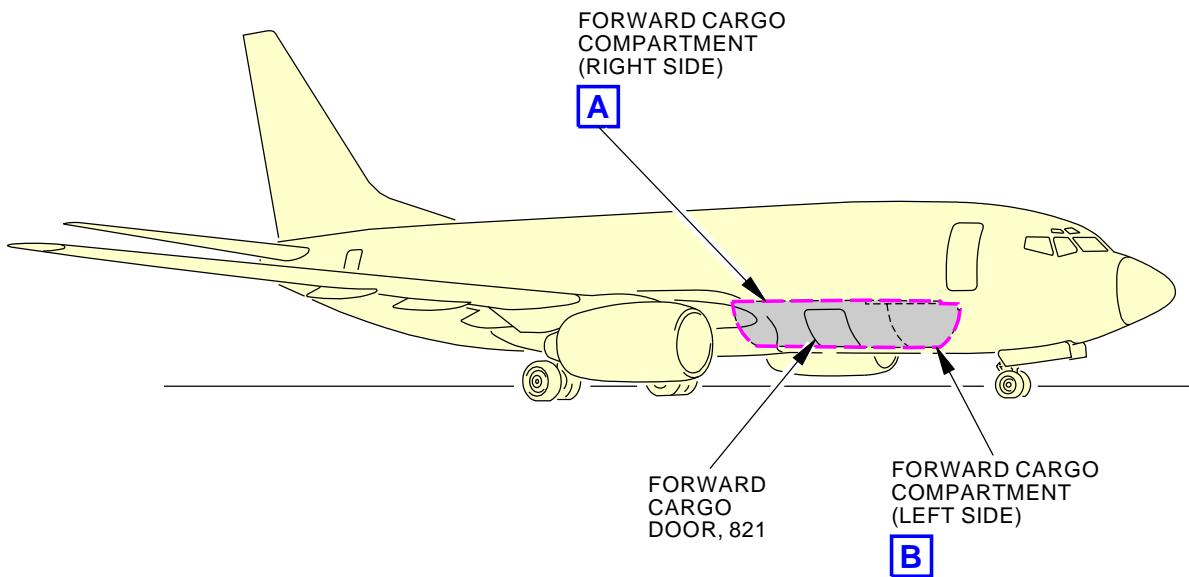
———— END OF TASK ————



53-05-03



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MPD ITEM
53-130-00

2080203 S0000436833_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-846 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

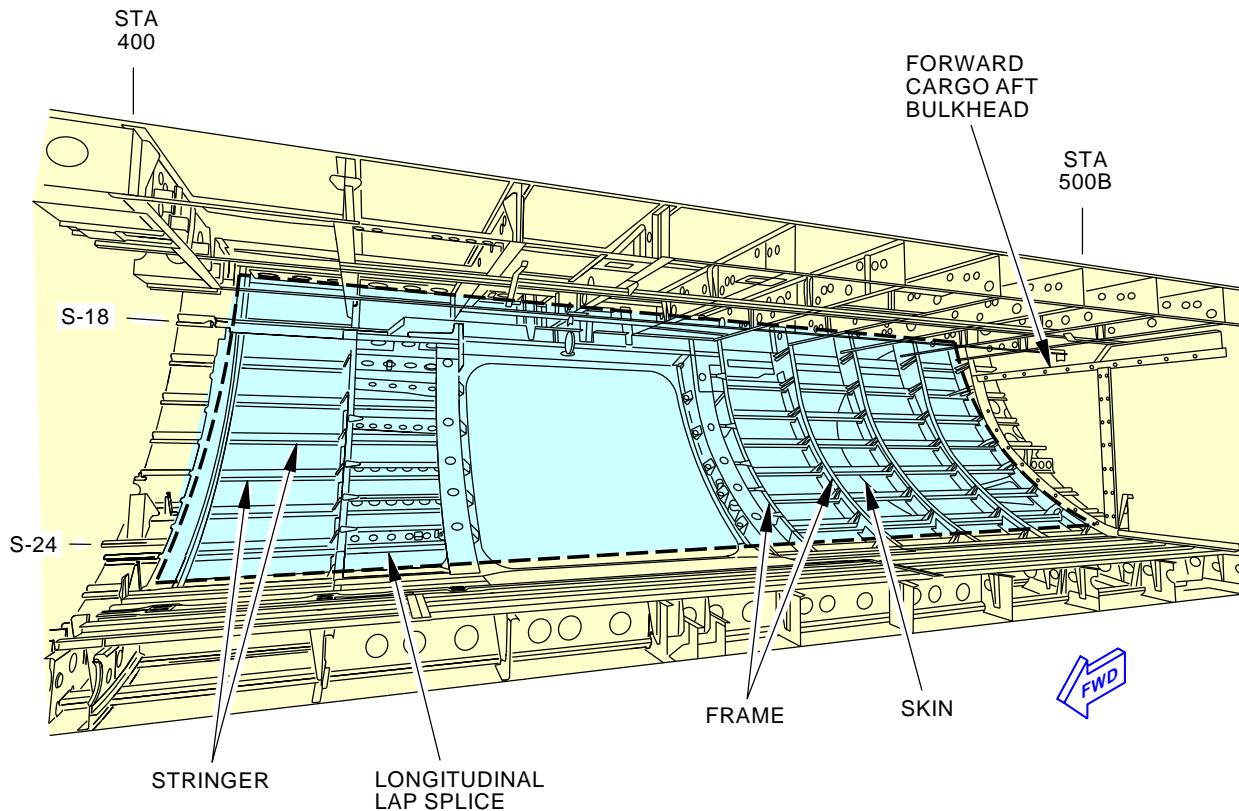
D633A101-AKS

53-05-03

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FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)
(RIGHT SIDE VIEW)

A

MPD ITEM
53-130-00

2080217 S0000436834_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-846 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

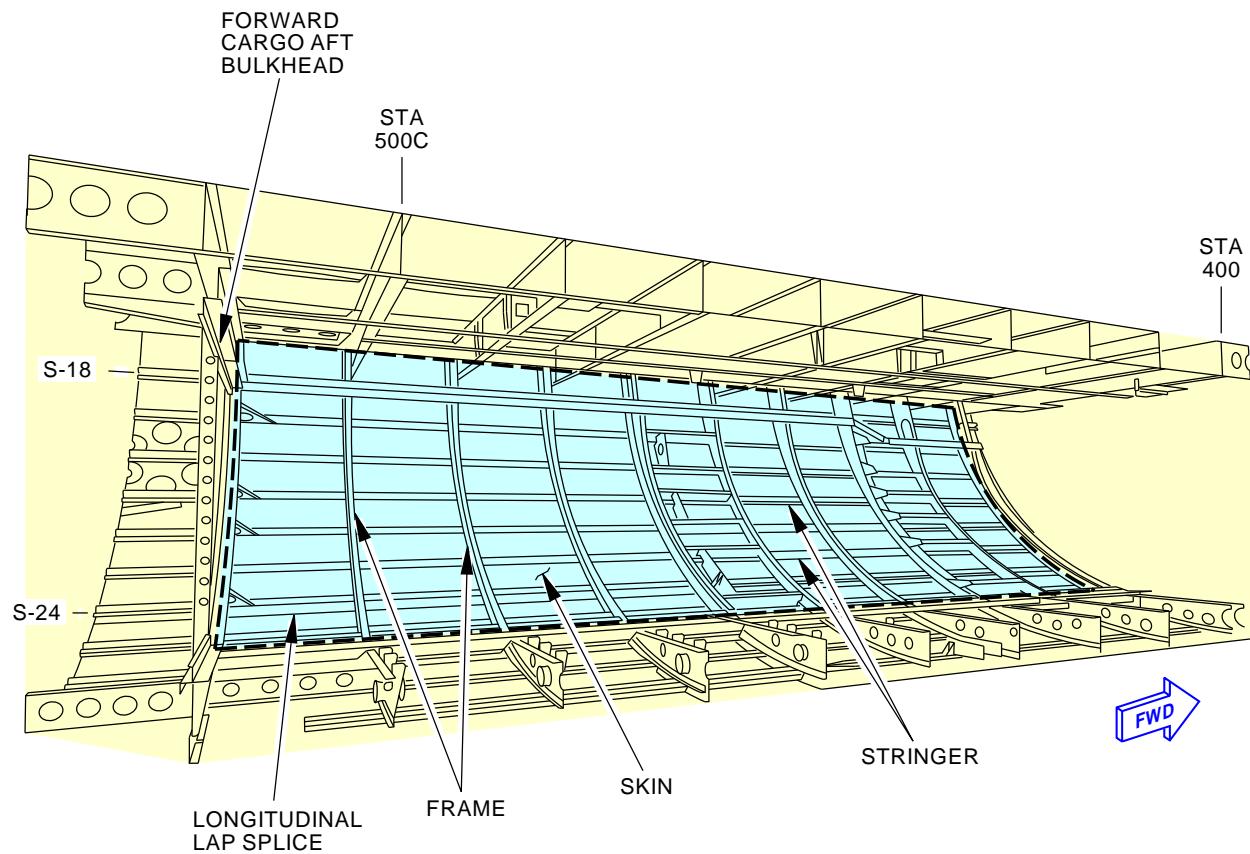
D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL



FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)
(LEFT SIDE VIEW)

B

MPD ITEM
53-130-00

2082663 S0000436835_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-846 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

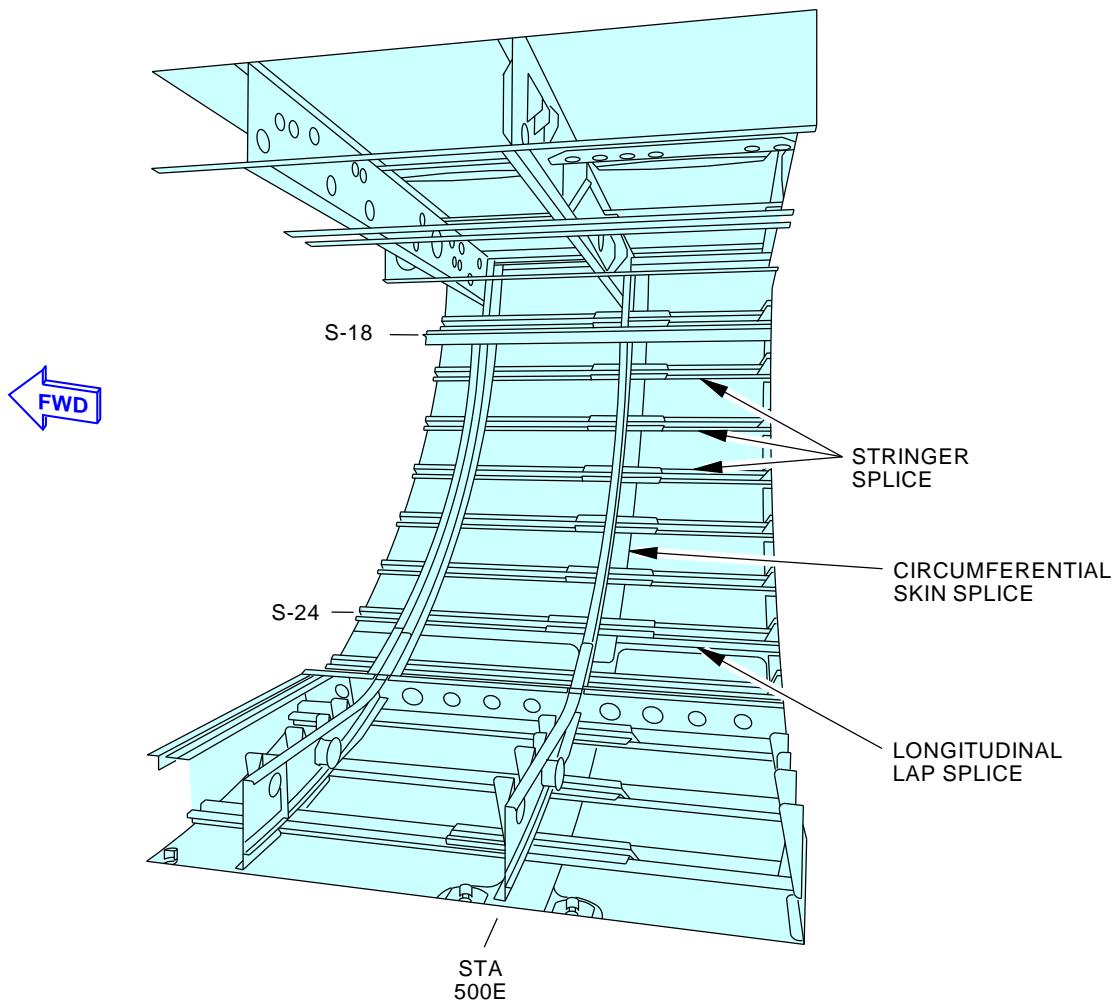
D633A101-AKS

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CIRCUMFERENTIAL SKIN AND STRINGER SPLICE -900 MODEL
(RIGHT SIDE VIEW, LEFT SIDE OPPOSITE)

MPD ITEM
53-130-00

2082409 S0000436836_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-846 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-814

- 15. INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT FLOOR STRUCTURE**
(Figure 217)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

C. Inspection

SUBTASK 53-05-03-010-012

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-014

- (2) Do a General Visual inspection of the forward cargo compartment floor structure.

SUBTASK 53-05-03-910-016

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-012

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

———— END OF TASK ————

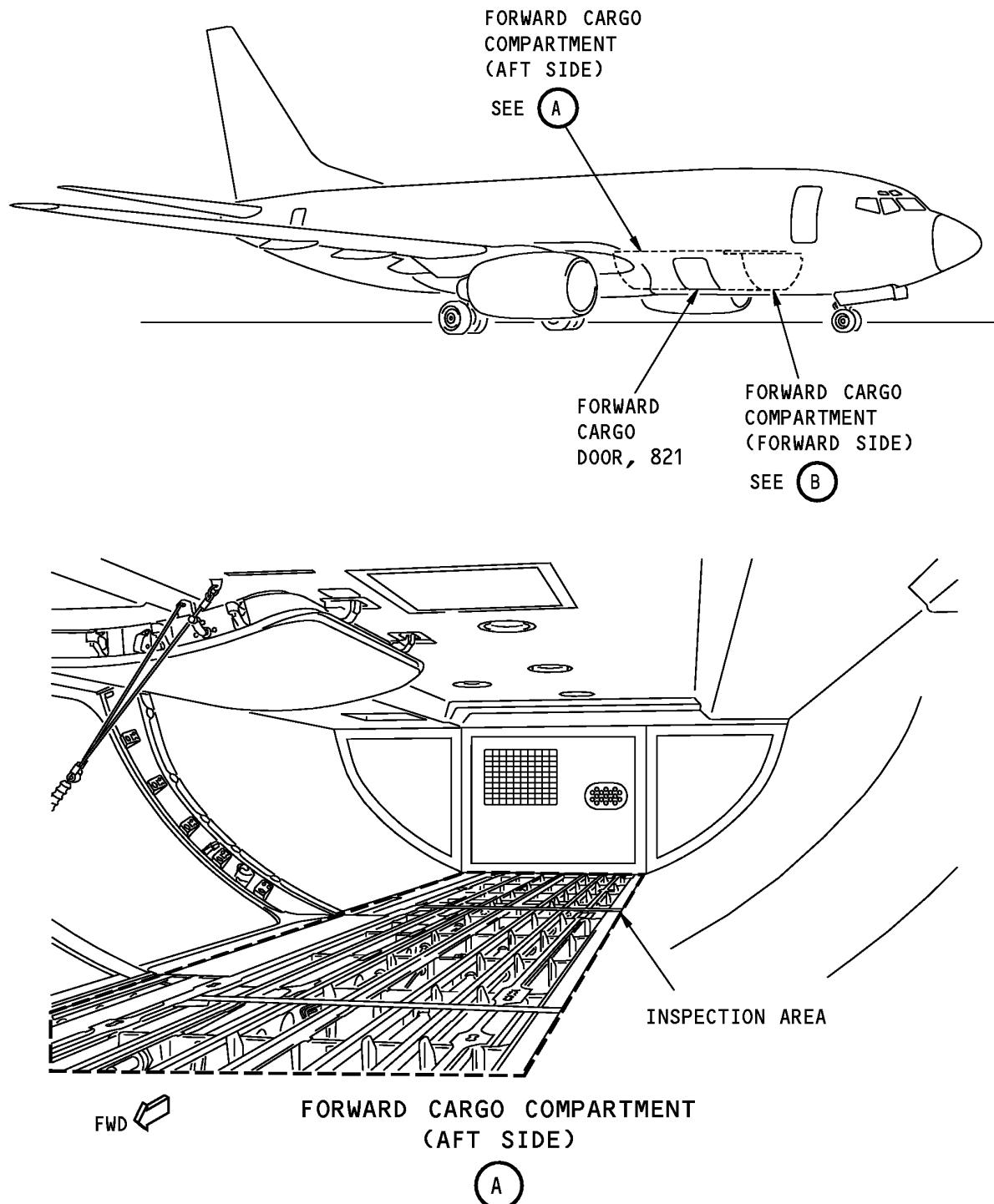


53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL



| Forward Cargo Compartment Floor Structure General Visual (Internal)
Figure 217/53-05-03-990-819 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

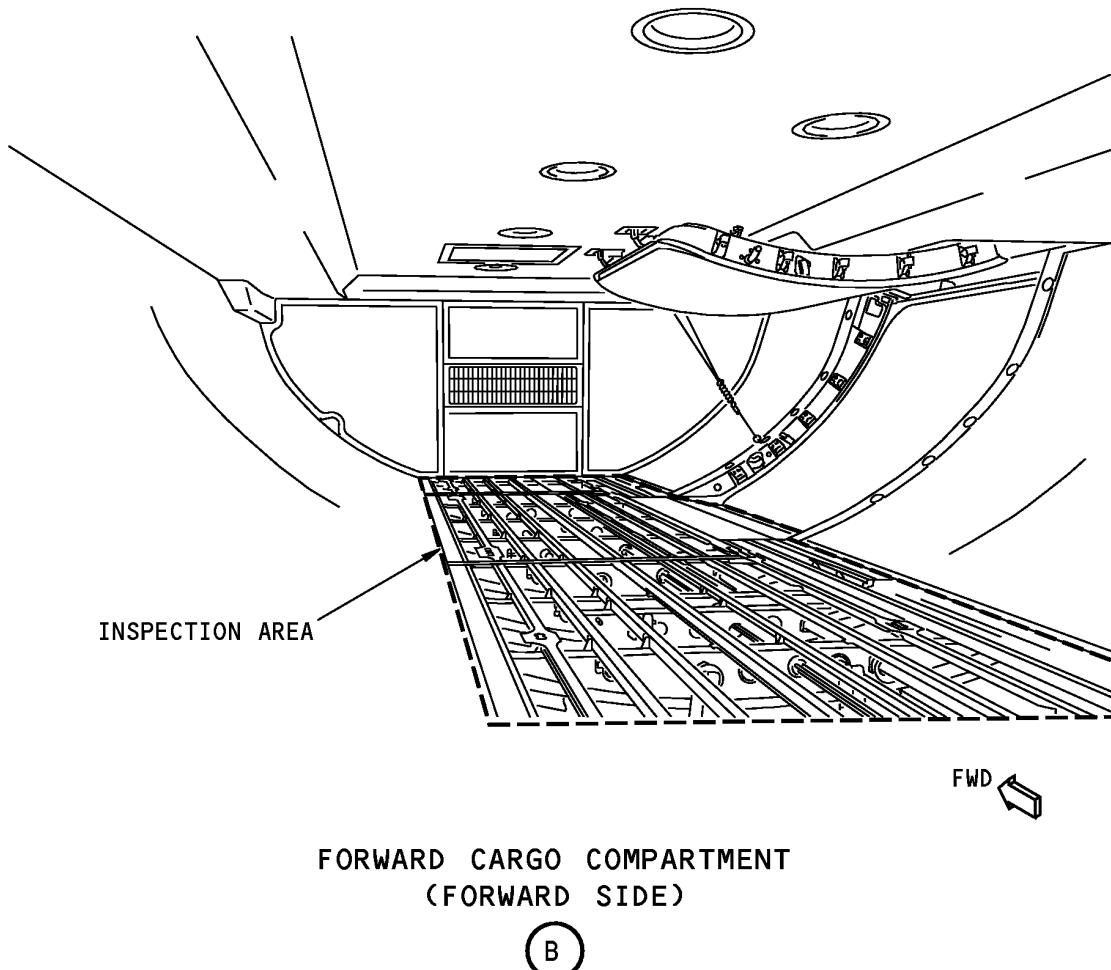
53-05-03

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL



| Forward Cargo Compartment Floor Structure General Visual (Internal)
Figure 217/53-05-03-990-819 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-815

16. INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE

(Figure 218)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

C. Inspection

SUBTASK 53-05-03-010-013

- (1) Open this access panel:

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-015

- (2) Do a General Visual inspection of the aft cargo compartment floor structure.

SUBTASK 53-05-03-910-017

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-013

- (4) Close this access panel:

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

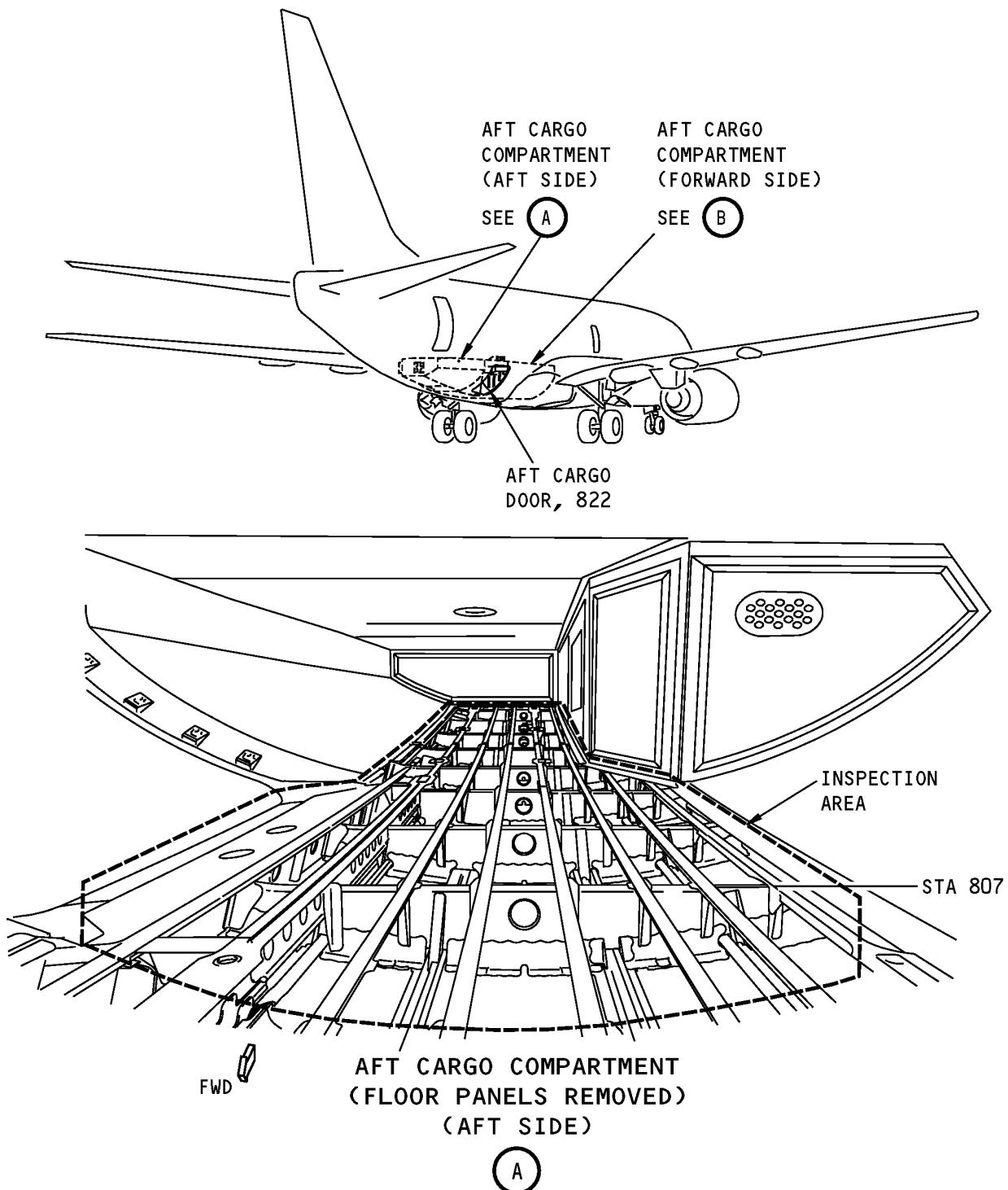
———— END OF TASK ————



53-05-03



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INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE
Figure 218/53-05-03-990-828 (Sheet 1 of 2)

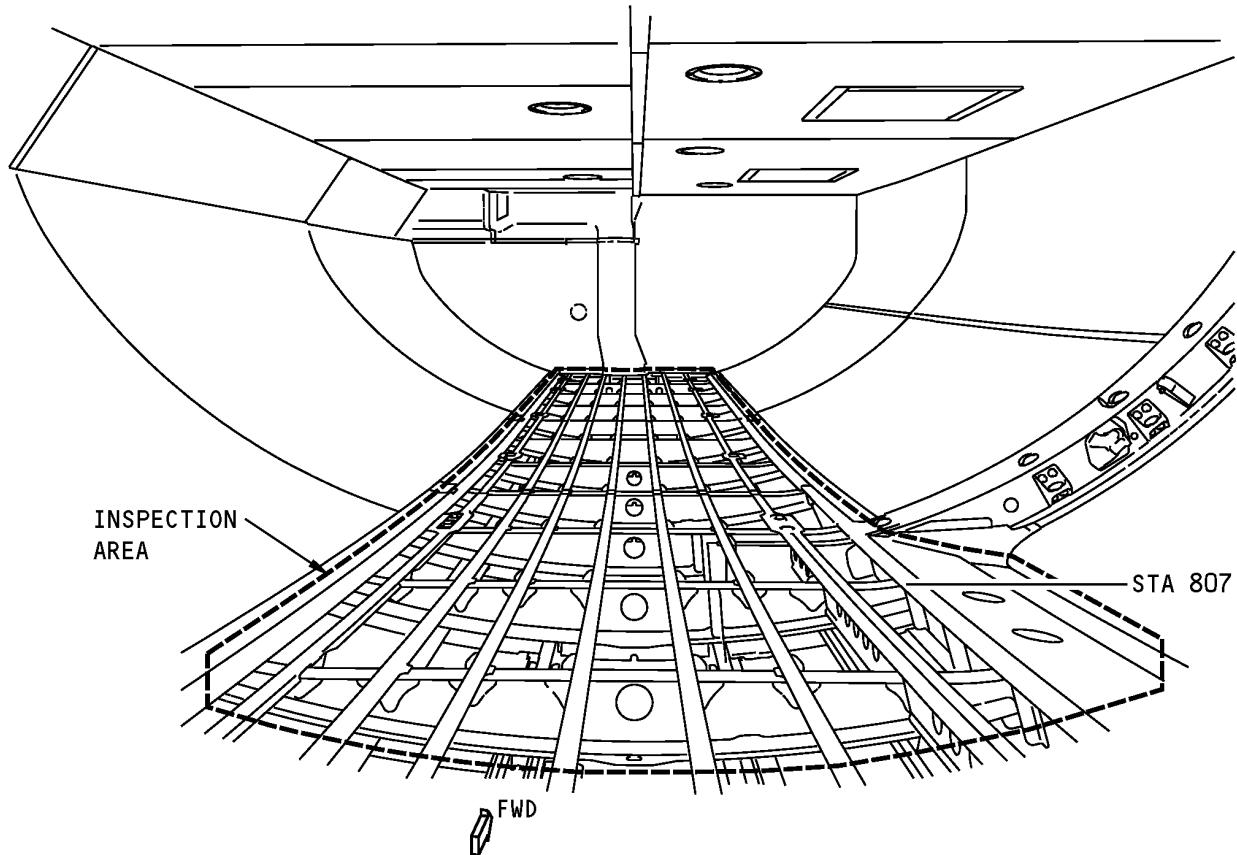
EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AFT CARGO COMPARTMENT
(FLOOR PANELS REMOVED)
(FORWARD SIDE)

B

INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE
Figure 218/53-05-03-990-828 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 53-05-03-211-803

17. INTERNAL - DETAILED: FORWARD CARGO DOOR CUTOUT

(Figure 219)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1221	Forward Cargo Door Cutout Inspection

C. Inspection

SUBTASK 53-05-03-010-057

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1221	Forward Cargo Door Cutout Inspection

NOTE: Remove door reveals. Remove sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-003

- (2) Do a Detailed inspection of the forward cargo door cutout surround structure.

SUBTASK 53-05-03-910-018

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-057

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1221	Forward Cargo Door Cutout Inspection

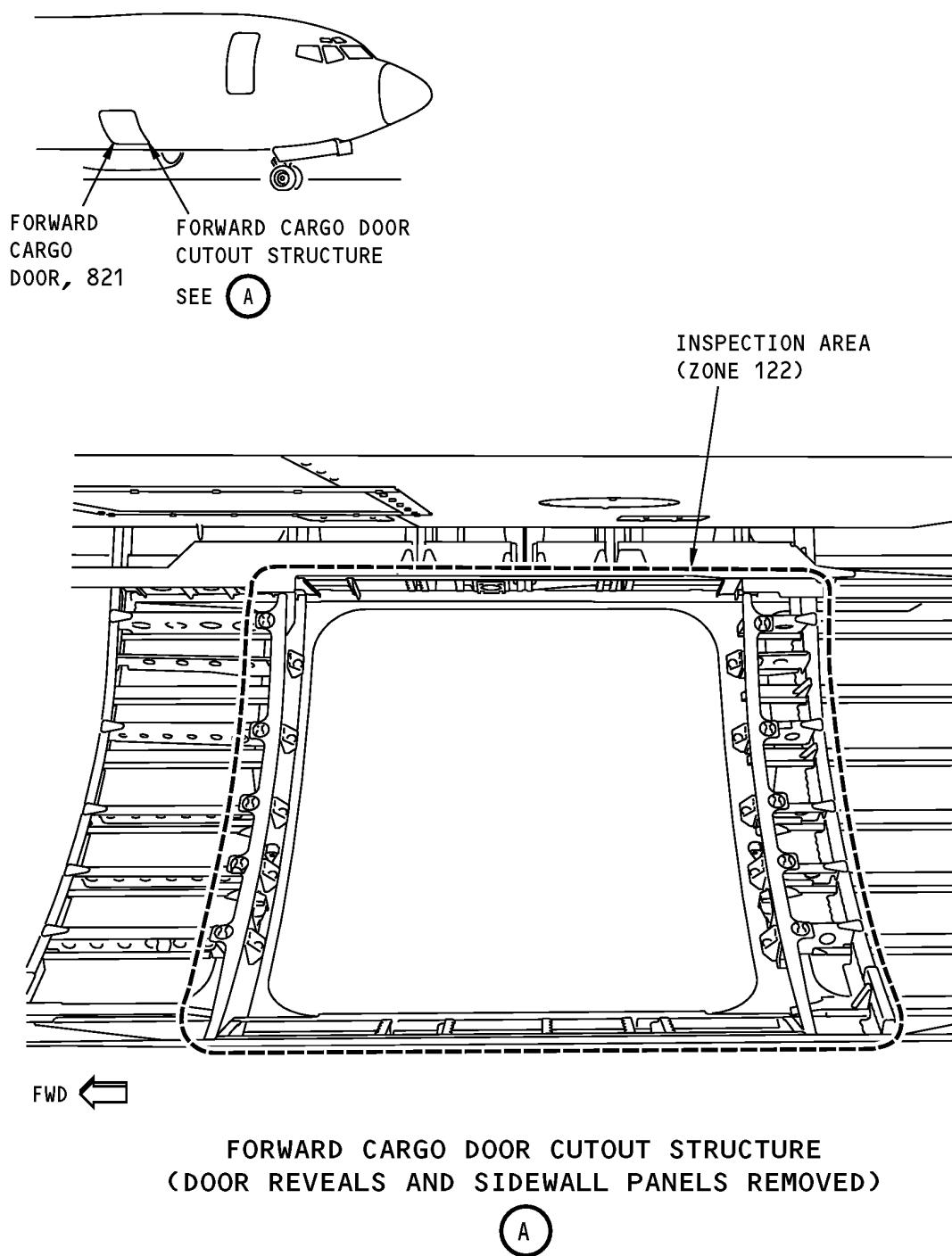
———— END OF TASK ————



53-05-03



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AIRCRAFT MAINTENANCE MANUAL



Forward Cargo Door Cutout Detailed (Internal)
Figure 219/53-05-03-990-821

EFFECTIVITY
AKS ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-816

18. INTERNAL - GENERAL VISUAL: FORWARD BILGE

(Figure 220)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

C. Inspection

SUBTASK 53-05-03-010-014

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

NOTE: Remove cargo floor panels and scuff plates. Remove/Displace insulation blankets as required.

SUBTASK 53-05-03-210-016

- (2) Do a General Visual inspection of the forward bilge skin panels including skins, frames, stringers, longitudinal lap splices, and cargo door cutout surround structure in bilge (note: inspection includes the circumferential skin and stringer splice at STA 500E for the -900 models).

SUBTASK 53-05-03-910-019

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-014

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

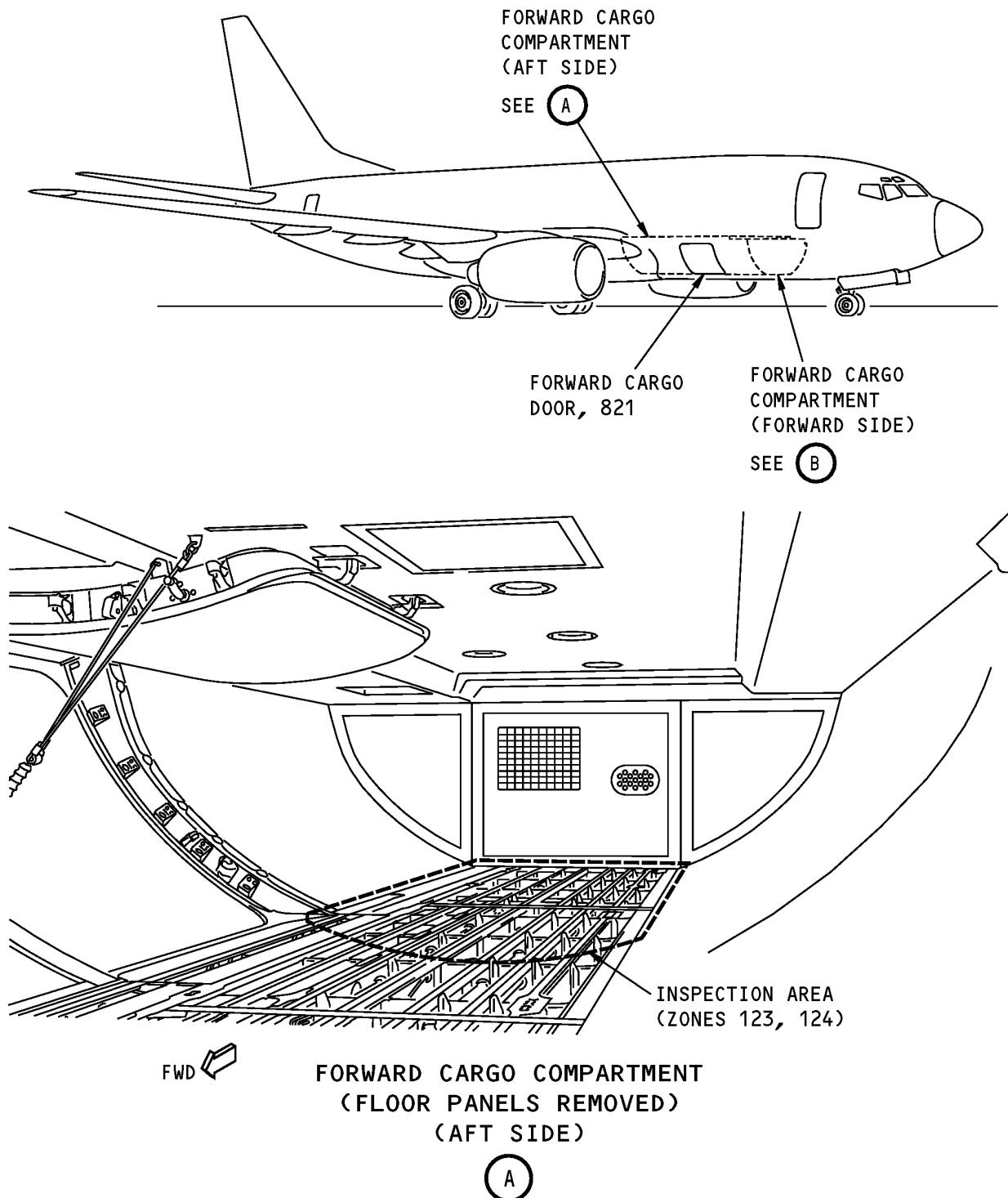
— END OF TASK —

EFFECTIVITY
AKS ALL

53-05-03



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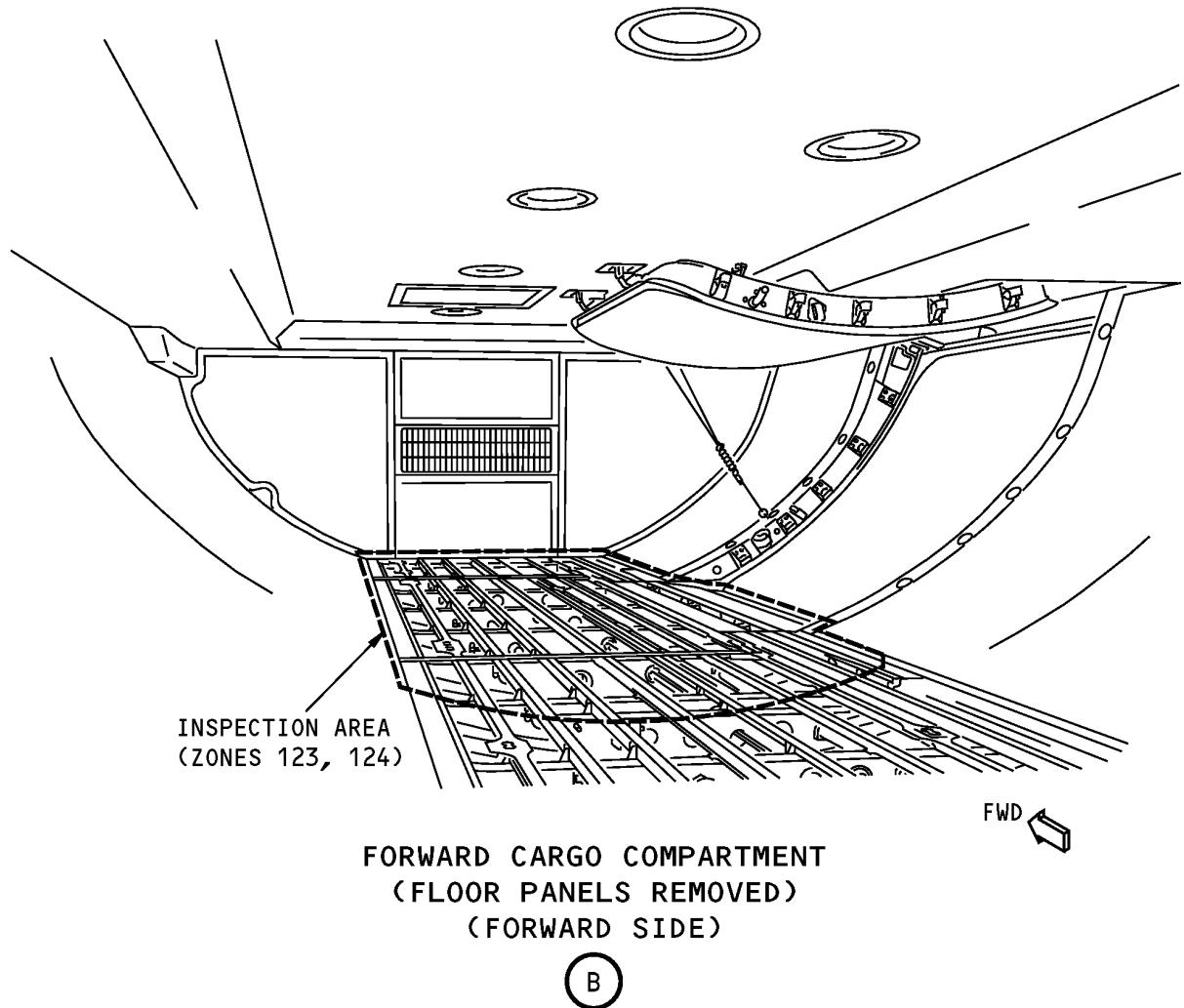
Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-825 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

53-05-03



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Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-825 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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TASK 53-05-03-210-817

19. INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT

(Figure 221)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

B. Access Panels

Number	Name/Location
S1203	Area Aft Of Forward Cargo Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-015

- (1) Open this access panel:

Number	Name/Location
S1203	Area Aft Of Forward Cargo Compartment Inspection

NOTE: Remove forward cargo compartment aft bulkhead panels. Remove/displace insulation blankets as required. Remove ducting as required.

SUBTASK 53-05-03-210-017

- (2) Do a General Visual inspection of the area aft of forward cargo compartment, including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, and forward side of Sta 540 bulkhead and bulkhead splices.

SUBTASK 53-05-03-910-020

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-015

- (4) Close this access panel:

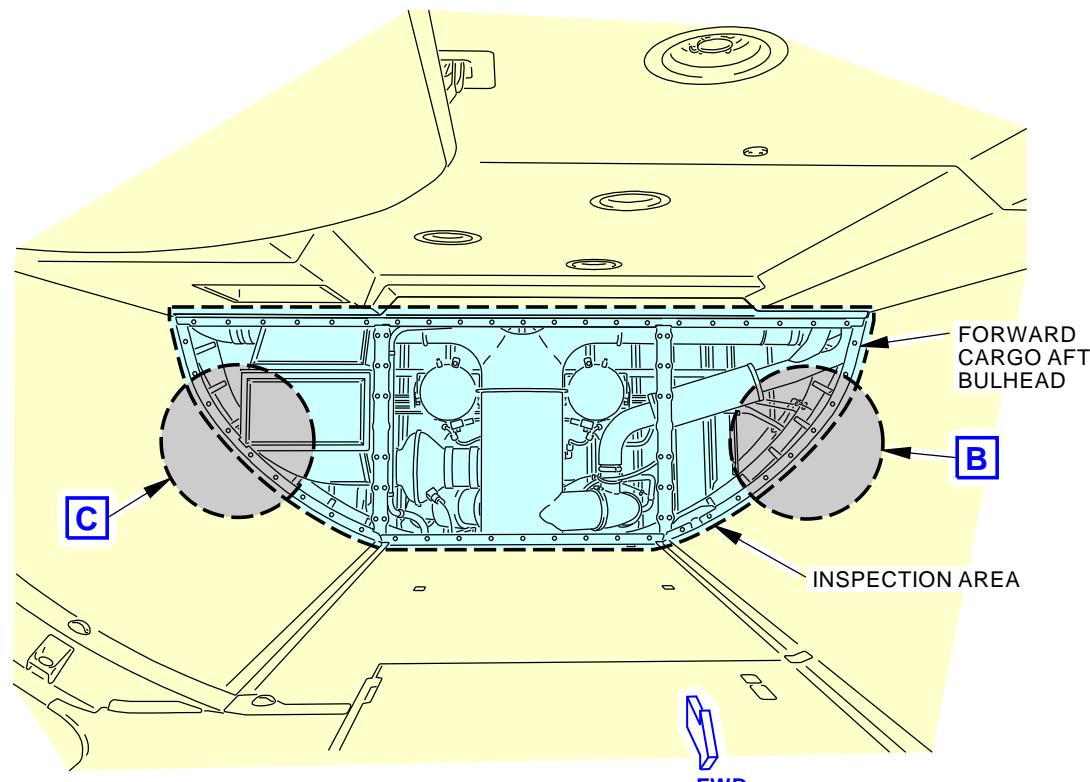
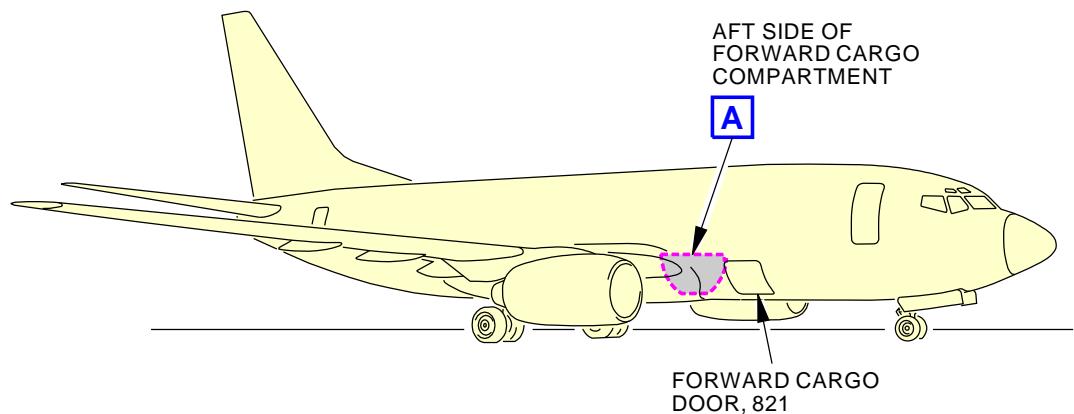
Number	Name/Location
S1203	Area Aft Of Forward Cargo Compartment Inspection

———— END OF TASK ————



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**AFT SIDE OF FORWARD CARGO COMPARTMENT
(AFT BULKHEAD PANELS REMOVED)**

A

MPD ITEM
53-170-00

2079477 S0000435859_V2

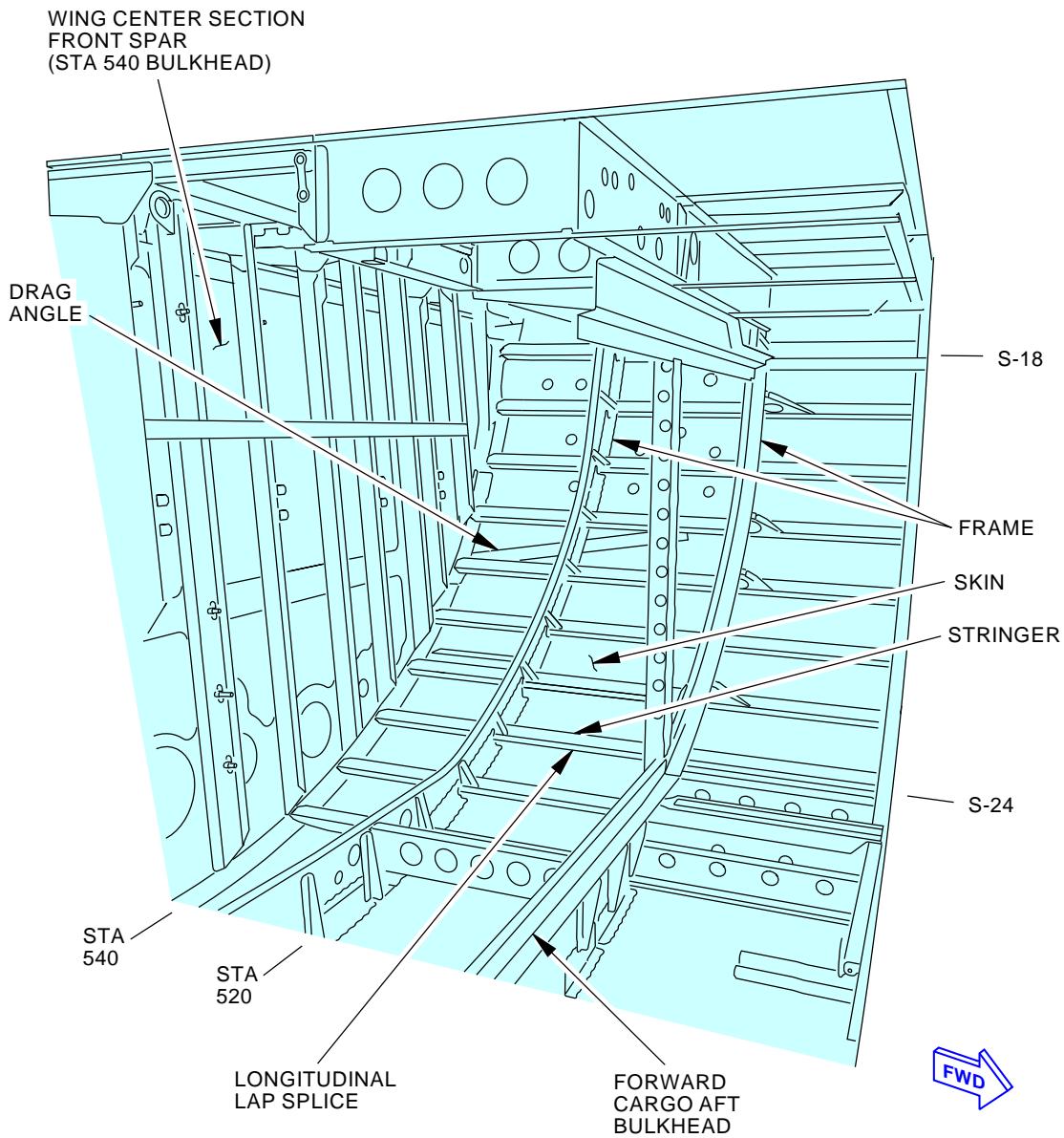
INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-847 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

D633A101-AKS

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AREA AFT OF FORWARD CARGO
(LEFT SIDE VIEW)

B

MPD ITEM
53-170-00

2079756 S0000435862_V2

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-847 (Sheet 2 of 3)

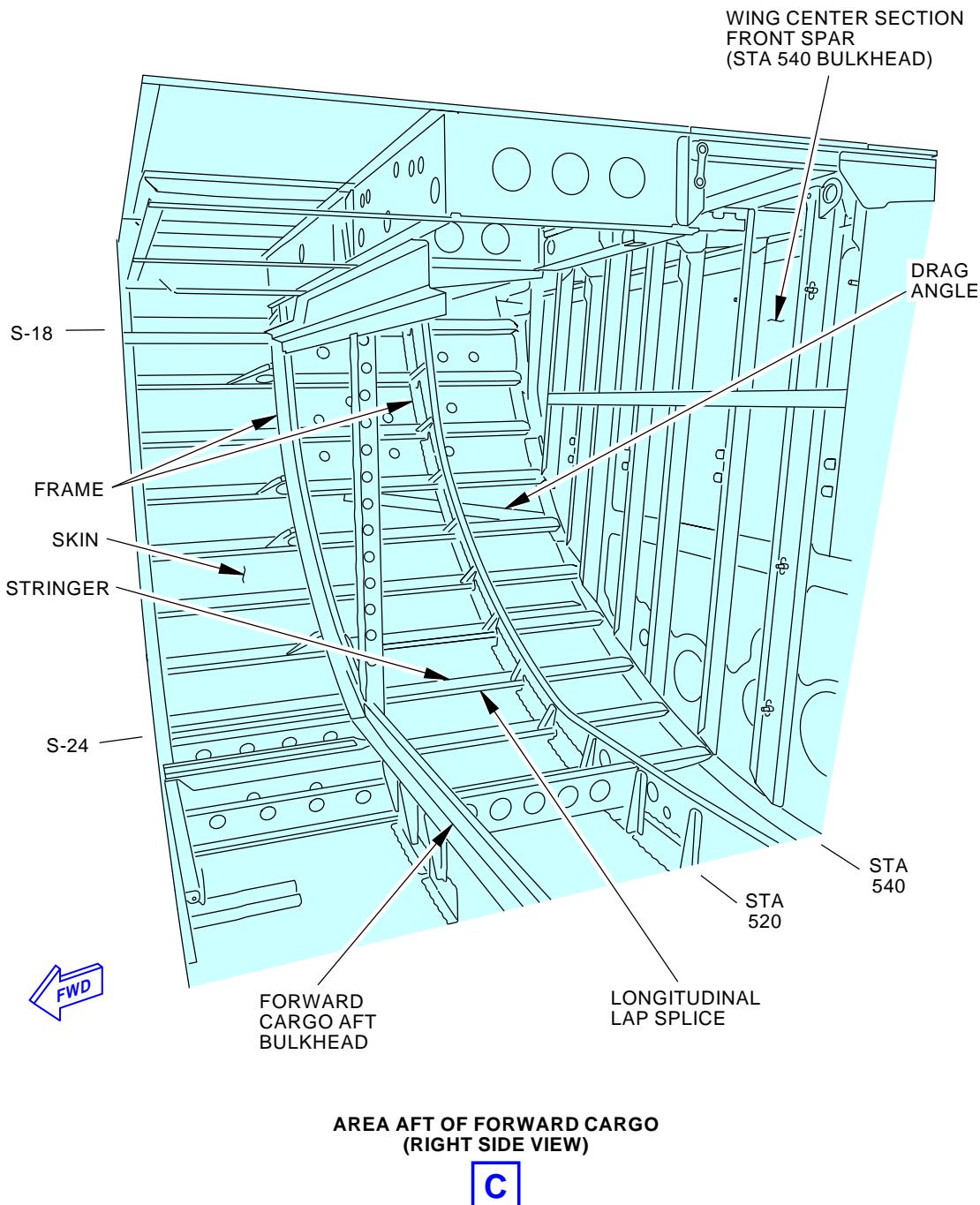
EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03



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AIRCRAFT MAINTENANCE MANUAL



INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-847 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-818

- 20. INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)**
(Figure 222)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
129	Keel Beam (Part) Body Station 501.70 to Body Station 540.00
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

C. Inspection

SUBTASK 53-05-03-010-016

- (1) Open these access panels:

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

EFFECTIVITY
AKS ALL

53-05-03



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SUBTASK 53-05-03-210-018

- (2) Do a General Visual inspection of the area under lower wing-to-body fairing (forward of wing box), including skin panels, longitudinal lap splices, keel beam extension, wing-to-body drag angles, and Sta 540 bulkhead.

SUBTASK 53-05-03-910-021

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-016

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

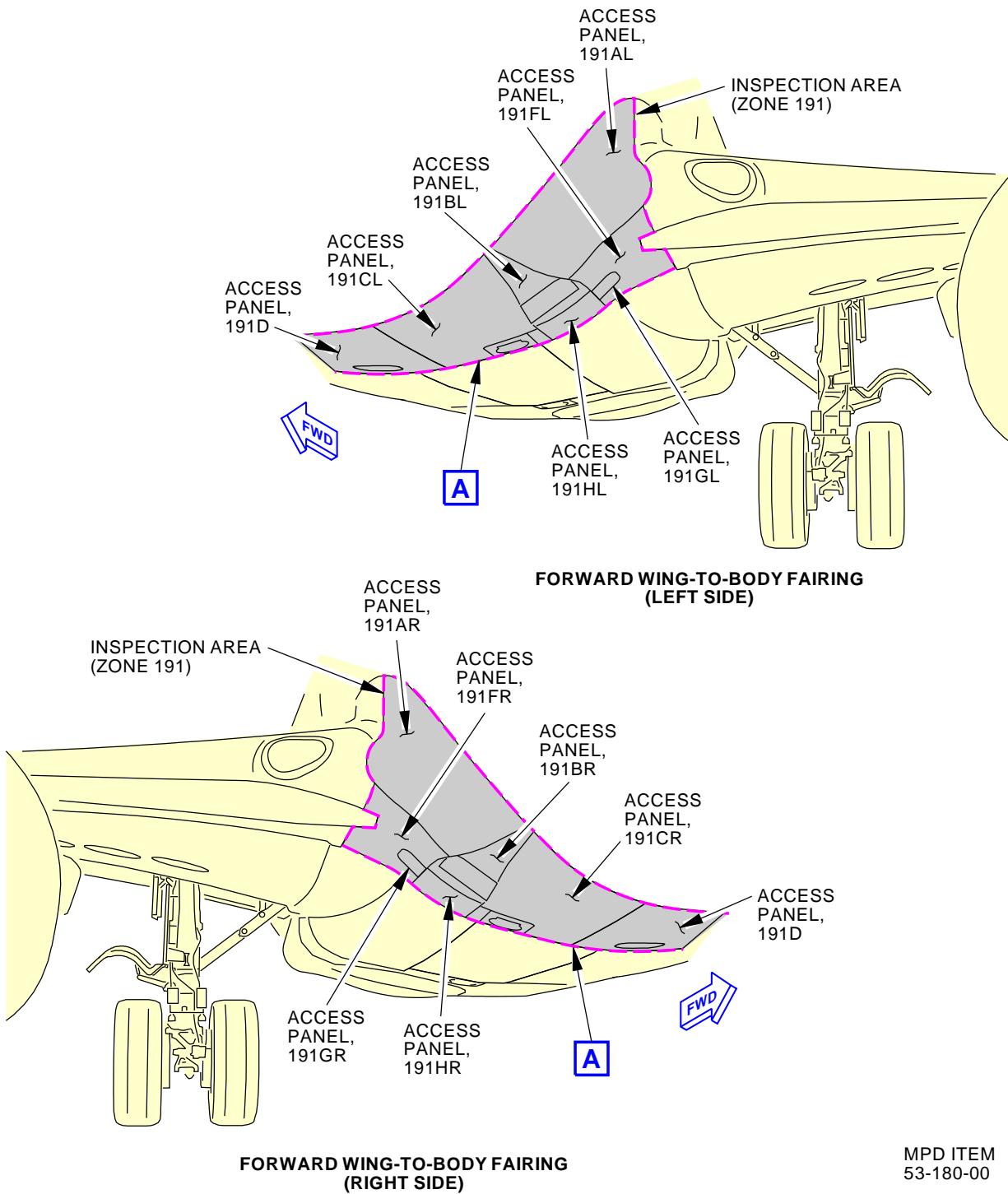
———— END OF TASK ————



53-05-03



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MPD ITEM
53-180-00

2077124 S0000435772_V2

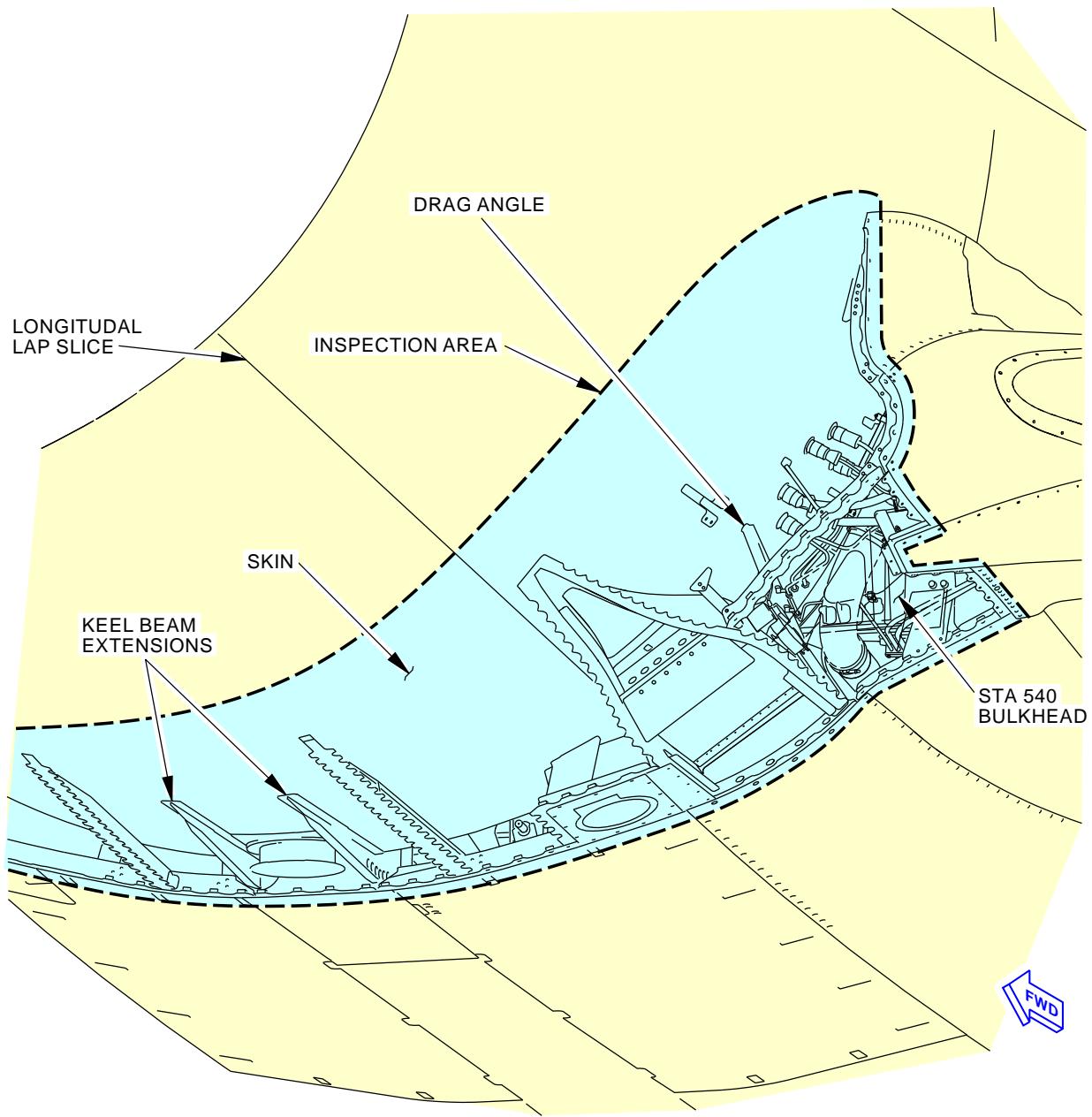
INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)
Figure 222/53-05-03-990-850 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

53-05-03



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(LEFT SIDE OF FUSELAGE SHOWN, RIGHT SIDE
OF FUSELAGE IS EQUIVALENT)

A

MPD ITEM
53-180-00

2078266 S0000435773_V2

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)
Figure 222/53-05-03-990-850 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-819

21. INTERNAL - GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION

(Figure 223)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right

B. Access Panels

Number	Name/Location
S1301	Area Above Wing Box Center Section Inspection

C. Inspection

SUBTASK 53-05-03-010-076

- (1) Special Access:

Number	Name/Location
S1301	Area Above Wing Box Center Section Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-019

- (2) Do a General Visual inspection of the fuselage lower lobe above wing box center section upper panel, including side skin panels (skins, frames and stringers), Sta 540 bulkhead, and overwing frames and stub beams.

SUBTASK 53-05-03-910-022

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

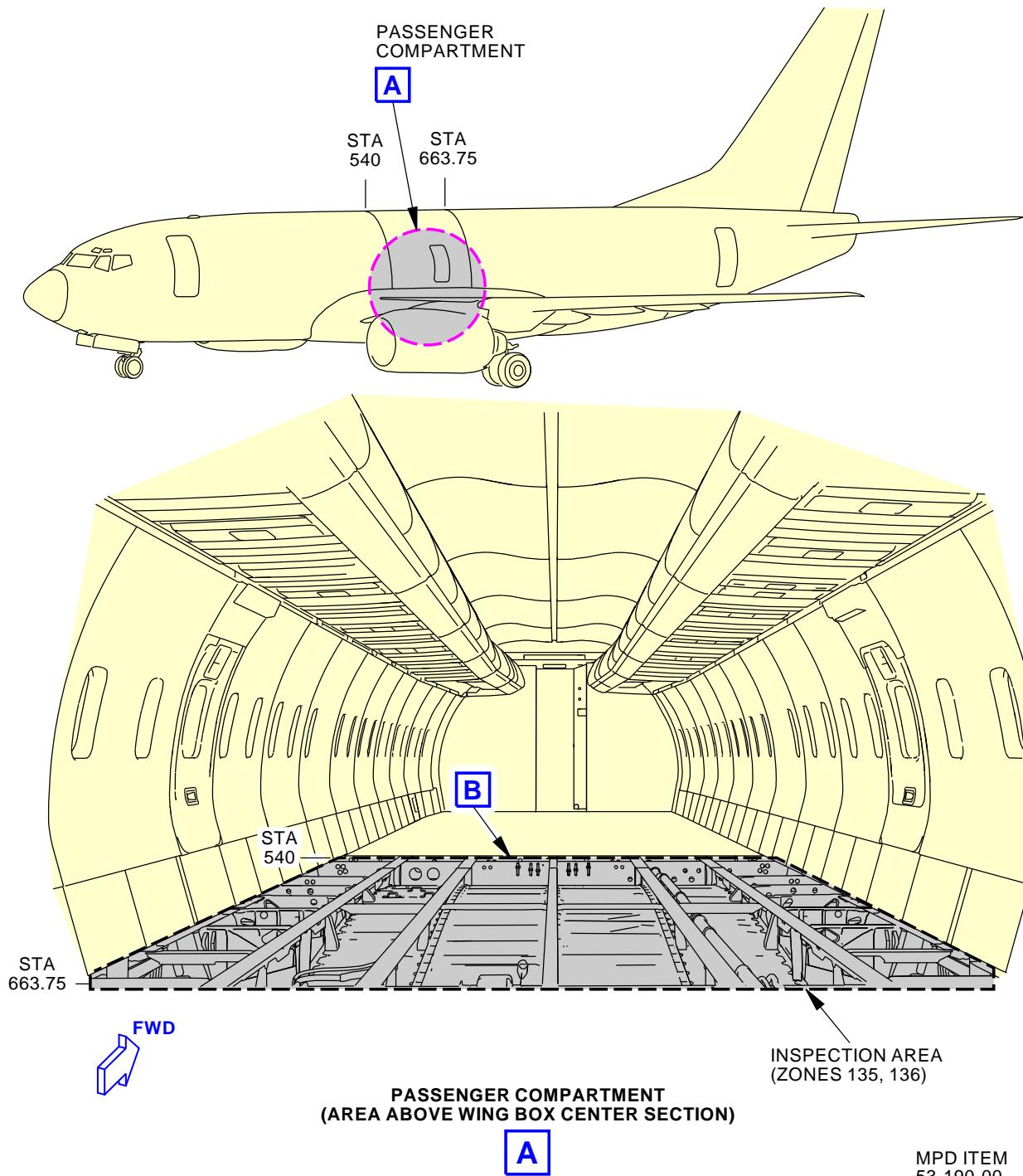
———— END OF TASK ———



53-05-03



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PASSENGER COMPARTMENT
(AREA ABOVE WING BOX CENTER SECTION)

A

MPD ITEM
53-190-00

2077193 S0000435832_V2

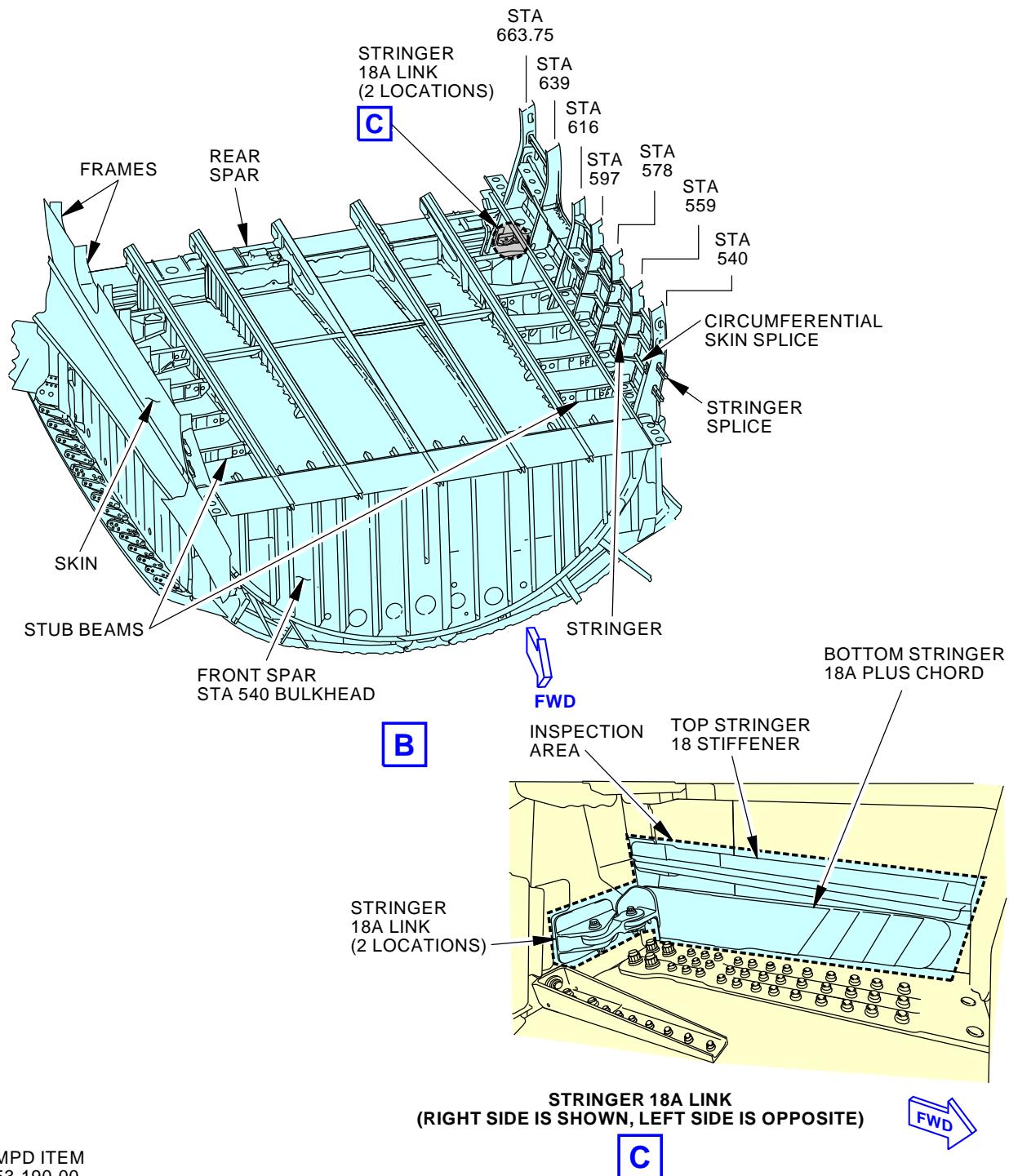
INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION
Figure 223/53-05-03-990-848 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS

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MPD ITEM
53-190-00

2077198 S0000435834_V3

INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION
Figure 223/53-05-03-990-848 (Sheet 2 of 2)

EFFECTIVITY

AKS ALL

D633A101-AKS

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-820

22. INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL

(Figure 224)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Access Panels

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

C. Inspection

SUBTASK 53-05-03-010-018

- (1) Open this access panel:

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-020

- (2) Do a General Visual inspection of the fuselage lower lobe above main landing gear wheel well, including:

1. Pressure deck web to stiffeners, stiffener attachment to floor beam at STA 727.
2. Side skin panels, circumferential skin and stringer splice.
3. Bulkheads at STA 663 and 727.
4. Side strut support frame at STA 706.
5. Main landing gear support frame at STA 695 and 716.
6. Wheel well frame at STA 685.

SUBTASK 53-05-03-910-023

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-018

- (4) Close this access panel:

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

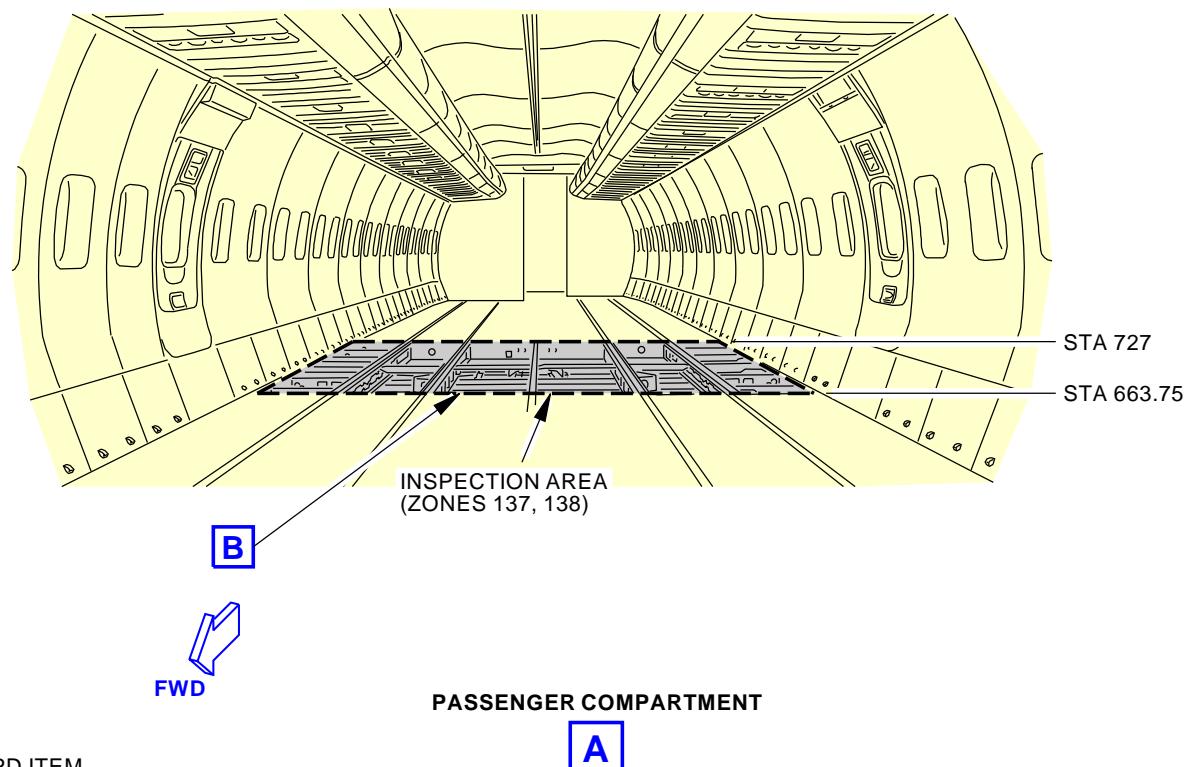
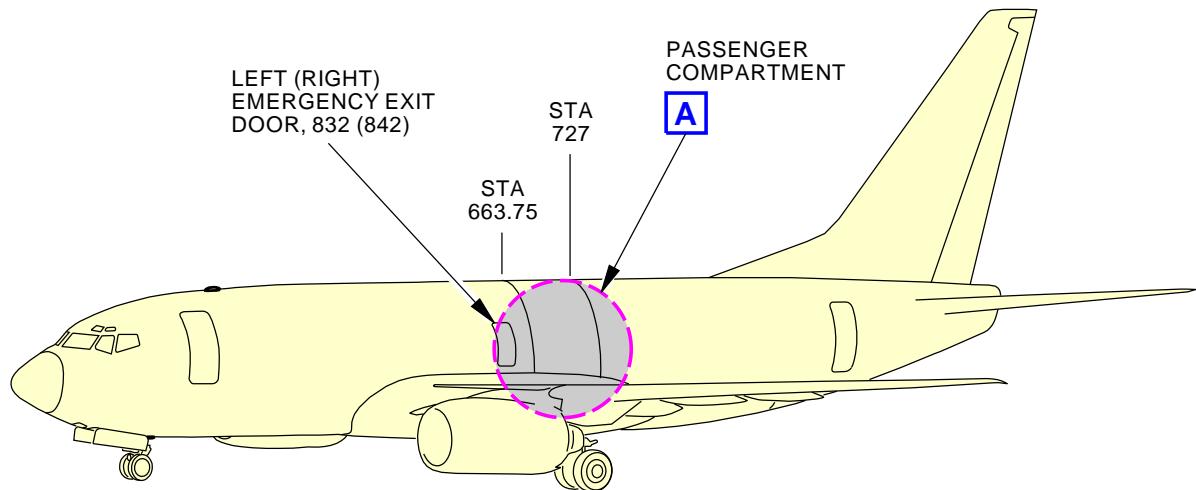
———— END OF TASK ————



53-05-03



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-200-00

2068994 S0000429080_V2

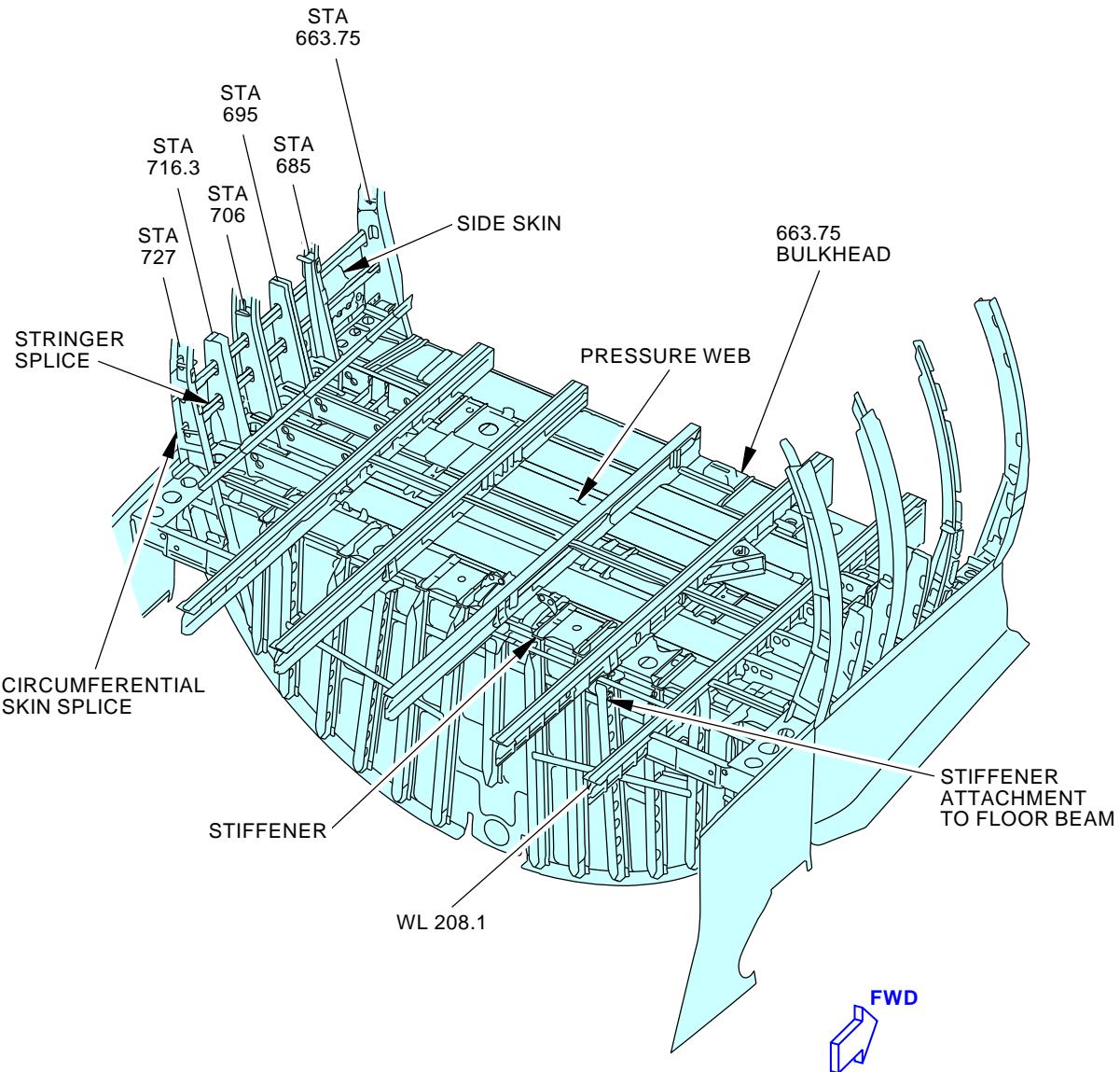
Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)
Figure 224/53-05-03-990-842 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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(TOP OF PRESSURE DECK)

B

MPD ITEM
53-200-00

2070775 S0000429084_V2

**Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)
Figure 224/53-05-03-990-842 (Sheet 2 of 2)**

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-821

23. **INTERNAL - GENERAL VISUAL: KEEL BEAM UNDER WING-TO-BODY FAIRING (under wing box)**
(Figure 225)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box

B. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

C. Inspection

SUBTASK 53-05-03-010-071

- (1) Open these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

NOTE: Option 1: Remove center wing-to-body fairing (192CL, 192CR, 192E, 192F) and open AC bay access door.

Option 2: Open AC bay door and remove AC pack to gain access to access holes.

SUBTASK 53-05-03-210-021

- (2) Do a General Visual inspection of the keel beam under wing-to-body fairing (under wing box, Sta 540 to 663.75), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

SUBTASK 53-05-03-910-026

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

SUBTASK 53-05-03-410-071

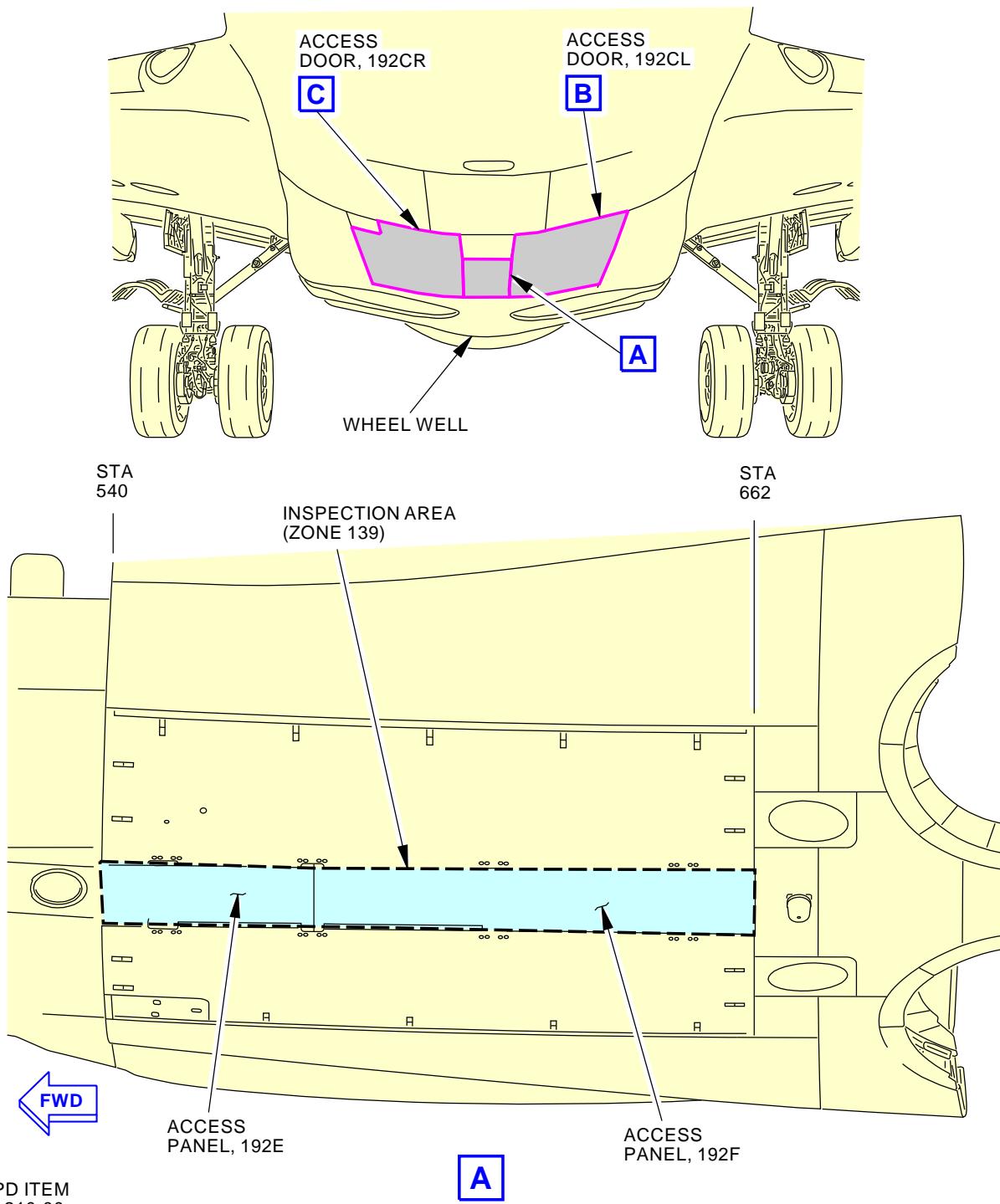
- (4) Close these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

— END OF TASK —

EFFECTIVITY
AKS ALL

53-05-03

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MPD ITEM
53-210-00

2084307 S0000436344_V2

Keel Beam
Figure 225/53-05-03-990-806 (Sheet 1 of 3)

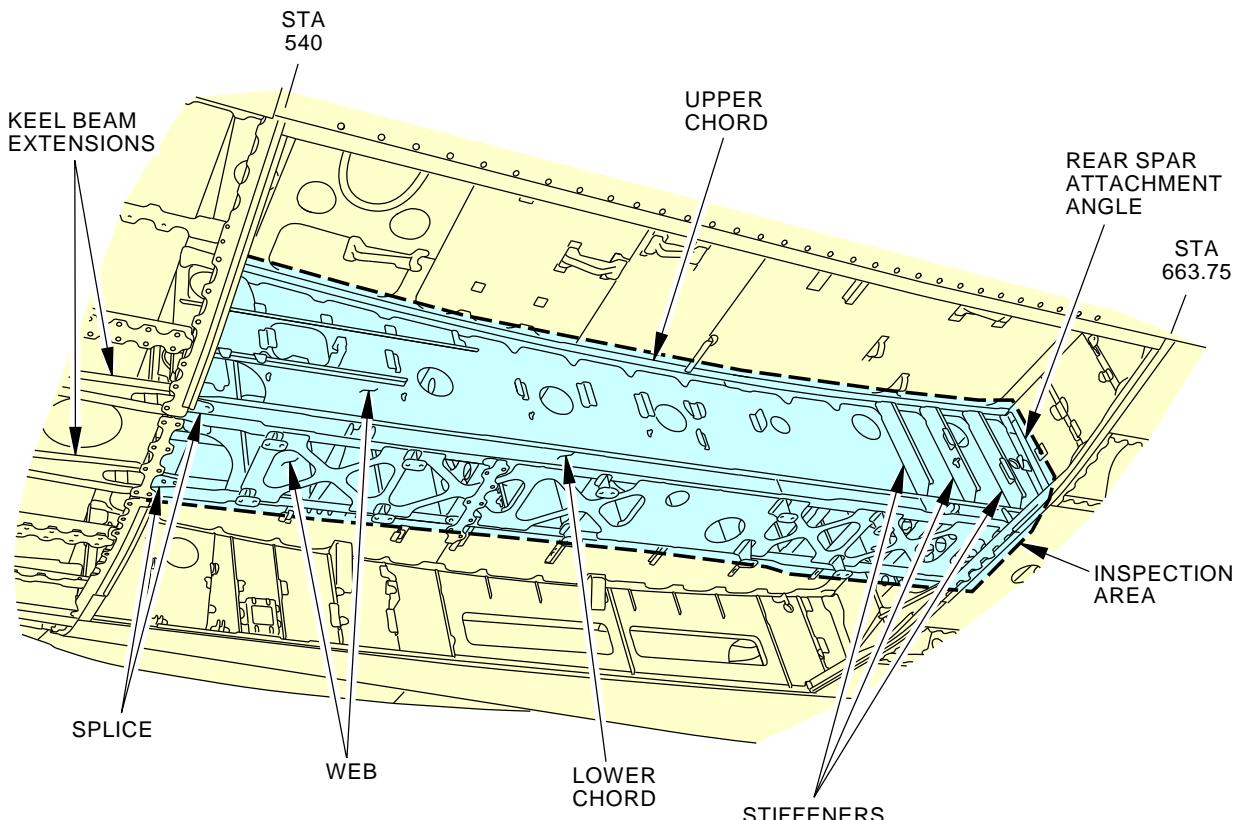
EFFECTIVITY	
AKS ALL	

53-05-03

D633A101-AKS



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KEEL BEAM
(STA 540 TO STA 663.75)
(ECS DOORS REMOVED)

B

MPD ITEM
53-210-00

2085210 S0000436345_V3

Keel Beam
Figure 225/53-05-03-990-806 (Sheet 2 of 3)

EFFECTIVITY
AKS ALL

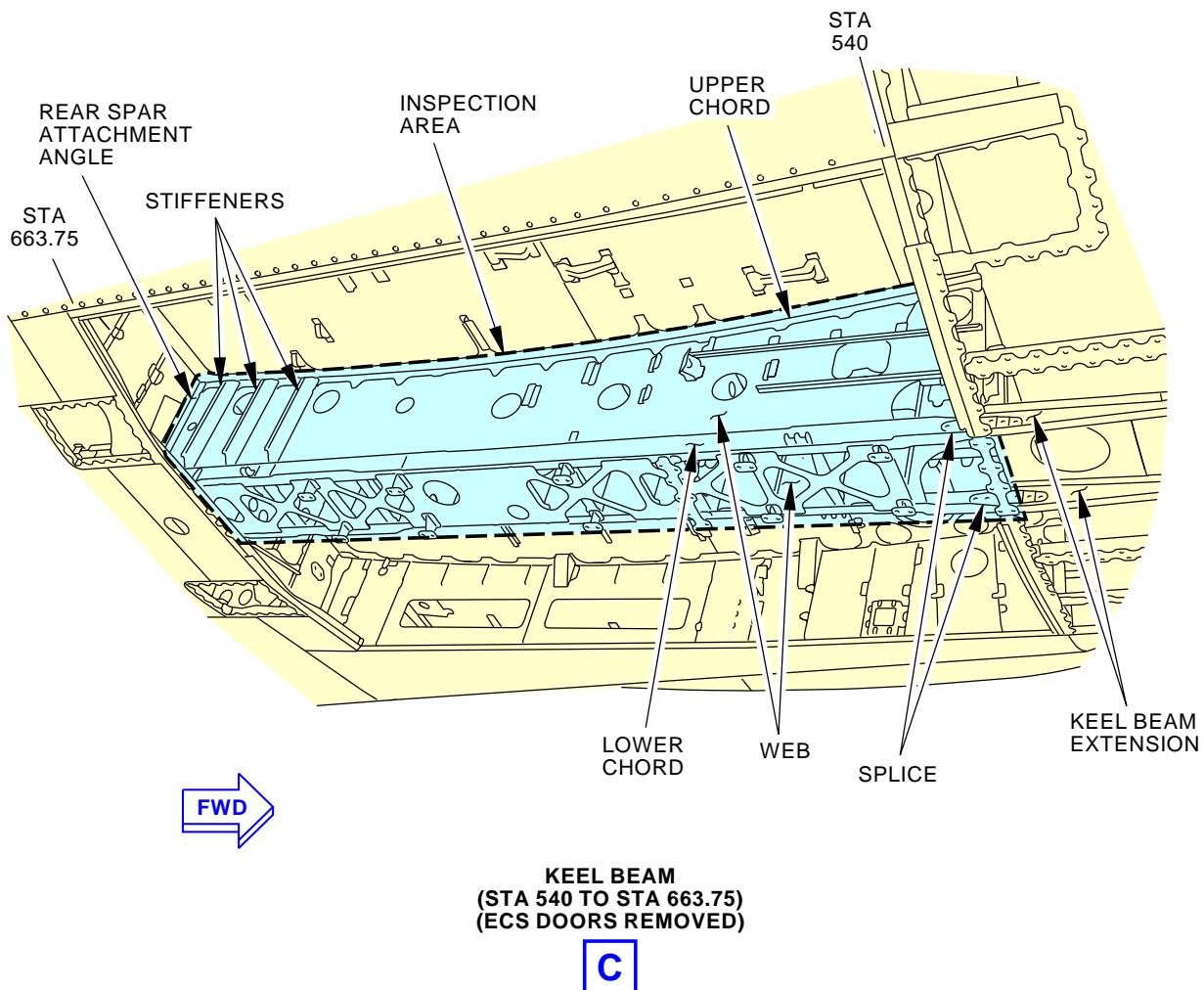
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53-05-03

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MPD ITEM
53-210-00

2084810 S0000436346_V4

Keel Beam
Figure 225/53-05-03-990-806 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-823

24. INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL

(Figure 226)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

B. Access Panels

Number	Name/Location
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

C. Inspection

SUBTASK 53-05-03-010-020

- (1) Open these access panels:

Number	Name/Location
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

SUBTASK 53-05-03-210-023

- (2) Do a General Visual inspection of the keel beam in wheel well (Sta 663.75 to 727), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

SUBTASK 53-05-03-910-024

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-020

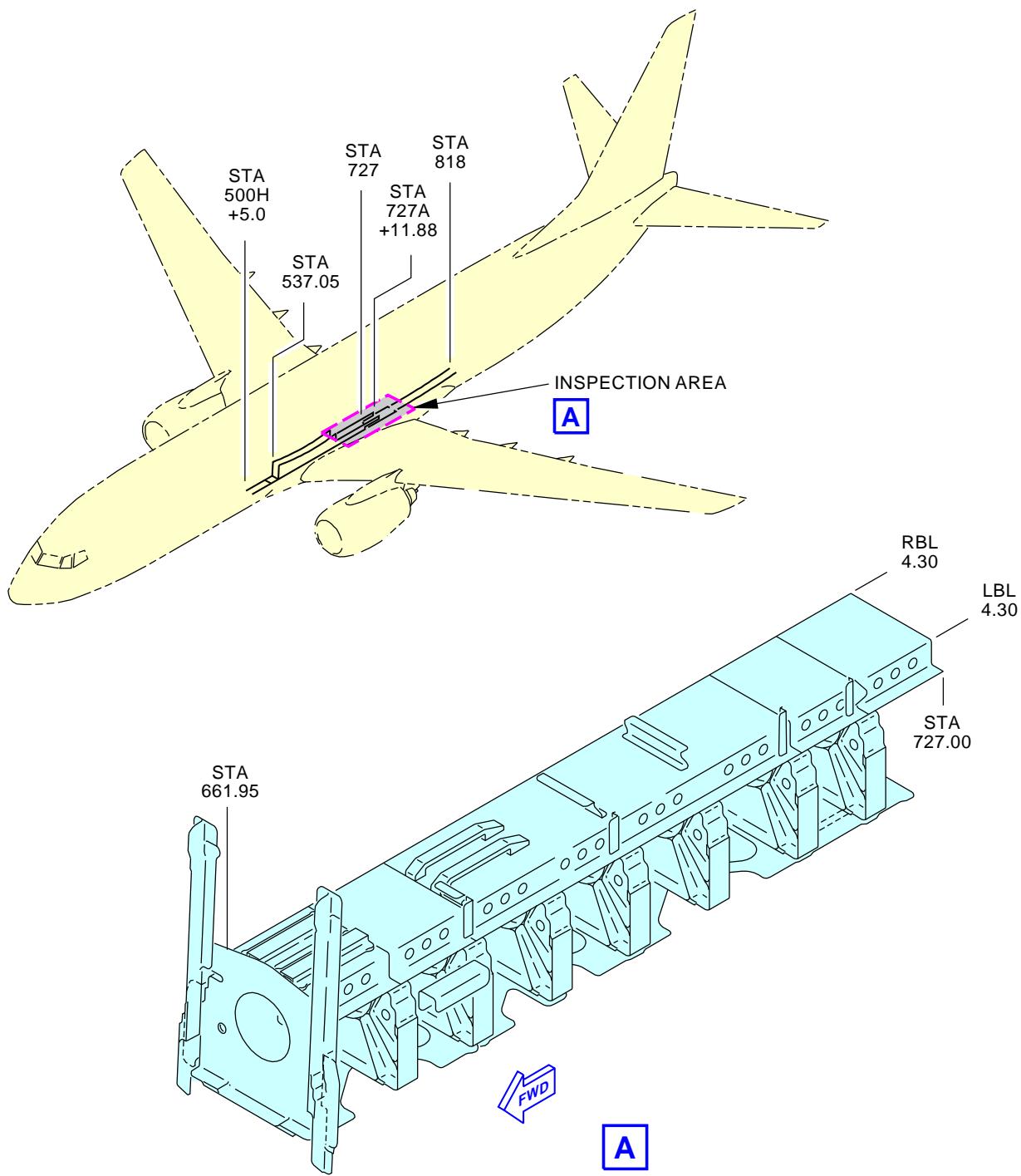
- (4) Close these access panels:

Number	Name/Location
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

———— END OF TASK ————



53-05-03



D65252 S0000161683_V2

INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL
Figure 226/53-05-03-990-827

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-824

25. INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT

(Figure 227)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-021

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

NOTE: Remove sidewall and ceiling panels, E6 LRU, access panels around vacuum lav tank. Remove/displace insulation blankets as required. Remove/displace vacuum lav components as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-024

- (2) Do a General Visual inspection of the aft cargo compartment, including:

1. Side skin panels (skin, frames, stringers), circumferential skin and stringer splices, (note: located at Sta 727I for -900 and 727L for -900ER models).
2. Stringer 18 strap at side of body.
3. Stringer 18A web, chord and links.
4. Aft side of STA 727 bulkhead and pressure web.

SUBTASK 53-05-03-910-025

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-021

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

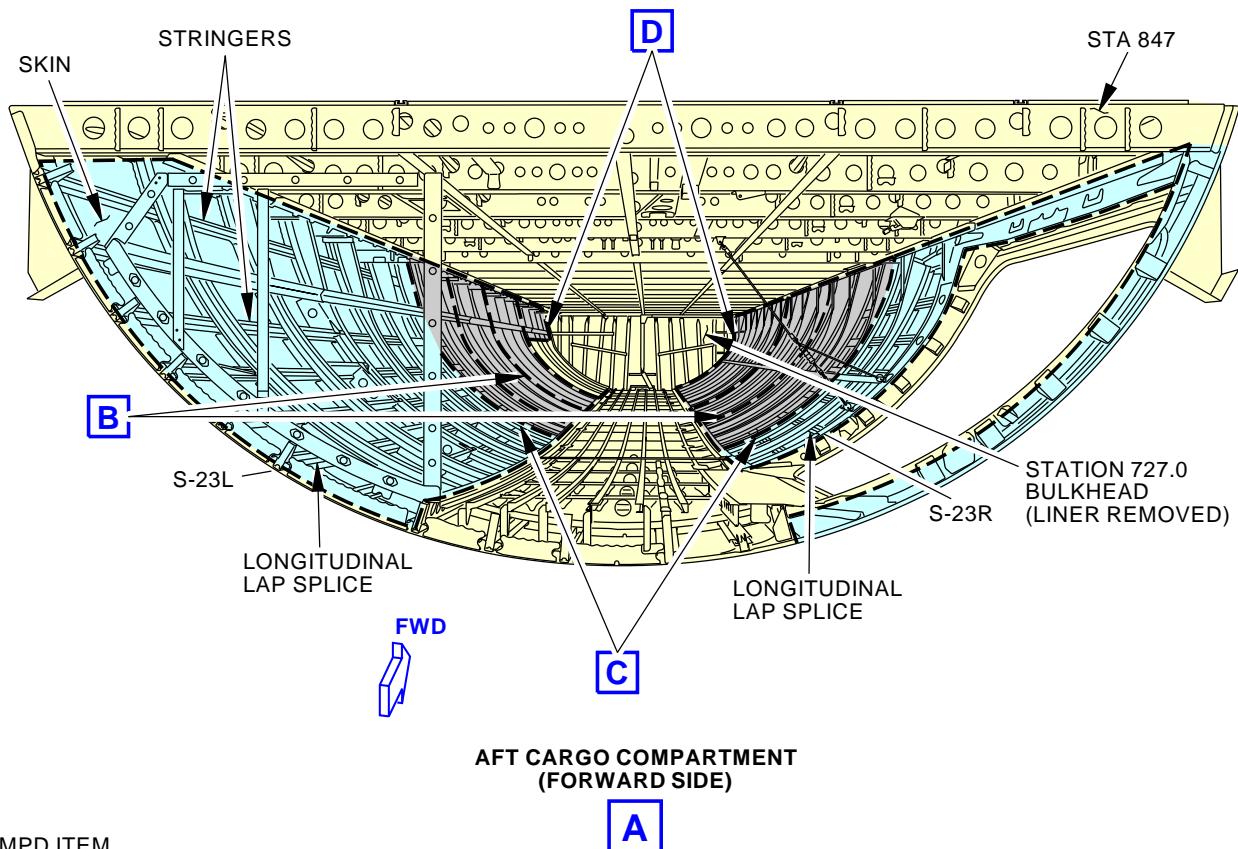
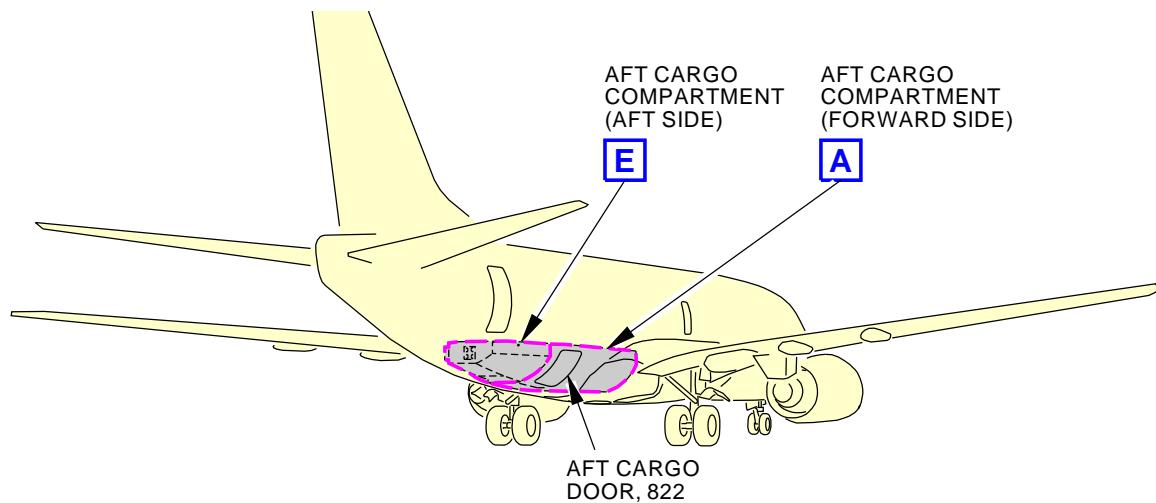
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MPD ITEM
53-230-00

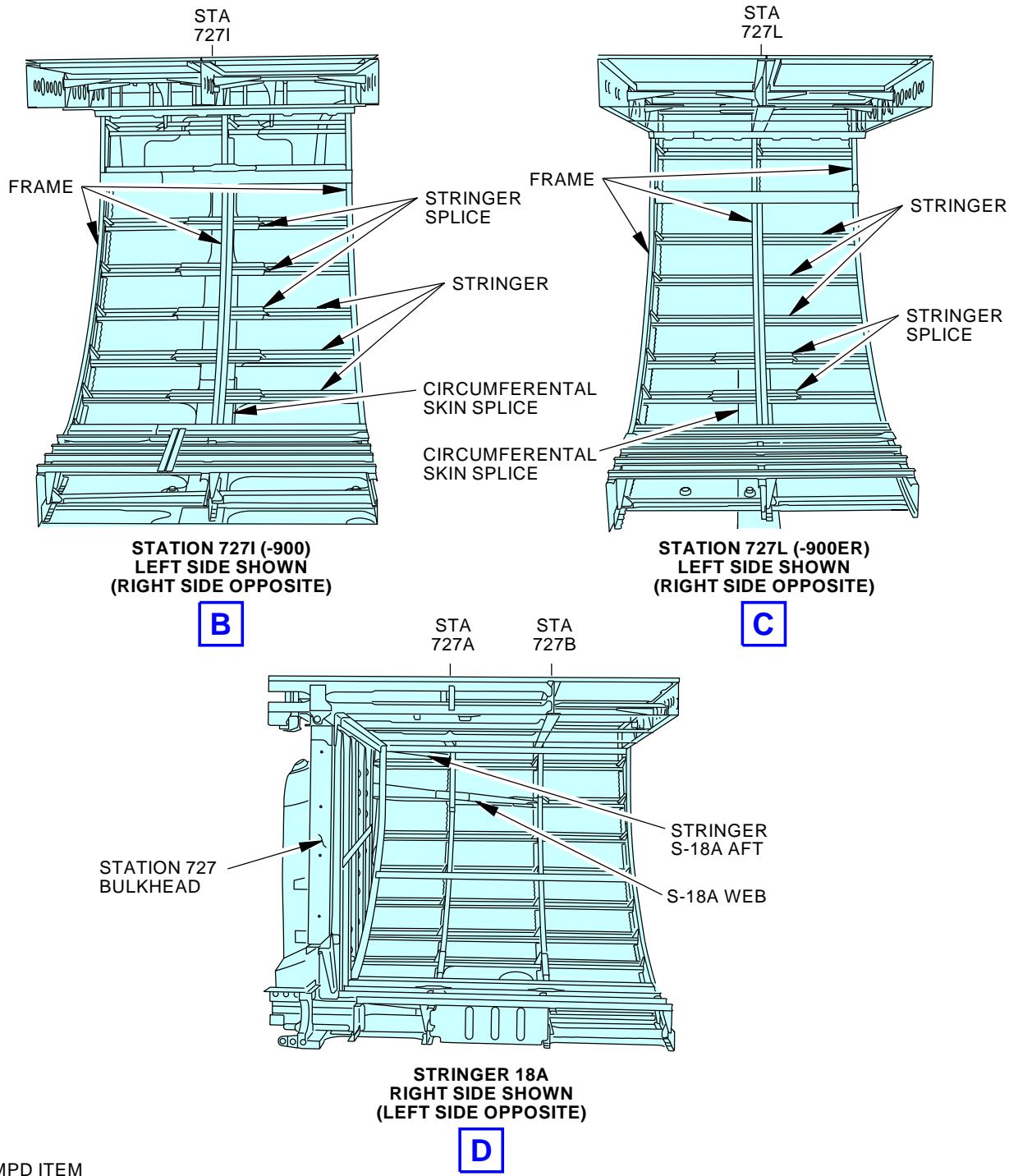
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INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-859 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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MPD ITEM
53-230-00

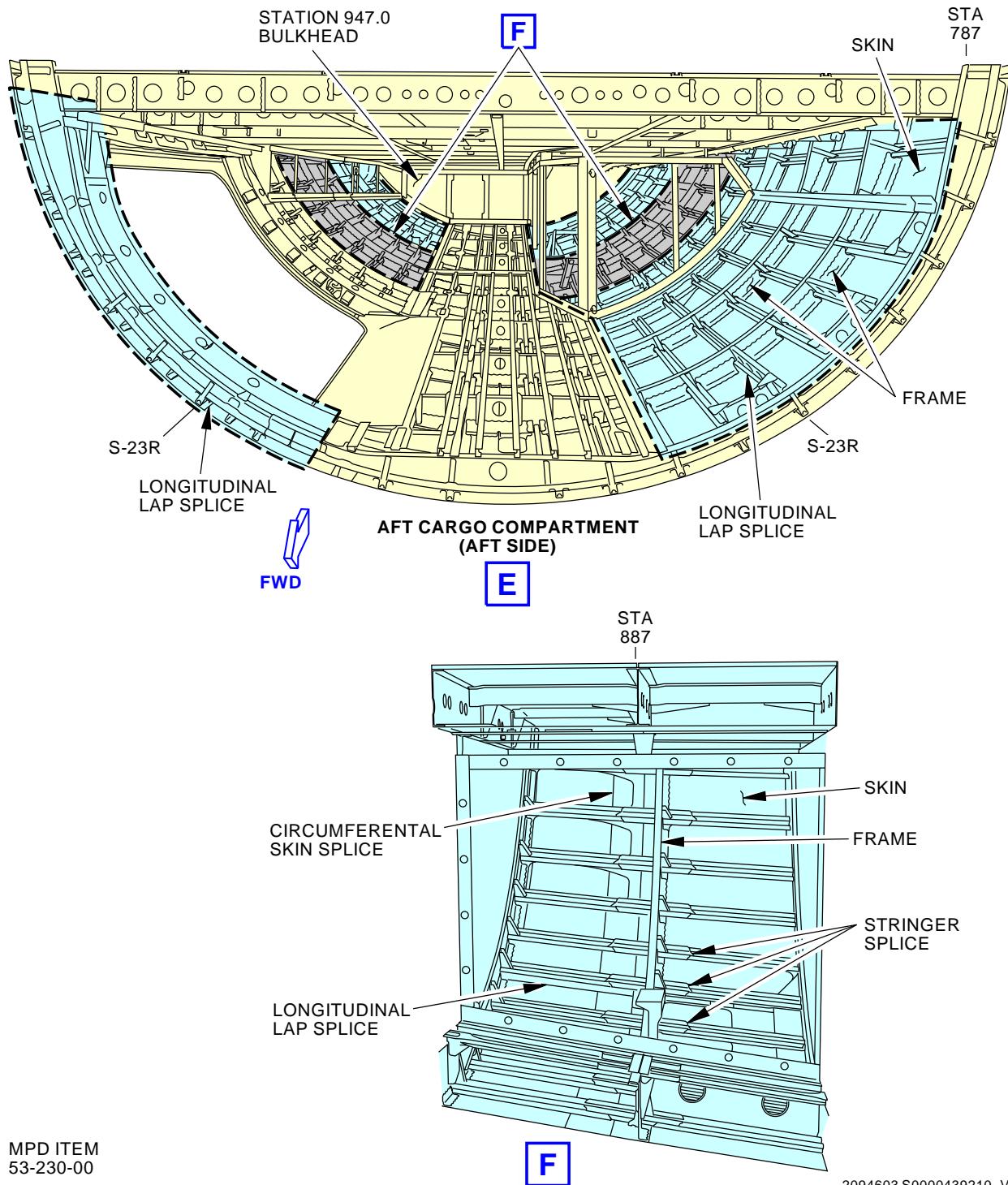
2094379 S0000439211_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-859 (Sheet 2 of 3)

EFFECTIVITY	AKS ALL
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D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL**


MPD ITEM
53-230-00

2094603 S0000439210_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-859 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-804

26. INTERNAL - DETAILED: AFT CARGO DOOR CUTOUT

(Figure 228)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

C. Inspection

SUBTASK 53-05-03-010-058

- (1) Special Access:

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

NOTE: Remove door reveals. Remove sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-004

- (2) Do a Detailed inspection of the aft cargo door cutout surround structure.

SUBTASK 53-05-03-910-029

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-058

- (4) Close this access panel:

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

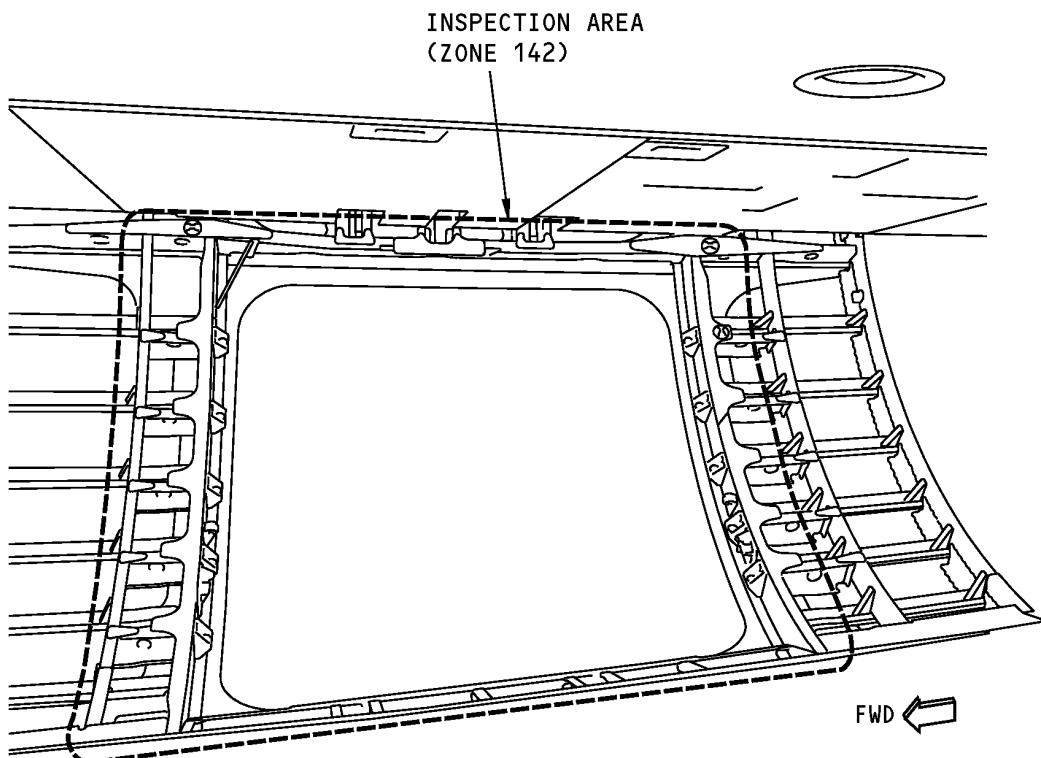
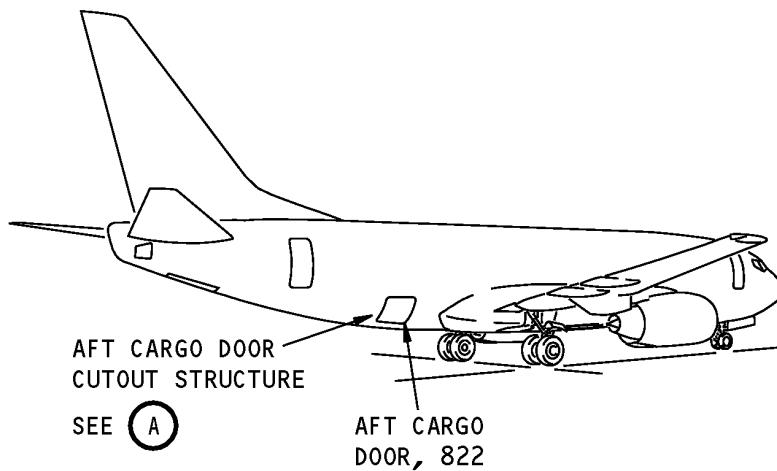
———— END OF TASK ————



53-05-03



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AFT CARGO DOOR CUTOUT STRUCTURE
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)

(A)

Aft Cargo Door Cutout Detailed (Internal)
Figure 228/53-05-03-990-820

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-825

27. INTERNAL - GENERAL VISUAL: AFT BILGE

(Figure 229,Figure 230)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1402	Aft Bilge Inspection

C. Inspection

SUBTASK 53-05-03-010-022

- (1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1402	Aft Bilge Inspection

NOTE: Remove cargo floor panels and scuff plates. Remove/Displace insulation blankets as required.

SUBTASK 53-05-03-210-025

- (2) Do a General Visual inspection of the aft bilge skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, (note: located at Sta 727I for -900 and 727L for -900ER models); Sta 727 bulkhead and pressure web, and cargo door cutout surround structure in bilge.

SUBTASK 53-05-03-910-030

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

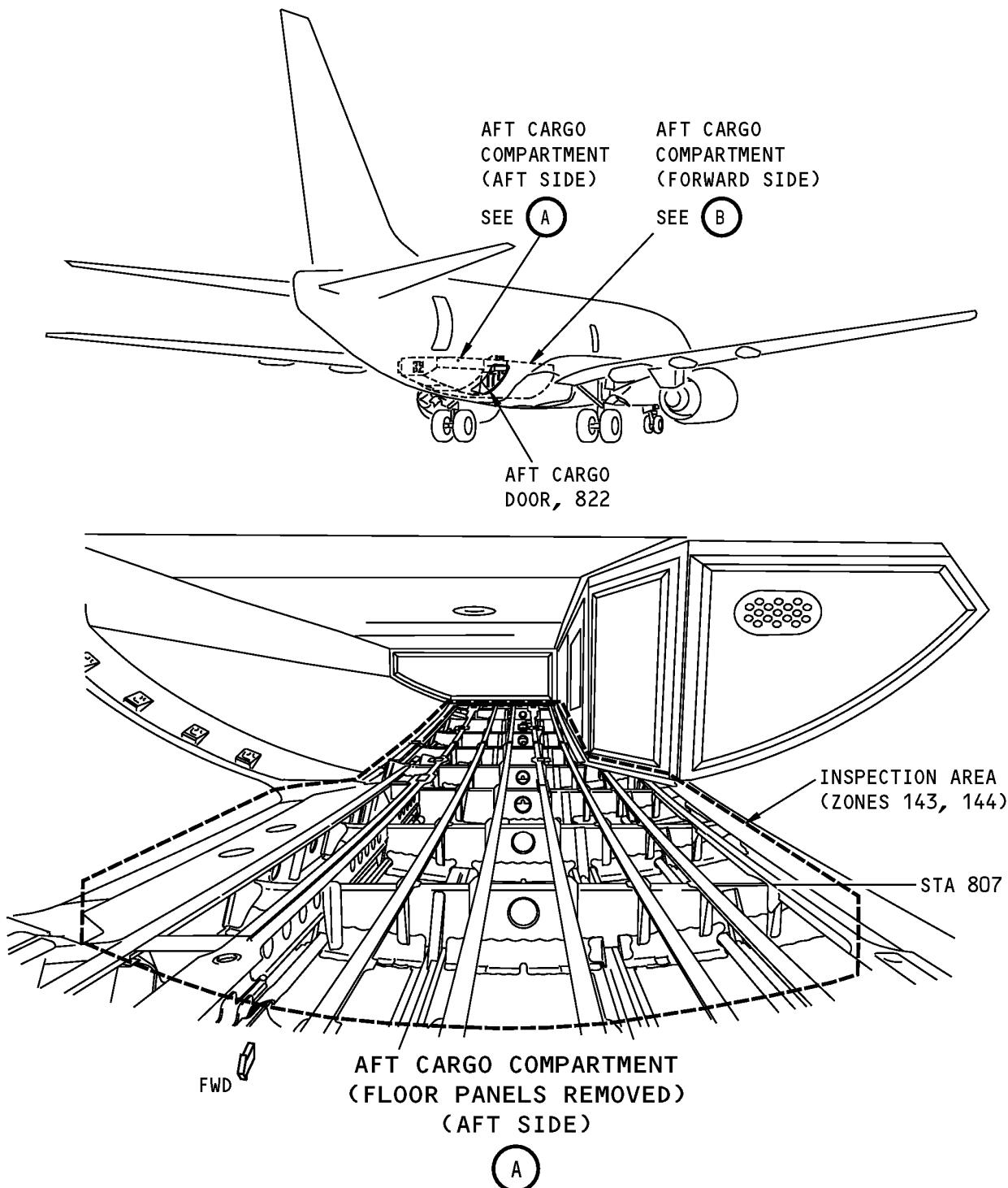
———— END OF TASK ————



53-05-03



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Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-826 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

53-05-03

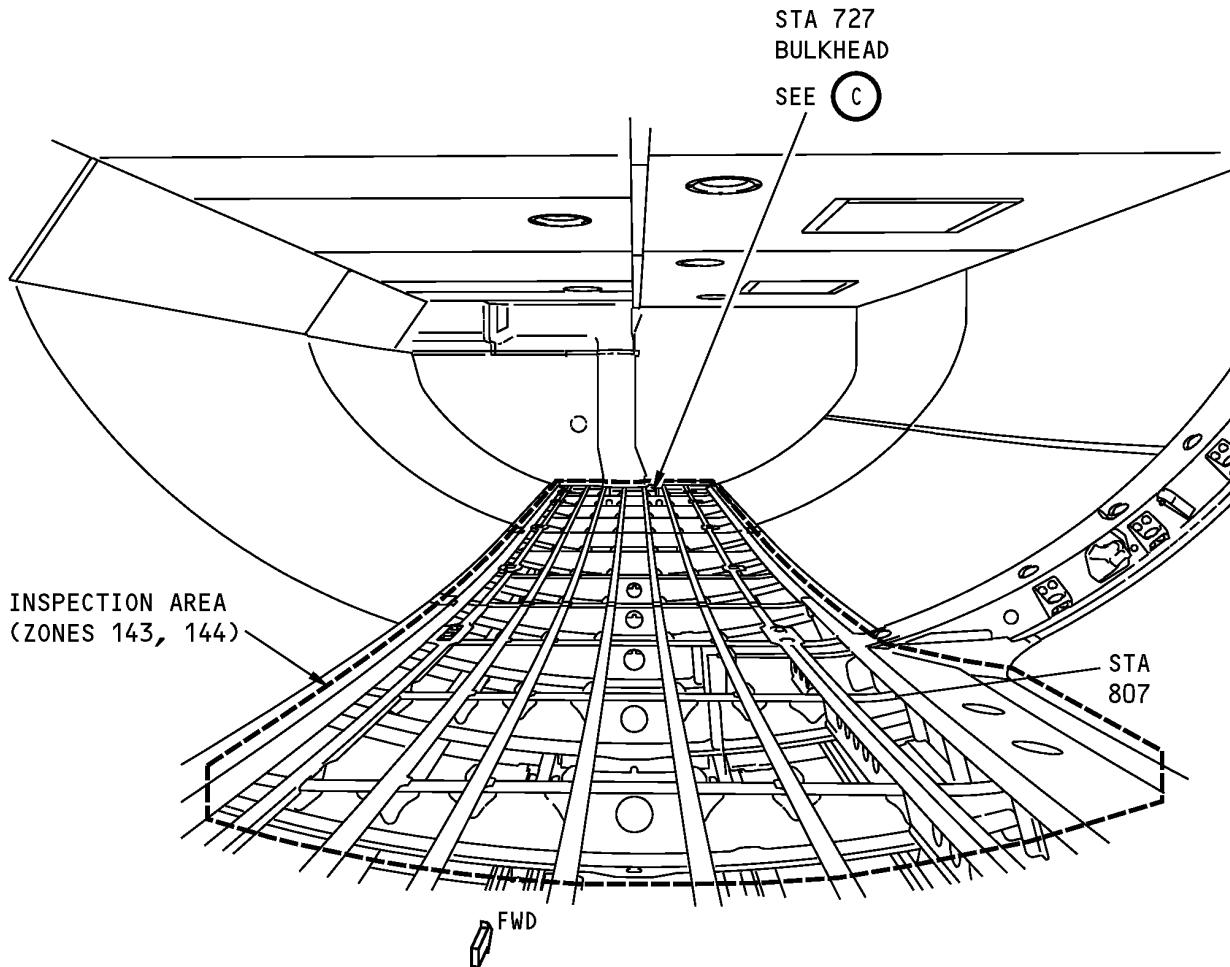
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AFT CARGO COMPARTMENT
(FLOOR PANELS REMOVED)
(FORWARD SIDE)

B

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-826 (Sheet 2 of 3)

EFFECTIVITY
AKS ALL

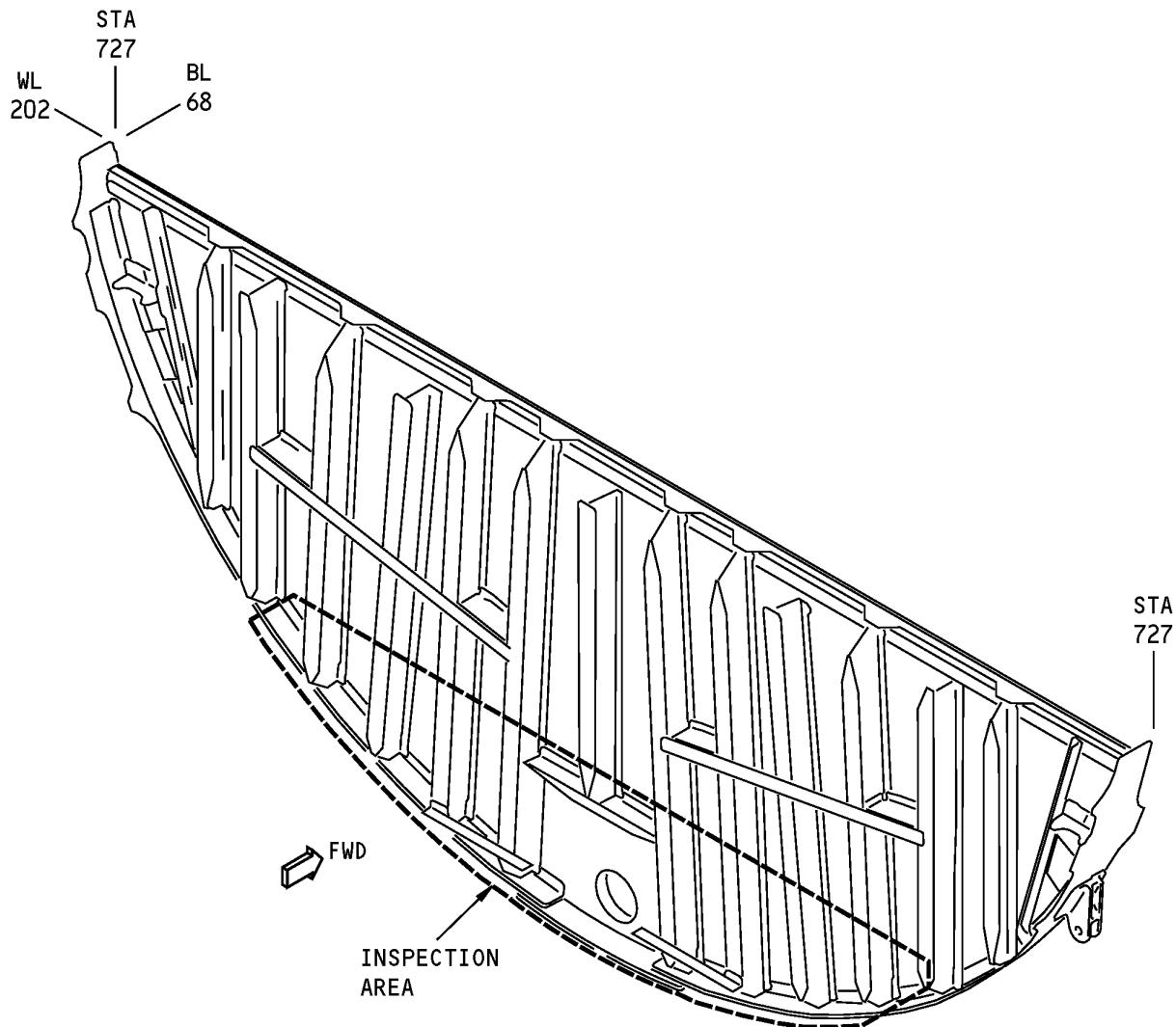
53-05-03

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STA 727 BULKHEAD

C

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-826 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

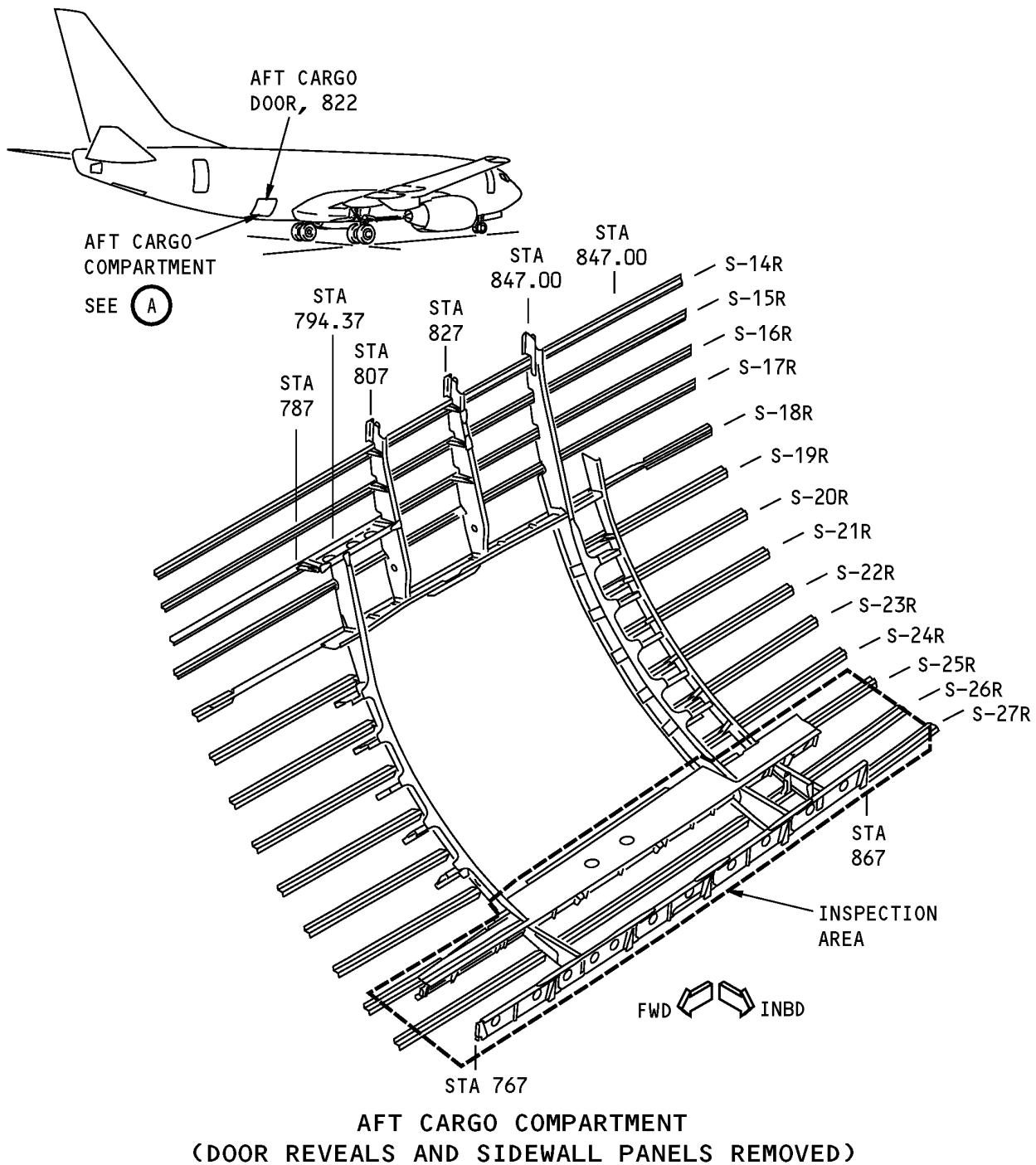
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Section 46 Aft Cargo Door Surround Structure Locations - General Visual (Internal)
Figure 230/53-05-03-990-832

EFFECTIVITY
AKS ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-826

28. INTERNAL - GENERAL VISUAL: AREA AFT OF CARGO COMPARTMENT

(Figure 231)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

B. Access Panels

Number	Name/Location
S1403	Area Aft of Cargo Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-023

- (1) Special Access:

Number	Name/Location
S1403	Area Aft of Cargo Compartment Inspection

NOTE: Remove aft cargo compartment aft bulkhead panel and potable water tank.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-026

- (2) Do a General Visual inspection of the area aft of cargo compartment, including:

1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.
2. Aft entry and galley door cutout surround structure in lower lobe.
3. STA 1016 bulkhead, including chords, pressure web, stiffeners, chord/web attachments.
4. Stringer splice fittings and tension bolts at STA 1016.

SUBTASK 53-05-03-910-031

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

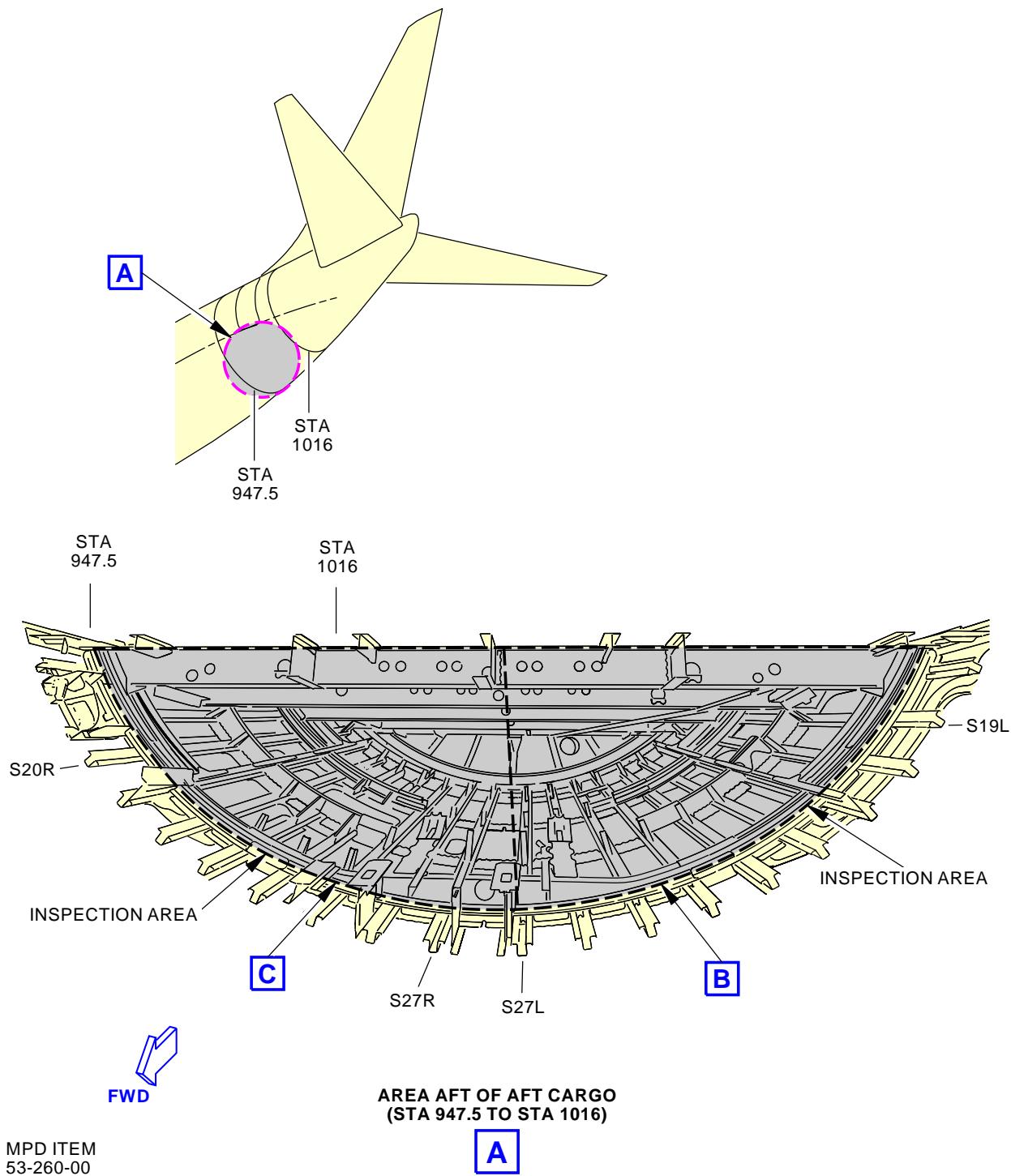
———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03



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MPD ITEM
53-260-00

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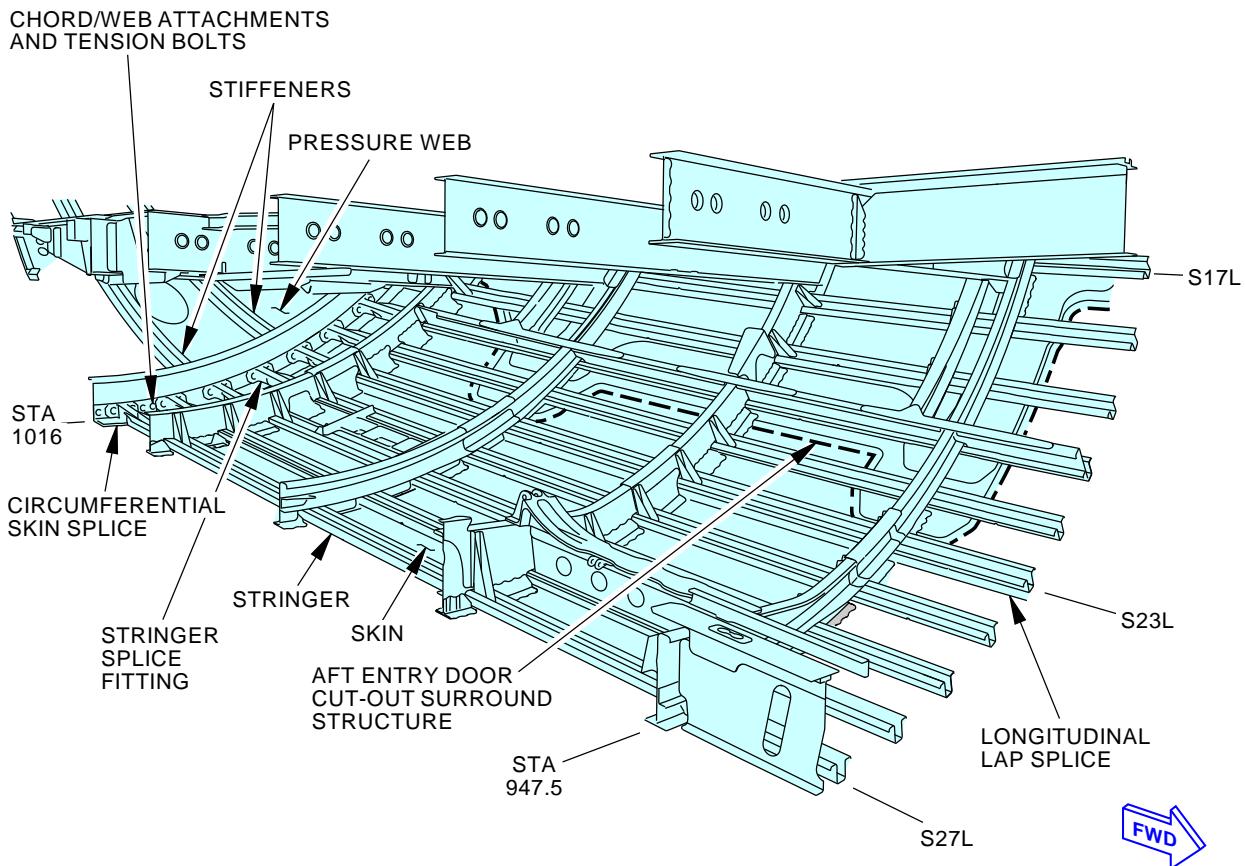
Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-866 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

D633A101-AKS

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AREA AFT OF AFT CARGO
(STA 947.5 TO STA 1016)
(LEFT SIDE)

B

MPD ITEM
53-260-00

2094973 S0000442106_V2

Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-866 (Sheet 2 of 3)

EFFECTIVITY
AKS ALL

53-05-03

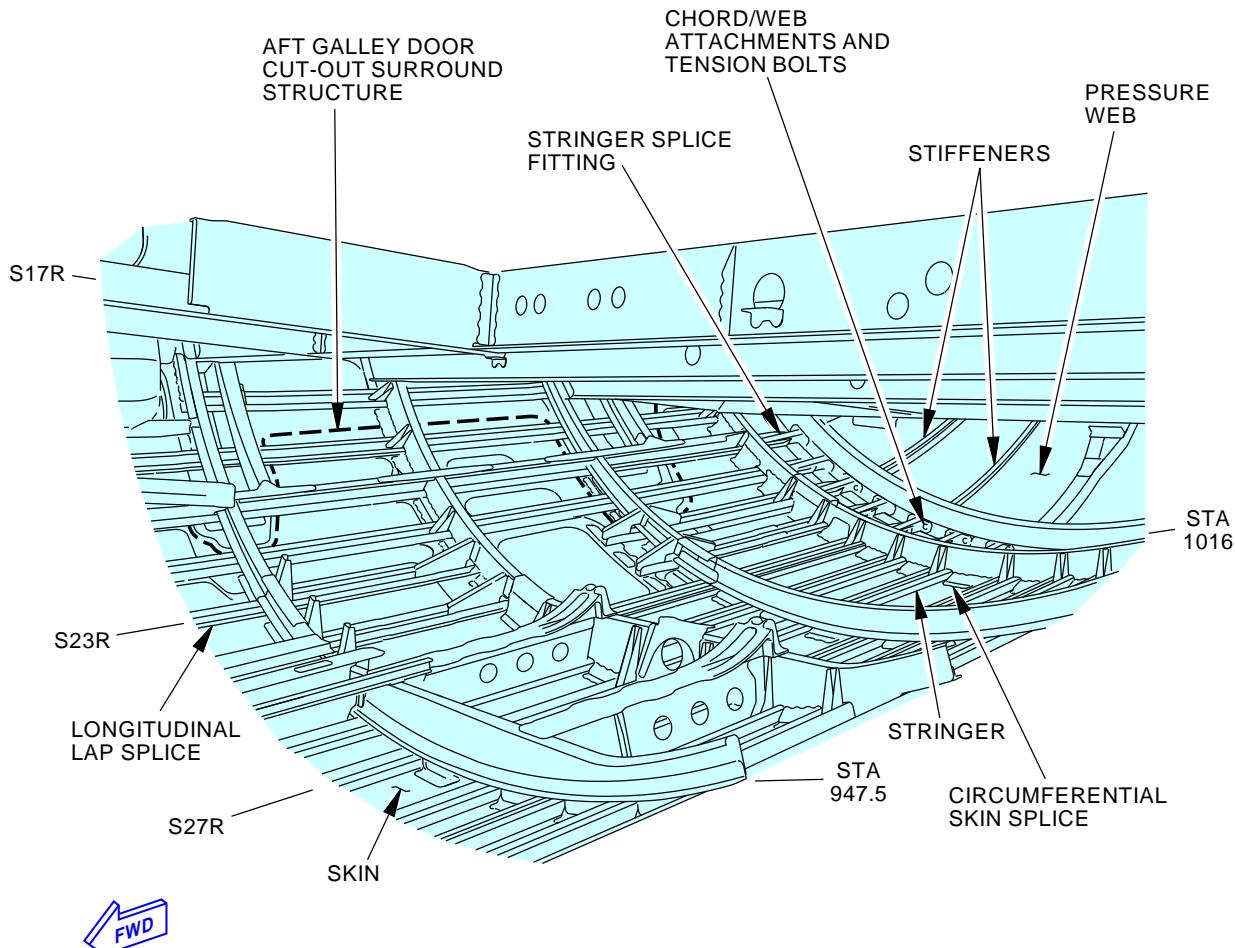
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AREA AFT OF AFT CARGO
(STA 947.5 TO STA 1016)
(RIGHT SIDE)

C

MPD ITEM
53-260-00

2095515 S0000442107_V2

Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-866 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-827

29. **INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)**
(Figure 232)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
149	Keel Beam (Part) Body Station 727.00 to Body Station 743.95
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

B. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

C. Inspection

SUBTASK 53-05-03-010-024

- (1) Open these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel



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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-03-210-027

- (2) Do a General Visual inspection of the area under lower wing-to-body fairing (aft of wheel well), including skin panels, longitudinal lap splices, circumferential skin splice, stringer 18 strap at side of body, stringer 18A (web, chords and links), and keel beam extension.

SUBTASK 53-05-03-910-032

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-024

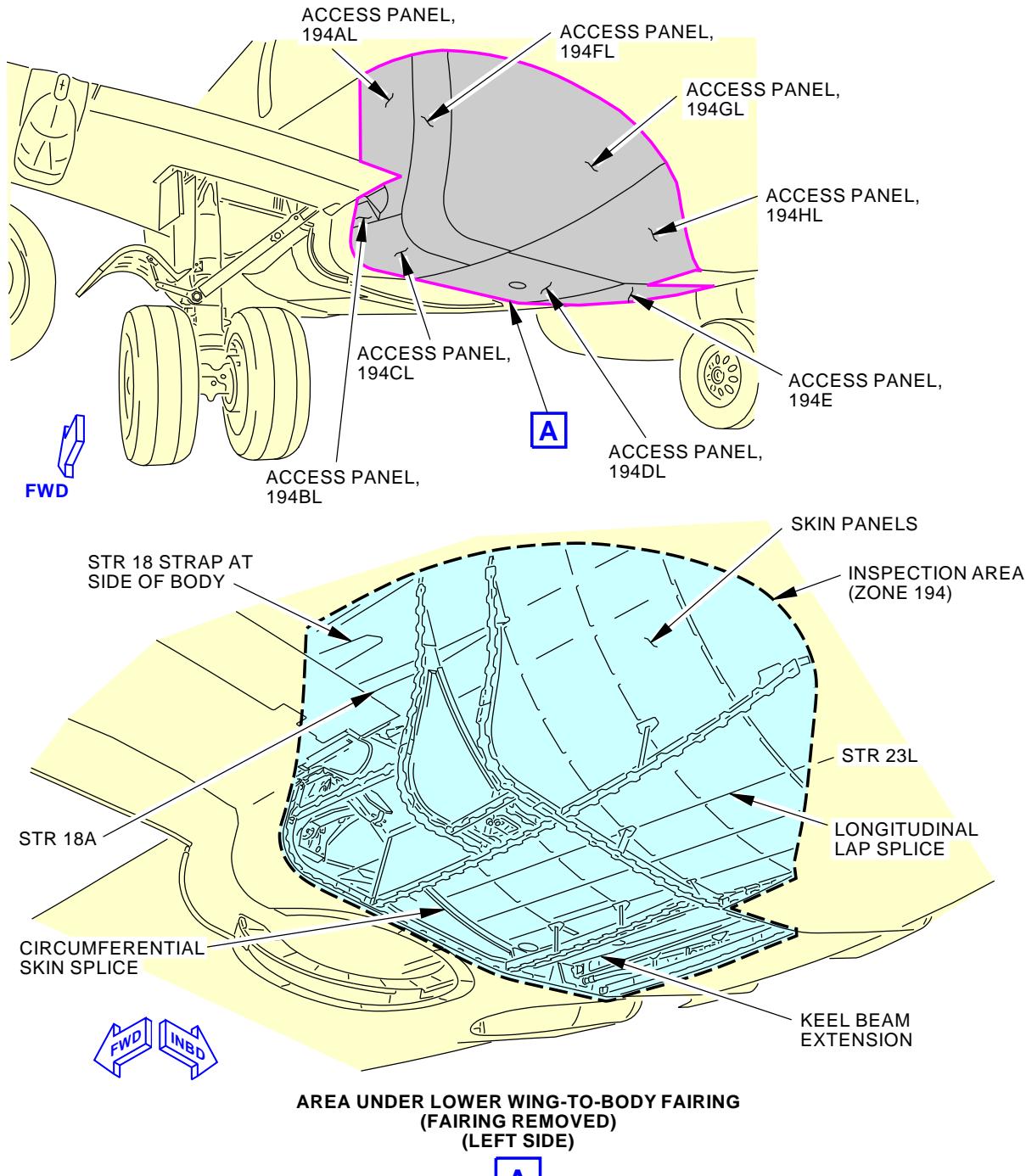
- (4) Close these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

———— END OF TASK ————



53-05-03

**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**

MPD ITEM
53-270-00

2089485 S0000441011_V2

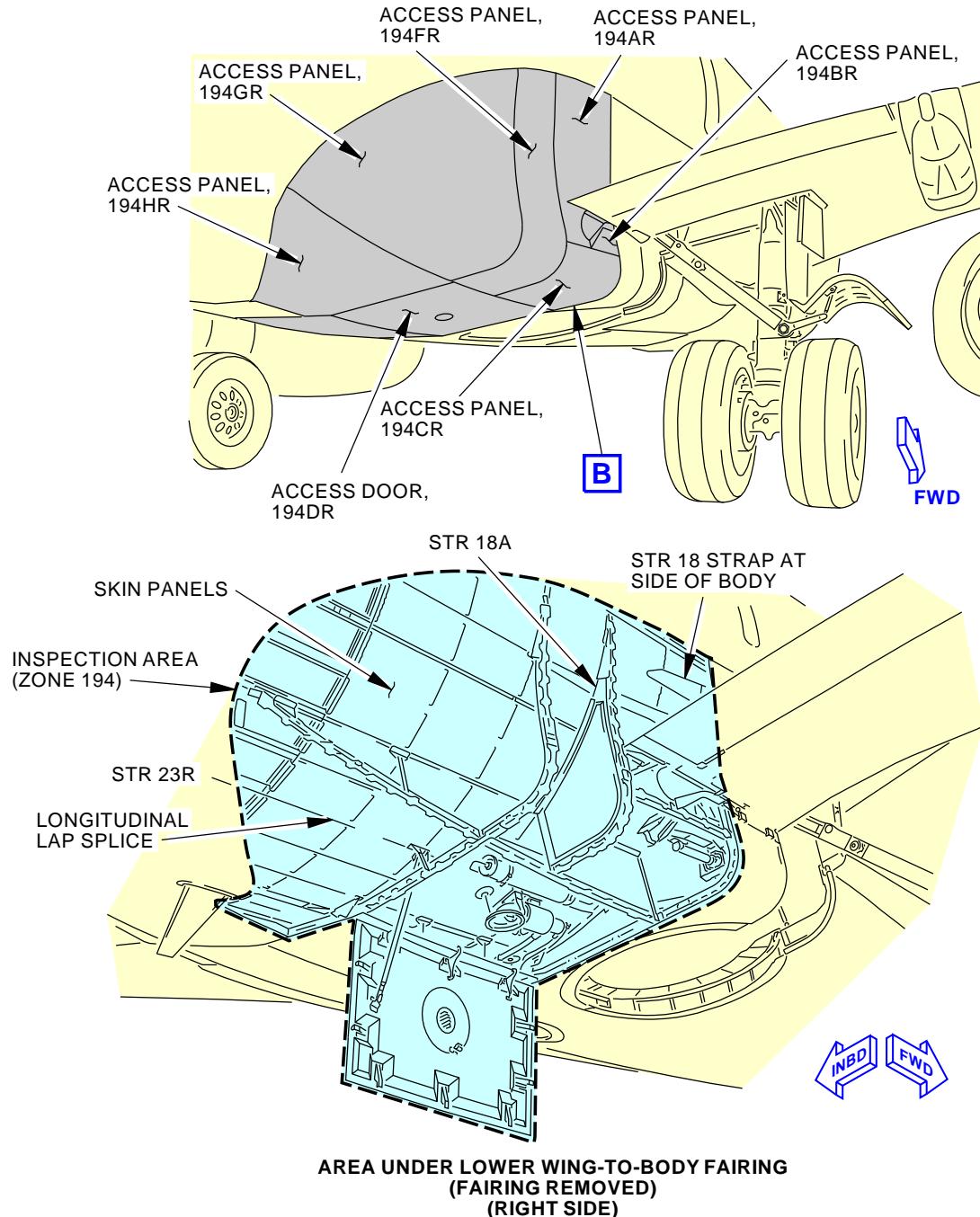
INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)
Figure 232/53-05-03-990-855 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**


MPD ITEM
57-270-00

2089514 S0000441012_V2

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)
Figure 232/53-05-03-990-855 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-828

30. **INTERNAL - GENERAL VISUAL: AREA UNDER WING-TO-BODY FAIRING (above wing)**
(Figure 233,Figure 234)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Access Panels

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

C. Inspection

SUBTASK 53-05-03-010-025

- (1) Open these access panels:

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

SUBTASK 53-05-03-210-028

- (2) Do a General Visual inspection of the area under above-wing wing-to-body fairing, including skin panels, circumferential skin splices, and stringer 18 strap at side of body.

SUBTASK 53-05-03-910-035

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-025

- (4) Close these access panels:

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

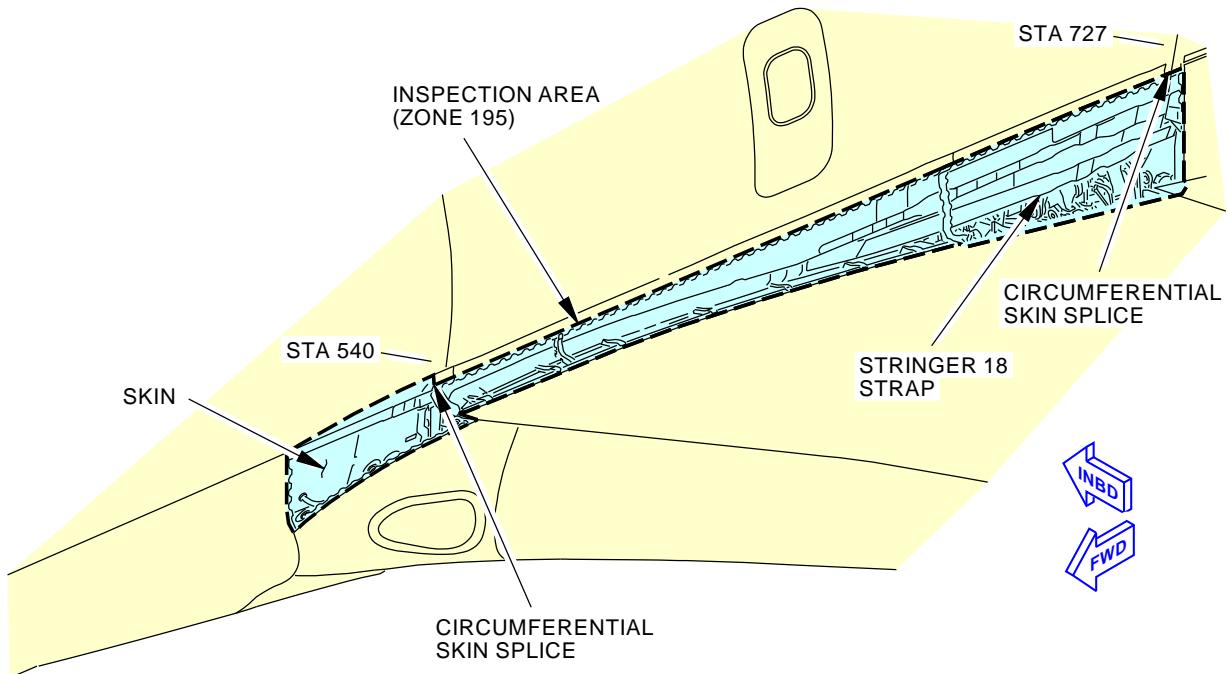
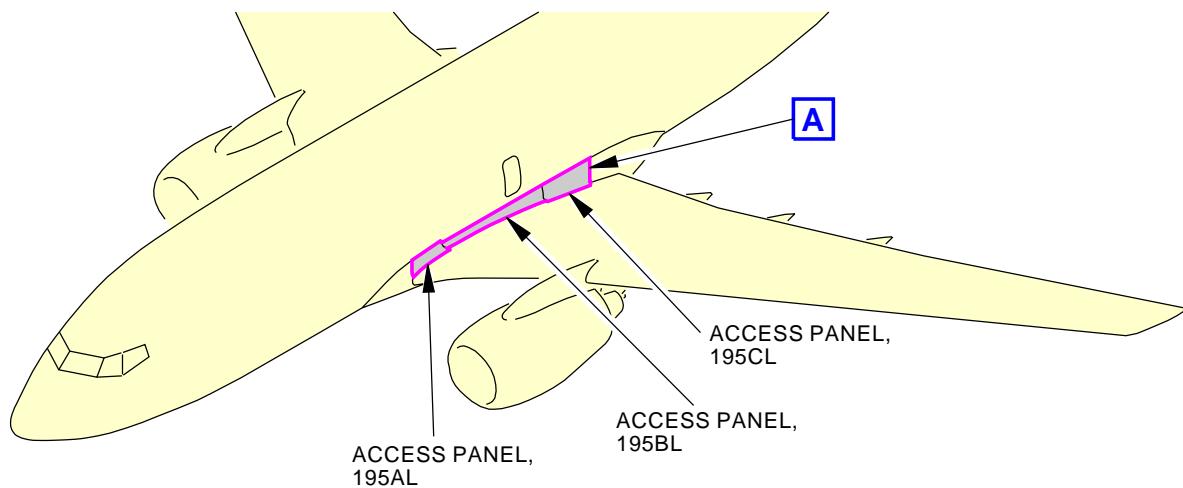
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53-05-03



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-280-00

A

2083283 S0000437150_V2

Internal - General Visual: Area Under Left Wing-to-Body Fairing
Figure 233/53-05-03-990-856

EFFECTIVITY
AKS ALL

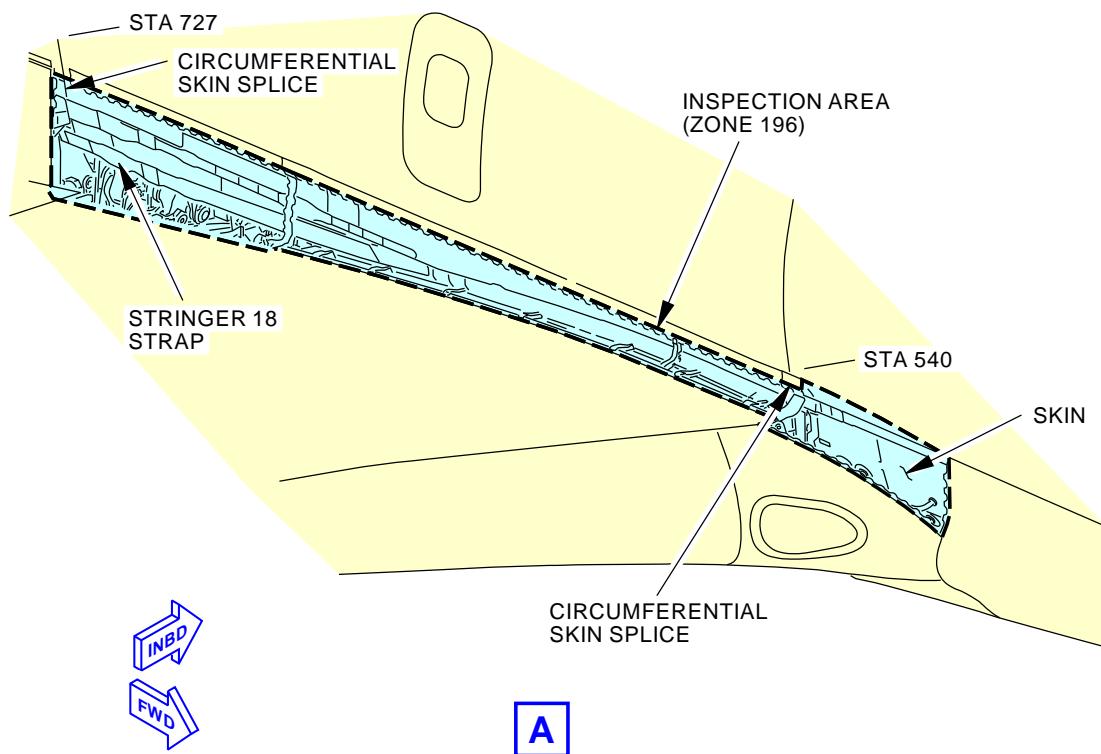
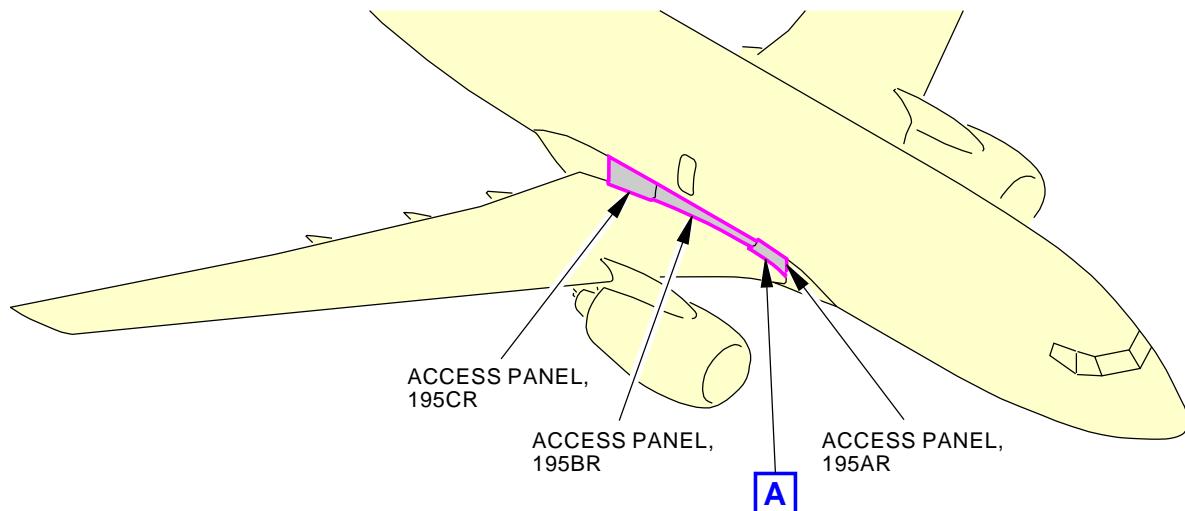
D633A101-AKS

53-05-03

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-280-00

2083297 S0000437151_V3

Internal - General Visual: Area Under Right Wing-to-Body Fairing
Figure 234/53-05-03-990-899

EFFECTIVITY
AKS ALL

D633A101-AKS

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TASK 53-05-03-210-829

31. EXTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT

(Figure 235,Figure 236)

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. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-03-010-026

- (1) Open these access panels:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

NOTE: Open automatic overwing exits.

SUBTASK 53-05-03-210-029

- (2) Do a General Visual inspection of the automatic overwing exit cutout structure, fittings and stops.

SUBTASK 53-05-03-910-034

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-026

- (4) Close these access panels:

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

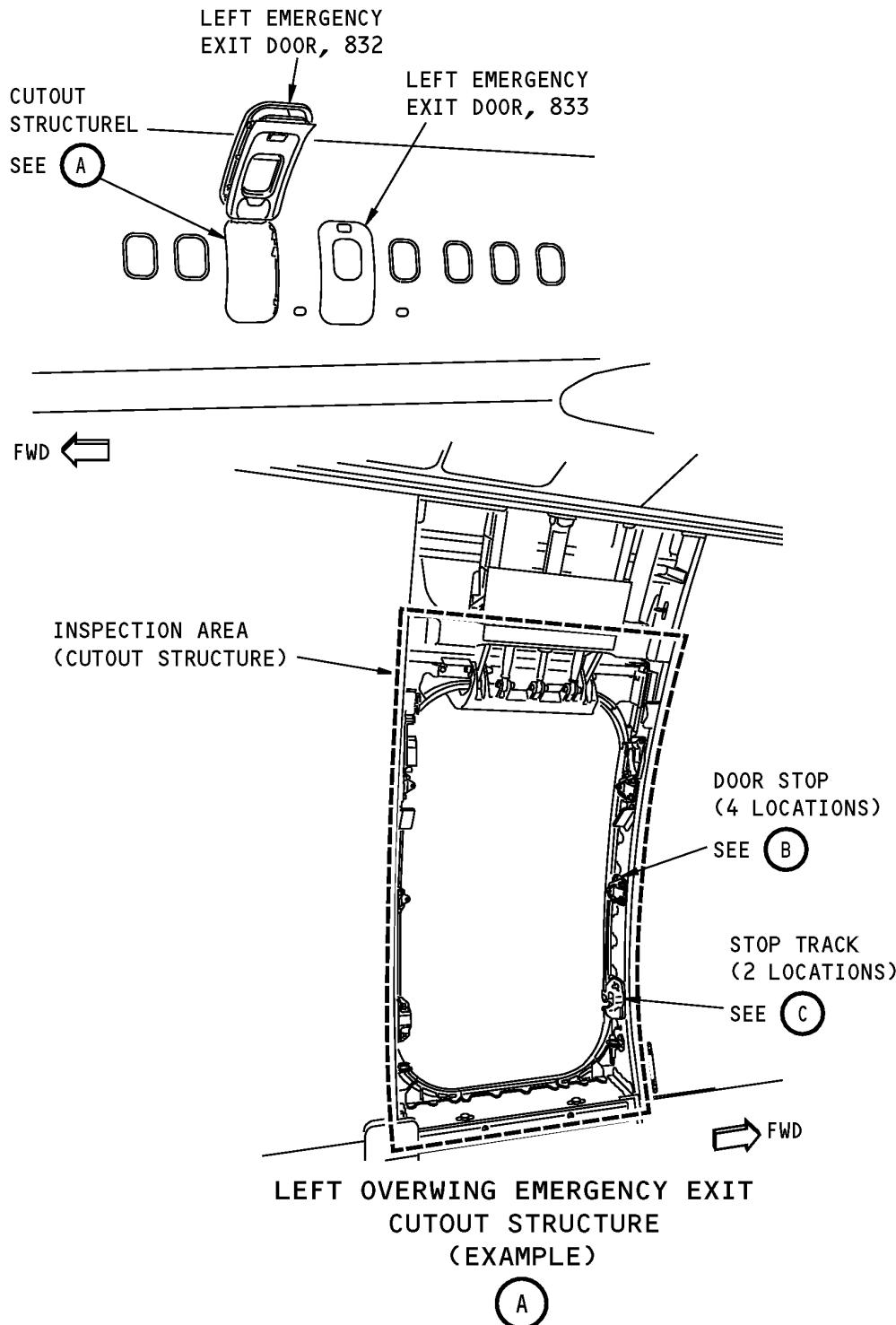
———— END OF TASK ————



53-05-03



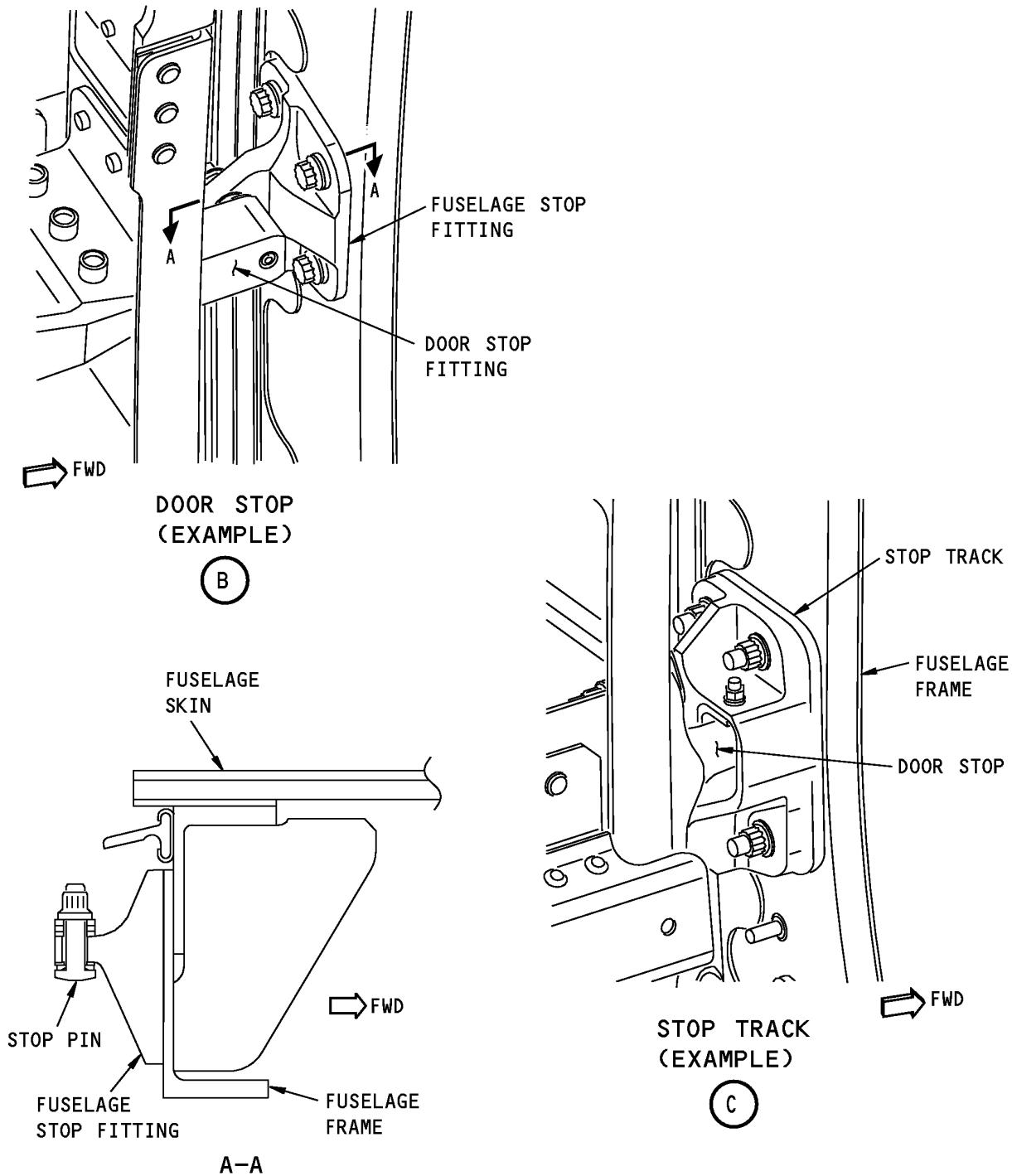
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



Left Overwing Emergency Exit Cutout
Figure 235/53-05-03-990-814 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

53-05-03



484672 S0000143827_V2

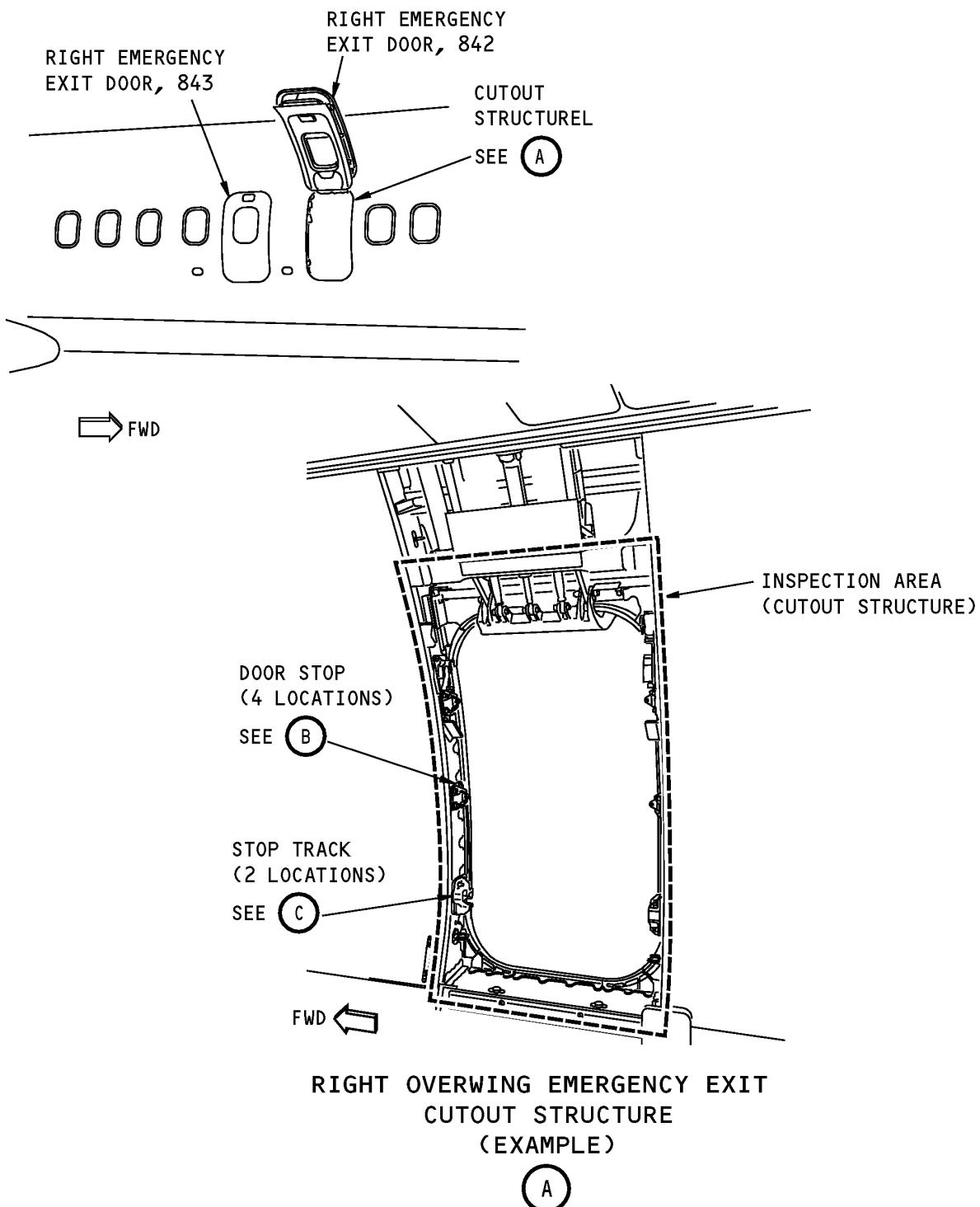
Left Overwing Emergency Exit Cutout
Figure 235/53-05-03-990-814 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



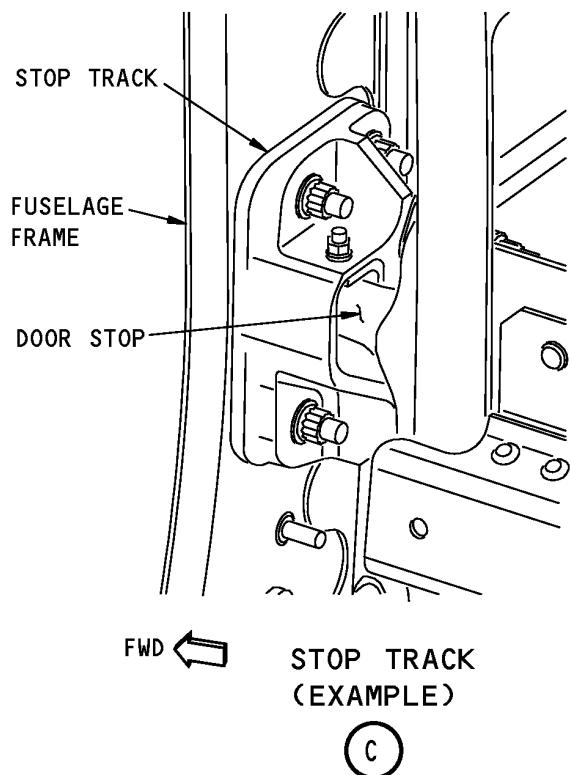
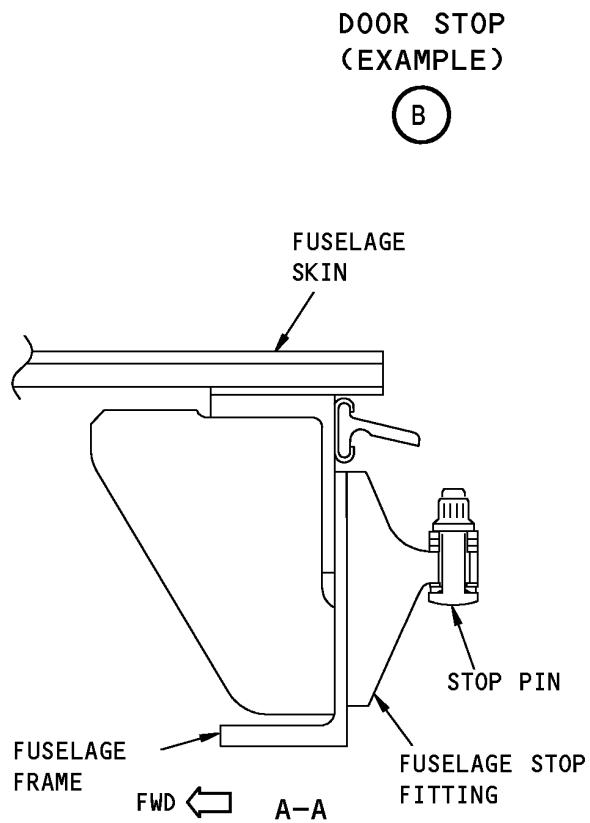
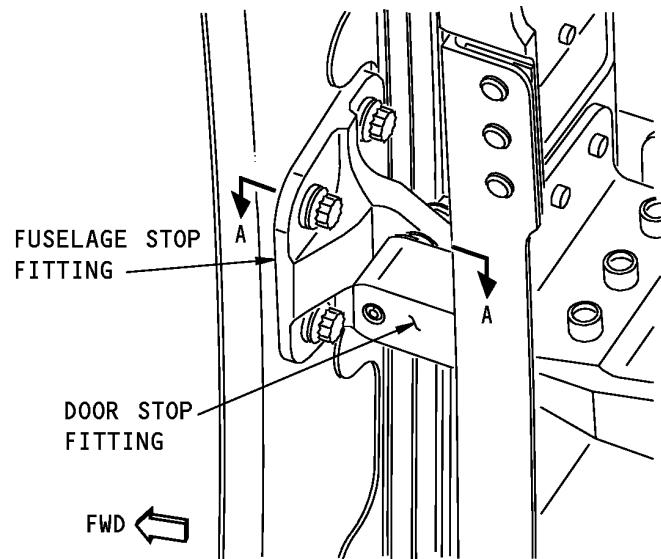
Right Overwing Emergency Exit Cutout
Figure 236/53-05-03-990-815 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

53-05-03

 BOEING

737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



484701 S0000143840_V2

Right Overwing Emergency Exit Cutout
Figure 236/53-05-03-990-815 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-805

32. **EXTERNAL - DETAILED: FORWARD ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES**
(Figure 237)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

C. Inspection

SUBTASK 53-05-03-010-059

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

NOTE: Open forward entry door.

SUBTASK 53-05-03-211-005

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on the forward door cutout surround structure.

SUBTASK 53-05-03-910-036

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-059

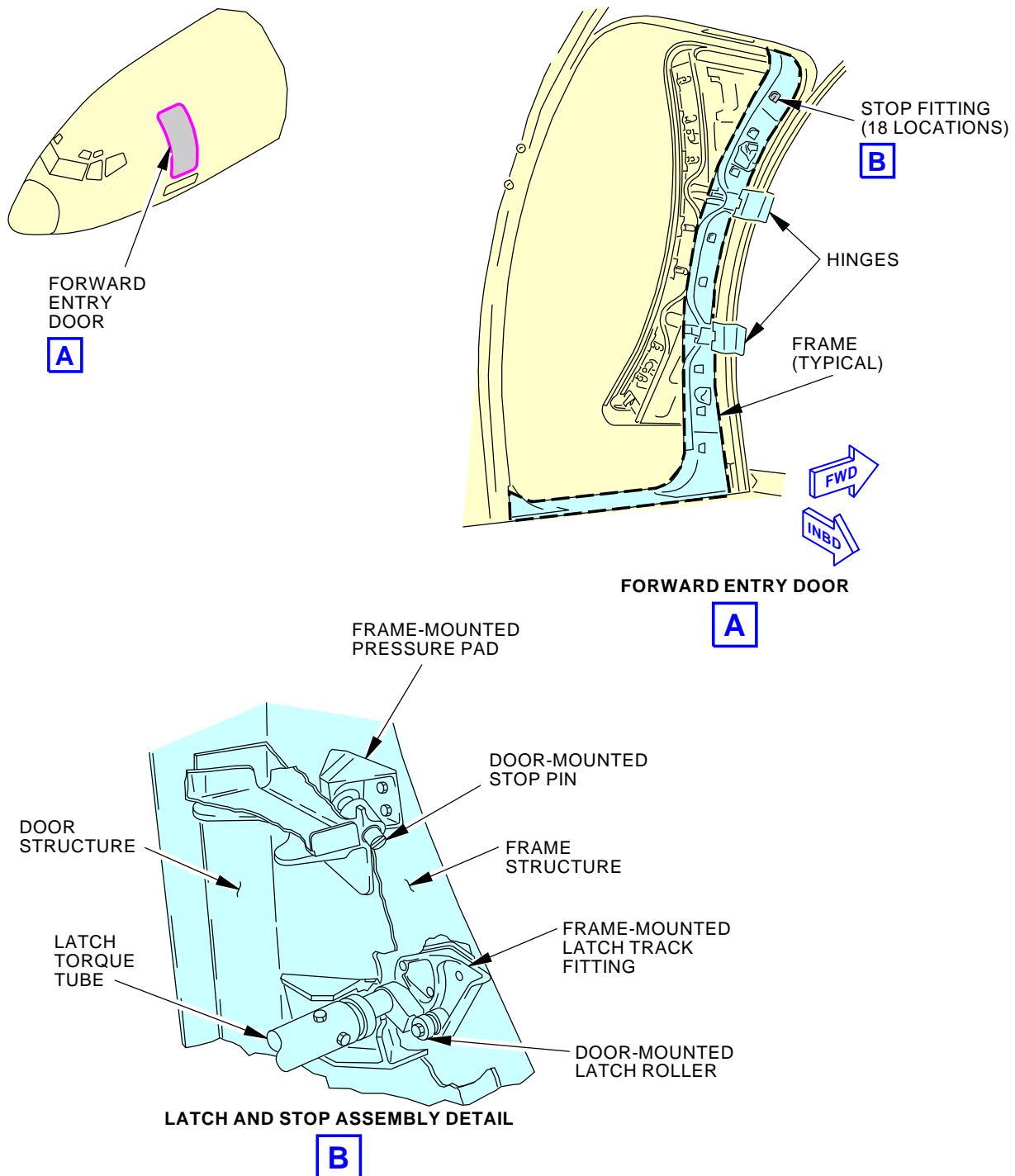
- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

———— END OF TASK ————



53-05-03



H45979 S0006584636_V2

External - Forward Entry Door Frame, Stop, Latches and Hinges
Figure 237/53-05-03-990-808

EFFECTIVITY
AKS ALL

53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-806

33. EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES

(Figure 238)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Access Panels

Number	Name/Location
841	Forward Galley Service Door

C. Inspection

SUBTASK 53-05-03-010-060

- (1) Open this access panel:

Number	Name/Location
841	Forward Galley Service Door

NOTE: Open forward galley service door.

SUBTASK 53-05-03-211-006

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on forward galley door cutout surround structure.

SUBTASK 53-05-03-910-037

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-060

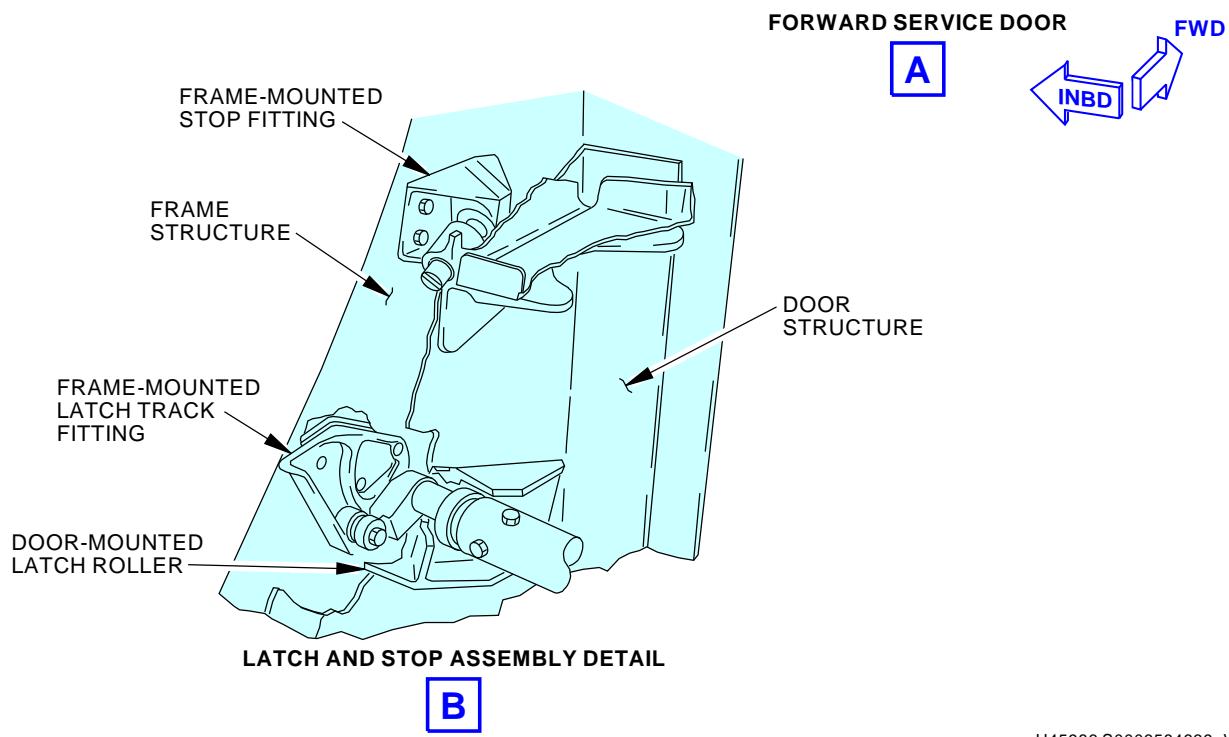
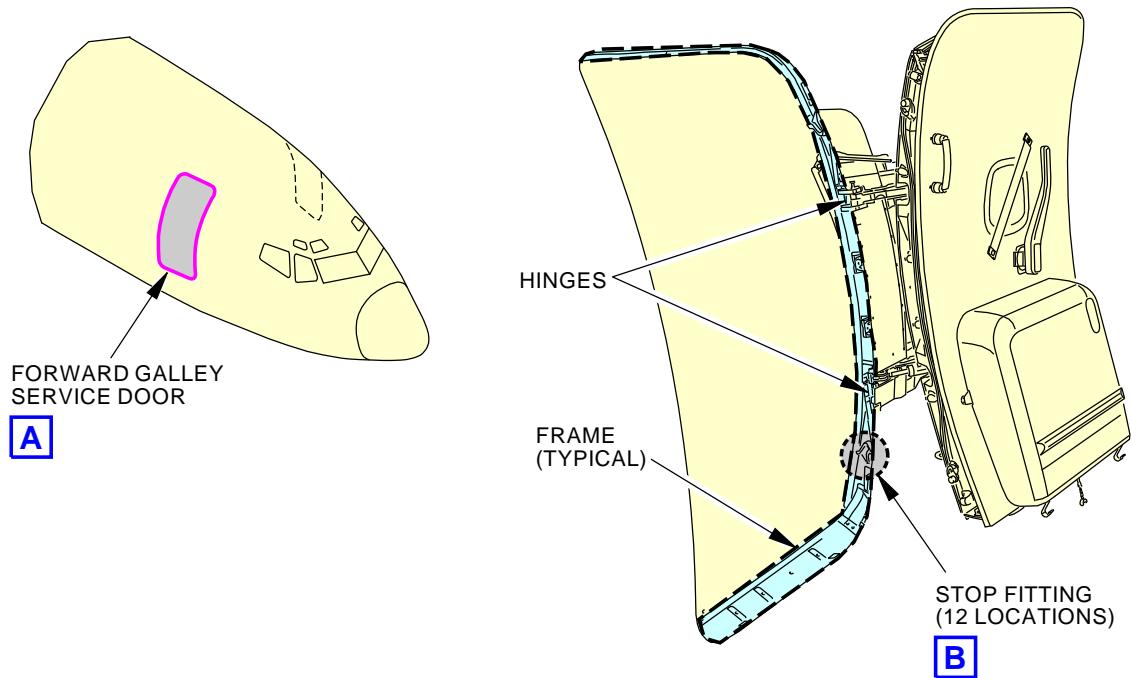
- (4) Close this access panel:

Number	Name/Location
841	Forward Galley Service Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03



H45986 S0006584639_V2

External - Forward Galley Service Door Frame, Stops, Latches and Hinges
Figure 238/53-05-03-990-809

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-807

34. EXTERNAL - DETAILED: AFT ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES

(Figure 239)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

C. Inspection

SUBTASK 53-05-03-010-061

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Open aft entry door.

SUBTASK 53-05-03-211-007

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft entry cutout surround structure.

SUBTASK 53-05-03-910-038

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-061

- (4) Close this access panel:

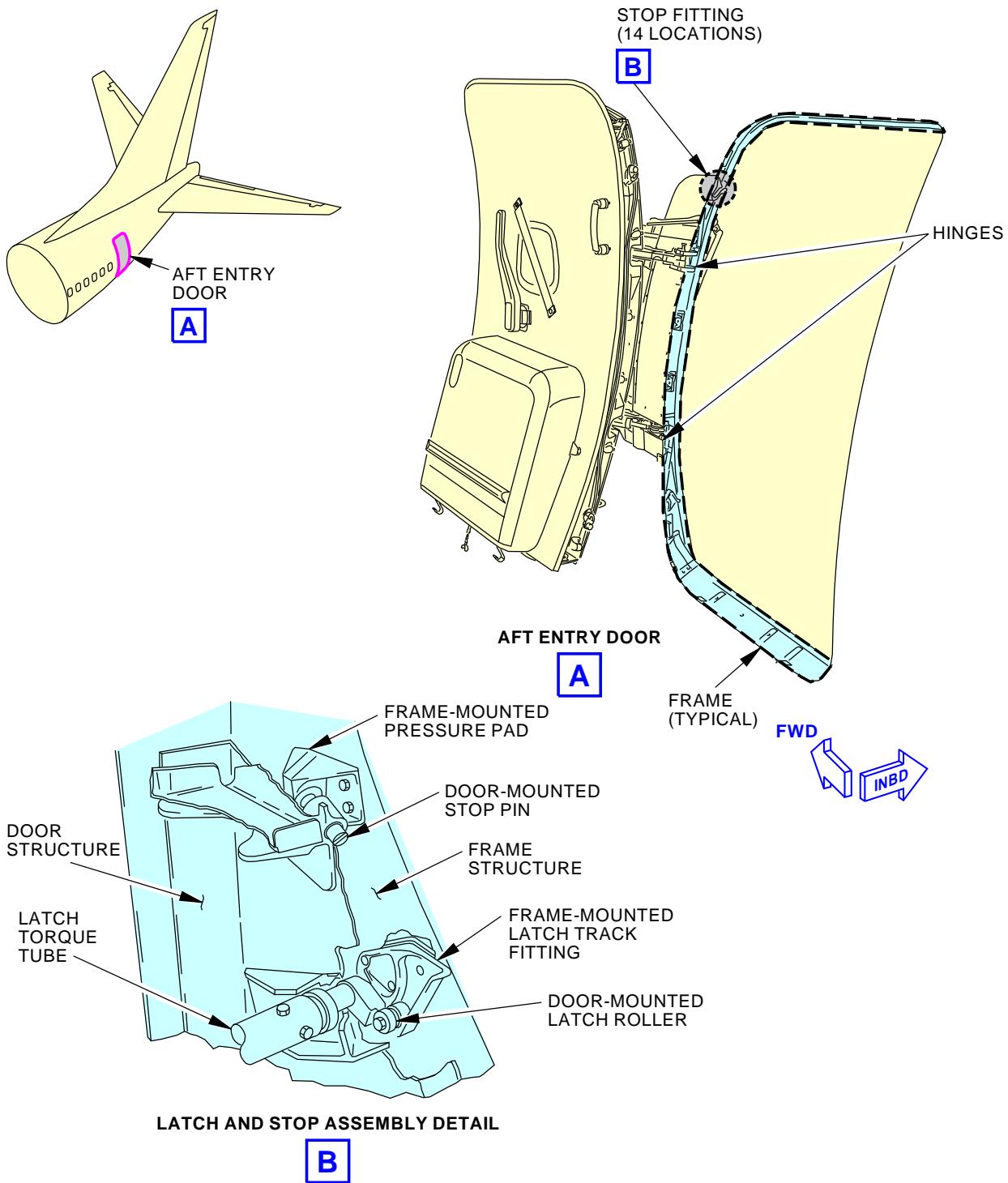
<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

———— END OF TASK ————

EFFECTIVITY

AKS ALL

53-05-03



H46018 S0006584642_V2

AFT Entry Door Frame, Stops, Latches and Hinges
Figure 239/53-05-03-990-810

EFFECTIVITY	
AKS ALL	

D633A101-AKS

53-05-03

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TASK 53-05-03-211-808

35. **EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES**
(Figure 240)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-03-010-062

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Open aft galley door.

SUBTASK 53-05-03-211-008

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft galley door cutout surround structure.

SUBTASK 53-05-03-910-039

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-062

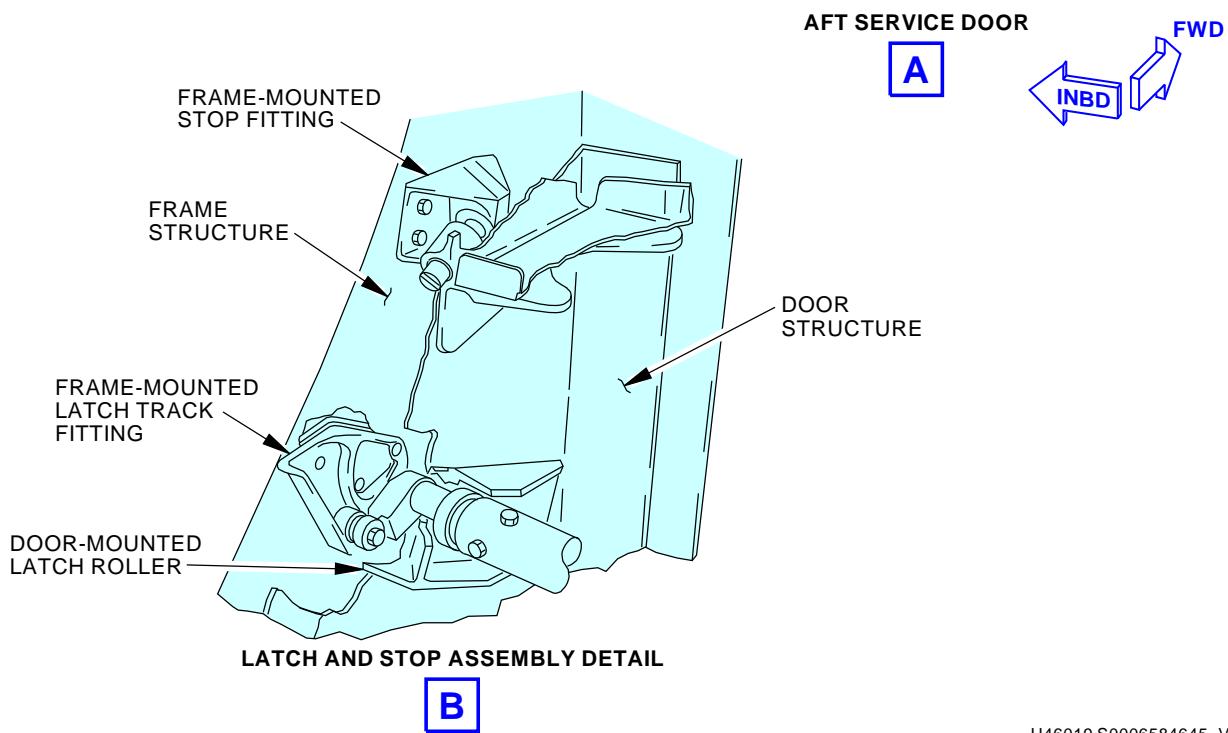
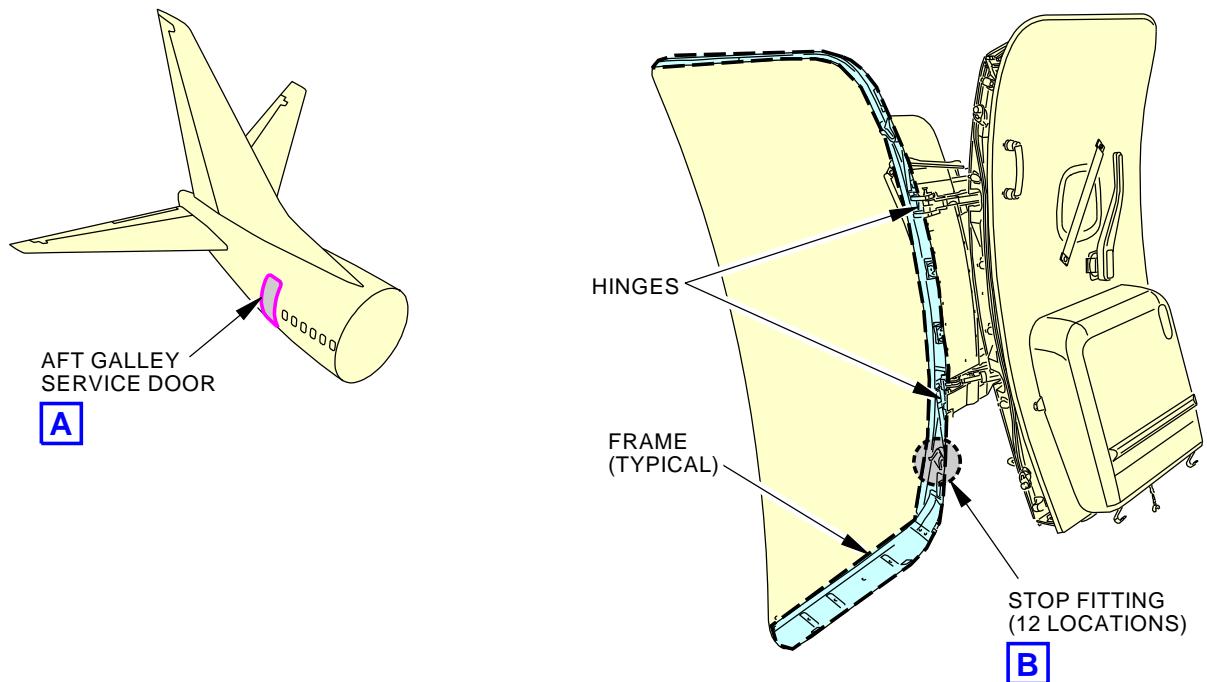
- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————



53-05-03



H46019 S0006584645_V2

Aft Galley Door Frame, Stop, Latches and Hinges
Figure 240/53-05-03-990-811

EFFECTIVITY

 AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-830

36. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Access Panels

Number	Name/Location
S2101	Flight Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-078

- (1) Special Access:

Number	Name/Location
S2101	Flight Compartment Inspection

NOTE: Remove glare shield, liners, overhead units and panels as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-030

- (2) Do a General Visual inspection of the flight compartment from Sta 178 to 270, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and structure adjacent to ground block behind rudder pedal. Inspection area does not include: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame (except structure adjacent to ground block behind rudder pedal); skin, frames and stringers above P5 panel.

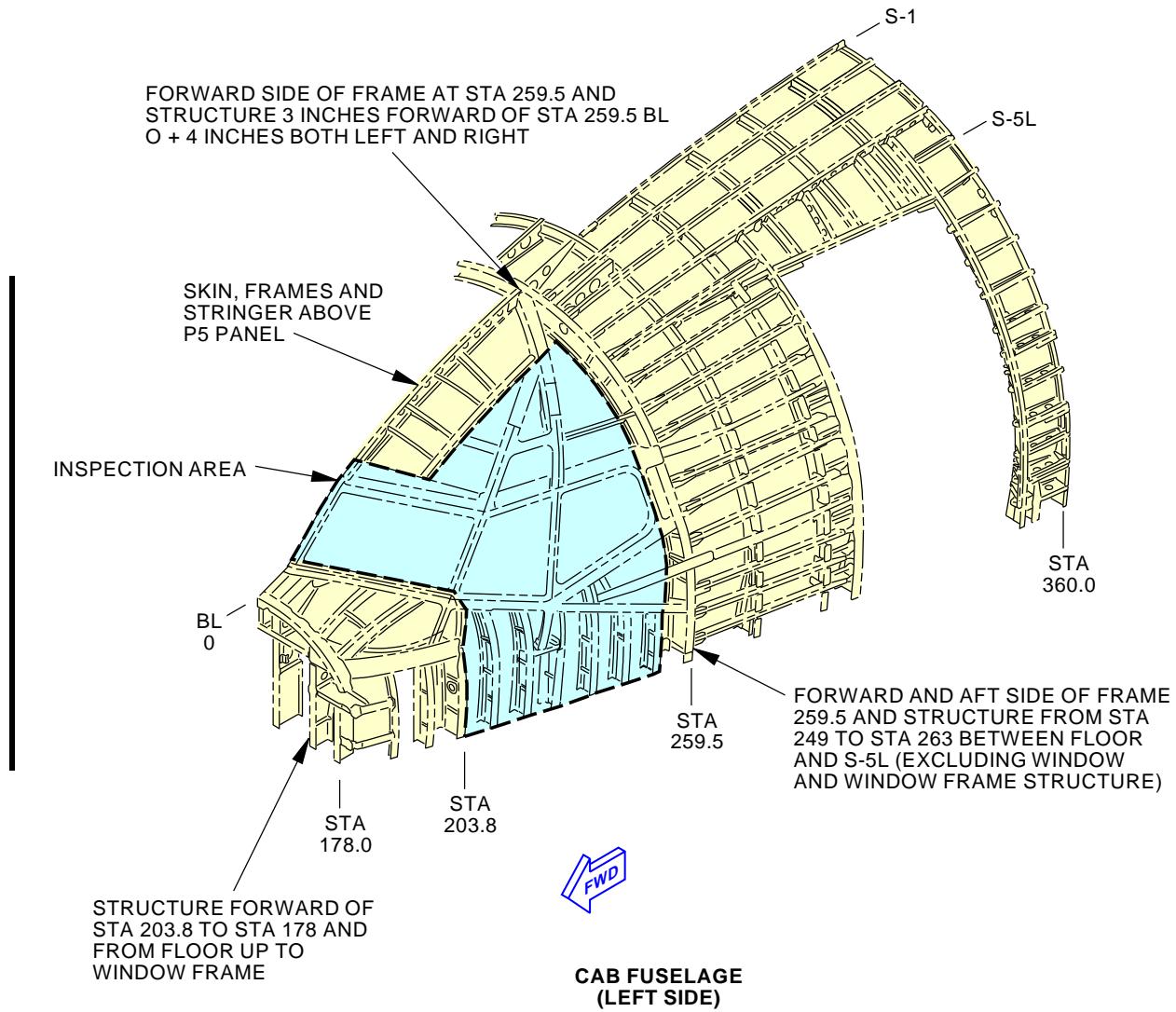
SUBTASK 53-05-03-910-040

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03



MPD ITEM 53-330-00

2293027 S0000519158_V3

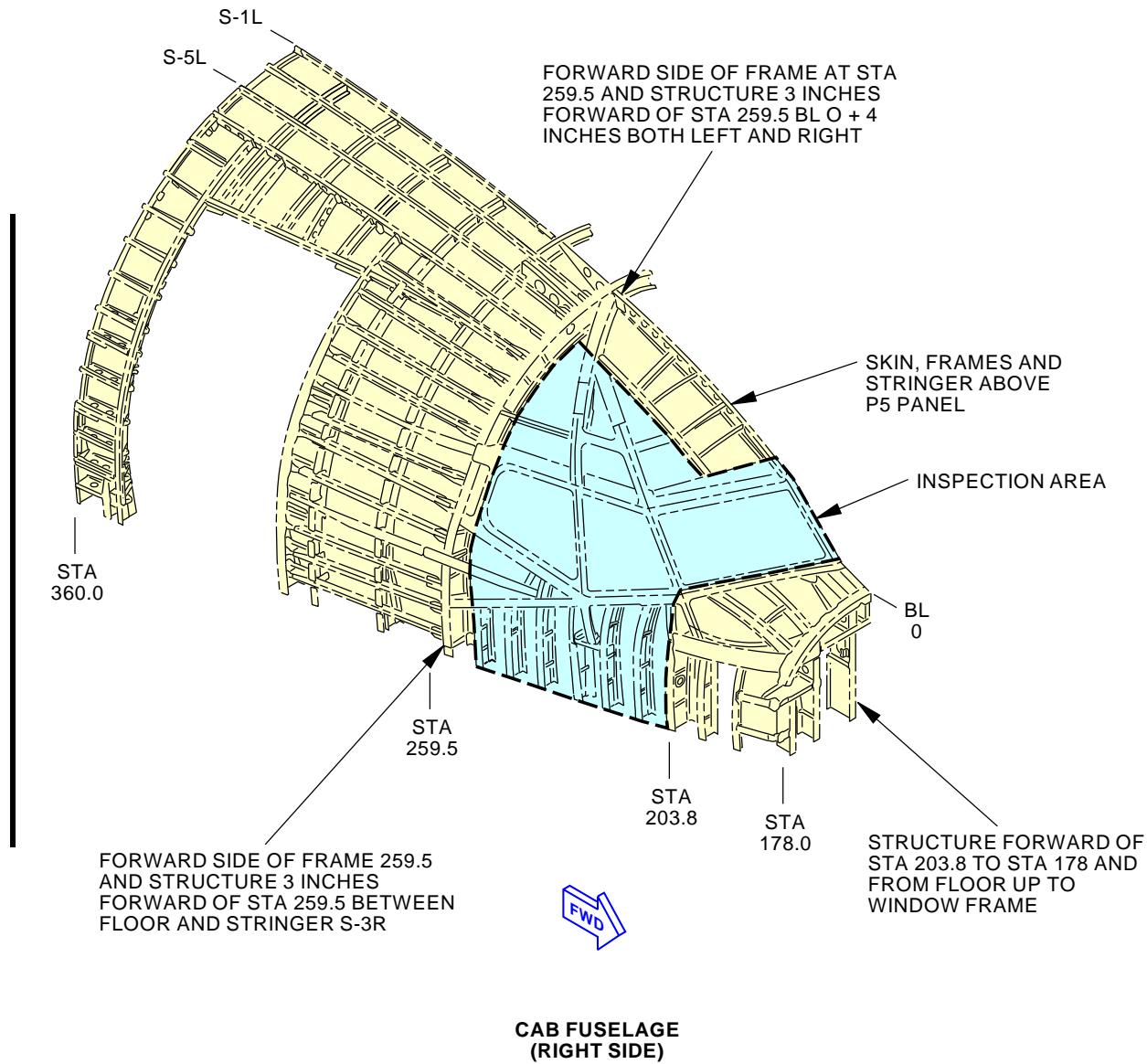
FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 241/53-05-03-990-900 (Sheet 1 of 2)

EFFECTIVITY	AKS ALL
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D633A101-AKS

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MPD ITEM 53-330-00

2293019 S0000519160_V3

FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 241/53-05-03-990-900 (Sheet 2 of 2)

EFFECTIVITY	AKS ALL
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D633A101-AKS

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TASK 53-05-03-210-831

37. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE

(Figure 242)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
211	Flight Compartment - Left
212	Flight Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

C. Inspection

SUBTASK 53-05-03-010-028

- (1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

NOTE: Remove sidewalls and floor panels as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-031

- (2) Do a General Visual inspection of the flight compartment floor structure.

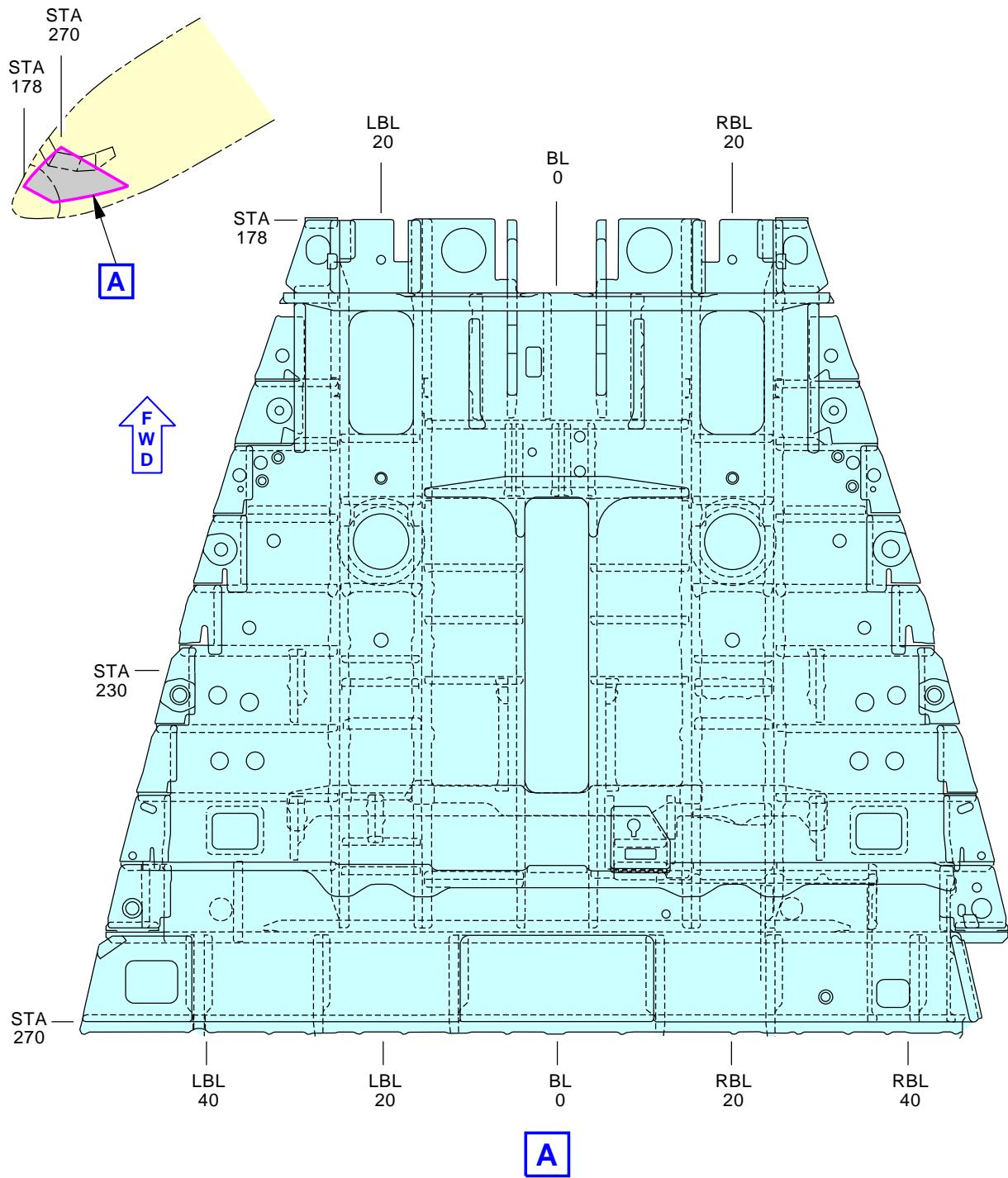
SUBTASK 53-05-03-910-041

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————



53-05-03



D63216 S0000162560_V2

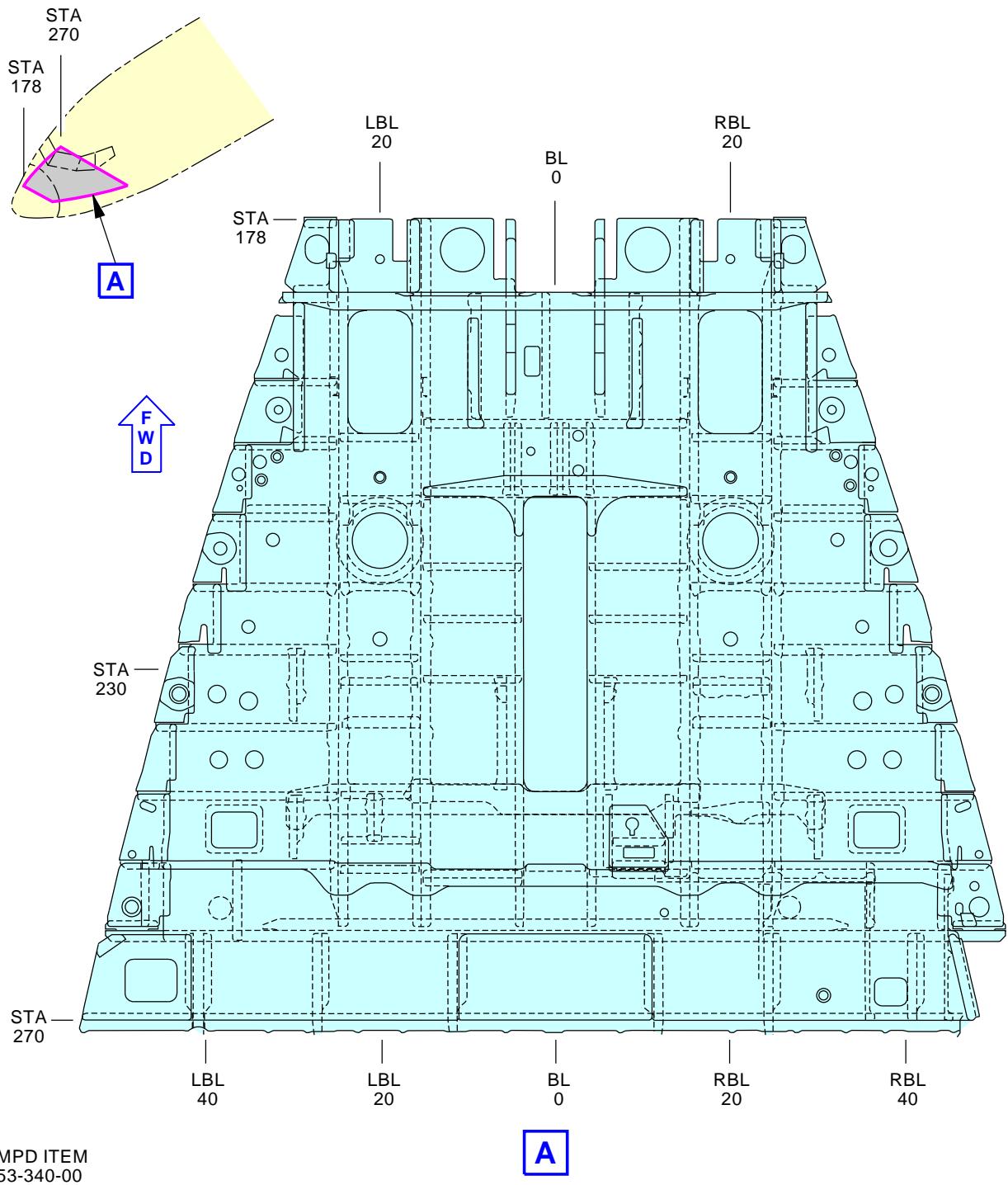
Flight Deck Floor Structure
Figure 242/53-05-03-990-829 (Sheet 1 of 2)

EFFECTIVITY
 AKS ALL

53-05-03



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Flight Deck Floor Structure
Figure 242/53-05-03-990-829 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-832

38. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 to 360**
(Figure 243)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Access Panels

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

C. Inspection

SUBTASK 53-05-03-010-029

- (1) Special Access:

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-032

- (2) Do a General Visual inspection of the passenger compartment from Sta 270 to 360 (except areas around door cutouts), including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.

SUBTASK 53-05-03-910-042

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

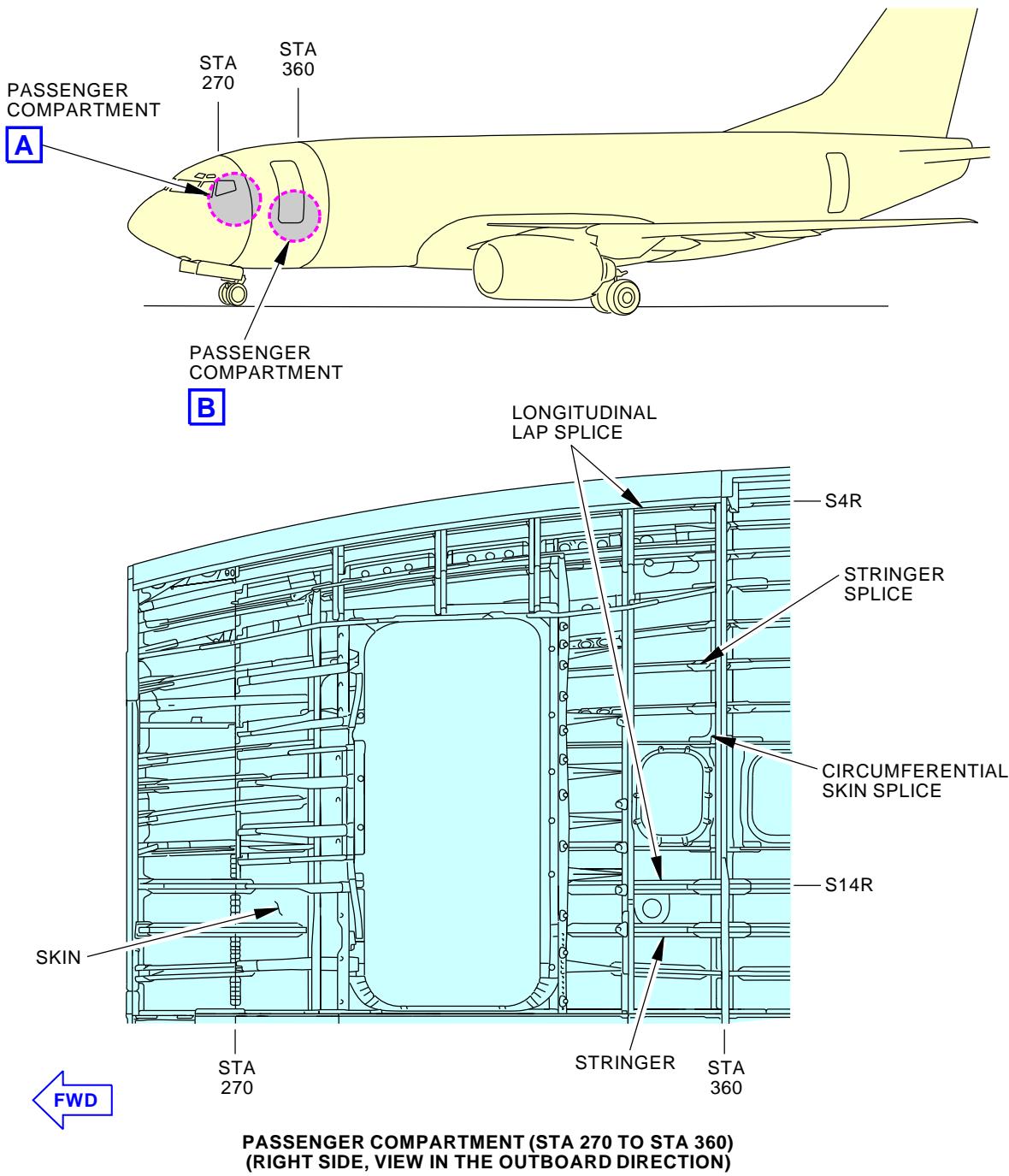
— END OF TASK —



53-05-03



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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT (STA 270 TO STA 360)
(RIGHT SIDE, VIEW IN THE OUTBOARD DIRECTION)

MPD ITEM
53-350-00

A

2071151 S0000430778_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360
Figure 243/53-05-03-990-860 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

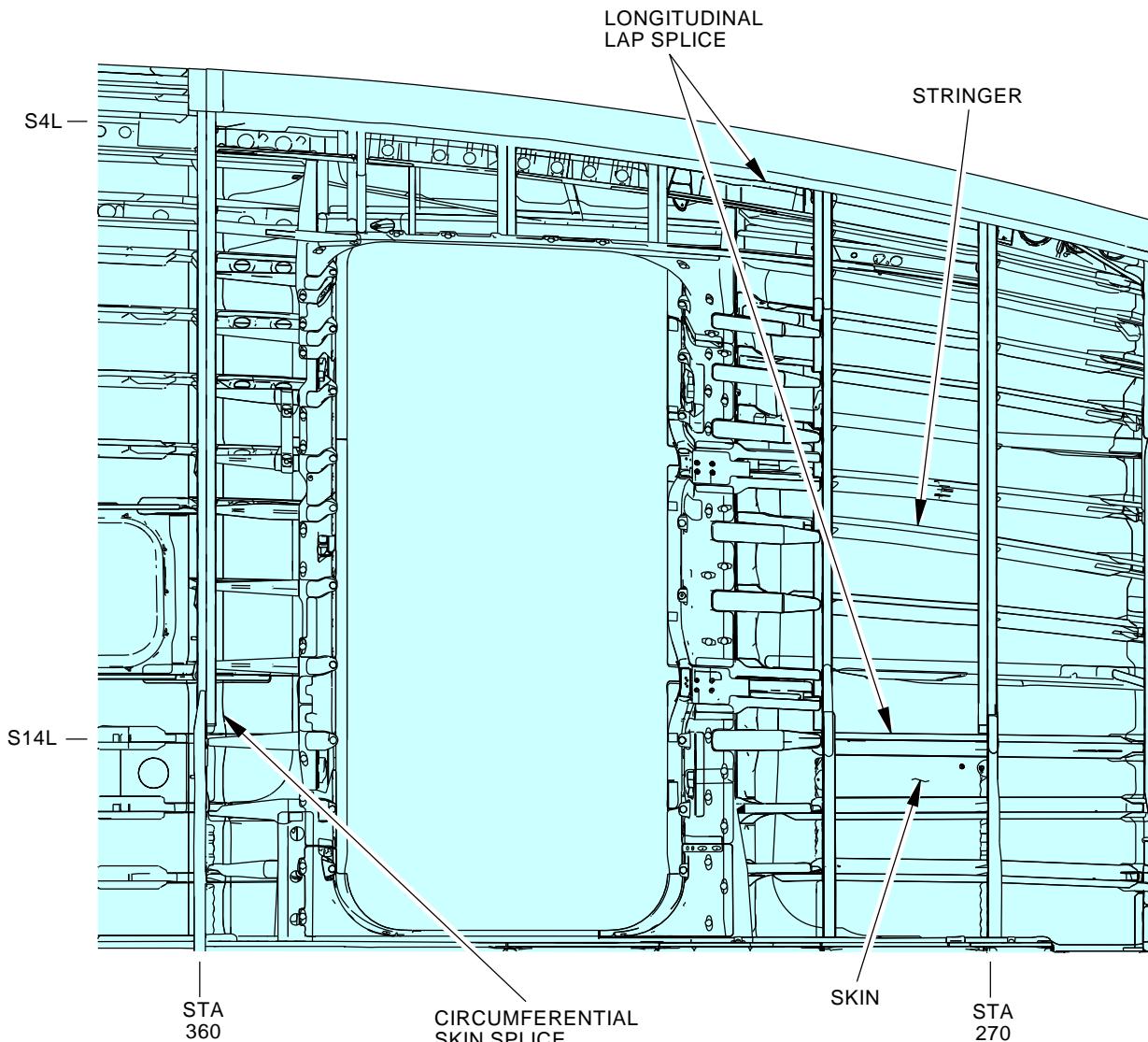
D633A101-AKS

53-05-03

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PASSENGER COMPARTMENT (STA 270 TO STA 360)
(LEFT SIDE, VIEW IN THE OUTBOARD DIRECTION)



B

MPD ITEM
53-350-00

2071155 S0000430781_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360
Figure 243/53-05-03-990-860 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-809

39. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 244)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

C. Inspection

SUBTASK 53-05-03-010-063

- (1) Special Access:

Number Name/Location

S2001	Passenger Compartment Door Cutouts Inspection
-------	---

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-009

- (2) Do a Detailed inspection of the forward entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-043

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

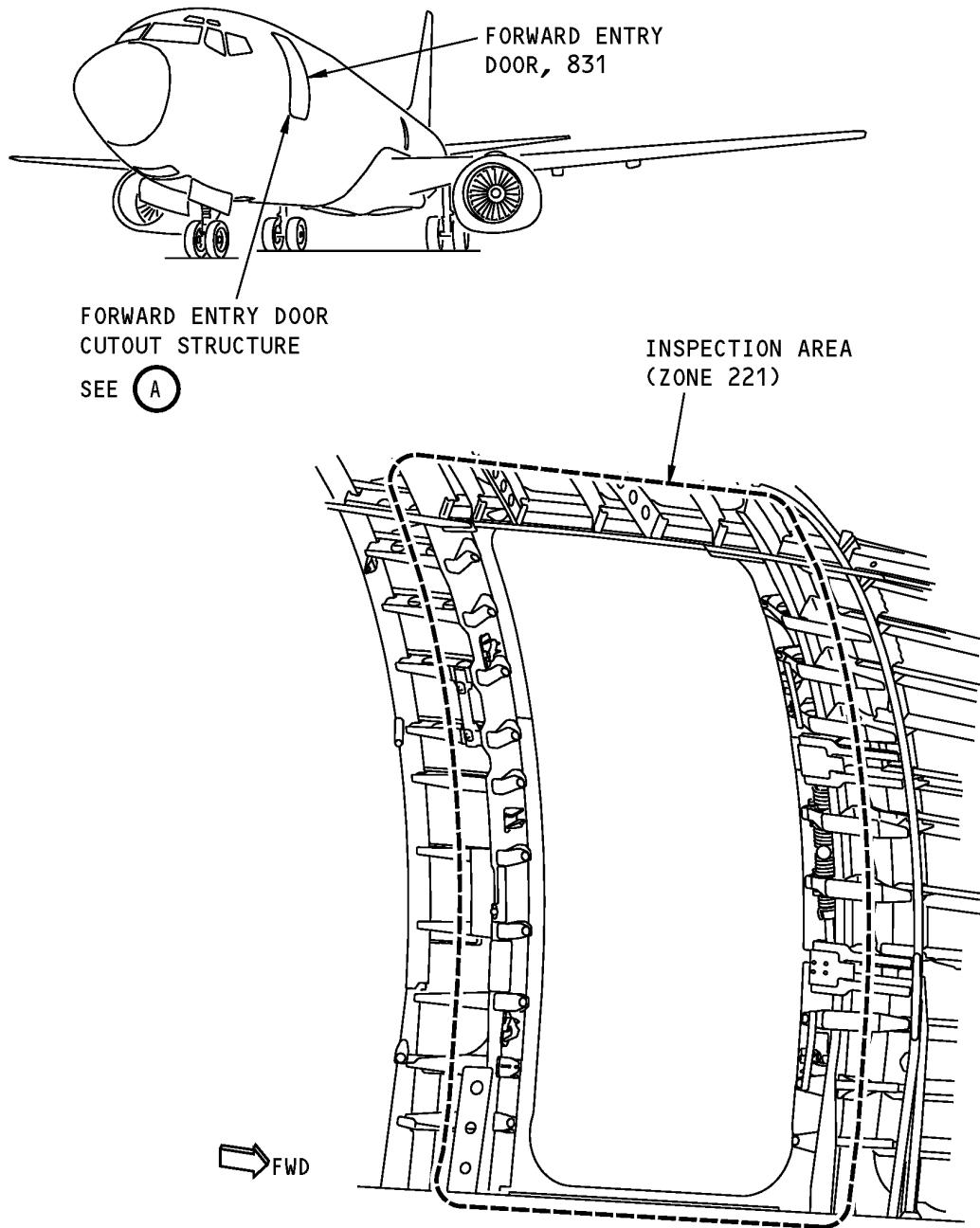
———— END OF TASK ————



53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



FORWARD ENTRY DOOR CUTOUT STRUCTURE
(LAVATORY, SIDEWALL PANELS AND INSULATION REMOVED)

A

Forward Entry Door Cutout Surround Structure (Lavatory, Sidewall Panels And Insulation Removed)
Figure 244/53-05-03-990-816

EFFECTIVITY
AKS ALL

53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-810

40. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

Figure 245

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Access Panels

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
S2001	Passenger Compartment Door Cutouts Inspection

C. Inspection

SUBTASK 53-05-03-010-064

- (1) Open this access panel:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lav. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-010

- (2) Do a Detailed inspection of the forward galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-044

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-064

- (4) Close this access panel:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

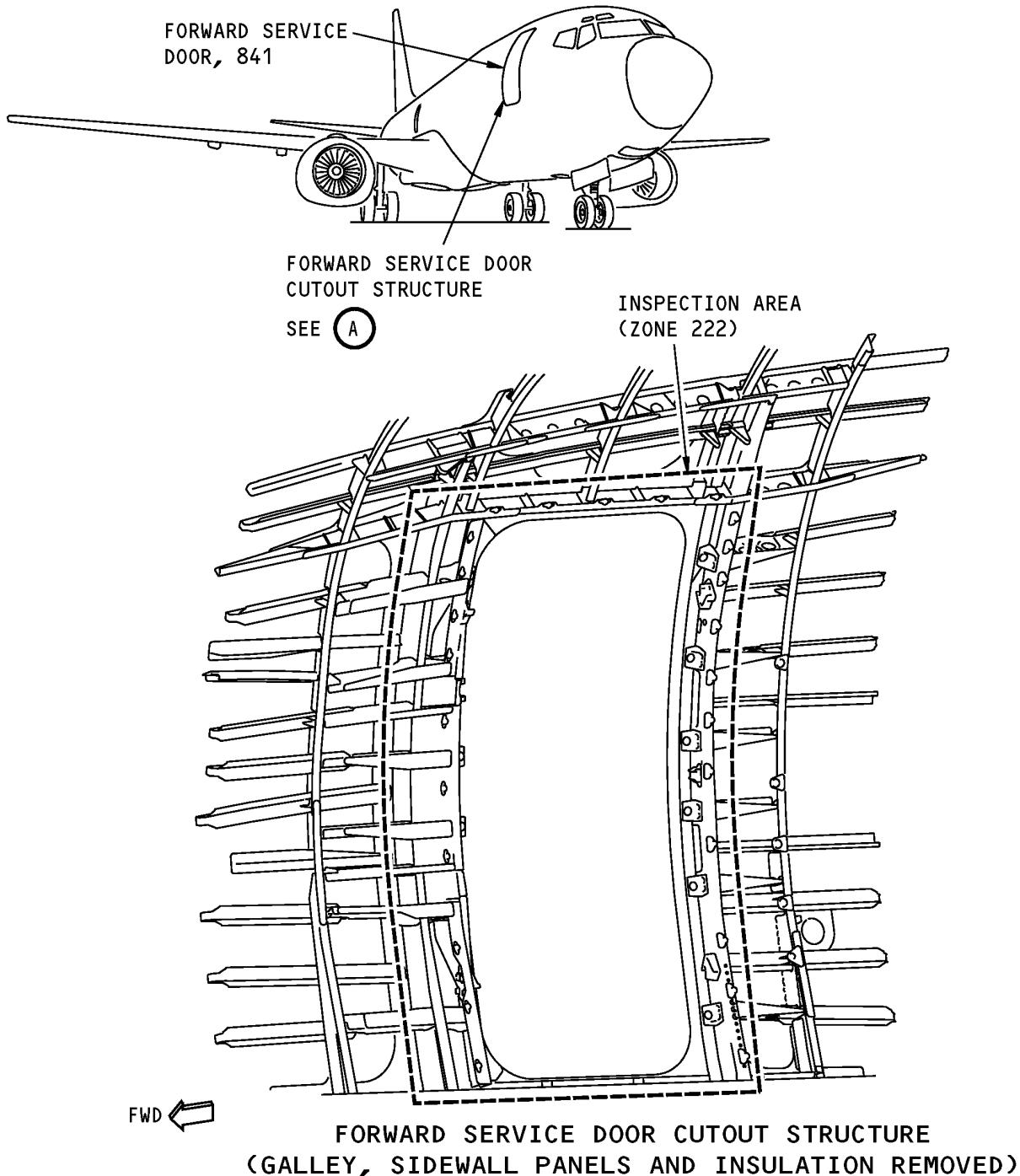
———— END OF TASK ————



53-05-03



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Forward Galley Service Door Cutout Surround Structure (Galley, Sidewall Panels and Insulation Removed)

Figure 245/53-05-03-990-813

(A)

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-811

41. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 246)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

B. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

C. Inspection

SUBTASK 53-05-03-010-065

- (1) Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-011

- (2) Do a Detailed inspection of the aft entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-045

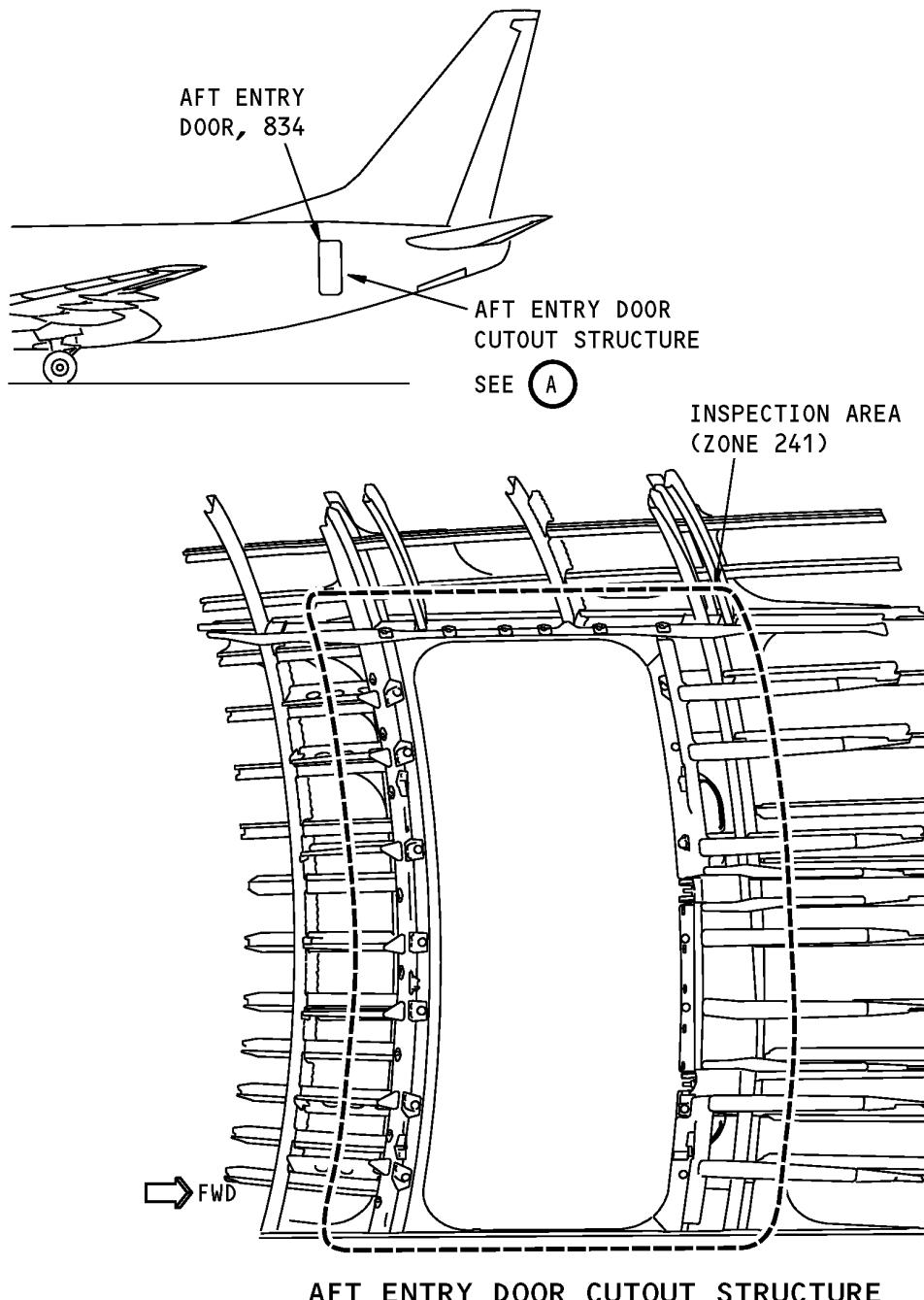
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————

EFFECTIVITY
AKS ALL



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AFT ENTRY DOOR CUTOUT STRUCTURE
(LAVATORY, SIDEWALL PANELS AND INSULATION REMOVED)

(A)

Passenger Compartment Door Cutouts
Figure 246/53-05-03-990-817

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-812

42. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 247)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

C. Inspection

SUBTASK 53-05-03-010-066

- (1) Special Access:

Number Name/Location

S2001	Passenger Compartment Door Cutouts Inspection
-------	---

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-012

- (2) Do a Detailed inspection of the aft galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-046

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

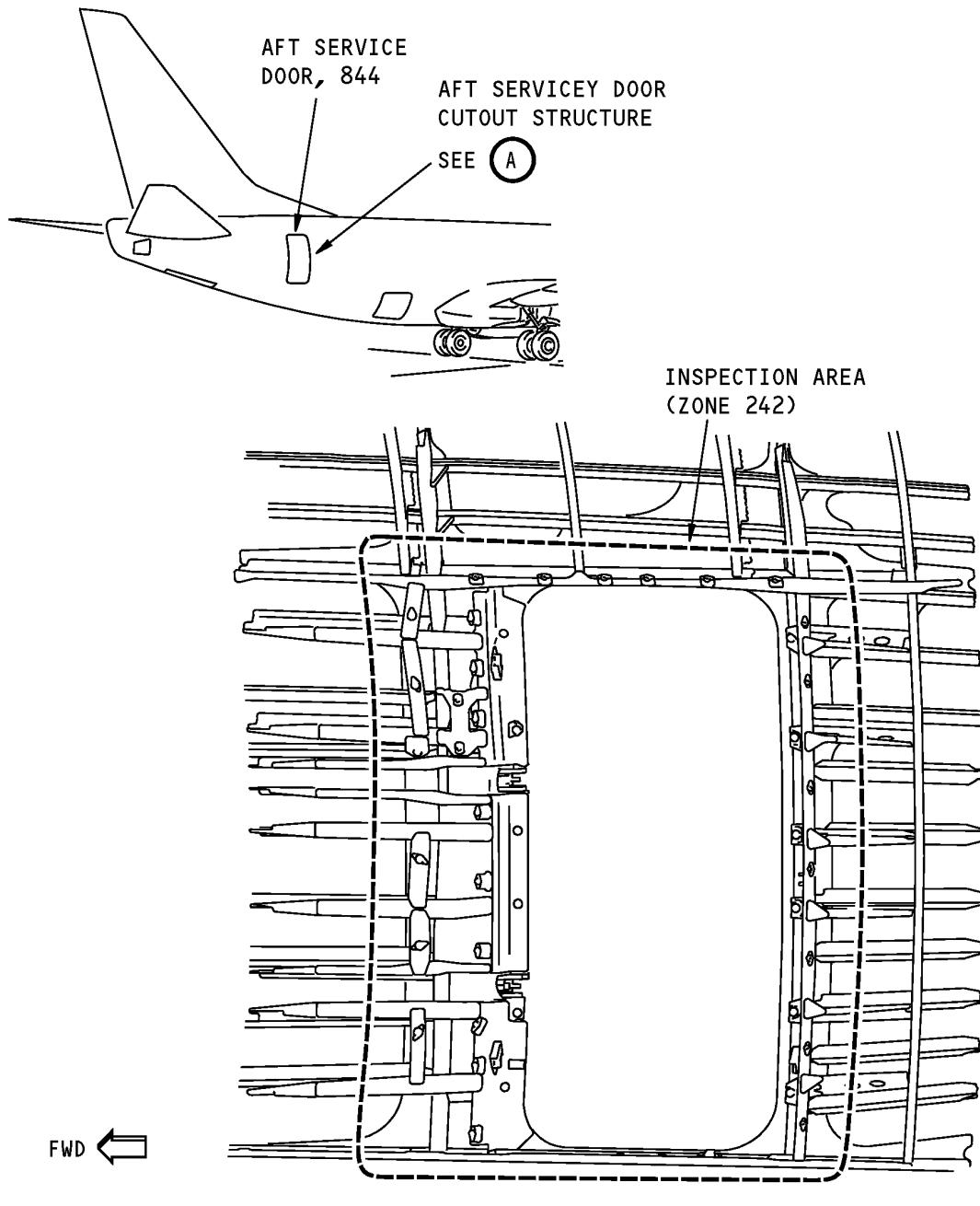
———— END OF TASK ————



53-05-03



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AIRCRAFT MAINTENANCE MANUAL



AFT SERVICE DOOR CUTOUT STRUCTURE
GALLEY, SIDEWALL PANELS AND INSULATION REMOVED)



Passenger Compartment Door Cutouts
Figure 247/53-05-03-990-818

EFFECTIVITY
AKS ALL

53-05-03



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TASK 53-05-03-210-833

43. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA**
(Figure 248)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
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

B. Access Panels

Number	Name/Location
S2002	Passenger Compartment Floor Structure - Dry Area Inspection

C. Inspection

SUBTASK 53-05-03-010-030

- (1) Special Access:

Number Name/Location

S2002	Passenger Compartment Floor Structure - Dry Area Inspection
-------	---

NOTE: Remove floor panels and sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-033

- (2) Do a General Visual inspection of the passenger compartment floor structure in dry area (away from doors, galleys and lavs). Exclude floor structure from Sta 540 to 727.

SUBTASK 53-05-03-910-047

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

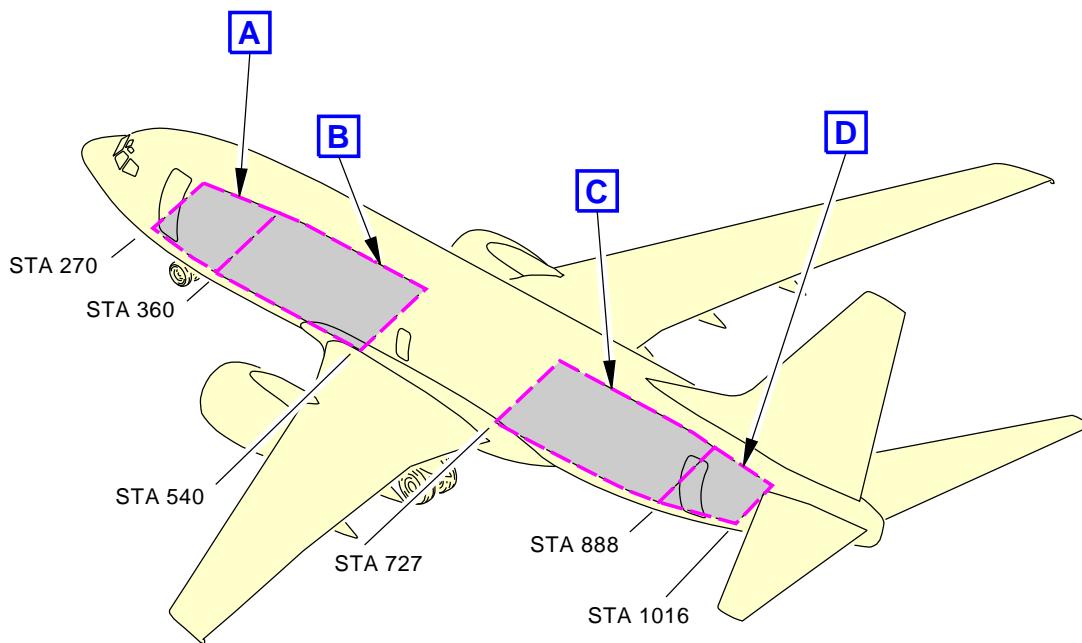
———— END OF TASK ————



53-05-03



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MPD ITEM
53-370-00

2099246 S0000444460_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-861 (Sheet 1 of 5)

EFFECTIVITY
AKS ALL

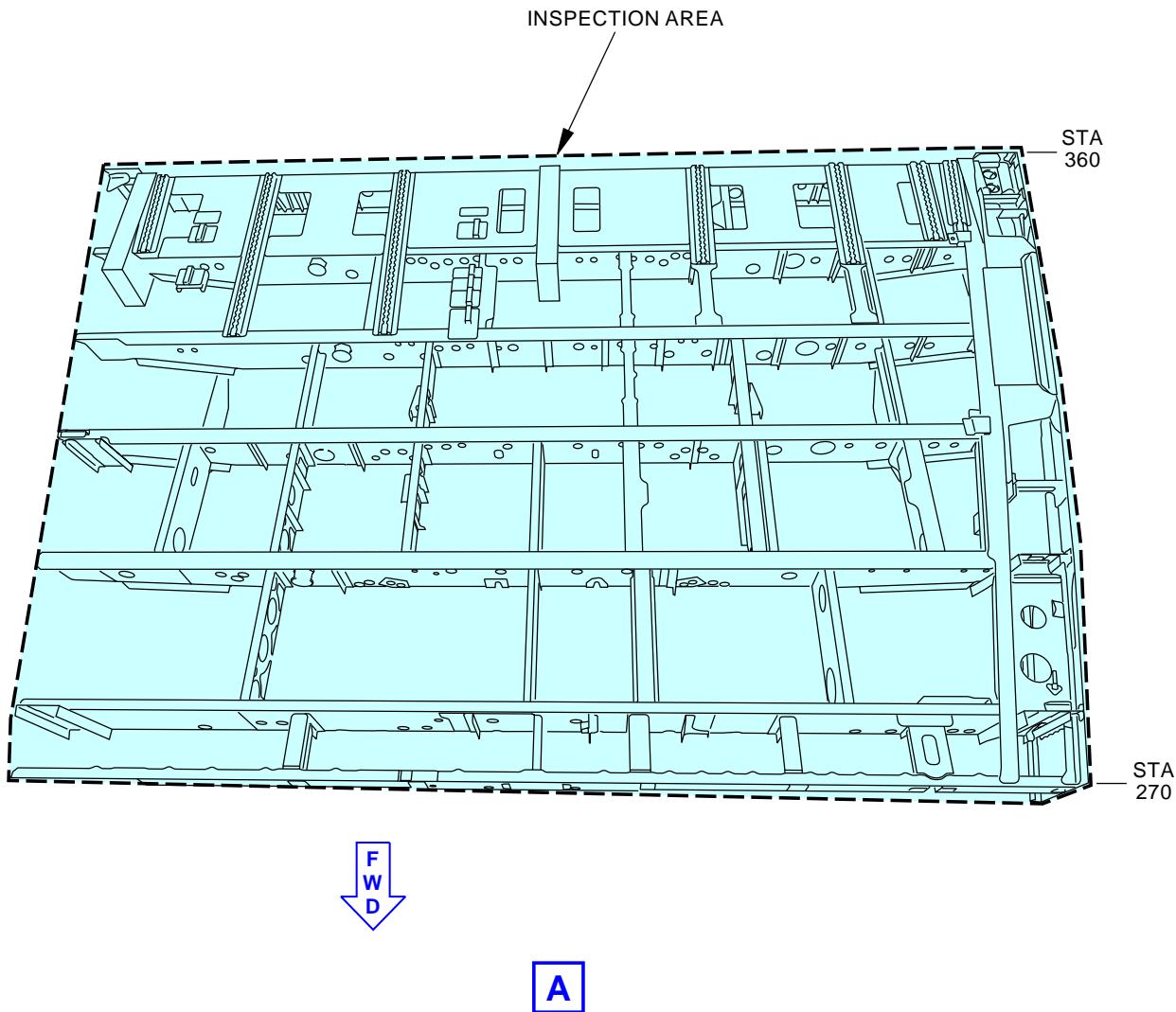
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53-05-03

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-370-00

2099970 S0000444461_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-861 (Sheet 2 of 5)

EFFECTIVITY
AKS ALL

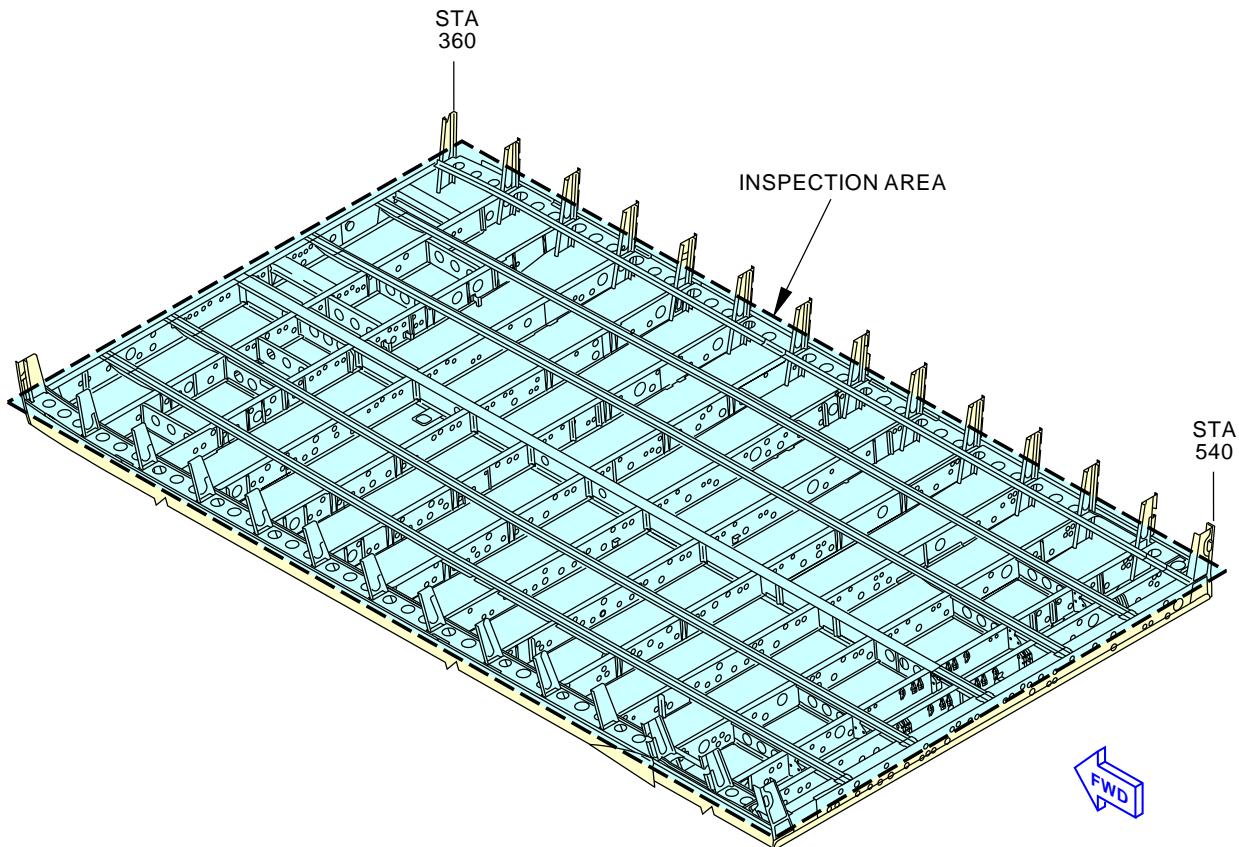
D633A101-AKS

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MPD ITEM
53-370-00

2102696 S0000444462_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-861 (Sheet 3 of 5)

EFFECTIVITY
AKS ALL

53-05-03

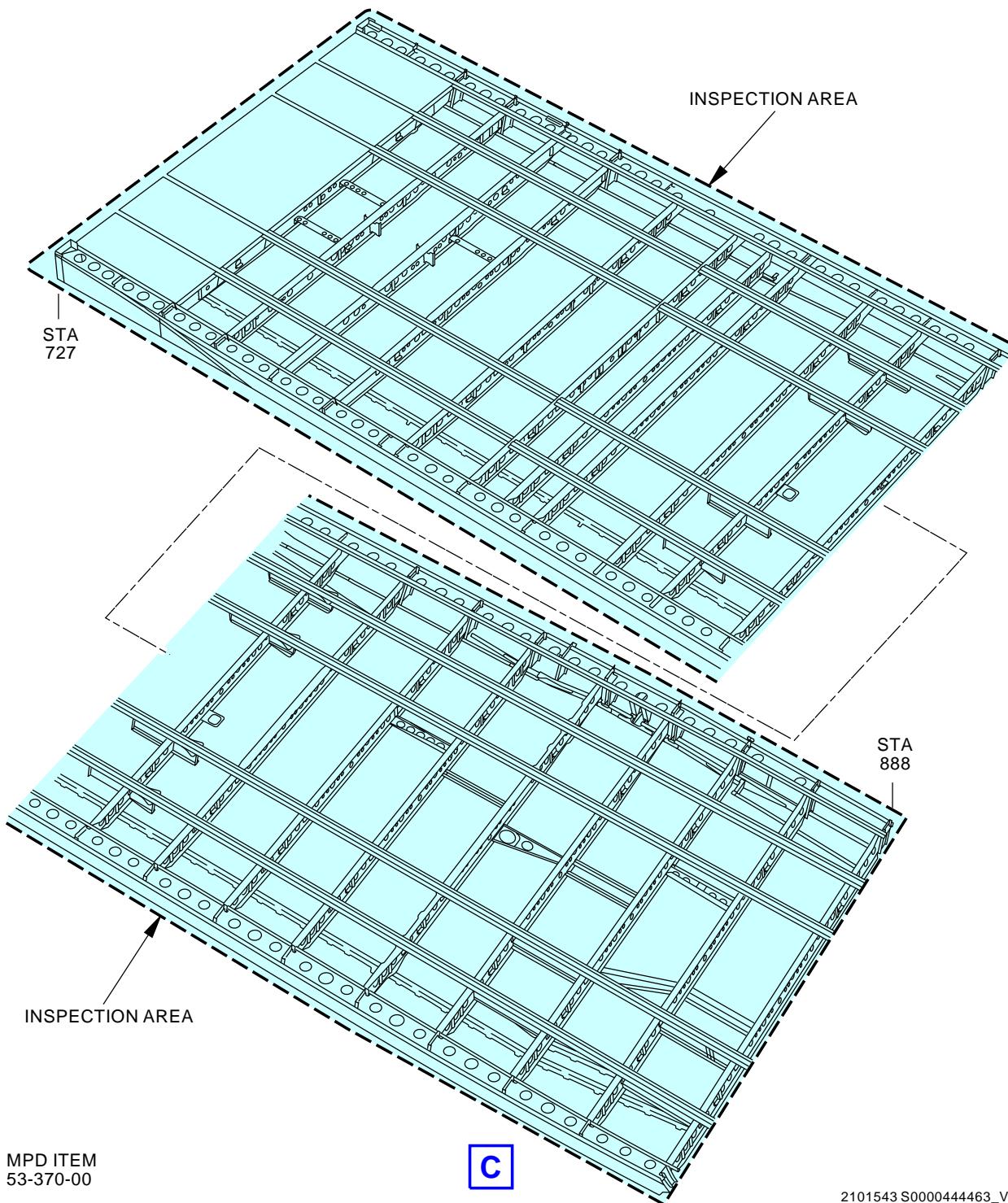
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INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-861 (Sheet 4 of 5)

EFFECTIVITY
AKS ALL

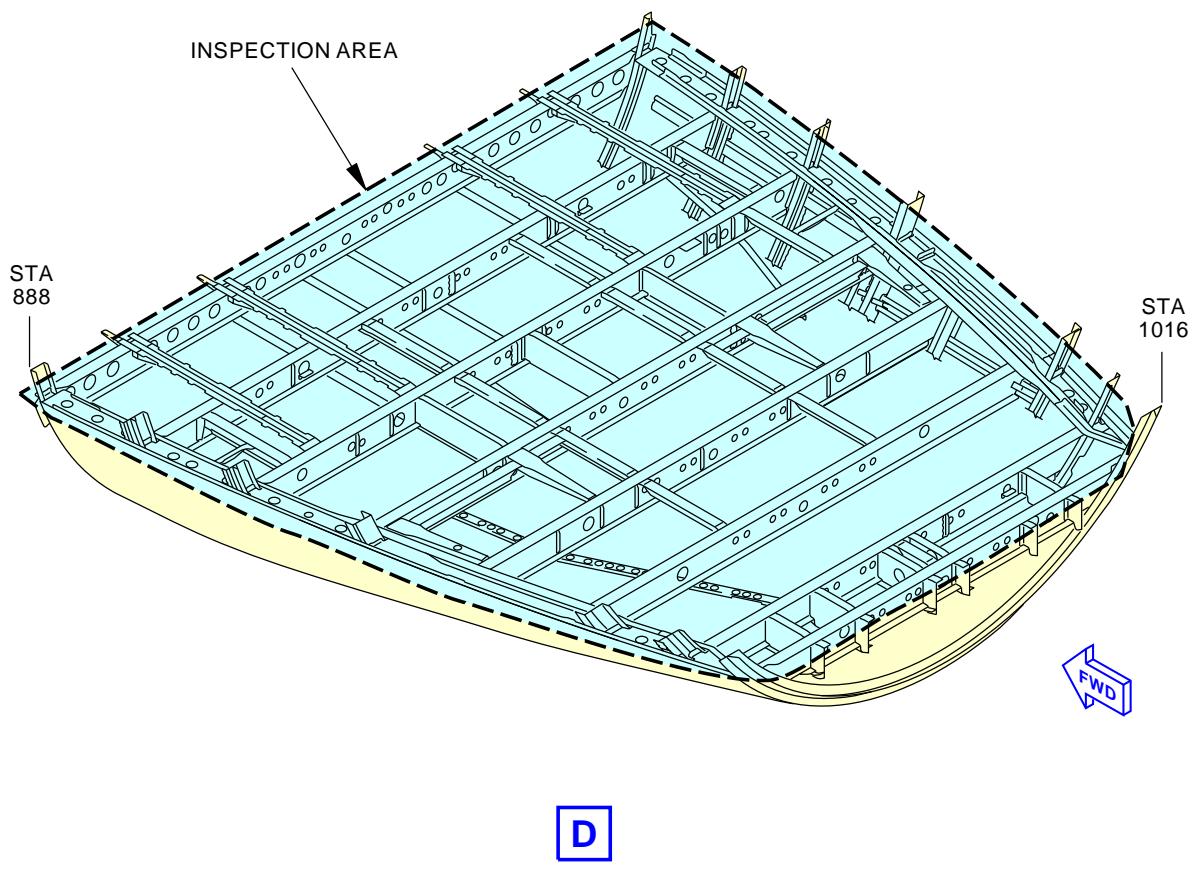
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737-600/700/800/900
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MPD ITEM
53-370-00

2102072 S0000444464_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-861 (Sheet 5 of 5)

EFFECTIVITY
AKS ALL

53-05-03

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AKS ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD

TASK 53-05-03-210-834

- 44. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**
(Figure 249,Figure 250)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
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

B. Access Panels

Number	Name/Location
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

C. Inspection

SUBTASK 53-05-03-010-031

- (1) Special Access:

Number	Name/Location
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

NOTE: Remove galleys and lavs. Remove floor panels and sidewalls as required.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-034

- (2) Do a General Visual inspection of the passenger compartment floor structure in wet area (within approximately 20 inches from doors, galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-048

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

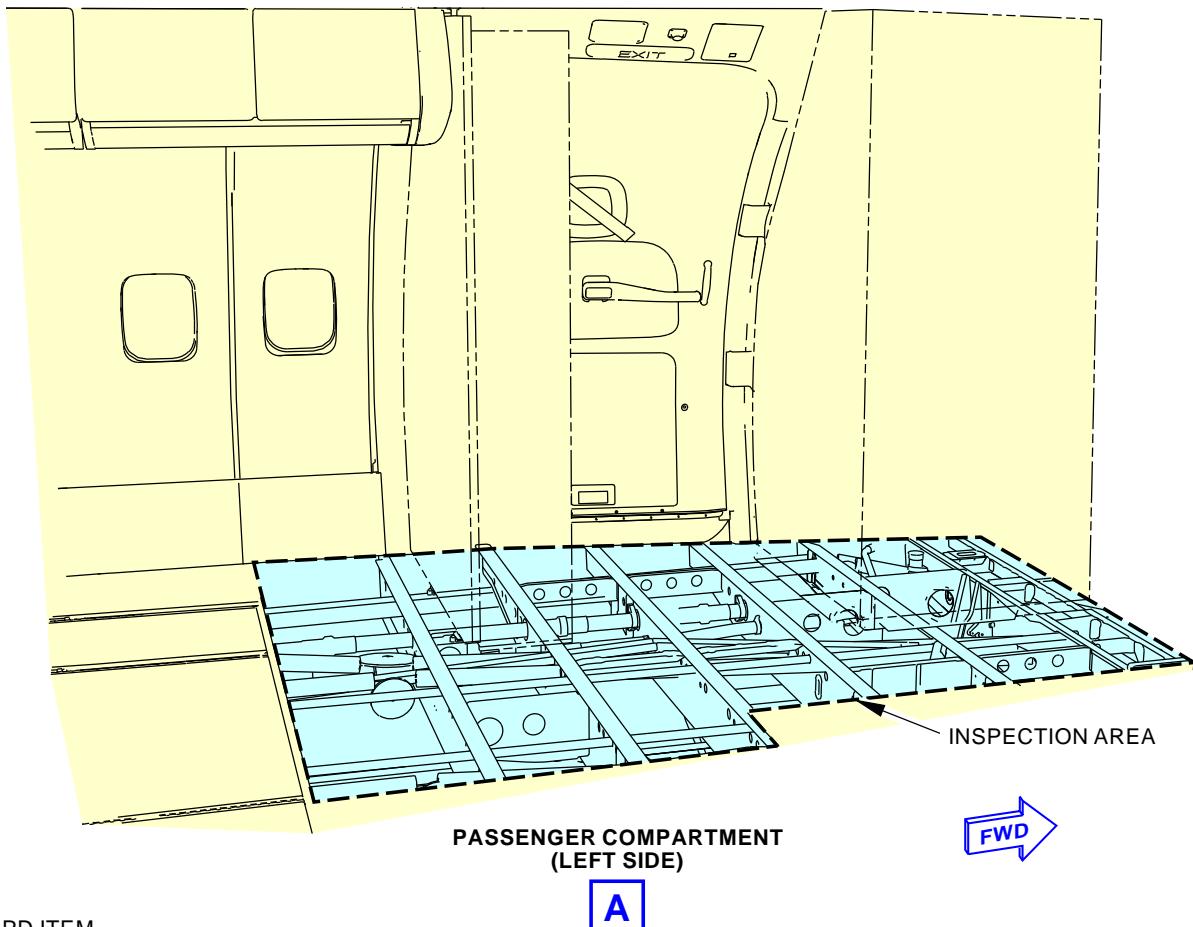
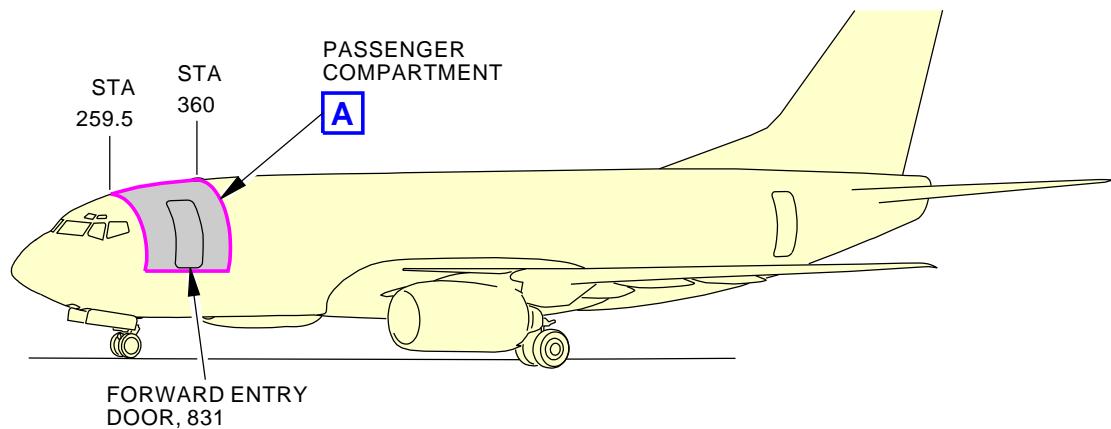
———— END OF TASK ————



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MPD ITEM
53-380-00

1363524 S0000246348_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 249/53-05-03-990-871 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL; AIRPLANES WITH A CURVED AFT
PRESSURE BULKHEAD

D633A101-AKS

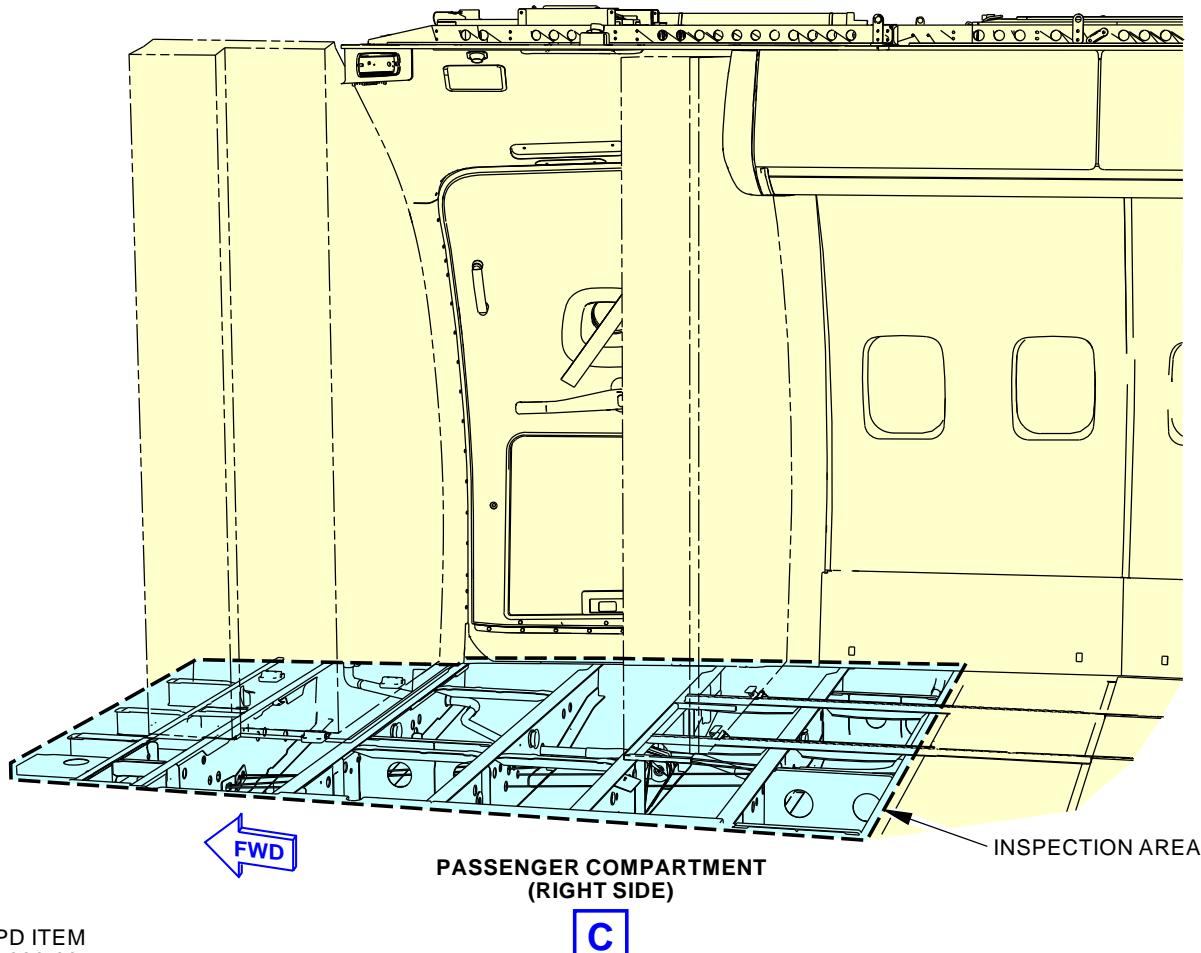
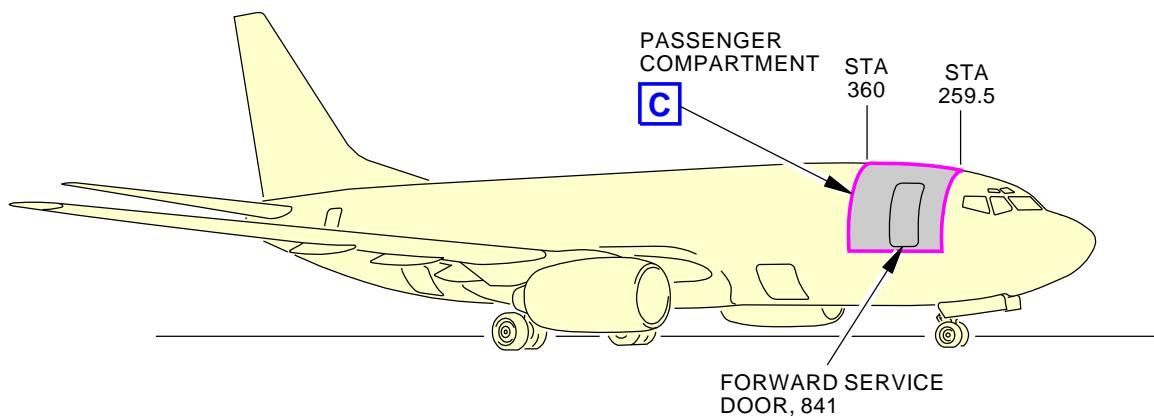
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MPD ITEM
53-380-00

1363522 S0000246349_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 249/53-05-03-990-871 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL; AIRPLANES WITH A CURVED AFT
PRESSURE BULKHEAD

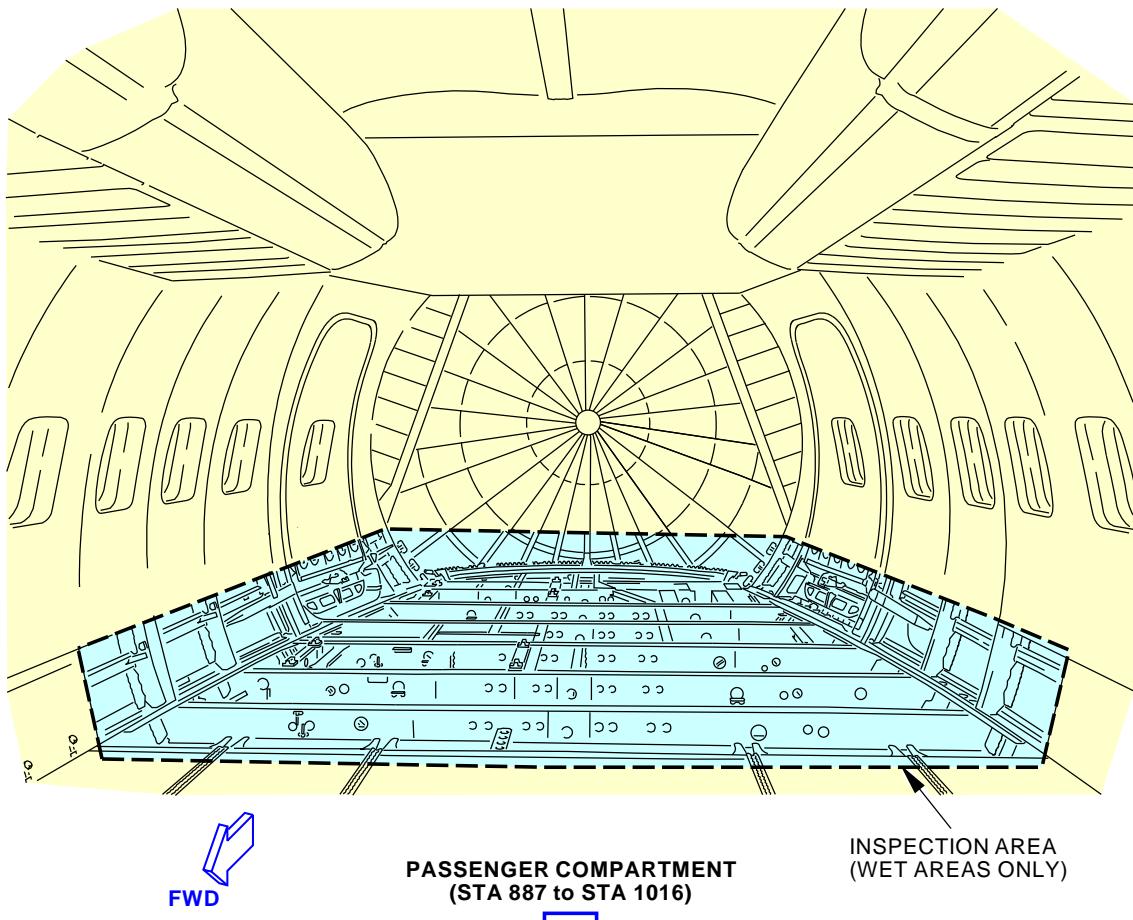
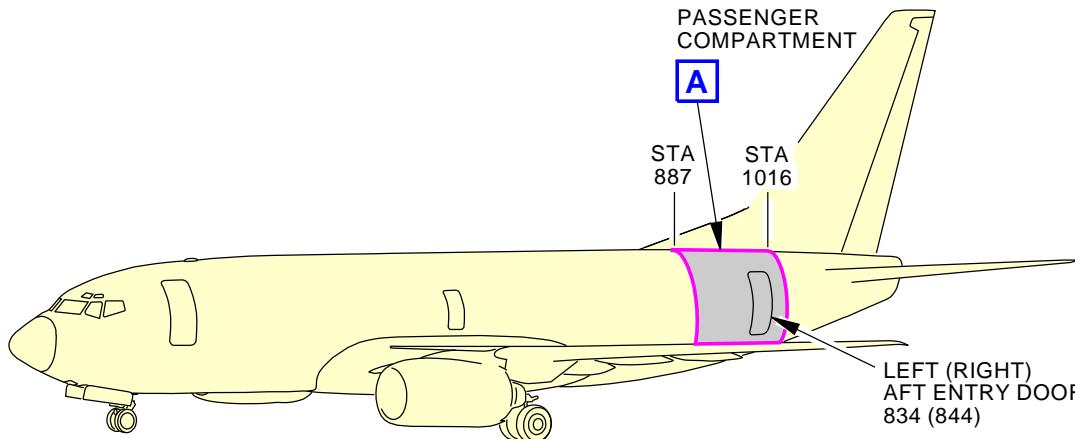
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MPD ITEM
53-380-00

J76715 S0000179157_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 250/53-05-03-990-872 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL; AIRPLANES WITH A CURVED AFT
PRESSURE BULKHEAD

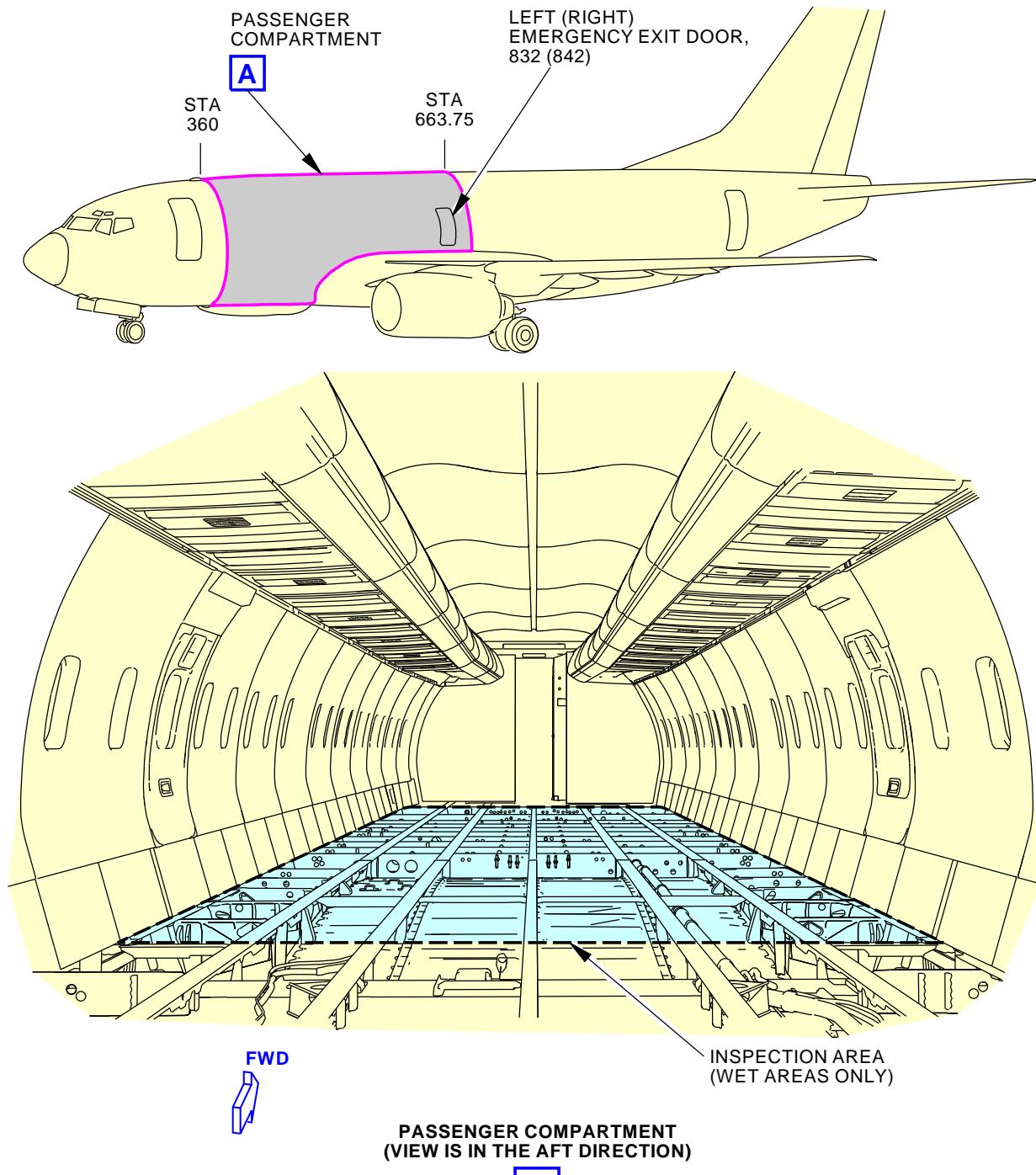
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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-380-00

D37065 S0000154098_V3

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 250/53-05-03-990-872 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL; AIRPLANES WITH A CURVED AFT
PRESSURE BULKHEAD

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AIRCRAFT MAINTENANCE MANUAL

AKS ALL

TASK 53-05-03-210-835

- 45. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**
(Figure 251)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
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

B. Access Panels

Number	Name/Location
S2004	Passenger Compartment Floor Structure - Wet Area Inspection

C. Inspection

SUBTASK 53-05-03-010-032

- (1) Special Access:

Number Name/Location

S2004	Passenger Compartment Floor Structure - Wet Area Inspection
-------	---

NOTE: Galleys and lavs removal is not required. Remove galley kick-plates and any other easily removable panels that may help inspect areas under galleys and lavs.

SUBTASK 53-05-03-210-035

- (2) Do a General Visual inspection of the galley and lav attach fittings and any other easily visible portions of the floor structure in wet area (within approximately 20 inches from galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-049

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

———— END OF TASK ————

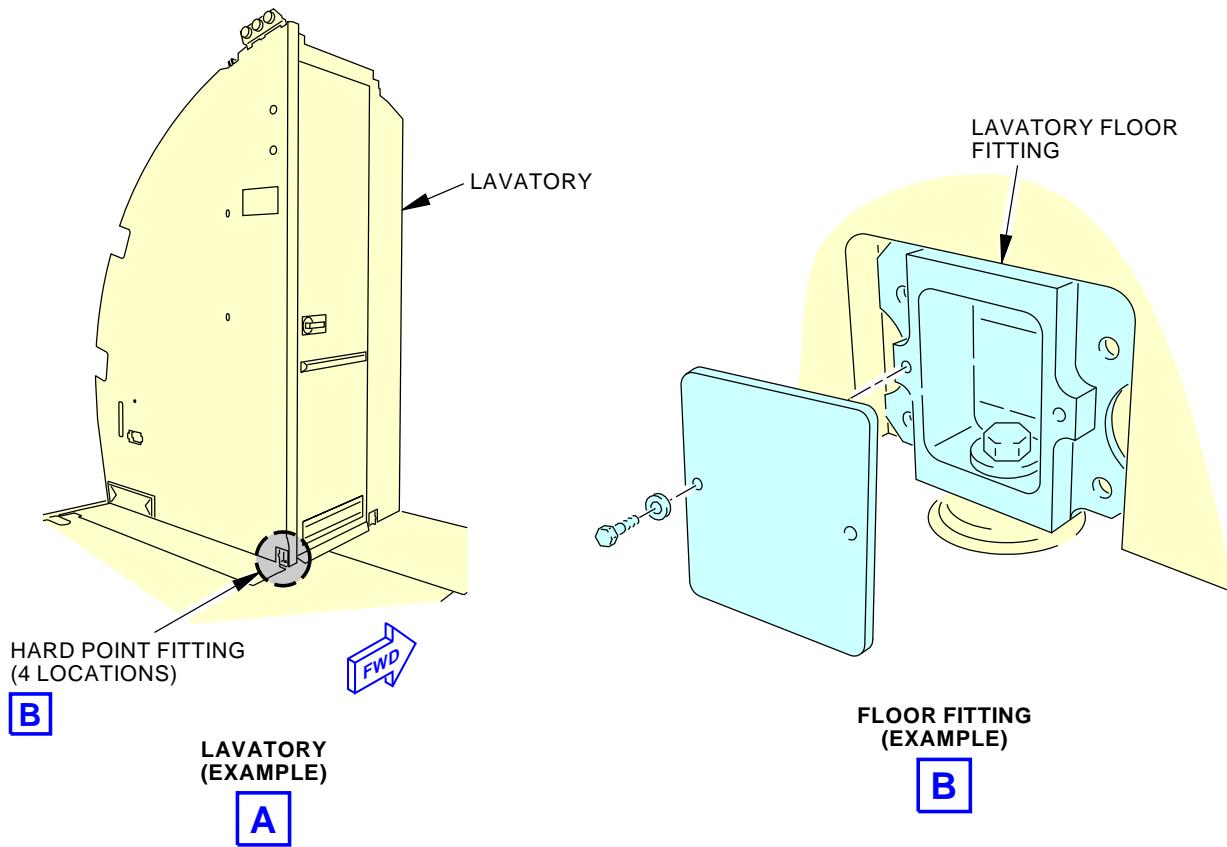
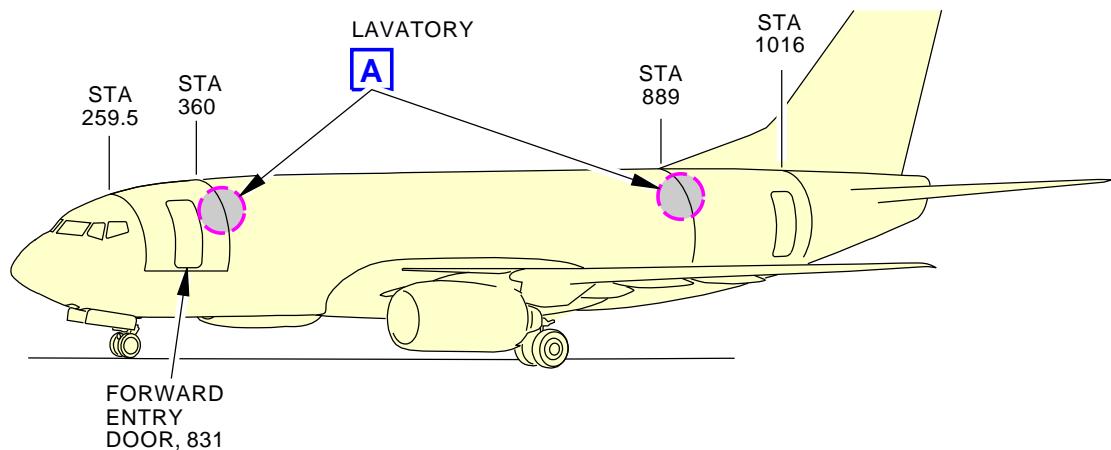
EFFECTIVITY

AKS ALL

53-05-03



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MPD ITEM
53-390-00

2341697 S0000533813_V2

Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-822 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

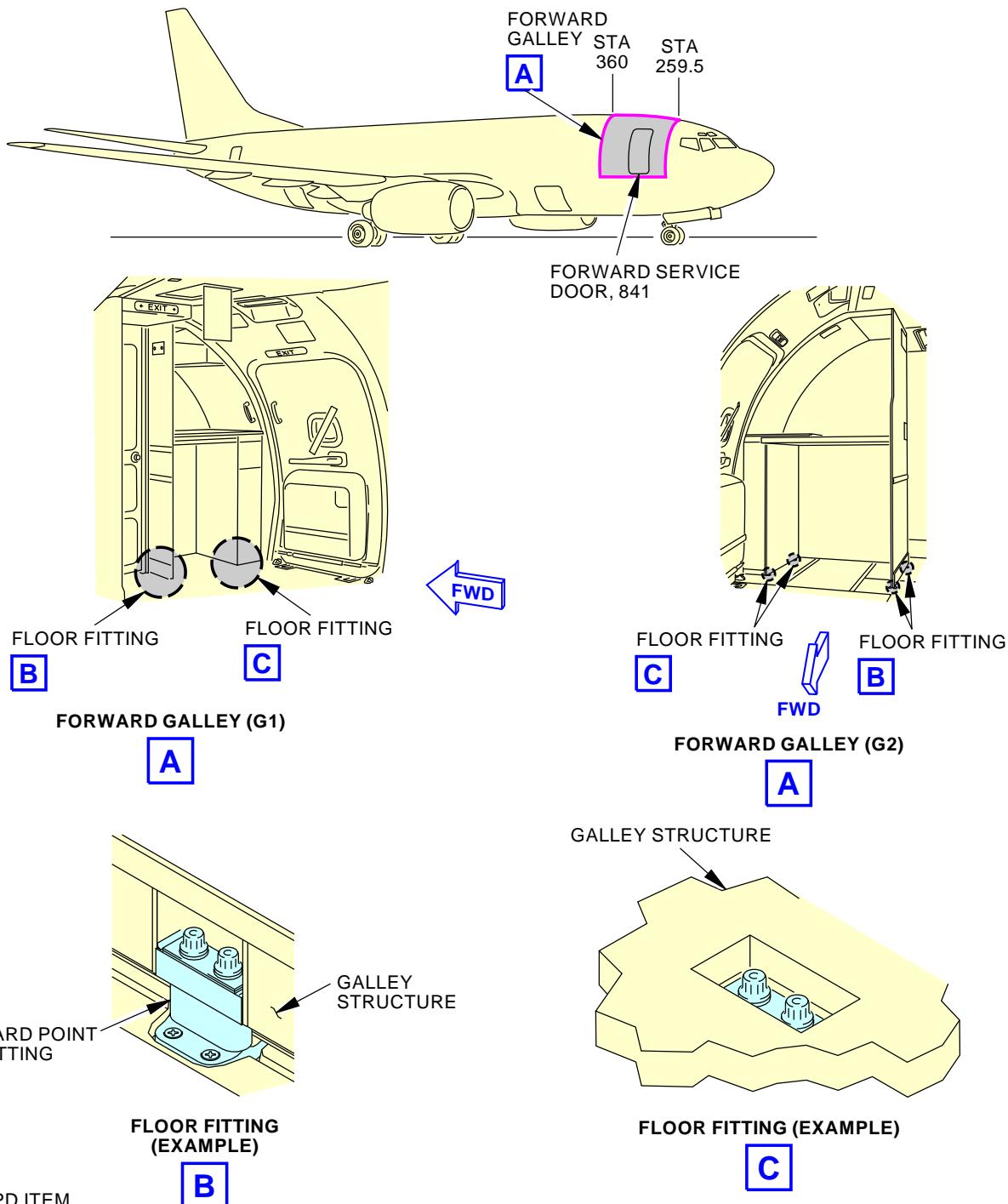
D633A101-AKS

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Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-822 (Sheet 2 of 3)

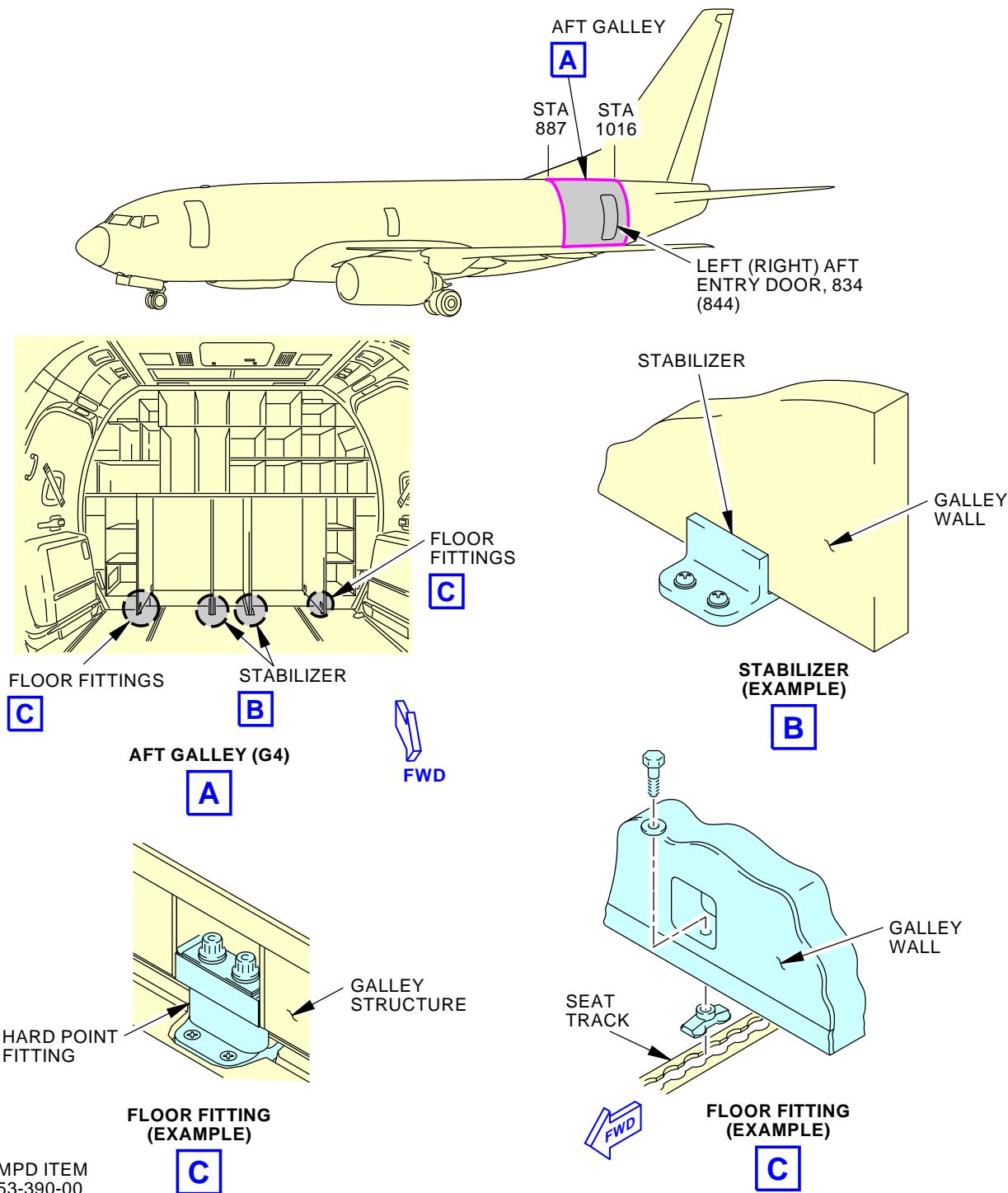
EFFECTIVITY
AKS ALL

53-05-03

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Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-822 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

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TASK 53-05-03-210-836

- 46. INTERNAL - GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 to 663.75**
(Figure 252)

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. Access Panels

Number	Name/Location
833	Emergency Exit
843	Emergency Exit
S2301	Forward Passenger Compartment STA 360 to 663.75

C. Inspection

SUBTASK 53-05-03-010-033

- (1) Open these access panels:

Number	Name/Location
833	Emergency Exit
843	Emergency Exit

Special Access:

Number	Name/Location
S2301	Forward Passenger Compartment STA 360 to 663.75

NOTE: Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-036

- (2) Do a General Visual inspection of the passenger compartment from STA 360 to 663.75, including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.
2. Window belt structure.
3. Overwing emergency exit cutout structure.
4. Forward cargo door cutout surround structure (portion in upper lobe).
5. STA 540 and 663 bulkheads and splices.
6. Overwing frames and stub beams.

SUBTASK 53-05-03-910-050

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-033

- (4) Close these access panels:

Number	Name/Location
833	Emergency Exit
843	Emergency Exit

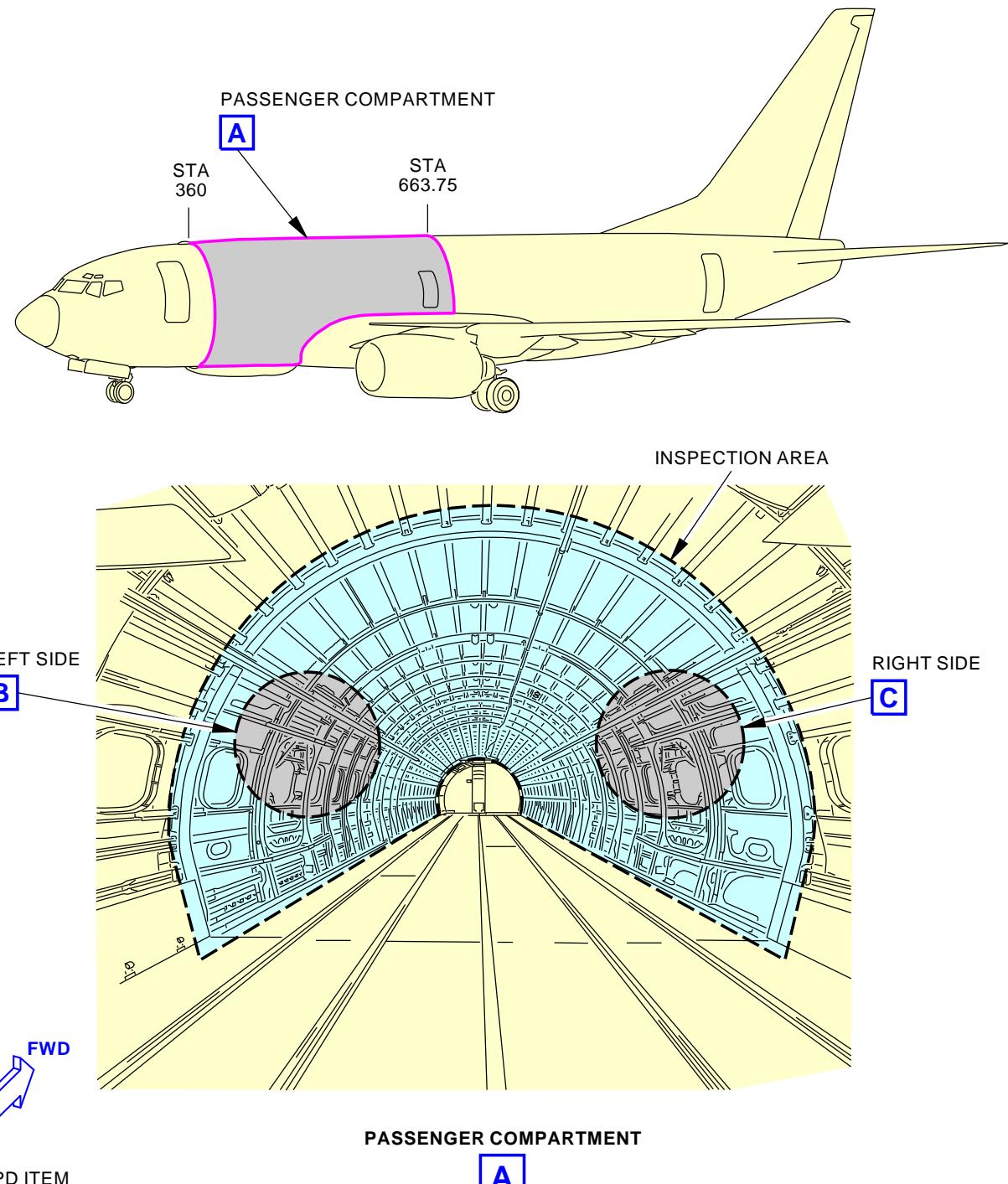
— END OF TASK —

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-400-00

2089687 S0000441136_V2

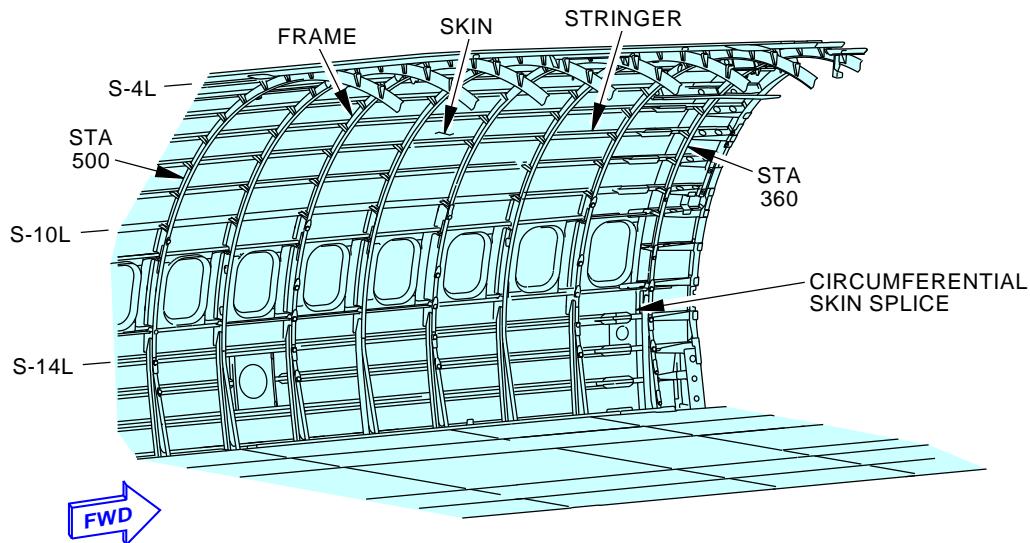
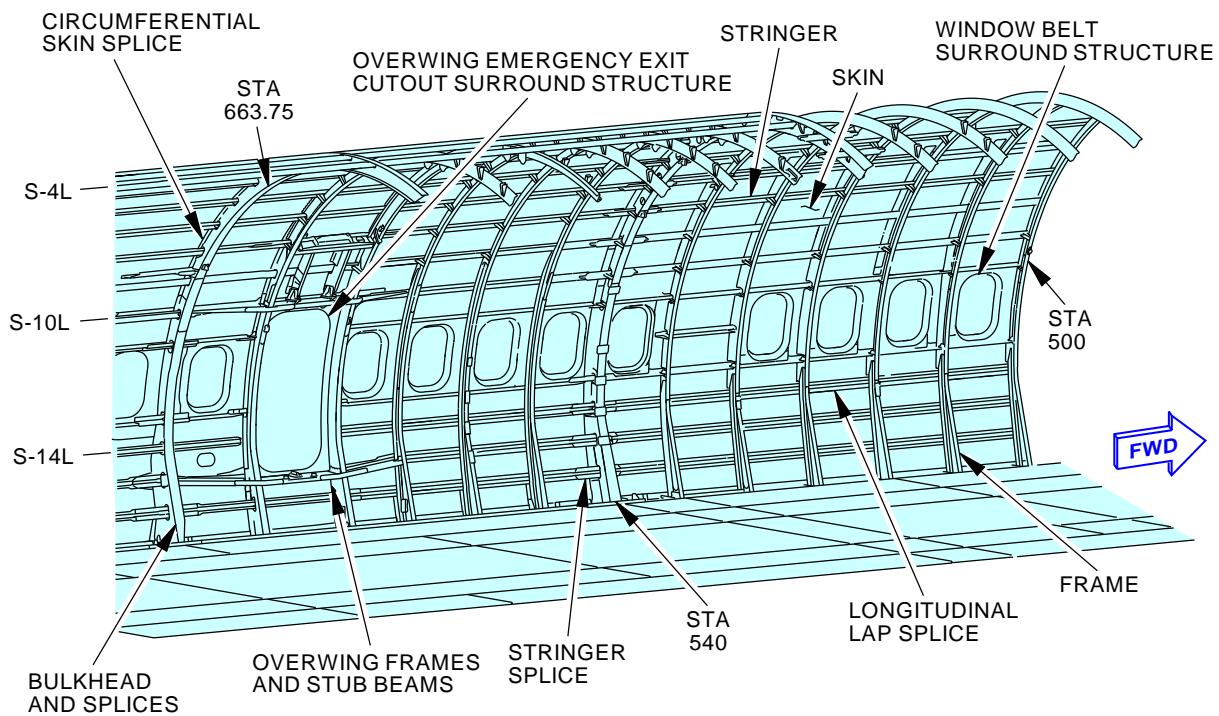
INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-862 (Sheet 1 of 3)

EFFECTIVITY	AKS ALL
-------------	---------

D633A101-AKS

53-05-03

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LEFT SIDE - PASSENGER COMPARTMENT
B

2093204 S0000441137_V2

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-862 (Sheet 2 of 3)

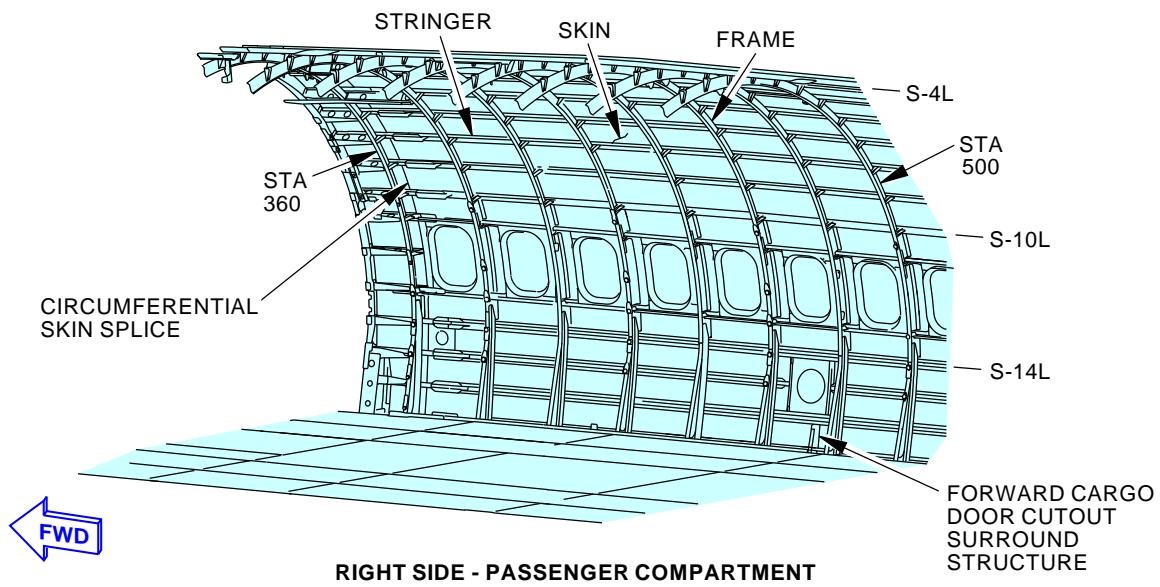
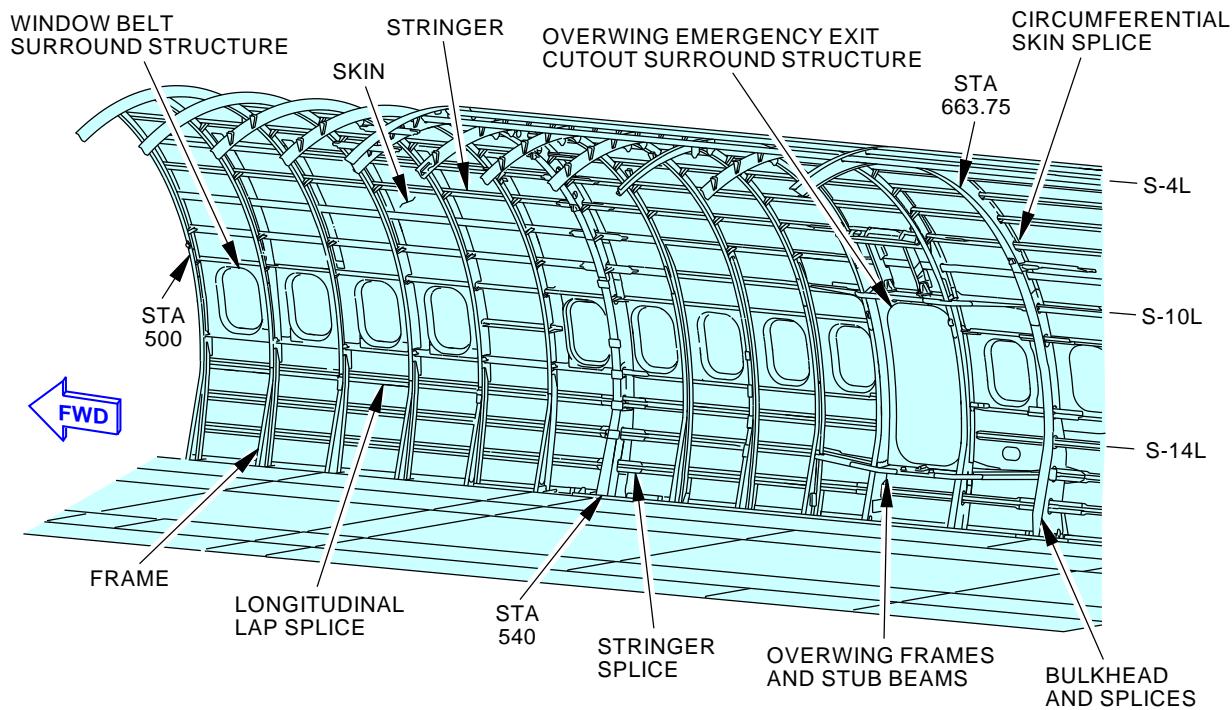
EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-400-00

C

2094904 S0000441138_V2

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-862 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-837

47. **INTERNAL - GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 to 1016**
(Figure 253)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

C. Inspection

SUBTASK 53-05-03-010-034

- (1) Special Access:

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/replace insulation blankets as required.

SUBTASK 53-05-03-210-037

- (2) Do a General Visual inspection of the passenger compartment from STA 663.75 to 1016 (except areas around door cutouts), including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices (note: inspection includes the circumferential skin and stringer splice at Sta 727I for the -900 models).
2. Window belt structure.
3. STA 663 bulkhead and splices.
4. STA 727 bulkhead.
5. Side strut support frame at STA 706.
6. Main landing gear support frames at STA 695 and 716.
7. Wheel well frame at STA 685.
8. Aft cargo door cutout surround structure (portion in upper lobe).
9. Forward side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments), including vertical fin front spar fittings.
10. Stringer splice fittings and tension bolts at STA 1016.

SUBTASK 53-05-03-910-051

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

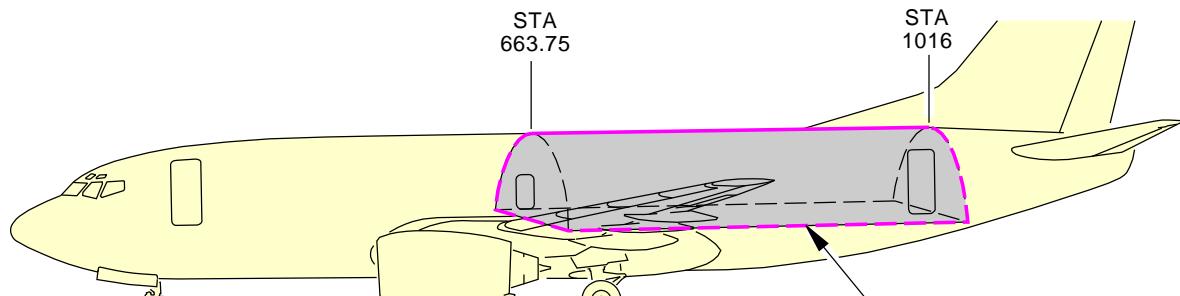
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53-05-03

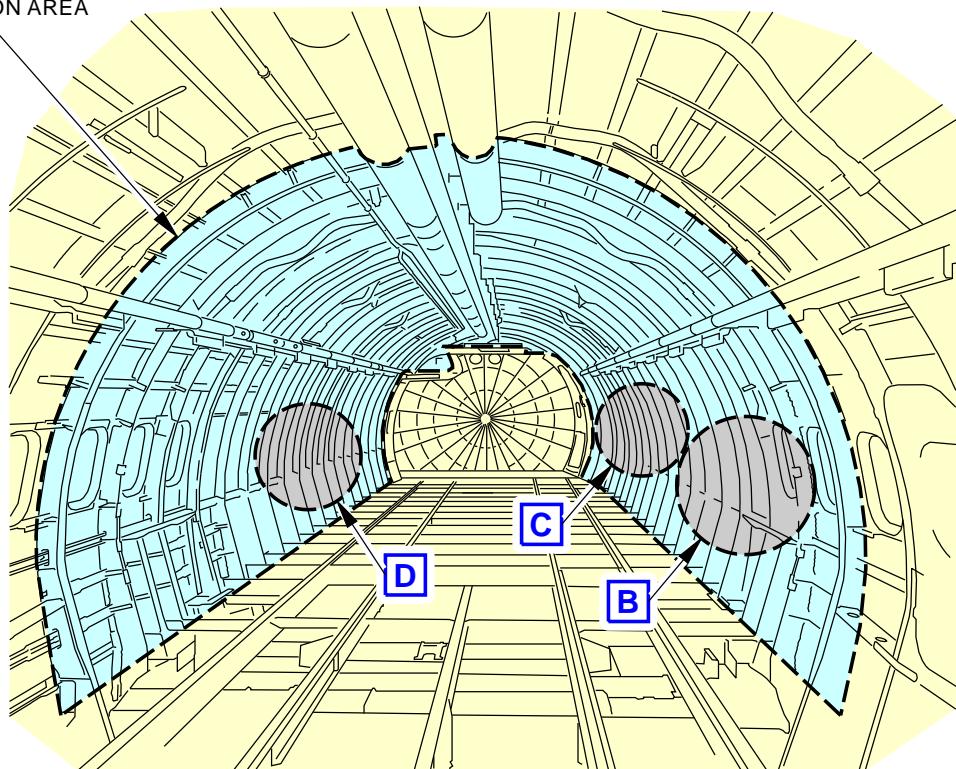


737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT
A

INSPECTION AREA



PASSENGER COMPARTMENT

A

MPD ITEM
53-410-00



2101150 S0000442502_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-863 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

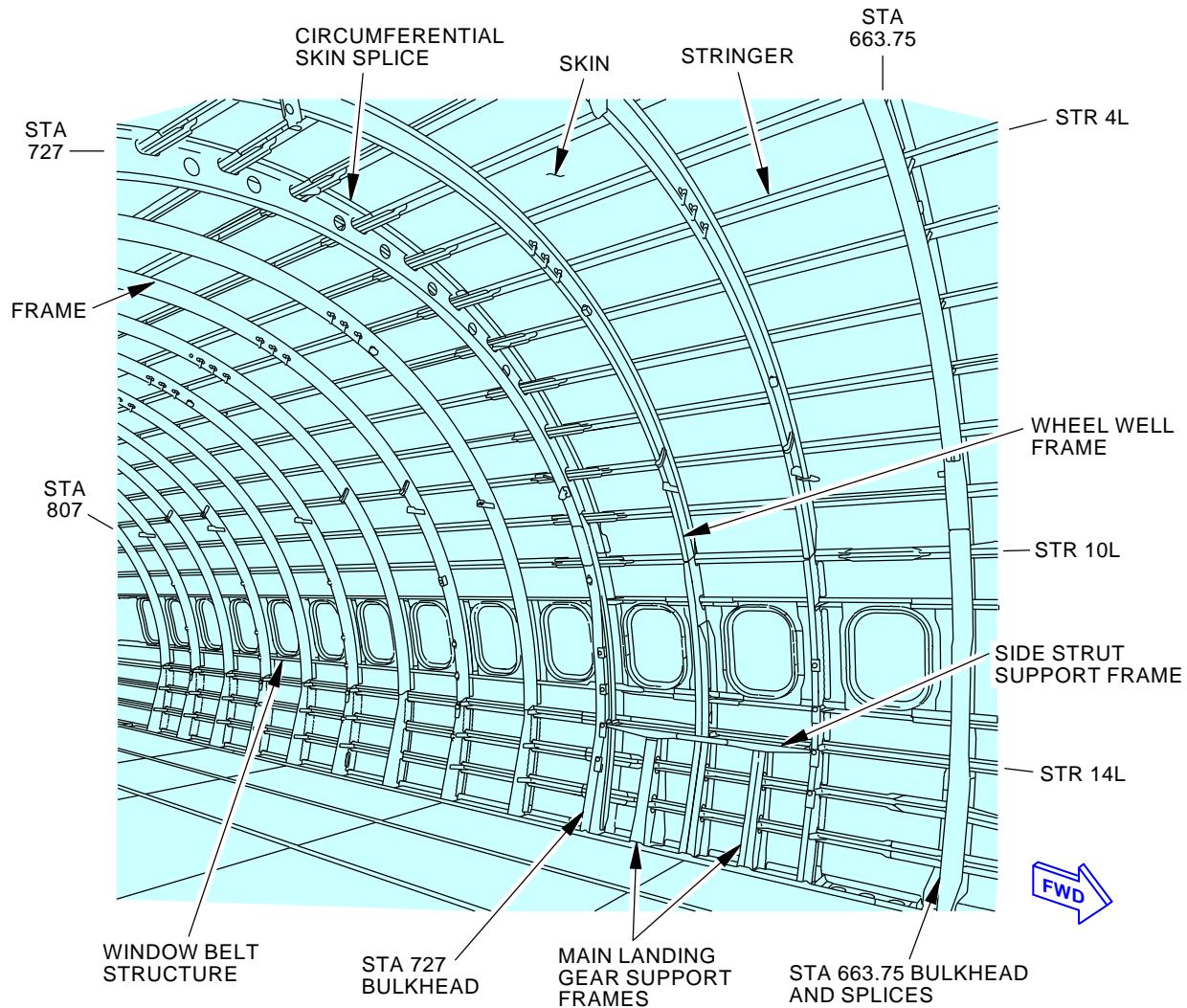
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53-05-03

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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT
(STA 663.75 TO 807)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)

B

MPD ITEM
53-410-00

2101205 S0000442500_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-863 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

53-05-03

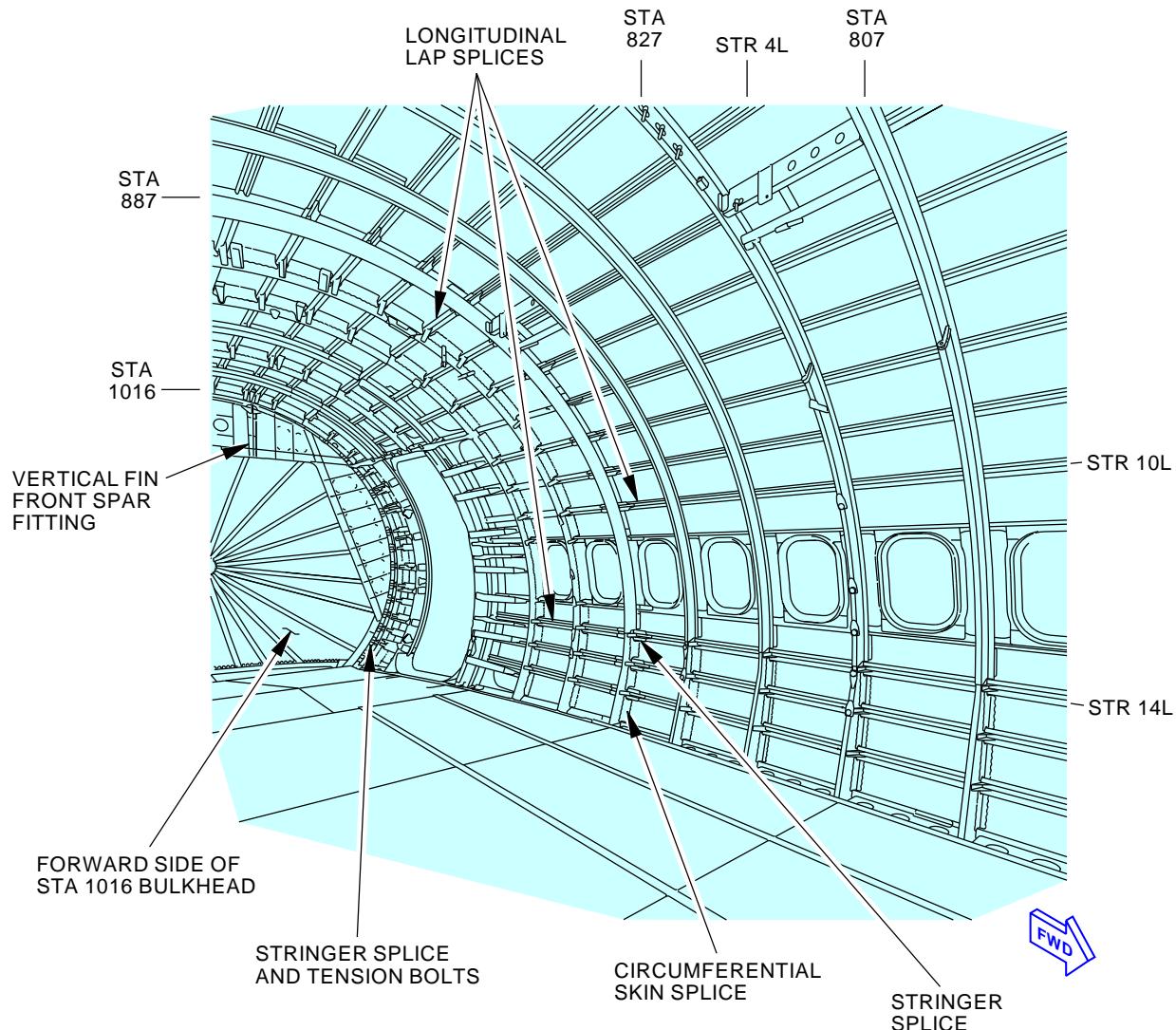
D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT
(STA 807 TO 1016)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)

C

MPD ITEM
53-410-00

2101274 S0000442503_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-863 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

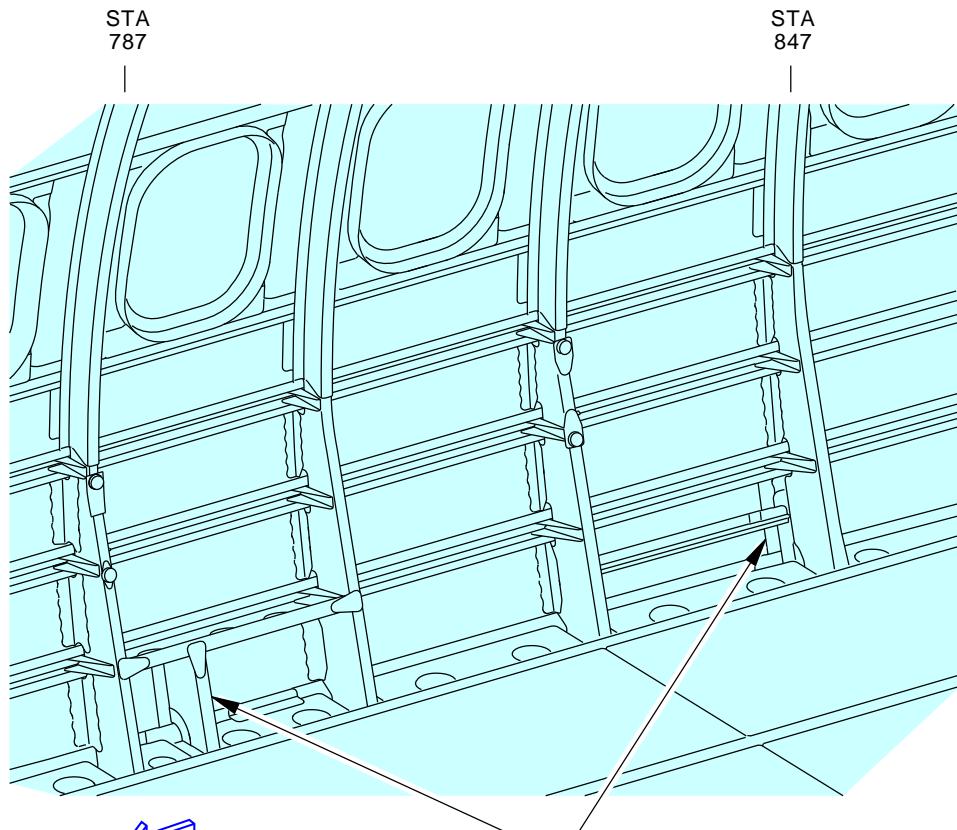
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53-05-03

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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT
(STA 787 TO 847)
(RIGHT SIDE ONLY)

D

MPD ITEM
53-410-00

2101287 S0000442504_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-863 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-838

48. INTERNAL - GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD

(Figure 254)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-03-010-035

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-03-210-038

- (2) Do a General Visual inspection of the area aft of STA 1016 pressure bulkhead to STA 1088, including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.
2. Aft side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments).
3. Stringer splice fittings and tension bolts at STA 1016.
4. STA 1088 bulkhead, including vertical fin rear spar fittings and horizontal stabilizer center section jackscrew fitting lugs and bolts.

SUBTASK 53-05-03-910-067

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-035

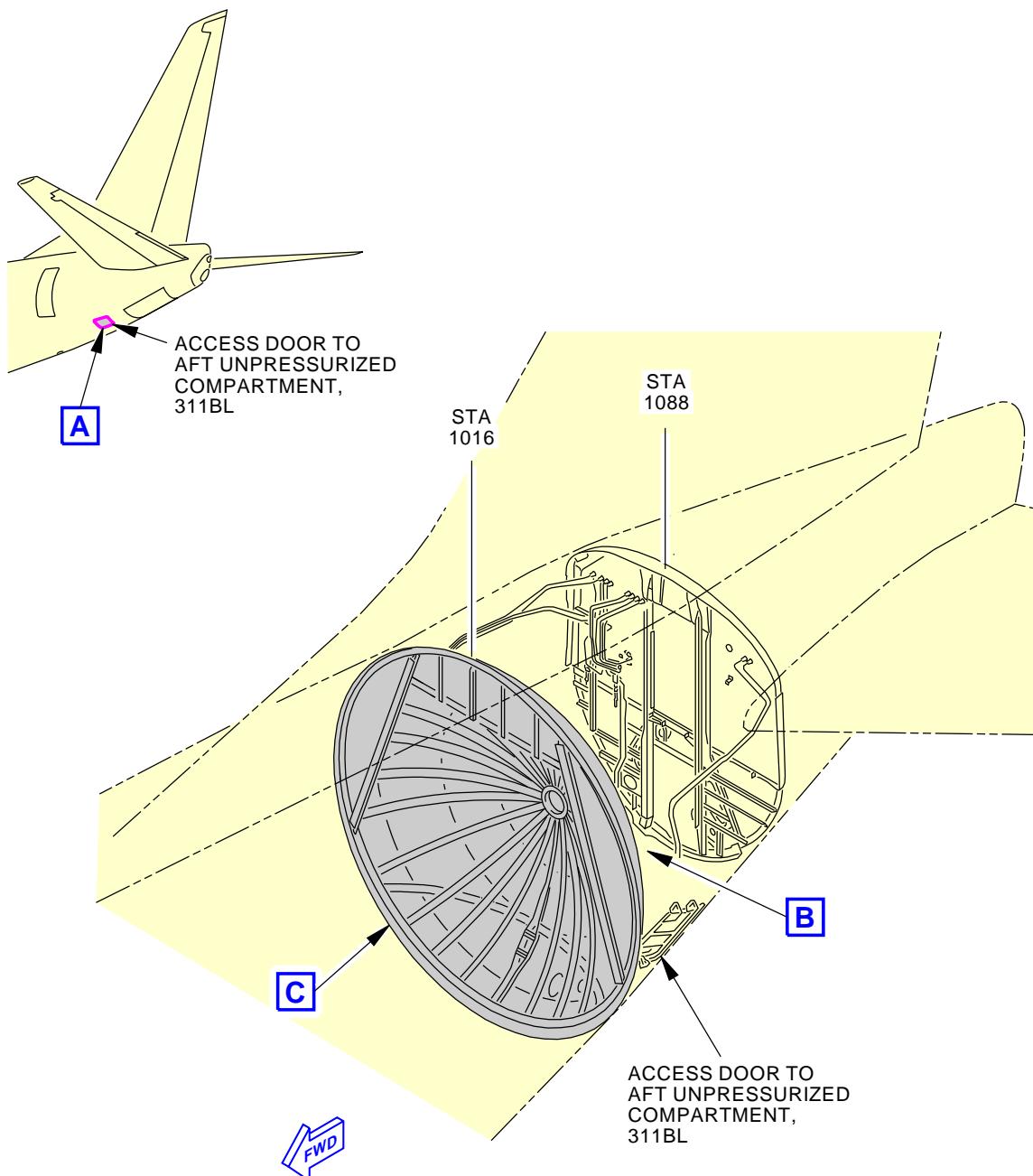
- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

———— END OF TASK ————



53-05-03



MPD ITEM
53-420-00

A

2100609 S0000445724_V2

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-851 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

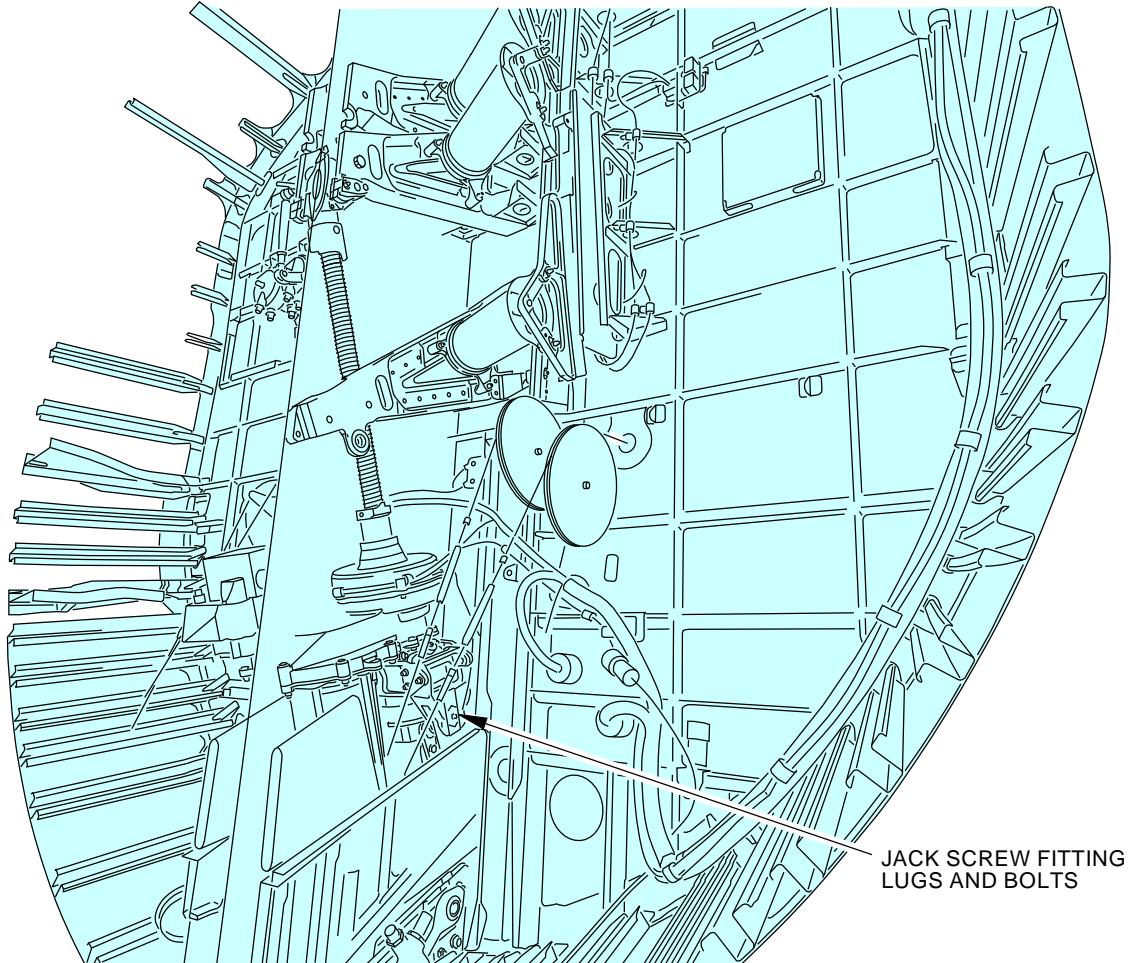
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53-05-03

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AIRCRAFT MAINTENANCE MANUAL



FWD

VIEW FROM BACK

B

MPD ITEM
53-420-00

2093789 S0000441634_V2

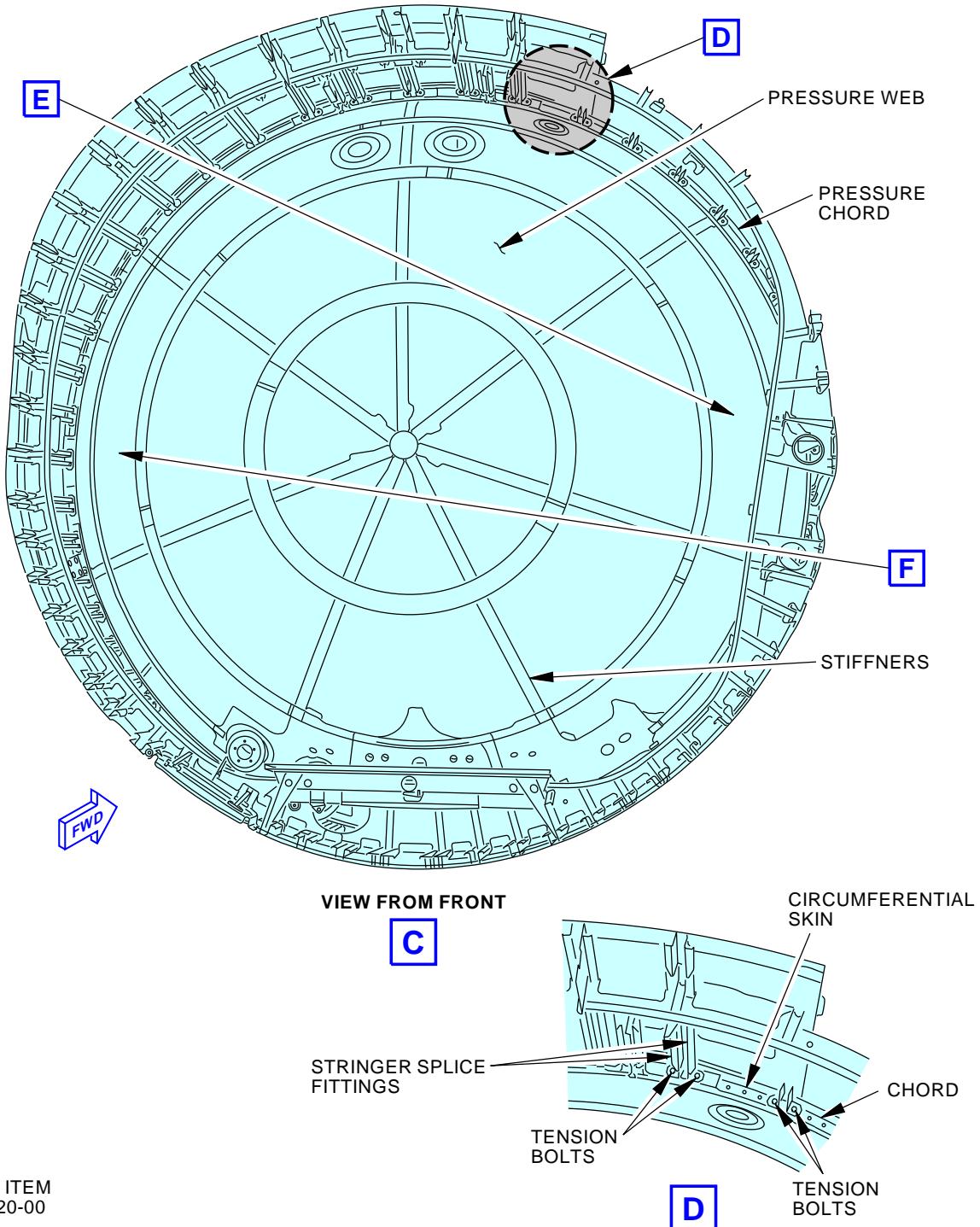
INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-851 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

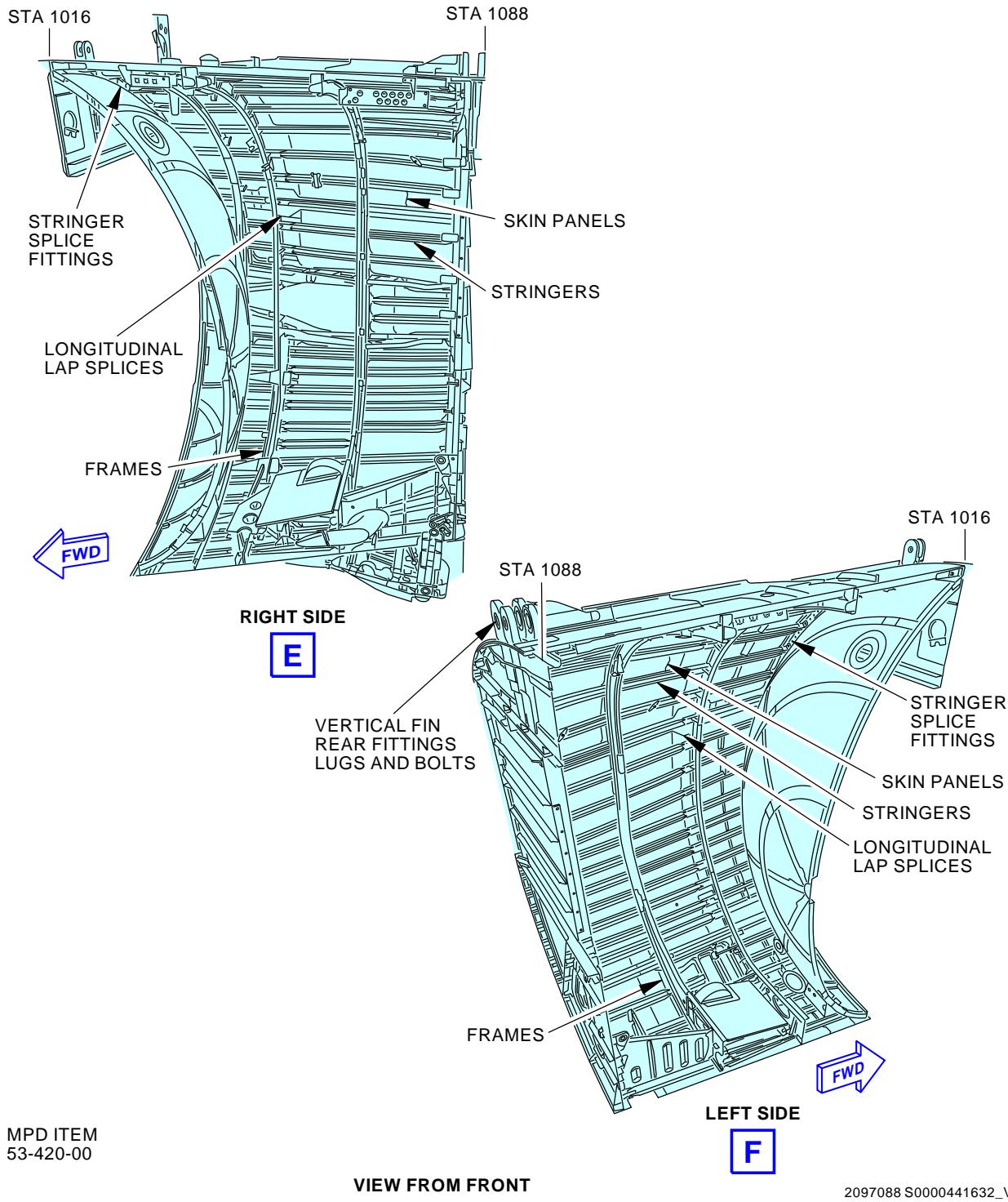
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INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-851 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

53-05-03

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INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-851 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-839

49. INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT

(Figure 255)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
315	APU Compartment - Left
316	APU Compartment - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-036

- (1) Open these access panels:

Number	Name/Location
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

Special Access:

Number	Name/Location
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection



53-05-03



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AIRCRAFT MAINTENANCE MANUAL

NOTE: For area below stringer 12, remove APU and firewalls; remove APU plenum as required. For area above stringer 12, adjust stabilizer trim as required. For access to Sta 1156 horizontal stabilizer hinge fitting lugs and bolts, remove gap seal and horizontal stabilizer rear spar sliding seal as required.

SUBTASK 53-05-03-210-039

- (2) Do a General Visual inspection of the stabilizer torsion box compartment and APU compartment, including:
1. Skin panels (skins, frames and stringers), longitudinal lap splices.
 2. STA 1088 bulkhead, including vertical fin rear spar fittings.
 3. Forward side of STA 1156 bulkhead, including horizontal stabilizer hinge fittings and bolts.
 4. Upper horizontal deck (at stringer 6) and lower horizontal deck (at stringer 12).

SUBTASK 53-05-03-910-068

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

SUBTASK 53-05-03-410-072

- (4) Close this access panel:

Number Name/Location

343AB Horizontal Stabilizer, Gap Cover - H. Stab. to Body

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 53-05-03-410-036

- (5) Close these access panels:

Number Name/Location

311BL Stabilizer Trim Access Door

315A APU Cowl Door

331A Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

332AB Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

332AT Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

341A Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

342AB Horizontal Stabilizer, Gap Cover - H. Stab. to Body

342AT Gap Cover, Horizontal Stabilizer

343AT Horizontal Stabilizer, Gap Cover - H. Stab. to Body

———— END OF TASK ————

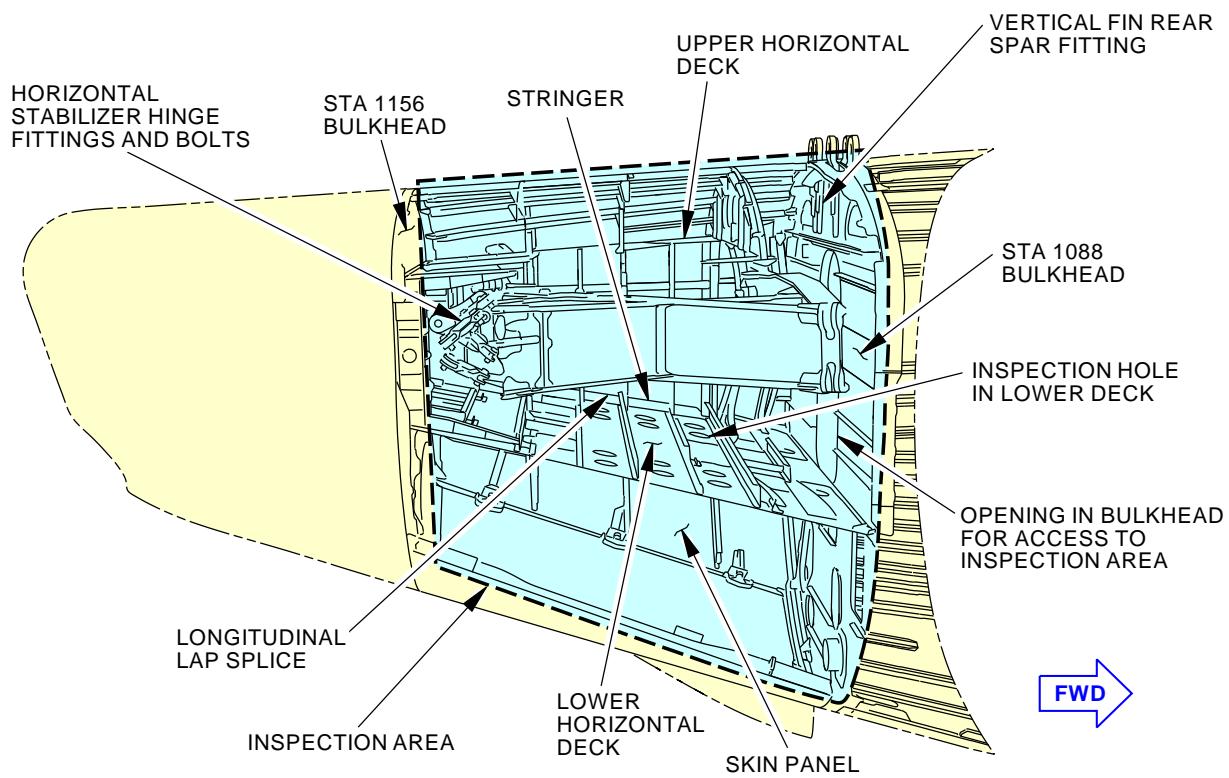
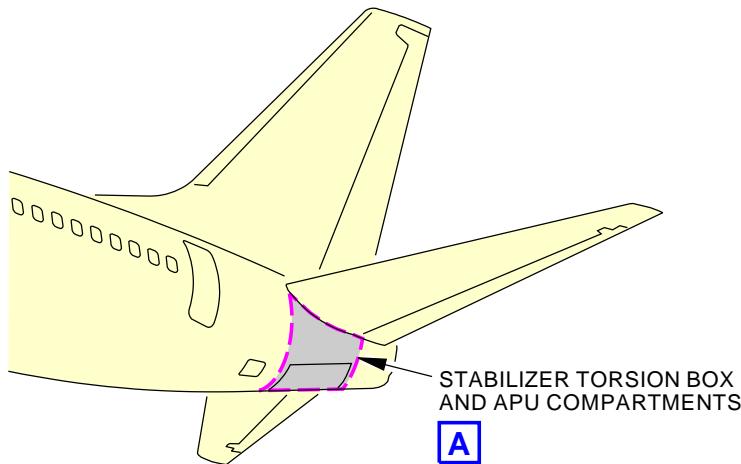
EFFECTIVITY
AKS ALL

53-05-03

D633A101-AKS



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-430-00

2097200 S0000441491_V2

INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT
Figure 255/53-05-03-990-857



D633A101-AKS

53-05-03

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-840

50. INTERNAL - GENERAL VISUAL: STA 1156 BULKHEAD

(Figure 256)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door

C. Inspection

SUBTASK 53-05-03-010-037

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door

SUBTASK 53-05-03-210-040

- (2) Do a General Visual inspection of the aft side of STA 1156 bulkhead.

SUBTASK 53-05-03-910-069

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-037

- (4) Close this access panel:

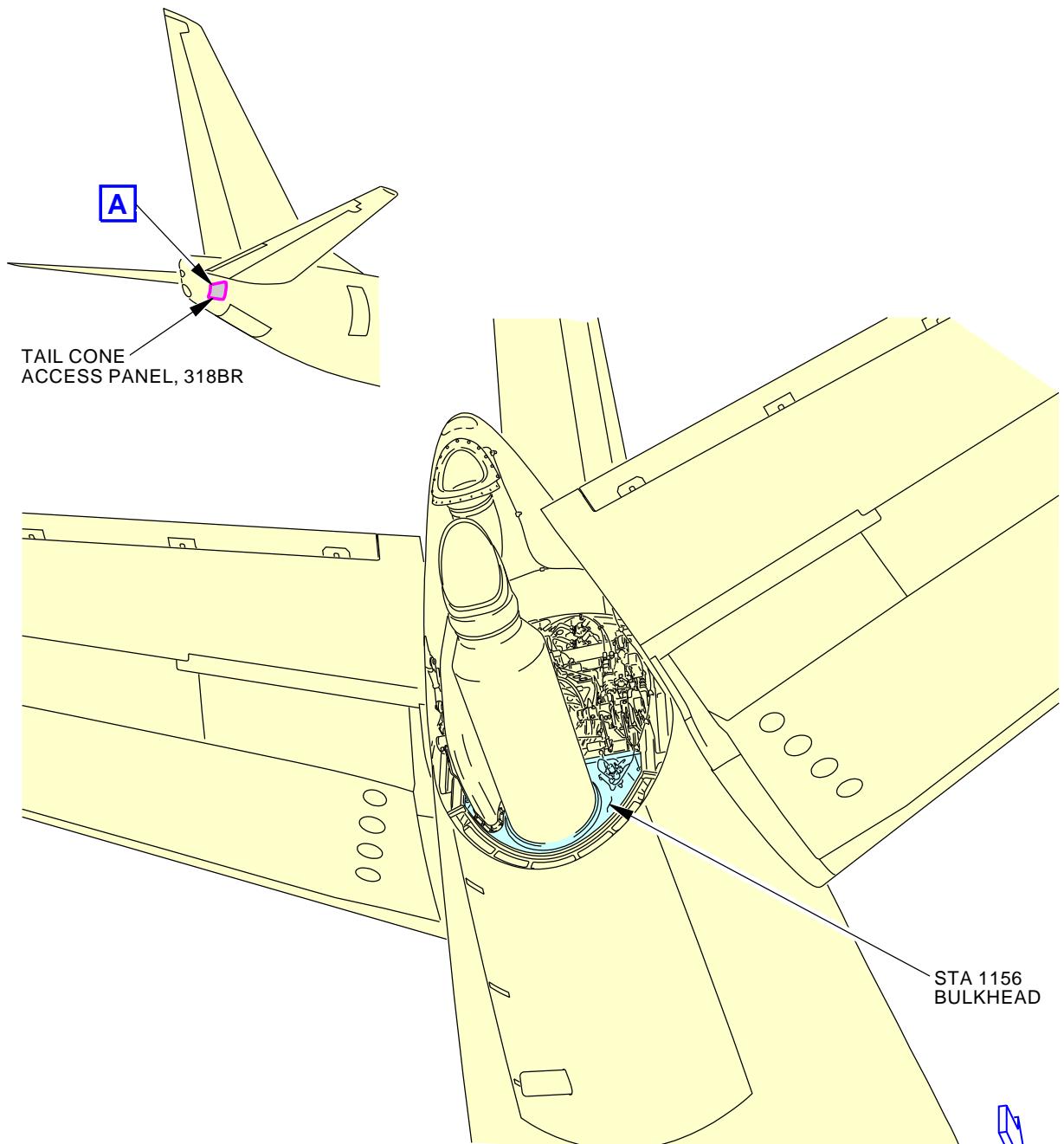
<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door

———— END OF TASK ————





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MPD ITEM
53-440-00

STA 1156 BULKHEAD
(TAIL CONE REMOVED FOR CLARITY)

A

2081370 S0000437527_V3

INTERNAL-GENERAL VISUAL: STA 1156 BULKHEAD
Figure 256/53-05-03-990-852

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-841

51. INTERNAL - GENERAL VISUAL: FUSELAGE SKIN UNDER DORSAL FIN

(Figure 257)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
321	Vertical Fin - Dorsal Fin

B. Access Panels

Number	Name/Location
321A	Vertical Fin, Dorsal Fin

C. Inspection

SUBTASK 53-05-03-010-038

- (1) Open this access panel:

Number	Name/Location
321A	Vertical Fin, Dorsal Fin

SUBTASK 53-05-03-210-041

- (2) Do a General Visual inspection of the fuselage skin under dorsal fin and aft to Sta 1016, including circumferential splice.

SUBTASK 53-05-03-910-070

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-038

- (4) Close this access panel:

Number	Name/Location
321A	Vertical Fin, Dorsal Fin

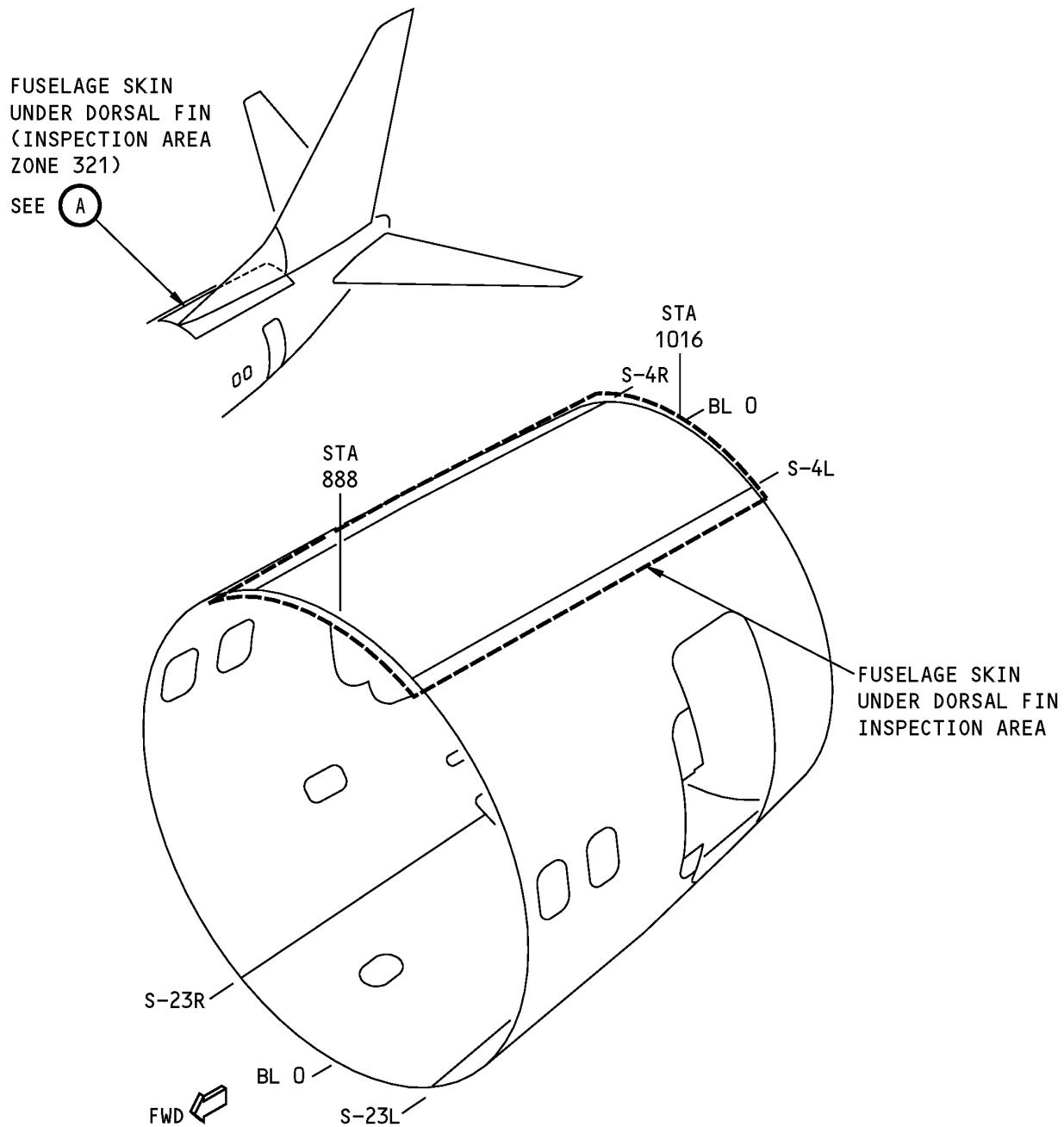
———— END OF TASK ————



53-05-03



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AIRCRAFT MAINTENANCE MANUAL



FUSELAGE SKIN UNDER DORSAL FIN



Internal-General Visual: Fuselage Skin Under Dorsal Fin
Figure 257/53-05-03-990-834

EFFECTIVITY
AKS ALL

53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-842

52. INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING

(Figure 258)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

B. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

C. Inspection

SUBTASK 53-05-03-010-039

- (1) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

NOTE: Pin removal is not required.

SUBTASK 53-05-03-210-042

- (2) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts (Sta 1016).

SUBTASK 53-05-03-910-071

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-039

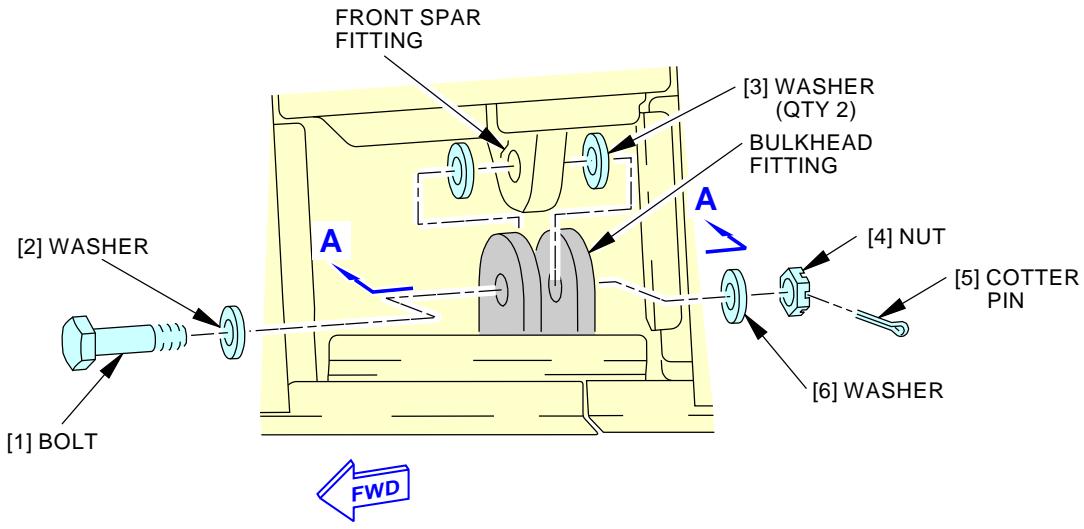
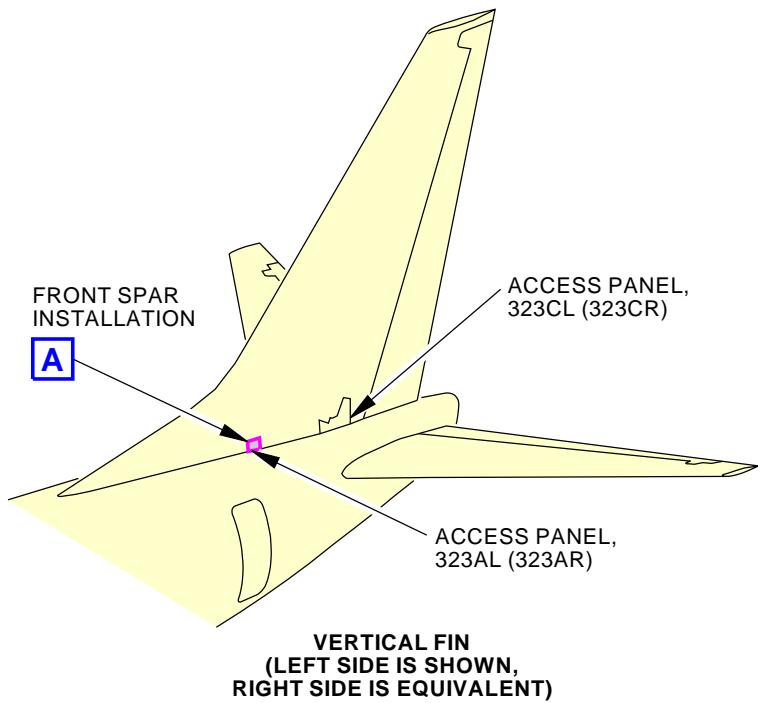
- (4) Close these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

———— END OF TASK ————

EFFECTIVITY
AKS ALL

53-05-03



FRONT SPAR INSTALLATION
(ACCESS PANEL REMOVED)

A

MPD ITEM
53-460-00

2087670 S0000439339_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 258/53-05-03-990-858 (Sheet 1 of 4)

EFFECTIVITY
AKS ALL

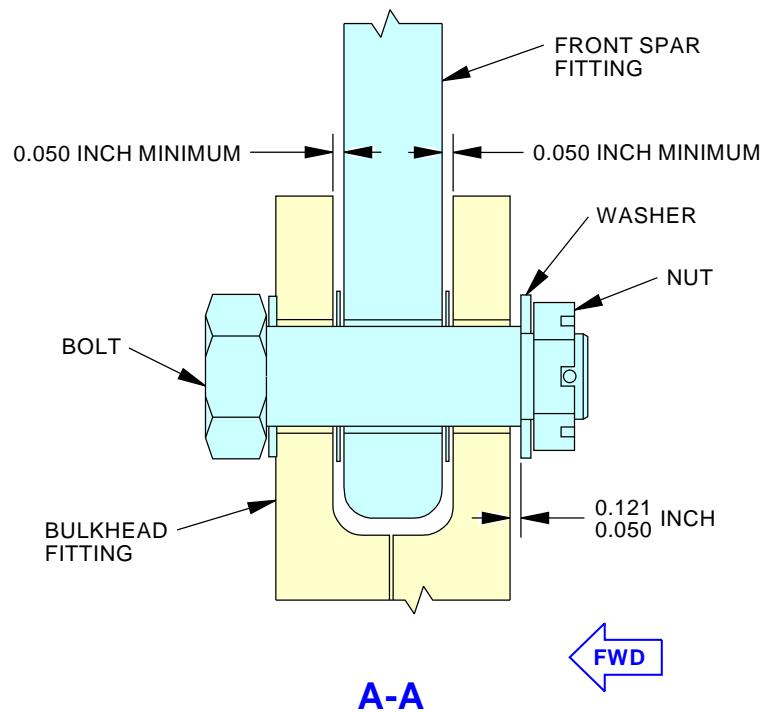
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53-05-03

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MPD ITEM
53-460-00

2087696 S0000439340_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 258/53-05-03-990-858 (Sheet 2 of 4)

EFFECTIVITY
AKS ALL

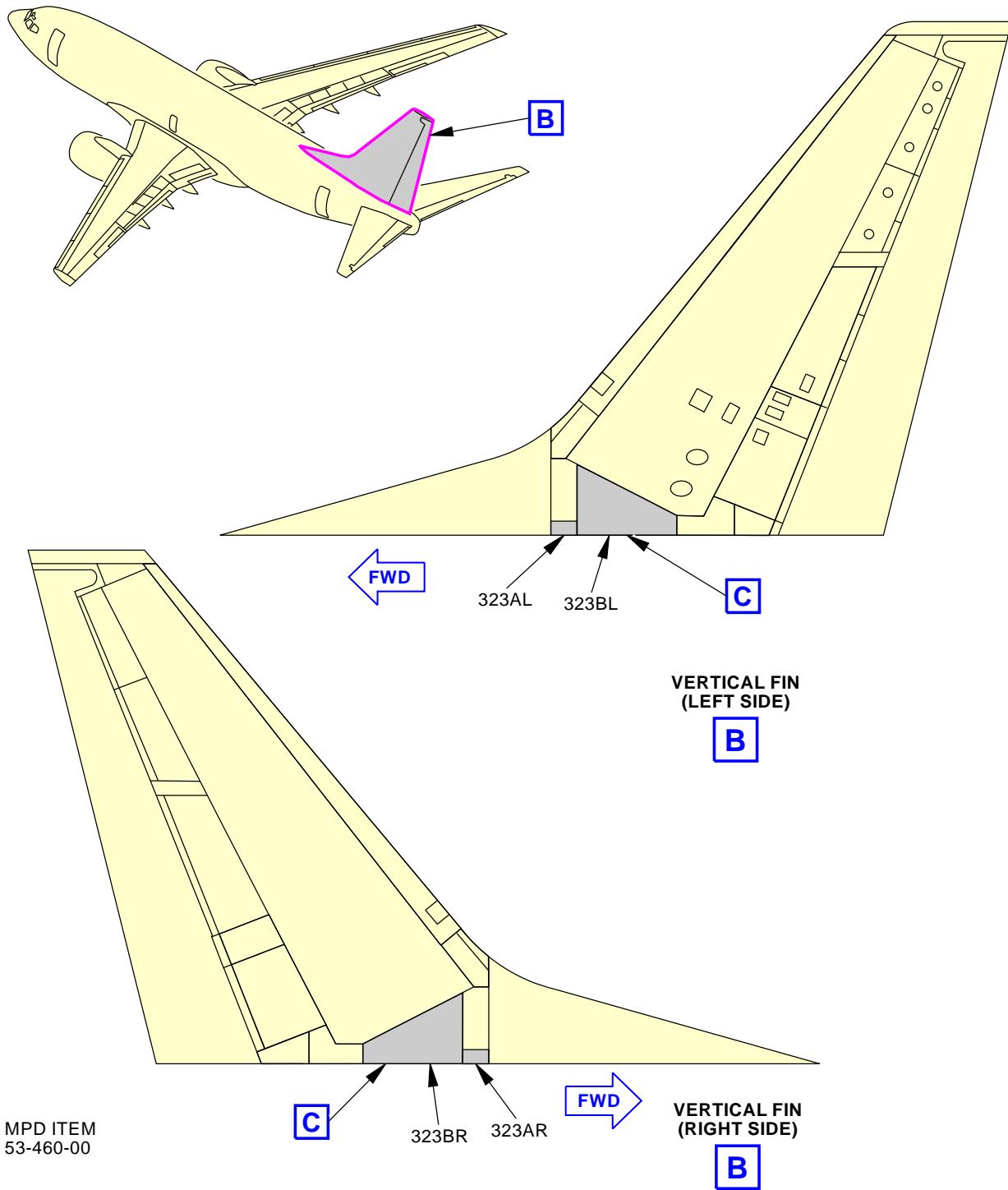
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INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 258/53-05-03-990-858 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

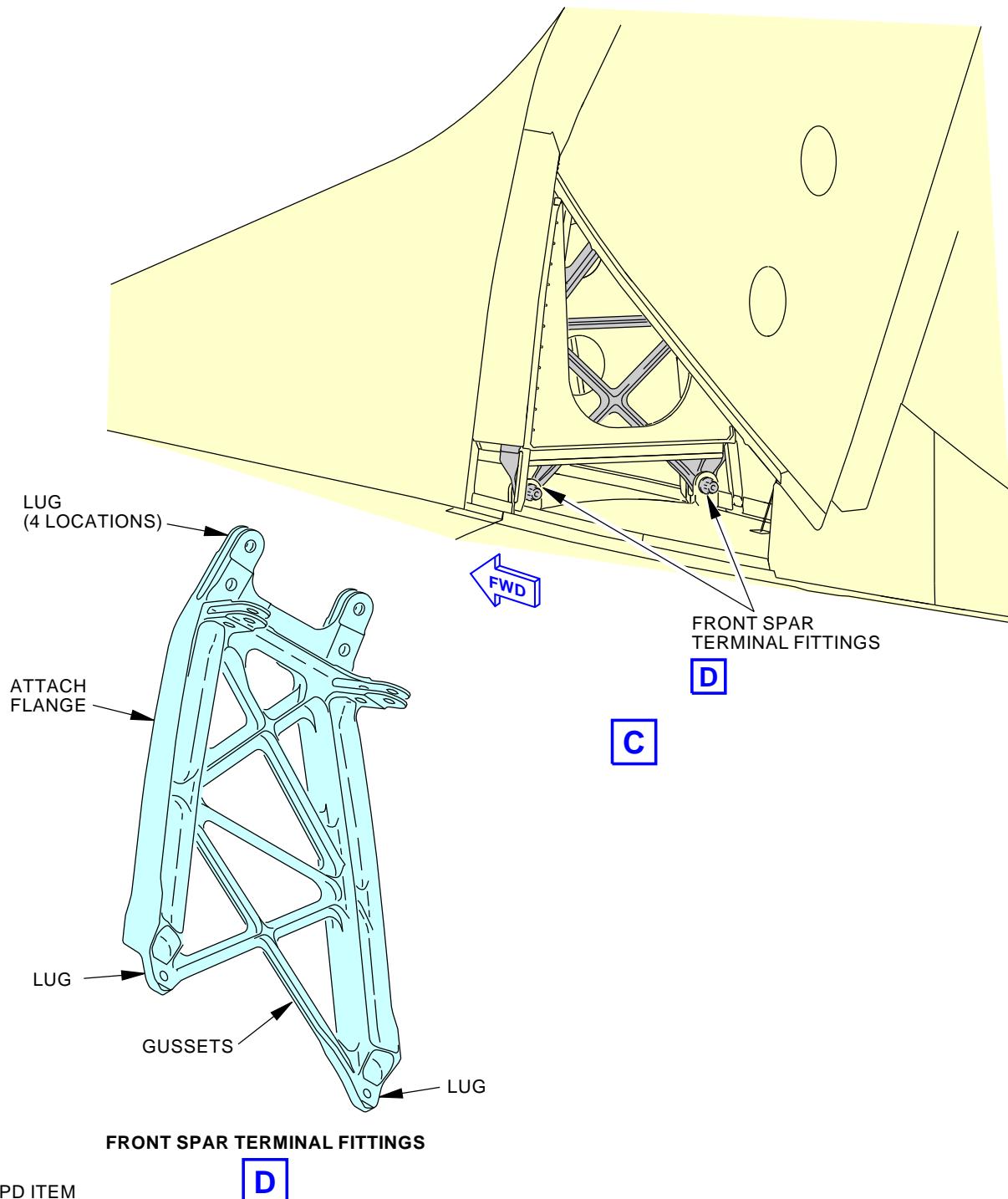
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INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 258/53-05-03-990-858 (Sheet 4 of 4)

EFFECTIVITY
AKS ALL

53-05-03



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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-843

53. INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING

(Figure 259)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

B. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

C. Inspection

SUBTASK 53-05-03-010-040

- (1) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

NOTE: Pin removal is required. Remove only one pin at a time.

SUBTASK 53-05-03-210-043

- (2) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts (STA 1016).

SUBTASK 53-05-03-910-072

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

SUBTASK 53-05-03-410-040

- (4) Close these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

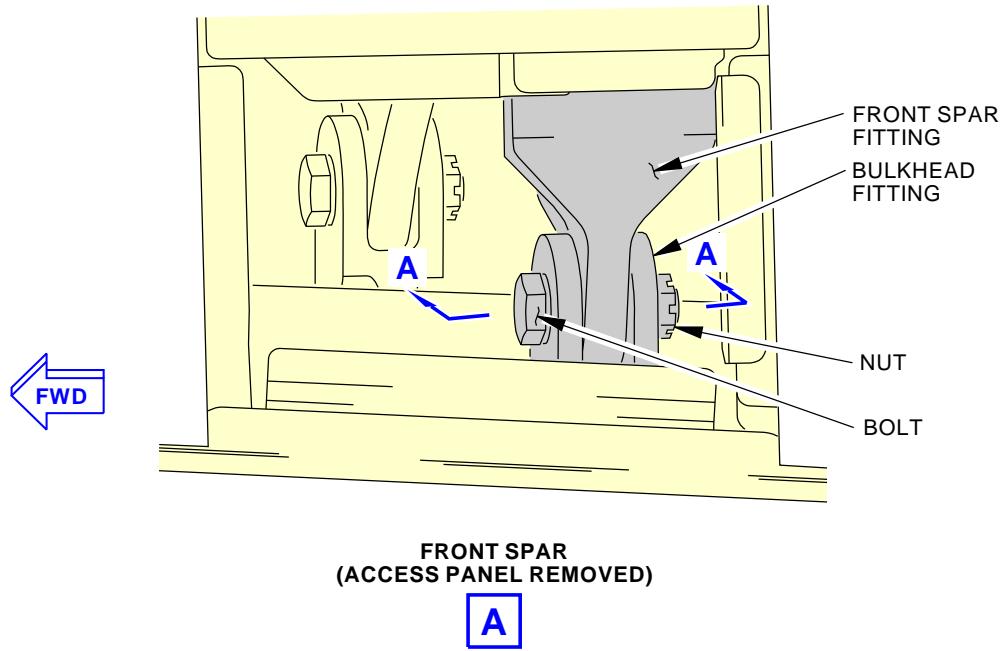
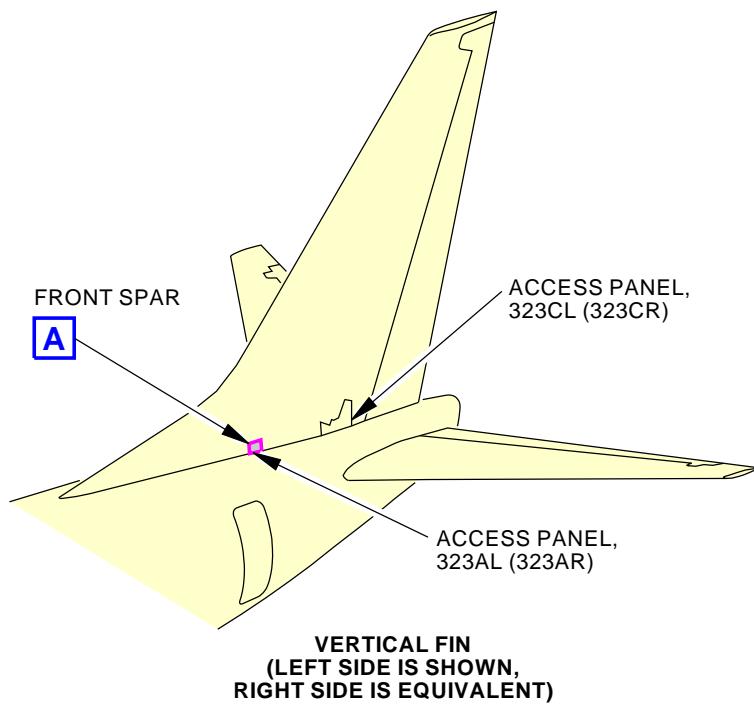
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53-05-03



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-470-00

2072432 S0000432636_V2

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)
Figure 259/53-05-03-990-895 (Sheet 1 of 2)

EFFECTIVITY

AKS ALL

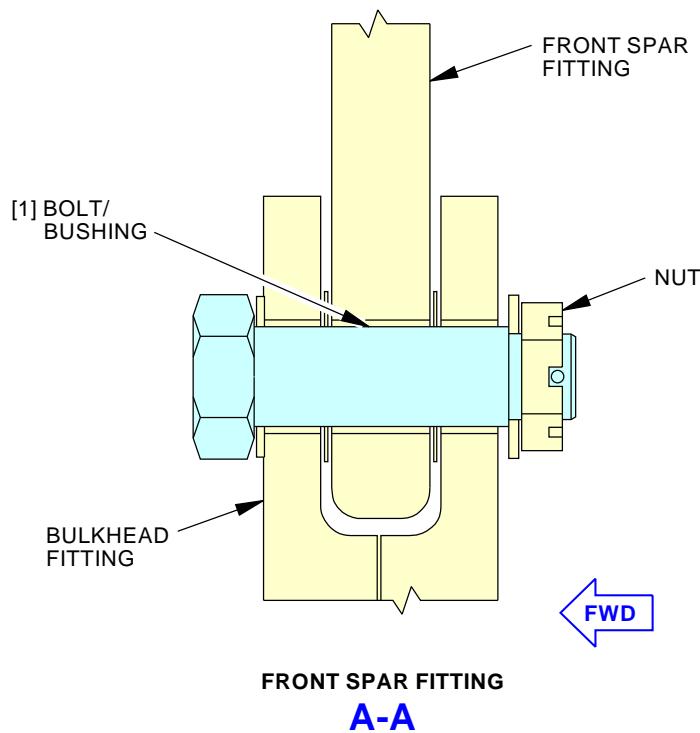
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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-470-00

2072440 S0000432646_V2

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)
Figure 259/53-05-03-990-895 (Sheet 2 of 2)

EFFECTIVITY _____
AKS ALL

D633A101-AKS

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-844

54. INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING

(Figure 260)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
323	Vertical Fin - Front Spar To Rear Spar

B. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

C. Inspection

SUBTASK 53-05-03-010-041

- (1) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 53-05-03-210-044

- (2) Do a General Visual inspection of the vertical fin rear spar fitting lugs and bolts at Sta 1088. Inspect fuselage skin under vertical fin from Sta 1016 to 1088.

SUBTASK 53-05-03-910-073

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-041

- (4) Close these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

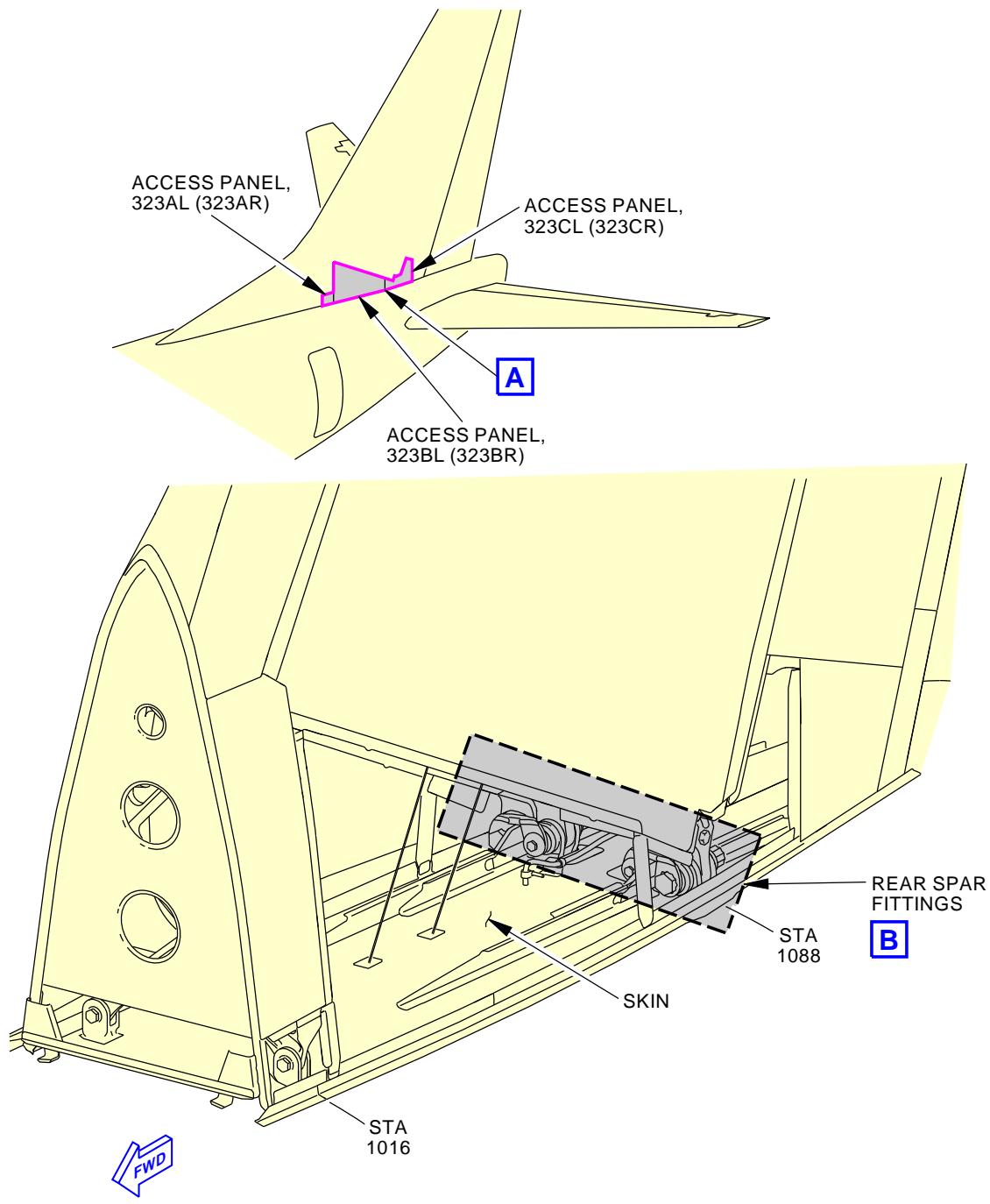
— END OF TASK —



53-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
53-480-00

2084332 S0000438778_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING
Figure 260/53-05-03-990-854 (Sheet 1 of 2)

EFFECTIVITY
AKS ALL

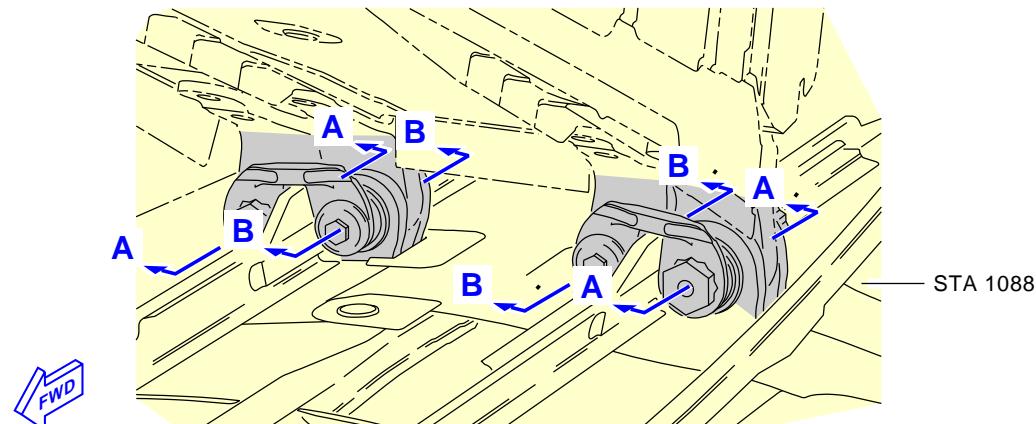
D633A101-AKS

53-05-03

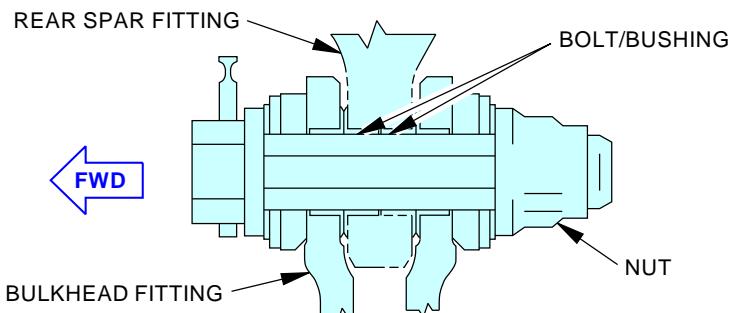
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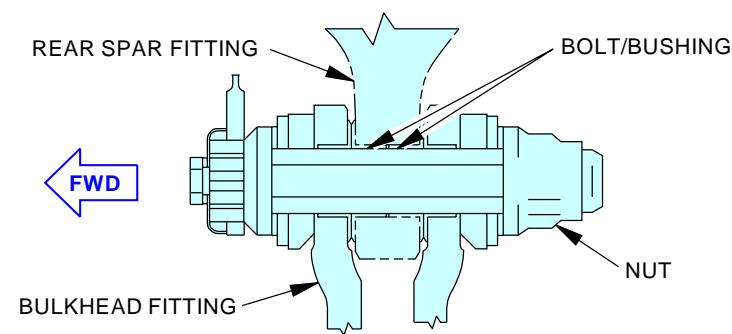
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AIRCRAFT MAINTENANCE MANUAL



REAR SPAR FITTINGS



OUTBOARD SPAR FITTING



MPD ITEM
53-480-00

INBOARD SPAR FITTING



2084337 S0000438779_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING
Figure 260/53-05-03-990-854 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

D633A101-AKS

53-05-03

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-861

55. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Access Panels

Number	Name/Location
S2101	Flight Compartment Inspection

C. Inspection

SUBTASK 53-05-03-010-079

- (1) Special Access:

Number	Name/Location
S2101	Flight Compartment Inspection

NOTE: Remove glare shield, liners, overhead units and panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-049

- (2) Do a General Visual inspection of the flight compartment, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and forward pressure bulkhead within the following areas: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame; and skin, frames and stringers above P5 panel.

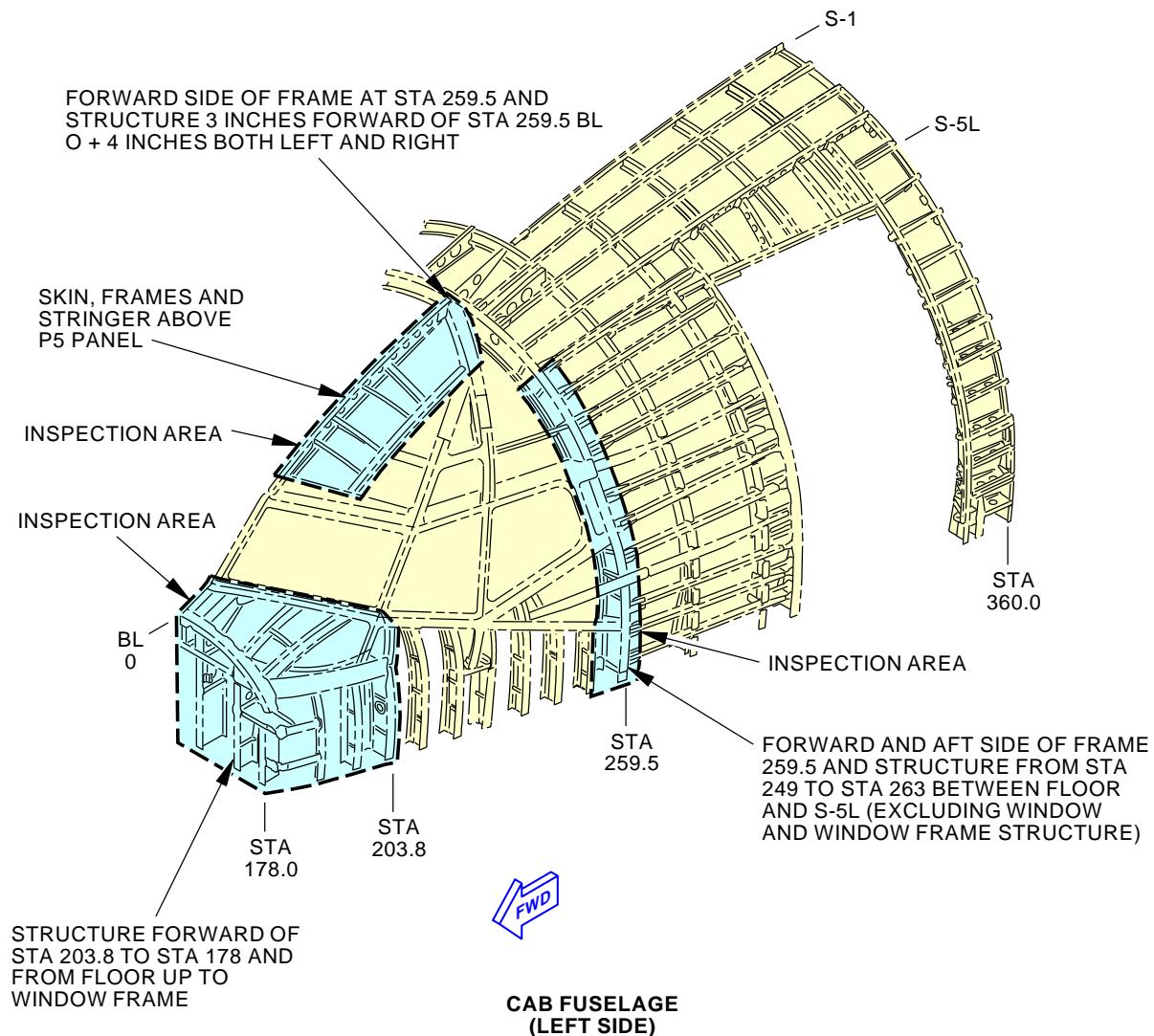
SUBTASK 53-05-03-910-077

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————

EFFECTIVITY
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53-05-03



MPD ITEM 53-335-00

2293154 S0000519282_V2

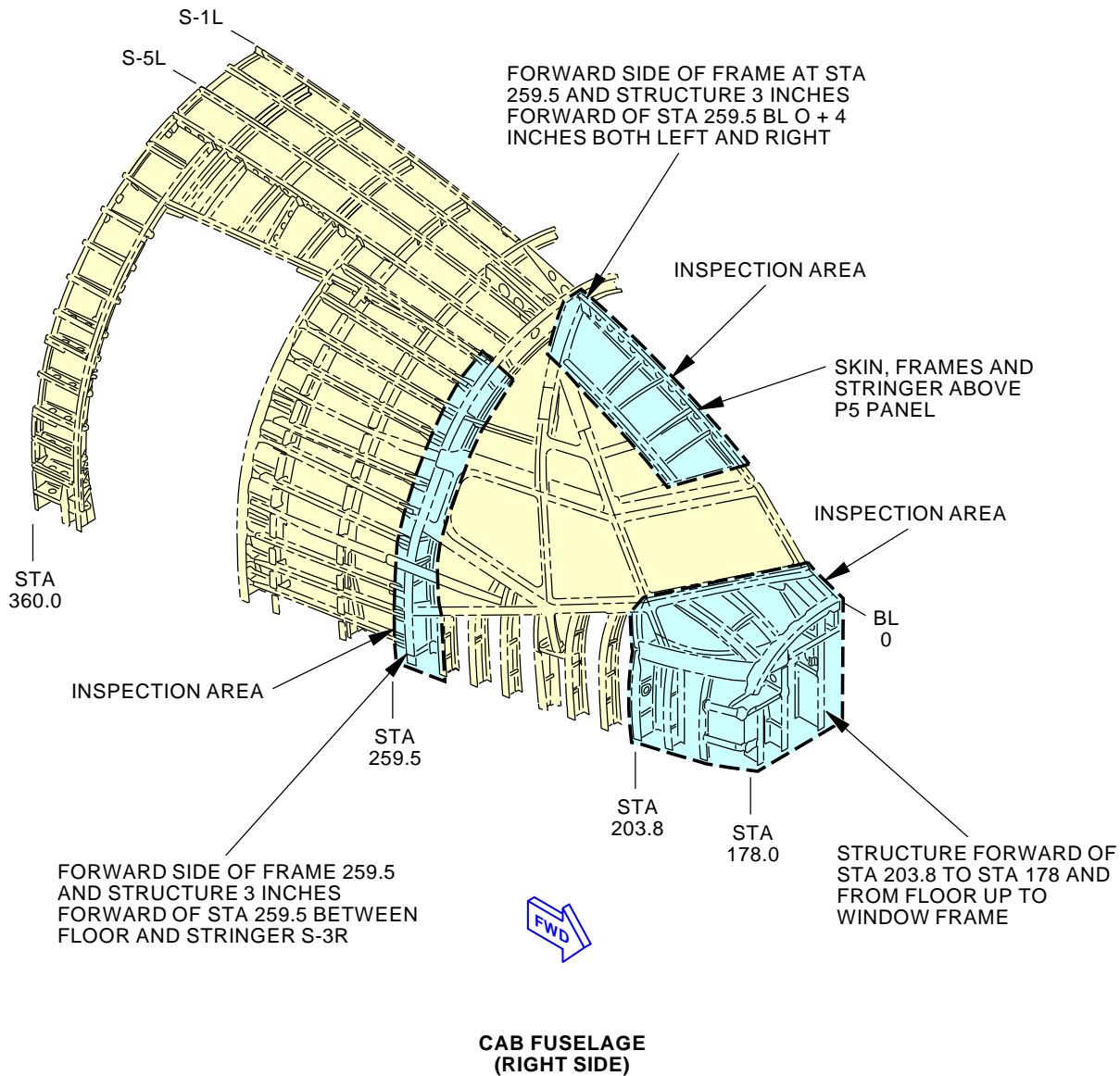
FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 261/53-05-03-990-901 (Sheet 1 of 2)

EFFECTIVITY	AKS ALL
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MPD ITEM 53-335-00

2293157 S0000519280_V2

**FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 261/53-05-03-990-901 (Sheet 2 of 2)**

EFFECTIVITY
AKS ALL

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AKS 012-999

TASK 53-05-03-210-862

56. INTERNAL - GENERAL VISUAL: CROWN SKIN PANEL

NOTE: This procedure is a scheduled maintenance task.

A. Inspection

- (1) Remove the Broadband Radome. Broadband Radome Removal, TASK 53-54-00-000-801
- (2) Remove the Adapter Plate.
- (3) Do a General Visual inspection of the crown skin and lugs under the Ku antenna base plate.
- (4) 737-6789 Basic Task Description, AMM 737-6789 Basic Task Description, TASK 51-05-01-210-806.
- (5) Install the Adapter Plate.
- (6) Install the Broadband Radome. Broadband Radome Installation, TASK 53-54-00-400-801
- (7) Operation check of Ku band antenna system.

B. References

Reference	Title
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

C. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

———— END OF TASK ————





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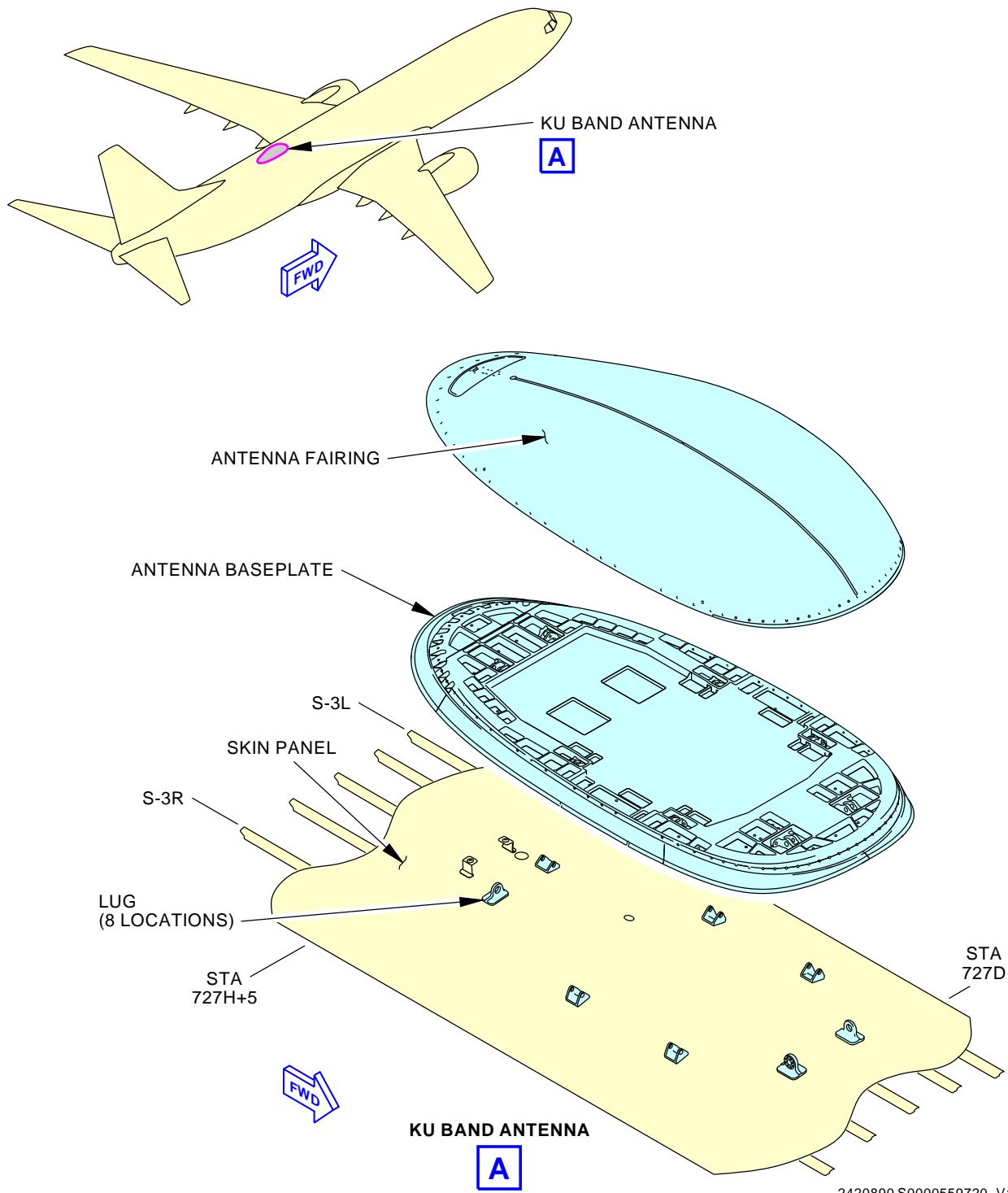


Figure 262/53-05-03-990-902

EFFECTIVITY
AKS 012-999

53-05-03

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PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) The removal of the passenger entry door scuff plates.
 - (2) The installation of the passenger entry door scuff plates.

TASK 53-11-01-000-801

2. Remove the Scuff Plate

(Figure 401, Figure 402, Figure 403)

A. Tools/Equipment

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

B. Consumable Materials

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740

C. Location Zones

Zone	Area
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

D. Procedure

SUBTASK 53-11-01-020-001

- (1) Remove the scuff plate:
 - (a) Remove the fasteners that attach the scuff plate to structure.
 - (b) Use a hard resin phenolic scraper, STD-1064 to release the scuff plate from structure.
 - (c) Remove the scuff plate.

NOTE: The door lining attached to the scuff plate is installed with a parting agent on the scuff plate for separation and removal of the scuff plate. It is possible to remove the door lining attached to the scuff plate with the scuff plate.

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

- (d) Remove sealant and parting agent from faying surfaces with solvent, B00148 and hard resin phenolic scraper, STD-1064.
- (e) Do a visual inspection of the nut plates to determine if they are in acceptable condition. If it is necessary, replace them.

— END OF TASK —

EFFECTIVITY
AKS ALL

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TASK 53-11-01-420-801

3. Install the Scuff Plate

(Figure 401, Figure 402, Figure 403)

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C50033	Chromated Conversion Coating for Aluminum - Alodine 1200	
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating) (Formerly 598-5002 Green Strippable Coating)	BAC5000
G02497	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 700-NC Mold Release)	BAC5000
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partail Coverall Film)	
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1

B. Location Zones

Zone	Area
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

C. Procedure

SUBTASK 53-11-01-110-001

- (1) Install the scuff plate:



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- (a) If it is necessary, clean all faying surfaces with a solvent, B00148 MEK.
- (b) Apply MIL-C-81706, class 1A, form II Alodine 1200 coating, C50033 and two coats of primer, C00259 to exposed metal surfaces of the outer skin that will be under the scuff plate.
- (c) Apply a coat of parting agent to the bottom side of the scuff plate and the outer skin.
- (d) Preferred peelable AC962-73C peelable parting agent, G50365
 - 1) Alternate Valspar 4A-183 green strippable coating, G02185
 - 2) Alternate peelable parting agent, G50366
 - 3) Alternate AZ 634-2 peelable parting agent, G50367
 - 4) Alternate Rexco Partail Coverall Film peelable parting agent, G50368
 - 5) Alternate temporary coating, G50369
 - 6) Alternate Frekote 710-NC non-peelable parting agent, G50313
- (e) Prepack the scuff plate in the area shown with sealant, A00247, minimum 0.35 inch (8.9 mm) thick.
- (f) Prepack the structure in the areas shown with sealant, A00247.
- (g) Apply sealant, A00247 to the structure surface that will touch the scuff plate.
- (h) Install the scuff plate.
- (i) If a new door lining will be installed on the scuffplate, do these steps:
 - 1) Apply sealant, A00247 to the area of the door lining that will touch the scuff plate.
 - 2) Apply Frekote 700-NC non-peelable parting agent, G02497 to the area of the scuff plate that will touch the door lining.
 - 3) Install the door lining on the scuff plate.
- (j) Apply primer, C00259 to the fastener holes.
- (k) Make sure the primer, C00259 is dry before the fasteners are installed.
- (l) Install the fasteners wet with compound, C00528.
- (m) Remove excess sealant from the edges of the scuff plate.
- (n) FOR FORWARD ENTRY DOOR;
Fill gaps and fastener recesses with sealant, A00247 and fair flush with adjacent surfaces.
- (o) FOR AFT ENTRY DOOR AND GALLEY SERVICE DOORS;
Fill gaps and fastener recesses with 3M EC-3587B compound, A01024 and fair flush with the adjacent surfaces.
- (p) FOR FORWARD ENTRY DOOR AND FORWARD GALLEY SERVICE DOOR;
Fill forward and aft edges of the scuff plate with 3M EC-3587B compound, A01024 and fair flush with adjacent surfaces.
NOTE: This will provide a smooth surface for the door seal.
- (q) FOR AFT ENTRY DOOR AND AFT GALLEY SERVICE DOOR;

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Fill forward and aft edges of the scuff plate with sealant, A00247 and fair flush with adjacent surfaces.

NOTE: This will provide a smooth surface for the door seal.

- (r) FOR FORWARD GALLEY SERVICE DOOR;
Apply sealant, A00247 aero-smoother around scuff plate at a 6 to 1 taper ratio.
- (s) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;
Apply a sealant, A02315 fillet seal around the scuff plate.
- (t) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;
Fill slots at forward area of the scuff plate with sealant, A00247 and fair flush with adjacent surfaces.

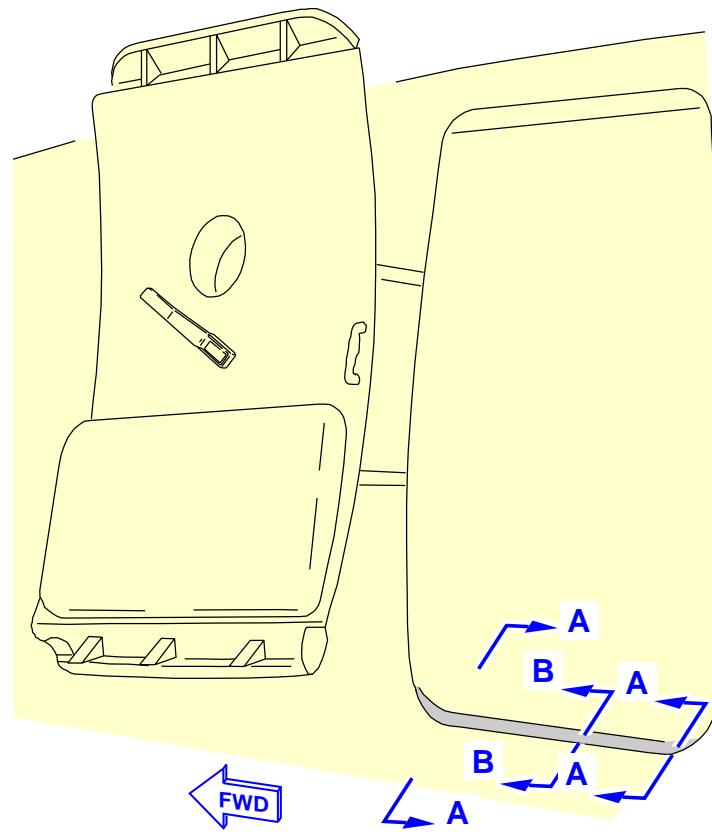
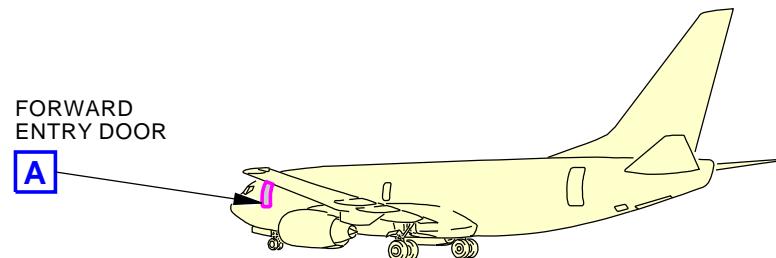
———— END OF TASK ————

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FORWARD ENTRY DOOR



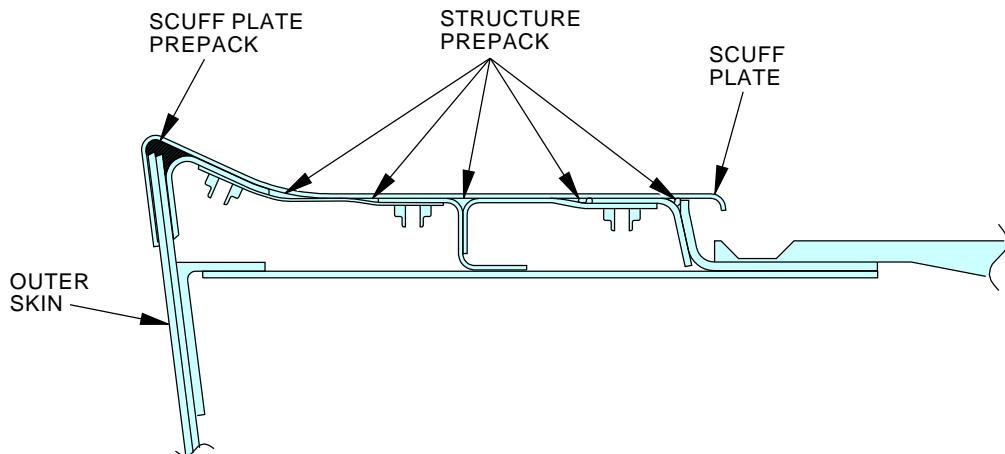
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Forward Entry Door Scuff Plate Installation
Figure 401/53-11-01-990-801 (Sheet 1 of 2)

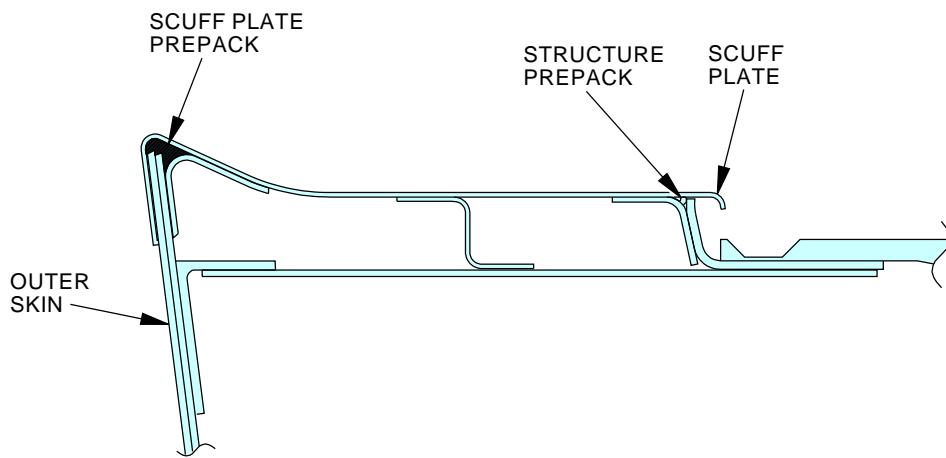
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A-A



B-B

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Forward Entry Door Scuff Plate Installation
Figure 401/53-11-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

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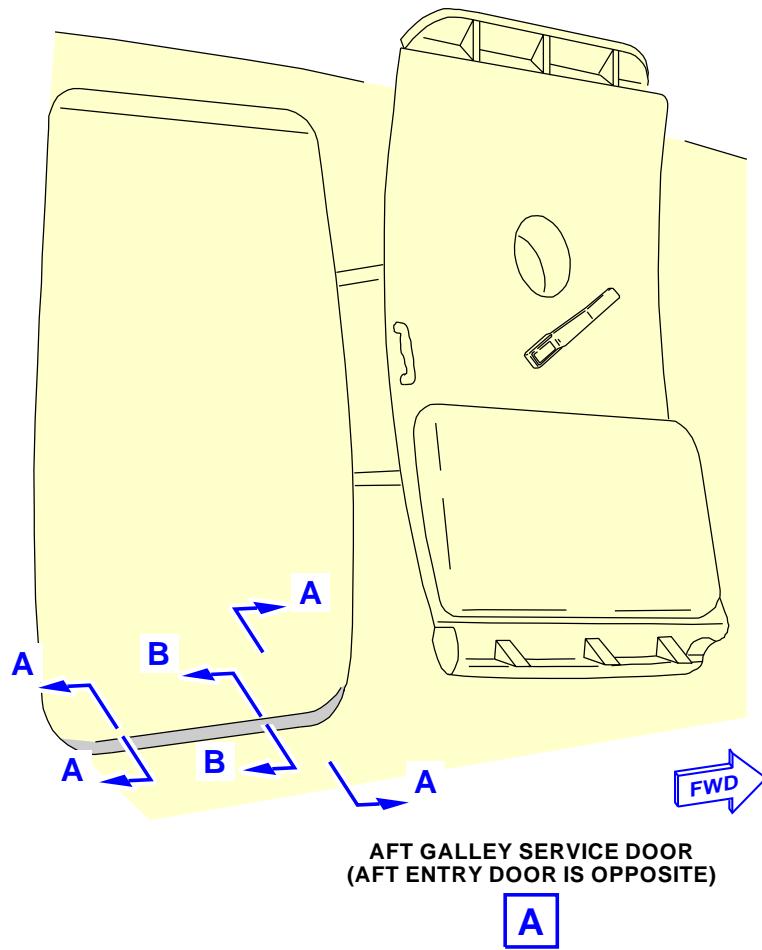
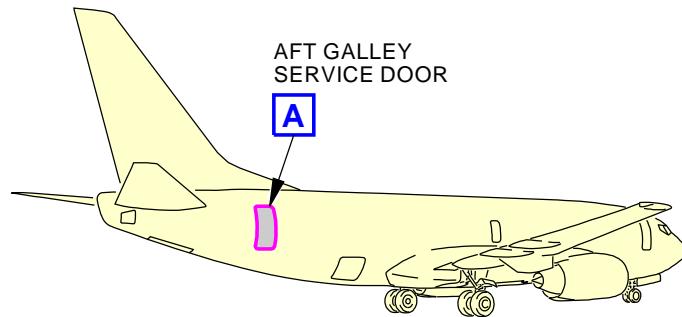
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AIRCRAFT MAINTENANCE MANUAL



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Aft Galley Service Door and Aft Entry Door Scuff Plate Installation
Figure 402/53-11-01-990-802 (Sheet 1 of 2)

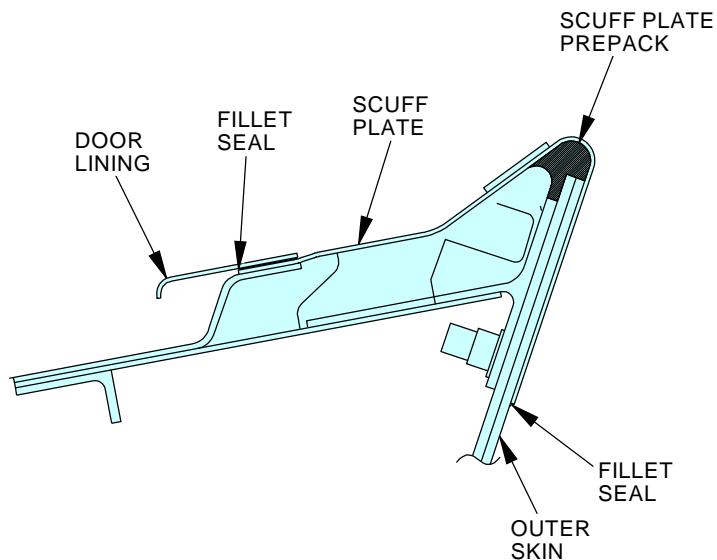
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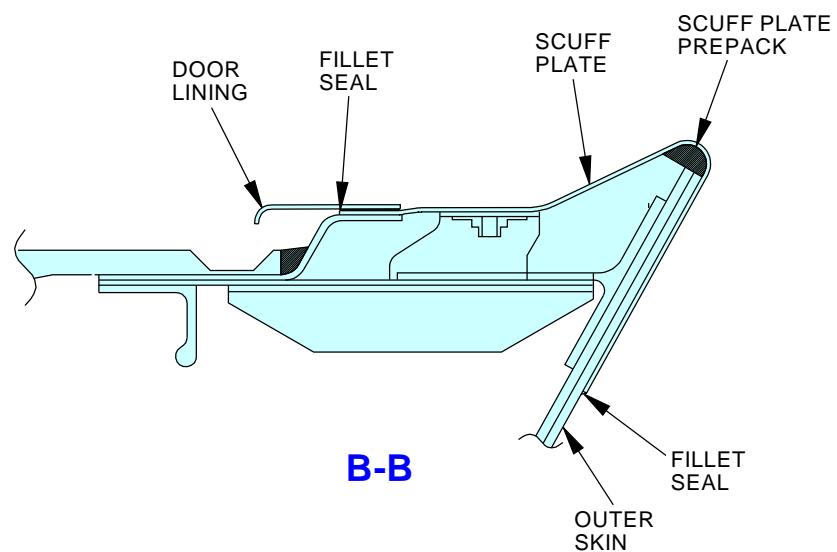
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A-A



B-B

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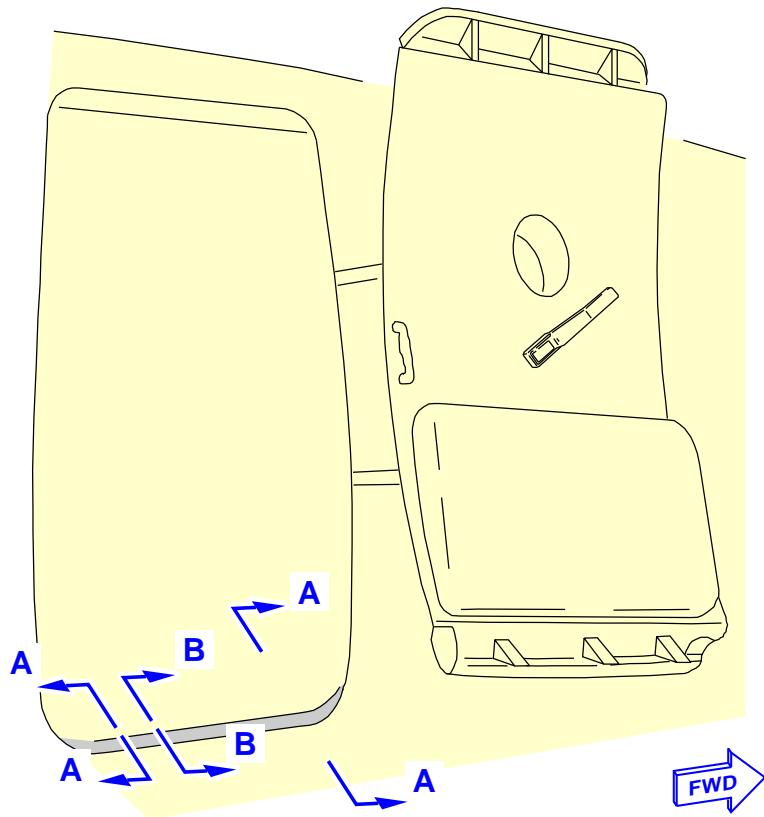
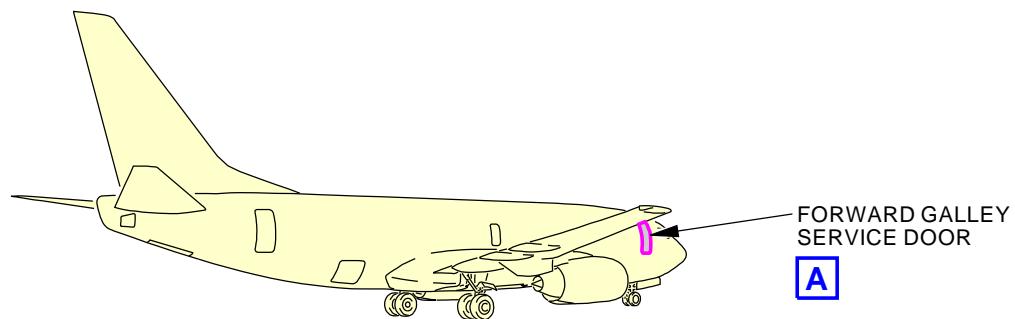
Aft Galley Service Door and Aft Entry Door Scuff Plate Installation
Figure 402/53-11-01-990-802 (Sheet 2 of 2)

EFFECTIVITY
AKS ALL

53-11-01



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FORWARD GALLEY SERVICE DOOR



M27808 S0006581006_V2

Forward Galley Service Door Scuff Plate Installation
Figure 403/53-11-01-990-803 (Sheet 1 of 2)

EFFECTIVITY	AKS ALL
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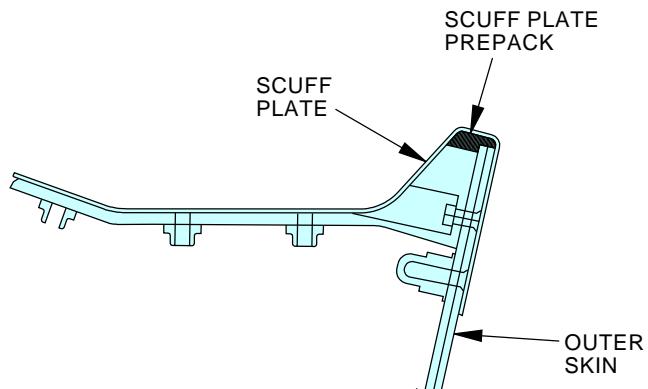
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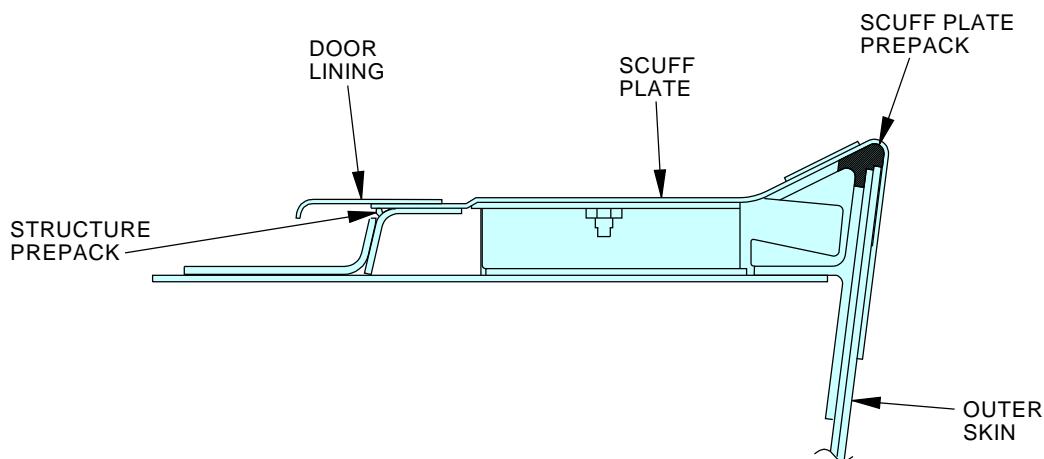
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A-A



B-B

M27780 S0006581007_V2

Forward Galley Service Door Scuff Plate Installation
Figure 403/53-11-01-990-803 (Sheet 2 of 2)

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CARGO DOOR SCUFF PLATE - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks:
 - (1) The first task is the removal of the scuff plates.
 - (2) second task is the installation of the scuff plates.
- B. All the installations of the scuff plates are almost the same.
- C. The clearances between the scuff plates and the airplane structure are sealed for aerodynamic smoothness.

TASK 53-11-02-020-801

2. Cargo Door Scuff Plate - Removal

A. References

Reference	Title
51-31-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES

B. Tools/Equipment

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

C. Consumable Materials

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740

D. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

E. Procedure

SUBTASK 53-11-02-020-003

- (1) Remove the filler scuff plate [1].

CAUTION: DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (a) Use a hard resin phenolic scraper, STD-1064 to release the scuff plate [1] from the structure.
- (b) Remove the filler scuff plate [1] away from the plane.

SUBTASK 53-11-02-020-001

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.

- (2) Remove the scuff plate [4].

- (a) Remove the screws [5] that attach the scuff plate [4] to the structure.

EFFECTIVITY	AKS ALL
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CAUTION: DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064 to release the scuff plate [4] from the structure.
- (c) Remove the scuff plate [4] away from the airplane.
- (d) Remove the filler scuff plate [6] from the structure.
 - 1) Use a hard resin phenolic scraper, STD-1064 to release the filler scuff plate [6] from structure.
- (e) Remove the scuff plate gasket [9] from the structure.

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.

CAUTION: BE CAREFUL WHEN YOU REMOVE THE SEAL WITH THE SEALANT REMOVAL TOOL. DAMAGE TO THE AIRPLANE SKIN CAN OCCUR.

- (3) Remove the sealant and parting agent from mating surfaces with solvent, B00148 and a hard resin phenolic scraper, STD-1064 (SEALS AND SEALING - MAINTENANCE PRACTICES, PAGEBLOCK 51-31-00/201).
- (4) Do a visual inspection of the nut plates [11] to find if they are in a satisfactory condition. If it is necessary, replace them.

SUBTASK 53-11-02-020-004

- (5) Remove the forward and aft scuff plates [2].
 - (a) Remove the screws [3] that attach the scuff plate [2] to the structure.

CAUTION: DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064 to release the scuff plate [2] from the structure.
- (c) Remove the scuff plate [2] away from the plane.

SUBTASK 53-11-02-020-005

- (6) Remove the scuff plate [7].
 - (a) Remove the screws [8] that attach the scuff plate [7] to the structure.

CAUTION: DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064 to release the scuff plate [7] from the structure.
- (c) Remove the scuff plate [7] from the structure.

— END OF TASK —

EFFECTIVITY
AKS ALL

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TASK 53-11-02-420-801

3. Cargo Door Scuff Plate - Installation

A. References

Reference	Title
20-30-88 P/B 201	AIRPLANE STRUCTURE CLEANING SOLVENTS (Series 88) - MAINTENANCE PRACTICES
51-31-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES
SOPM 20-41-05	Application of Corrosion Inhibiting Compounds
SOPM 20-50-19	General Sealing

B. Consumable Materials

Reference	Description	Specification
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A50250	Sealant - P/S 870 Class B-1/2 Corrosion Inhibitive Sealant	BMS5-95 Class B-1/2
A50419	Sealant - Pressure And Environmental-Chromate, Type I, Class B-2	BMS5-95 Type I Class B-2
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C50033	Chromated Conversion Coating for Aluminum - Alodine 1200	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating) (Formerly 598-5002 Green Strippable Coating)	BAC5000
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partail Coverall Film)	
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1
G50734	Tape - Flame Retardant Hi-Tak (Av-DEC - HI-TAK HT3935-7FR-XXX)	

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door



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D. Procedure

SUBTASK 53-11-02-370-001

- (1) Apply Alodine 1200 coating, C50033 and one layer of primer, C00259 to the exposed metal surfaces of the outer skin that will be below the scuff plates.

SUBTASK 53-11-02-420-001

- (2) Install the scuff plate [7].

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.

- (a) Clean all mating surfaces with solvent, B00184 or solvent, B00666 (AIRPLANE STRUCTURE CLEANING SOLVENTS (Series 88) - MAINTENANCE PRACTICES, PAGEBLOCK 20-30-88/201).
- (b) Apply one layer of BMS 3-23, corrosion inhibiting compound, G00009 to the surface of the structure.
- (c) Install the gasket [9] as follows:
 - 1) Install the gasket [9] until its outboard edge aligns with the outboard edge of the holes on the scuff plate [7].
- (d) Install the HI-TAK Tape, G50734 [10] as follows:
 - 1) Install the forward edge HI-TAK Tape, G50734 [10] to align with the forward edge holes on the scuff plate [7].
 - 2) Install the inboard edge HI-TAK Tape, G50734 [10] to align with the inboard edge holes of the scuff plate [7].
 - 3) Install the aft edge HI-TAK Tape, G50734 [10] to align with the aft edge holes on the scuff plate [7].
 - 4) Install the middle strip HI-TAK Tape, G50734 [10] on the center of the rail.
NOTE: The HI-TAK Tape, G50734 [10] can hang along the center of the scuff plate [7].
- (e) Install the scuff plate [7] in its position.
- (f) Install the screws [8] that attach the scuff plate [7] to the structure.
 - 1) Apply BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 Class B-2 to the screws [8].
 - 2) Torque the screws [8] to an 18 in-lb (2 N·m) to 22 in-lb (2 N·m).

SUBTASK 53-11-02-420-003

- (3) Install the forward and aft scuff plates [2].



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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.

- (a) Clean all mating surfaces with solvent, B00148 or solvent, B00666(AIRPLANE STRUCTURE CLEANING SOLVENTS (Series 88) - MAINTENANCE PRACTICES, PAGEBLOCK 20-30-88/201).
- (b) Apply Alodine 1200 coating, C50033 and one layer of primer, C00259 to the exposed metal surfaces of the outer skin that will be below the scuff plates [2].
- (c) Apply one layer of BMS 3-23, corrosion inhibiting compound, G00009, Type II to the structure and the skin area. SOPM 20-41-05.
- (d) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (SEALS AND SEALING - MAINTENANCE PRACTICES, PAGEBLOCK 51-31-00/201. Preferred AC962-73C peelable parting agent, G50365.
 - 1) Optional Valspar 4A-183 green strippable coating, G02185.
 - 2) Optional AZ-534-2B peelable parting agent, G50366.
 - 3) Optional AZ 634-2 peelable parting agent, G50367.
 - 4) Optional Rexco Partail Coverall Film peelable parting agent, G50368.
 - 5) Optional temporary coating, G50369.
 - 6) Optional Frekote 710-NC non-peelable parting agent, G50313.
- (e) Apply a fay surface seal between the skin and the forward and aft scuff plate [2] with BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 class B-2. SOPM 20-50-19.
- (f) Install the forward and aft scuff plate [2] in its position.
- (g) Install the screws [3] that attach the scuff plate [2] to the structure.
 - 1) Apply BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 to the screws [3].
 - 2) Torque screws [3] to an 18 in-lb (2 N·m) to 22 in-lb (2 N·m).
- (h) Install the filler scuff plates [1].

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.

- (i) Clean all mating surfaces with solvent, B00148 or solvent, B00666 (AIRPLANE STRUCTURE CLEANING SOLVENTS (Series 88) - MAINTENANCE PRACTICES, PAGEBLOCK 20-30-88/201).
- (j) Bond the filler scuff plate [1] to the structure with BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419. SOPM 20-50-19.

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SUBTASK 53-11-02-420-002

- (4) Install the scuff plate [4].

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.

- (a) Clean all mating surfaces with solvent, B00148 or solvent, B00666 (AIRPLANE STRUCTURE CLEANING SOLVENTS (Series 88) - MAINTENANCE PRACTICES, PAGEBLOCK 20-30-88/201).
- (b) Apply one layer of BMS 3-23, corrosion inhibiting compound, G00009, Type II to the structure and the skin area. SOPM 20-41-05.
- (c) Install the inboard edge of the gasket [9] to align with the inboard edge holes on the scuff plate [4].
- (d) Install the filler [6].
 - 1) Bond the rubber filler to the structure with BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 Class B-2.
- (e) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (SEALS AND SEALING - MAINTENANCE PRACTICES, PAGEBLOCK 51-31-00/201. Preferred AC962-73C peelable parting agent, G50365.
 - 1) Optional Valspar 4A-183 green strippable coating, G02185.
 - 2) Optional AZ 534-2B peelable parting agent, G50366.
 - 3) Optional AZ 634-2 peelable parting agent, G50367.
 - 4) Optional Rexco Partail Coverall Film peelable parting agent, G50368.
 - 5) Optional temporary coating, G50369.
 - 6) Optional Frekote 710-NC non-peelable parting agent, G50313.
- (f) Apply BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 to the scuff plate [4] around the rubber filler [6].
SOPM 20-50-19
- (g) Apply a fay surface seal between the skin and the scuff plate [4] with BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419. SOPM 20-50-19
- (h) Install the scuff plate [4] in its position.
- (i) Install the screws [5] that attach the scuff plate [4] to the structure.
 - 1) Apply BMS 5-95, P/S 870 Class B-1/2 sealant, A50250 or sealant, A50419 to the screws [5].
 - 2) Torque the screws [5] to an 18 in-lb (2 N·m) to 22 in-lb (2 N·m).

SUBTASK 53-11-02-390-001

- (5) Remove excess sealant from the gap and the edge after squeeze-out has stopped.

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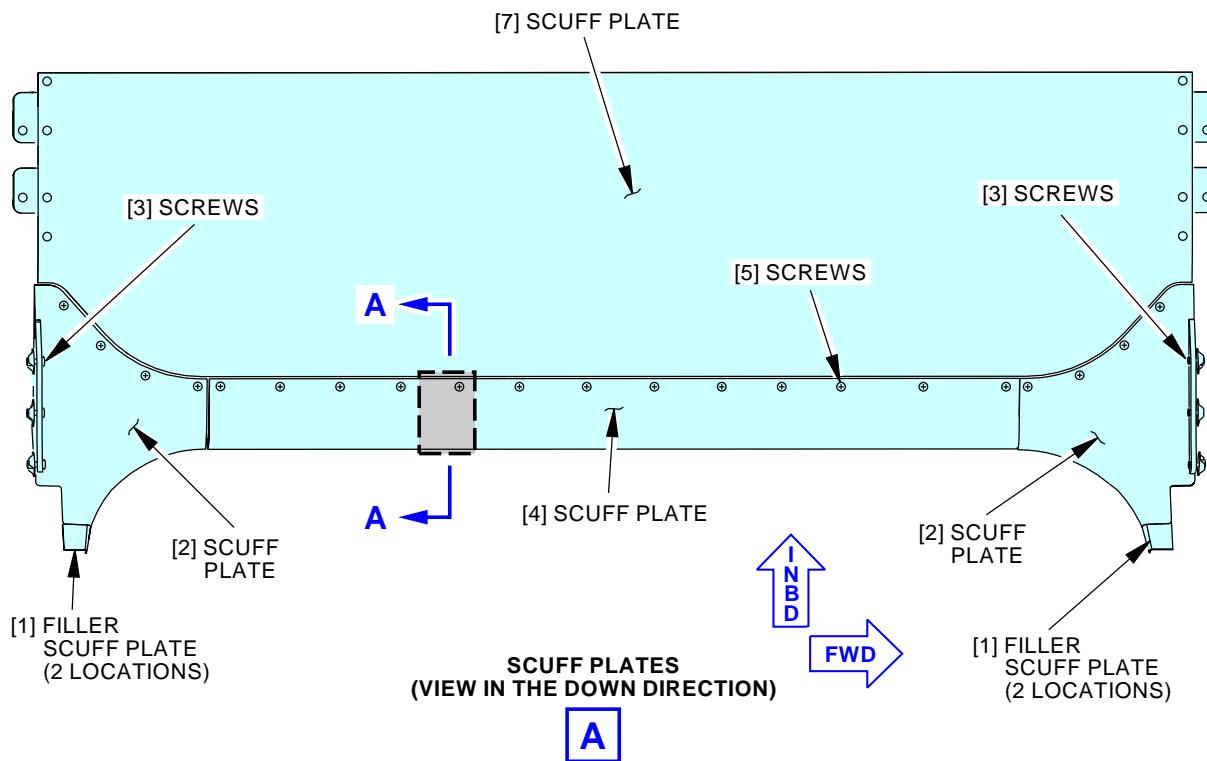
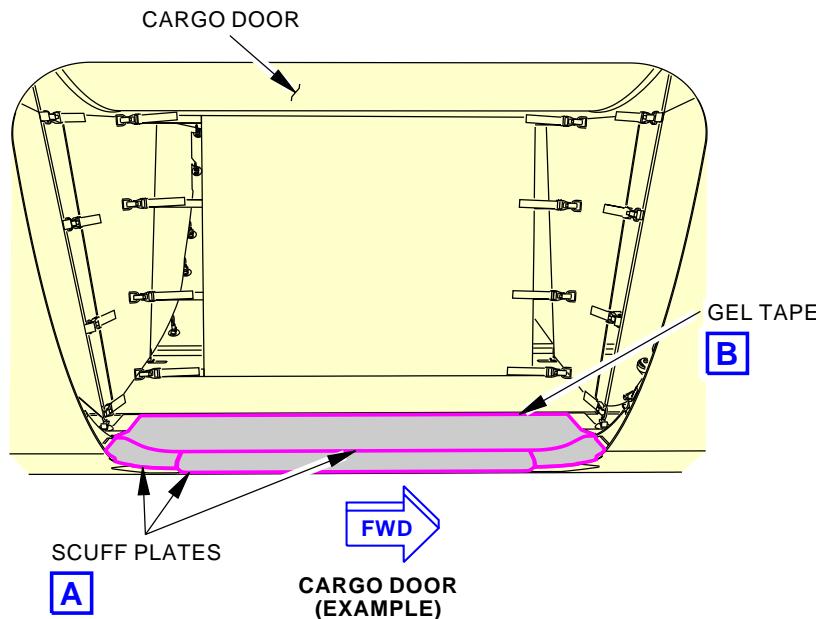
SUBTASK 53-11-02-390-002

- (6) Apply 3M EC-3587B compound, A01024 to the gaps and fastener recesses common to the door seal, as follows:
 - (a) Clean areas to be filled with solvent, B00148 or solvent, B00666.
 - (b) Fill the gaps and fastener recesses that are common to the door seal with 3M EC-3587B compound, A01024 and fair flush with adjacent surfaces.
 - (c) Sand the filled areas smooth and flush with adjacent surfaces.

———— END OF TASK ————

EFFECTIVITY
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Cargo Door Scuff Plate Installation
Figure 401/53-11-02-990-801 (Sheet 1 of 2)

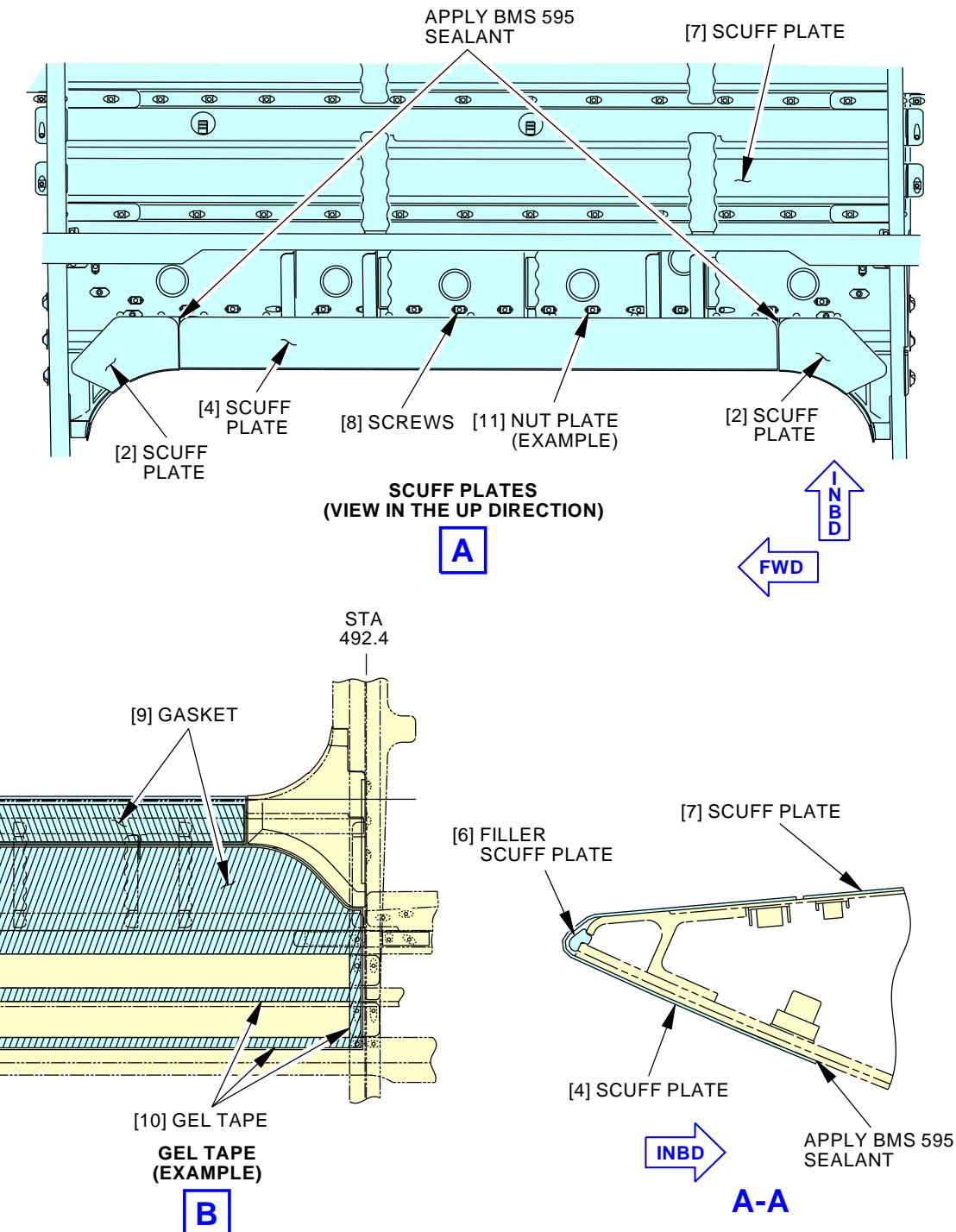
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Cargo Door Scuff Plate Installation
Figure 401/53-11-02-990-801 (Sheet 2 of 2)

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FRAMES AND BULKHEADS CORROSION PREVENTION - MAINTENANCE PRACTICES

1. General

- A. This procedure contains 7 tasks:
 - (1) Corrosion Prevention of the Crown Frames, Stringers and Skin.
 - (2) Corrosion Prevention of the Lower Lobe Structure.
 - (3) Corrosion Prevention of the Galley and Lavatory Areas.
 - (4) Corrosion Prevention of the Main Gear Wheel Well and Keel Beam.
 - (5) Corrosion Prevention of the Nose Gear Wheel Well.
 - (6) Corrosion Prevention of the Door Openings.
 - (7) Corrosion Prevention of the Upper Lobe Frames, Stringers and Skin.

TASK 53-11-37-600-811

2. Crown Frames, Stringers and Skin - Corrosion Prevention

Figure 201

A. General

- (1) The fuselage is of semi monocoque construction utilizing aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated concurrently with fuselage structure.
- (2) The stringers, frames and skins have been found susceptible to corrosion due to moisture entrapment between the skin and insulation blankets. Added to this moisture spillage, condensation or moisture through open doors running along frames or stringers collecting at some dammed location contribute to corrosion. Corrosion can readily start where protective finishes have been broken or deteriorated.
- (3) Treatment of the interior structure should be accomplished at the same time as longitudinal lap splices are treated or whenever access is gained to expose the frame/stringer/skin structure. For lap splices, refer to INSPECTION AND DETECTION, SUBJECT 51-00-51.
- (4) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (5) Delamination of the waffle doublers on the crown and side skin panels has been reported. If left untreated, delaminated doublers may promote corrosion and cracking of the skin interior and doublers.
- (6) Stress corrosion has been attributed to reported three cracks in the right side BS540 bulkhead forging refer to Figure 201 (Sheet 1).
- (7) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION

EFFECTIVITY	AKS ALL
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(Continued)

Reference	Title
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-37-610-061

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-009

- (2) Corrosion Inspection/Removal

- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to SRM 737-678 for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the first opportunity consistent with the maintenance schedule (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

SUBTASK 53-11-37-610-010

- (3) Application of Corrosion Inhibitors

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-011

- (4) Prevention Treatment

- (a) Maintenance Prevention



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- 1) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
 - 2) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
 - 3) Open plugged drains.
 - 4) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
 - 5) In all areas, except where indicated, apply a coat of epoxy primer, C00259 primer to inboard flanges of stringers and allow to dry thoroughly.
 - 6) Allow solvent to evaporate before reinstalling insulation blankets.
 - 7) Reinstall blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (b) Improved Corrosion Protection
- 1) On airplanes with sealant applied to inboard flanges of stringers, apply a coat of sealant, A00247, class F, by spray, brush or roller coat to inboard face of stringer flanges and edges of frames where contacted by the insulation blanket, in areas above the window belt, between stations 259.5 and 1015. On other airplanes stringers may have either sealant or an additional coat of Type 1 (yellow) primer, C00259.
 - 2) Apply corrosion inhibiting compound, G00009 to all exposed structure. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for methods of application of corrosion inhibiting compound, G00009.
 - 3) On some airplanes operators may wish to rework insulation blankets by removing the sewn cap strip from the lower edge of the blanket and continuously penetrate the stitch sealing. The blankets to be reworked must be fabricated with water-repellent fillers. All 737 airplanes are known to be delivered utilizing water-repellent fillers.
 - 4) Some airplane have had the tightly sealed covers replaced with unsealed covers to permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
 - 5) The sealant, A00247 class F, is applied by spray, brush or roller coating to the inner flanges of stringers and edges of frames where contacted by the insulation blankets above the window belt, between stations 259.5 and 1015. Airplane stringers may have sealant, A00247 or an additional coat of yellow primer, C00259.

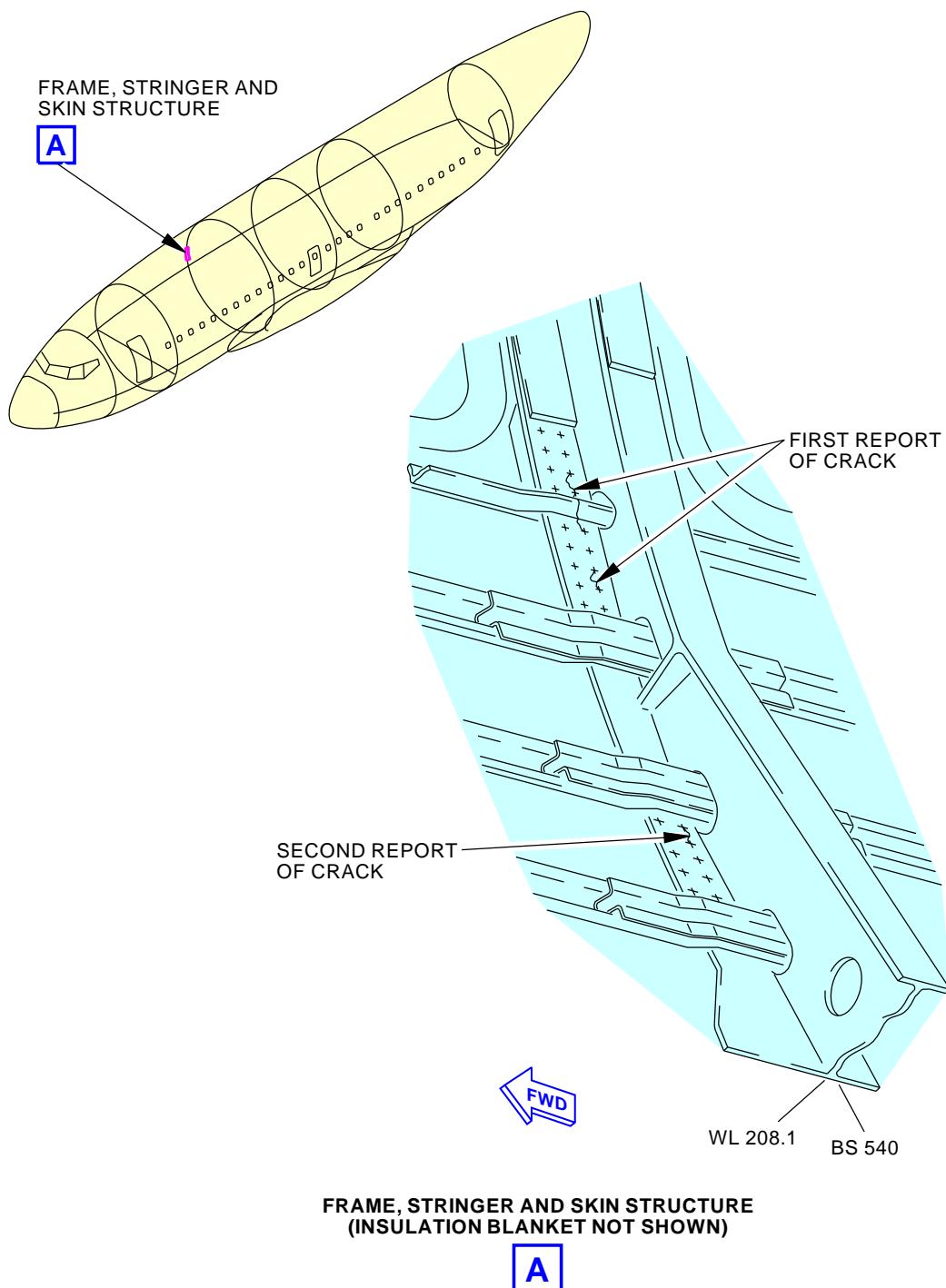
SUBTASK 53-11-37-610-012

- (5) Frequency of Application
- (a) Periodic inspection is required to areas identified susceptible to corrosion and should be consistent to the schedules identified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
 - (b) Periodic application of corrosion inhibiting compound, G00009 compounds is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— END OF TASK ———

EFFECTIVITY	AKS ALL
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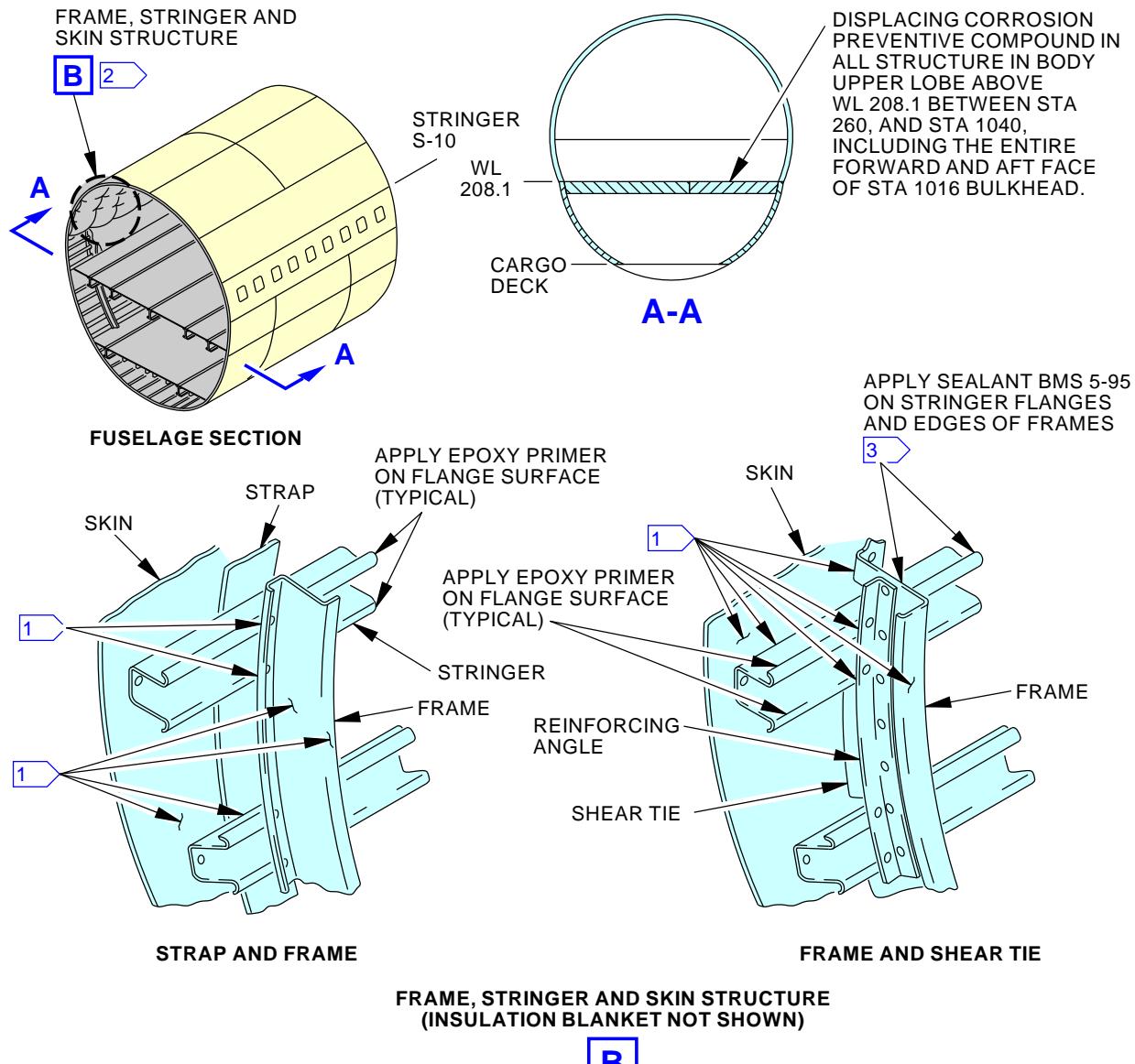
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Crown Frames, Stringers and Skin
Figure 201/53-11-37-990-811 (Sheet 1 of 2)

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- 1** APPLY BMS 3-23 TO ALL EXPOSED STRUCTURE
- 2** WHEN INSULATION BLANKETS ARE REINSTALLED, ENSURE THAT OUTBOARD SURFACE OF UPPER BLANKET OVERLAPS LOWER BLANKET.
- 3** IN AREAS ABOVE THE WINDOW BELT BETWEEN STA 259.5 AND STA 1015 WHERE BLANKETS CONTACT STRINGER FLANGES AND EDGES OF FRAMES. BETWEEN BODY STATIONS 540 AND 1016 WHERE STRINGER SOUND DAMPING CAPS ARE USED, SEALANT IS NOT REQUIRED.

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Crown Frames, Stringers and Skin
Figure 201/53-11-37-990-811 (Sheet 2 of 2)

EFFECTIVITY	AKS ALL
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TASK 53-11-37-600-812

3. Lower Lobe Structure - Corrosion Prevention

Figure 202

A. General

- (1) The fuselage is of semimonocoque construction utilizing aluminum skins, circumferential frames and longitudinal stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints. The floor beams act as tension ties across the frames. In the lower lobe area, shear ties from the skin to the frame are used between stringers with an inner angle on the frame.
- (2) The lower lobe structure including stringers, frames, shear ties, faying surfaces at doublers and straps, etc., are susceptible to corrosion due to moisture accumulation, moisture laden insulation blankets, cargo spillage, toilet effluent leakage and environmental contaminants. The lower lobe areas described herein include the cargo compartments, bilge areas and the electronic compartment.
- (3) To help clean out contamination in the lower lobe, dams divide the bilge into compartments for optional hose out operations (Figure 202 (Sheet 3)). But on some airplanes, these dams have foam blocks which can become soaked with moisture and cause corrosion.
- (4) Some lower lobe doublers came apart from the skin, and corrosion and cracks occurred on airplanes with 1400 flight hours or more. The damaged areas were between Stringers 26L and 26R under the forward cargo compartment, BS 360-540 and between Stringers 25L and 25R under the aft cargo compartment, BS 727-1016.
- (5) At the nose wheel well, the three hinge bracket supports for the wheel well doors on the left and right side have pockets that can catch moisture.
- (6) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (7) Treatment of the areas under galleys and lavatories is described in Figure 203.
- (8) Much corrosion and separation of doublers has been reported in the lower lobe. Areas where corrosion is of particular concern is from BS 260 to BS 360, stringers S-19 left to S-19 right.
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00032	Coating - Protective Enamel, General Use	BMS10-60 Type I

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(Continued)

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11 Type II
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
100	Lower Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-37-610-013

- (1) Make the regular inspections of INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop of find the start of corrosion. Inspect the areas beneath the forward and aft cargo floors. Skin bulges, missing fasteners, or white powdery deposits are signs of corrosion.

SUBTASK 53-11-37-610-014

WARNING: DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (2) If you find corrosion (skin bulges, missing fasteners or large amounts of white deposits at the fastener heads or faying surfaces), refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-11-37-610-015

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-016

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the first opportunity consistent with the maintenance schedule.

NOTE: The treatment of internal structure described above should be made at first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in SRM 737-678.

SUBTASK 53-11-37-610-017

- (5) The corrosion inhibiting compound, G00009 should not be used in the vicinity of oxygen system components. The suggested protection system for areas near oxygen system components is as follows:

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- (a) Clean corrosion and repair affected area per the SRM 737-678.
- (b) Chemical treat bare aluminum surfaces.
- (c) Apply one coat of green primer, C00259 Type 1.
- (d) Apply one coat of yellow primer, C00259 type 1.
- (e) Apply coating, C00260, type 2 epoxy or coating, C00032 polyurethane enamel top coat.

SUBTASK 53-11-37-610-018

(6) Prevention Treatment

- (a) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
- (b) Remove sidewall lining and insulation blankets in the cargo compartment and beneath the upper lobe entry and cargo doors to expose frame, stringer, doublers and skin.
- (c) Remove floor panels to gain access to bilge areas, if required.
- (d) Remove ceiling lining for access to main deck floor beams and intercostals.
- (e) Open plugged drains.
- (f) Make sure that all drain paths are clear at the frames and stringers in the airframe lower lobe and stringer ends at station bulkhead.
- (g) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (h) Apply a coat of primer, C00259 primer to the inboard flange surfaces of stringers and allow to dry thoroughly.
- (i) Replace or repair broken or damaged leveling compounds used for drainage.
- (j) The chromate-loaded sealant, A00247, class F, is applied to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (k) Apply corrosion inhibiting compound to all exposed structure under the cargo floor and to the sidewalls beneath the upper lobe entry and cargo doors. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Earlier installations utilizing silicone rubber loops may deteriorate because of exposure to hydrocarbons such as corrosion inhibitors and should be replaced with the nylon twine.

- (l) Allow solvent to evaporate before reinstalling insulation blankets.
- (m) Install blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-019

(7) Frequency of Application

- (a) Periodic inspection is required to areas identified susceptible to corrosion and should be consistent to the schedules identified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.

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- (b) Periodic application of corrosion inhibiting compound, G00009 compounds is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— END OF TASK ————

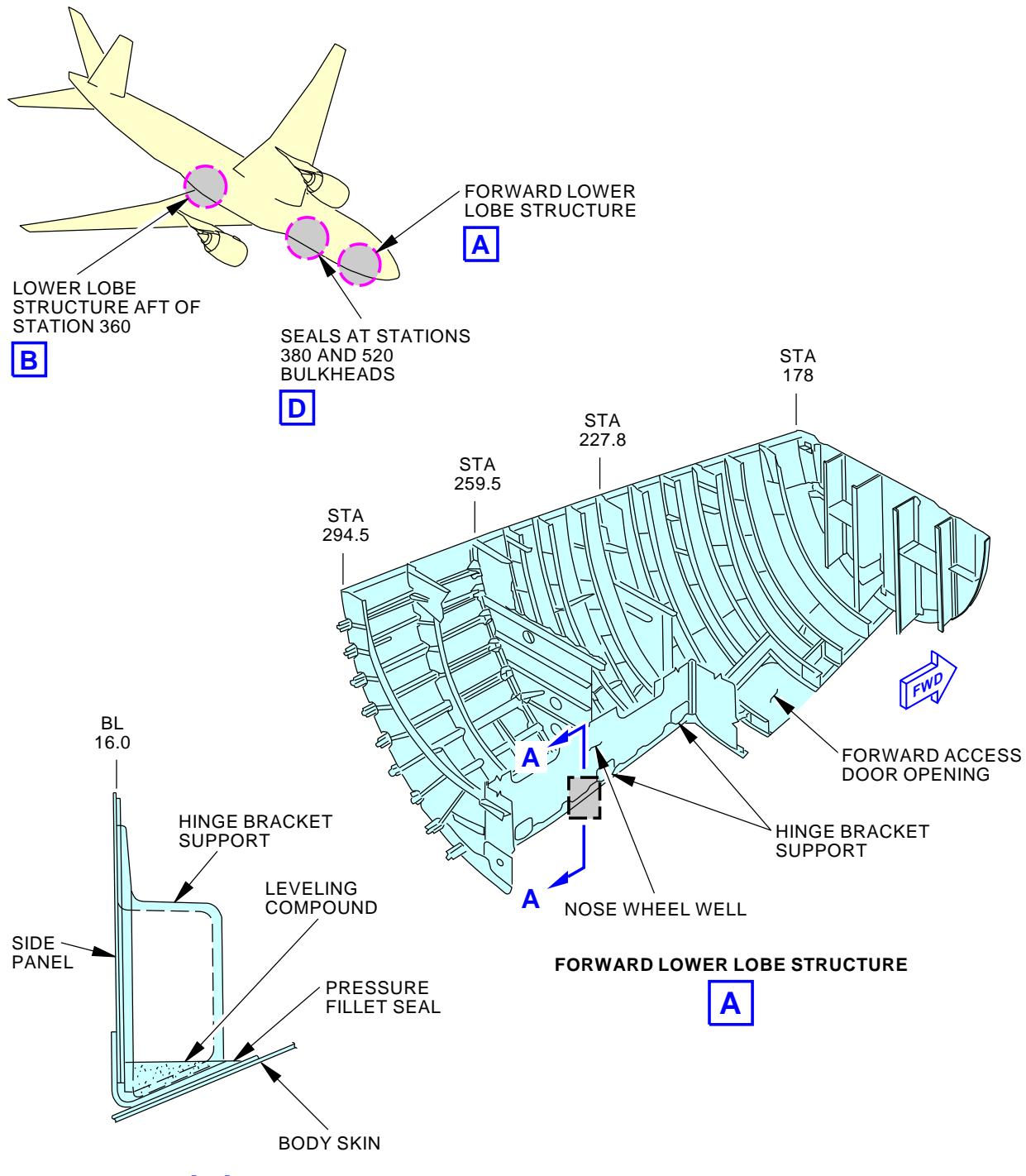
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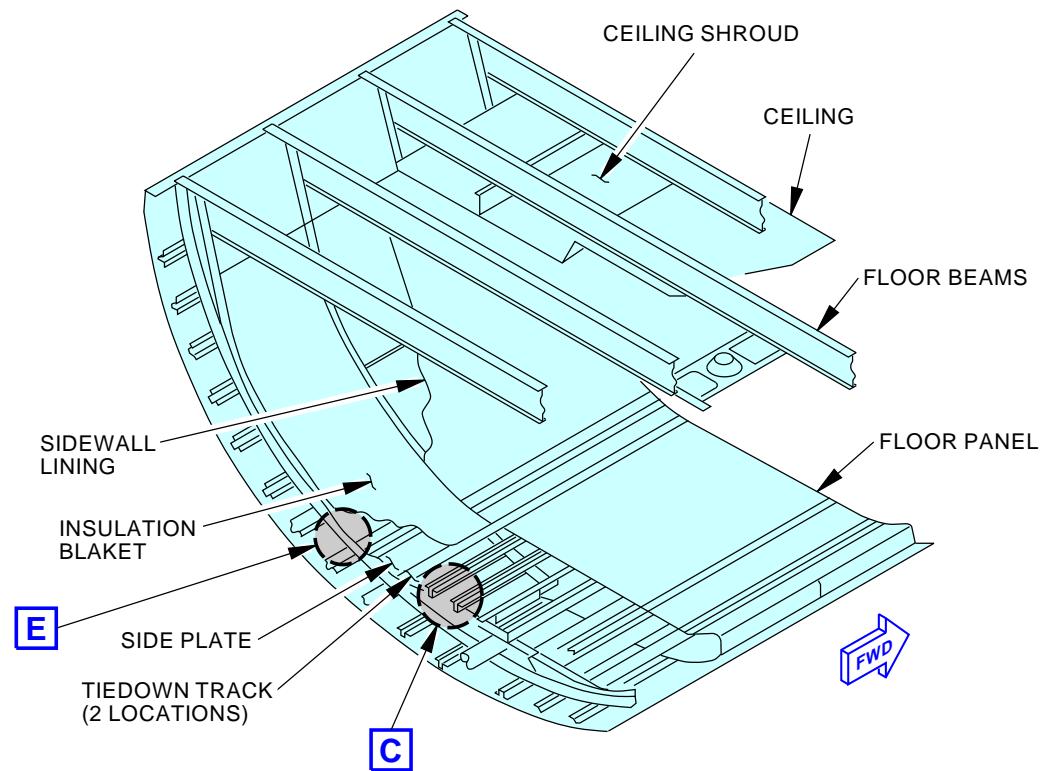
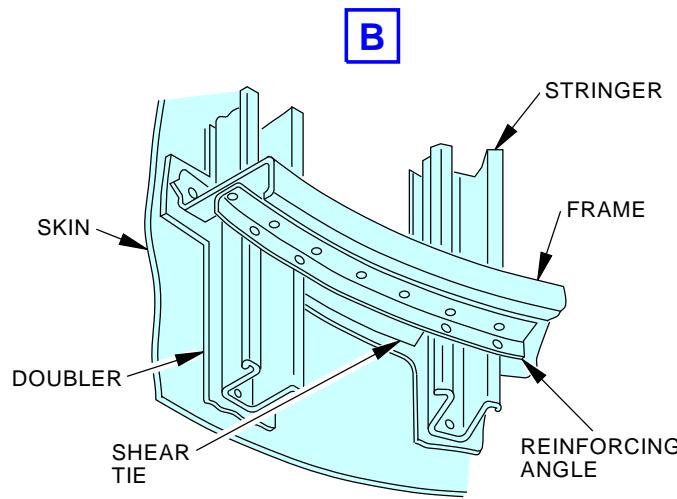


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Lower Lobe Structure
Figure 202/53-11-37-990-803 (Sheet 1 of 4)

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LOWER LOBE STRUCTURE AFT

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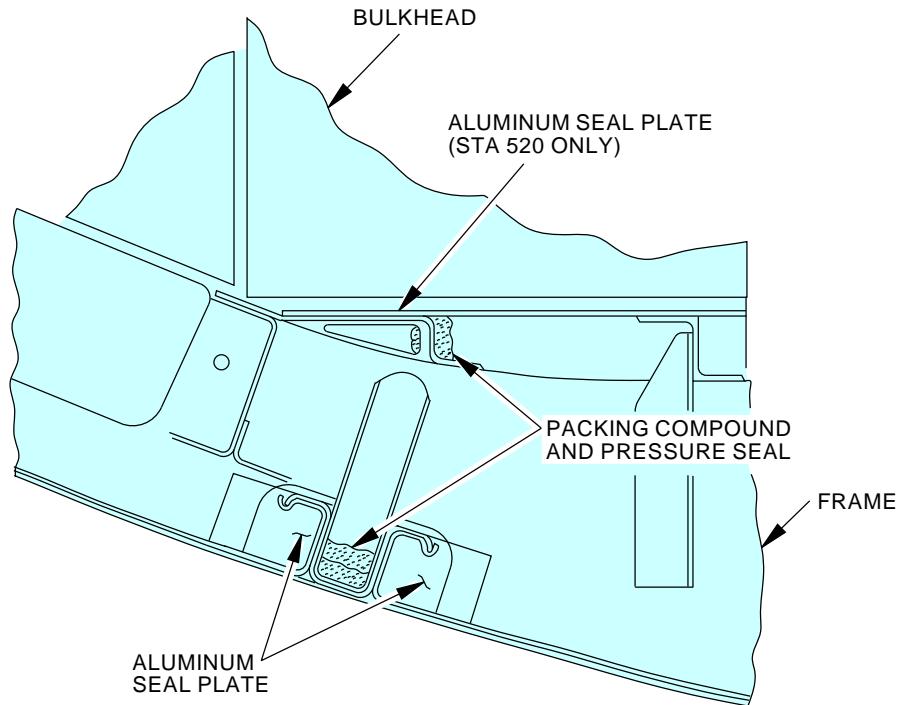
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Lower Lobe Structure
Figure 202/53-11-37-990-803 (Sheet 2 of 4)

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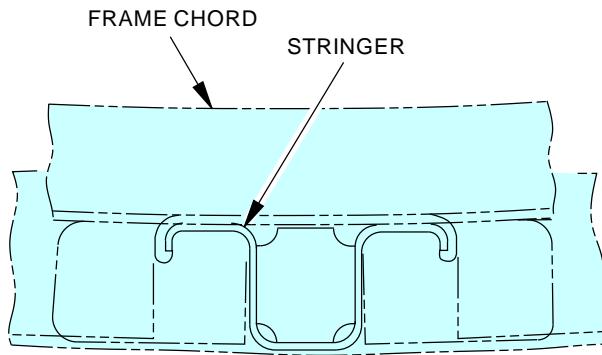


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SEALS AT STATIONS 380 AND 520 BULKHEAD

D



DAMS FOR HOSE-OUT OPTION

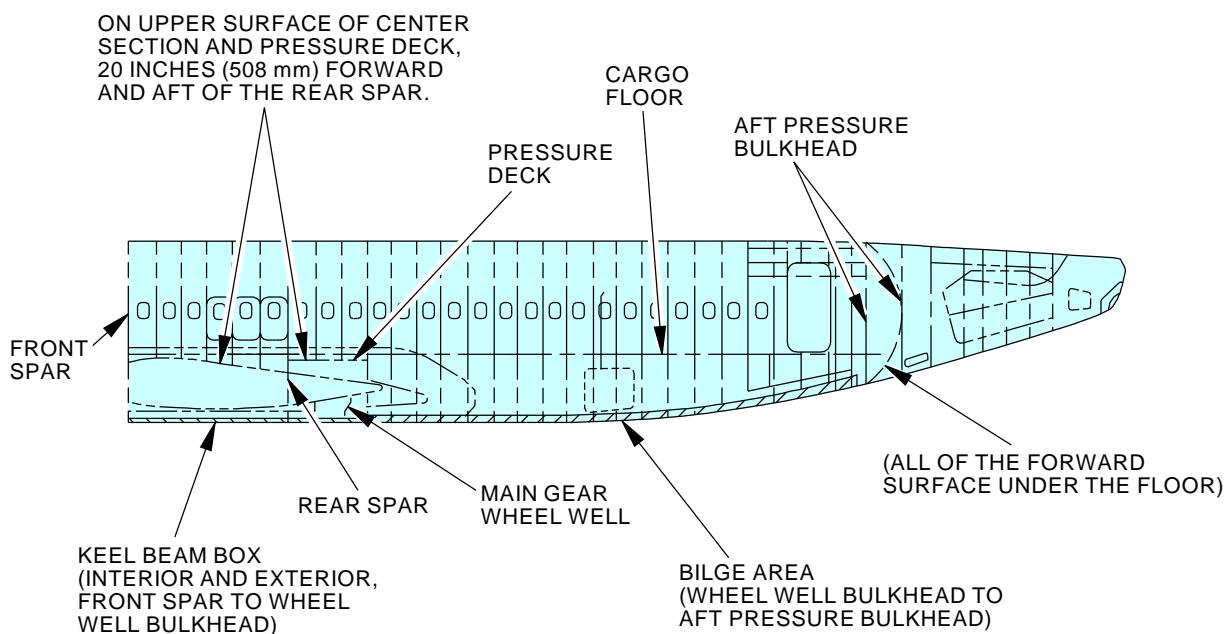
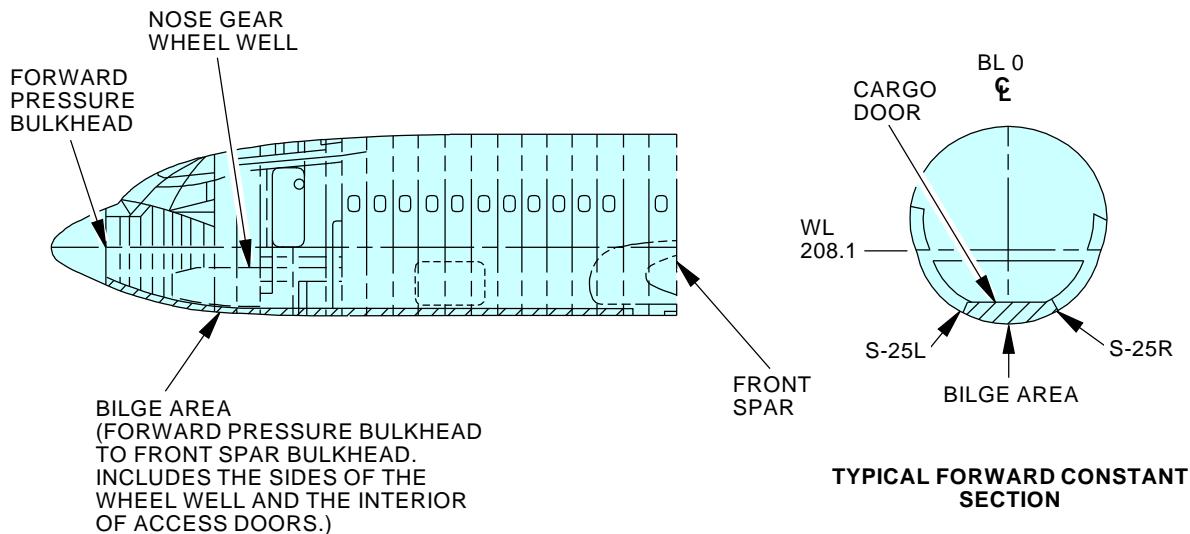
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Lower Lobe Structure
Figure 202/53-11-37-990-803 (Sheet 3 of 4)

EFFECTIVITY
AKS ALL

53-11-37



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Lower Lobe Structure
Figure 202/53-11-37-990-803 (Sheet 4 of 4)

EFFECTIVITY
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TASK 53-11-37-600-804

4. Galley and Lavatory Areas - Corrosion Prevention

Figure 203

A. General

- (1) Areas under galleys and lavatories are susceptible to corrosion because of spillage of fluids or food. Leakage from plumbing lines also contributes to corrosion. Seat tracks in galley or lavatory areas are particularly susceptible because of exposure to traffic debris and spillage which collect inside the track. Corrosion has also been reported on the forward lavatory bulkhead-to-floor area and door post, aft of the lavatory door.
- (2) Corrosion of the aluminum faced floor panels under galleys and lavatories has been alleviated by using fiberglass faced balsa panels.
- (3) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lie on the skins. Reports of water soaked blankets have been common in these instances.
- (4) Unsealed covers permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
- (5) A water dam and seal has been added to the outboard side of the forward lavatory floor, and between the aft lavatories. Floor drains have been added to the aft lavatories and a drain installation to the forward lavatory.
- (6) For improved corrosion protection, a production change has been made to apply sealant, A00247, class F, to inboard flanges of stringers and to portions of frames that contact insulation blankets.
- (7) Severe corrosion and corrosion cracking have been reported on the lower ten inches of the bulkhead forward face. Corrosion of the bulkhead web can result in severe cracks and rapid cabin depressurization. The corrosion, has been attributed to fluids from galleys and lavatories. A plugged drain hole in the station 1016 frame chord assembly can trap these fluids and thereby accelerate the corrosion process. See Figure 203 for aft pressure bulkhead.
- (8) Apply corrosion inhibiting compound corrosion inhibiting compound, G00009 to wet areas (doorways, galleys and lavatories) of the main cabin Ref. (Figure 203).
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23



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D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-37-610-020

- (1) Periodically examine galley and lavatory areas to detect early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-021

- (2) Where extensive corrosion exists (noticeable skin bulges, missing fasteners, or large amounts of white deposits) refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-11-37-610-022

WARNING: DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-023

- (4) For minor corrosion to minimize the down time of the airplane, the corrosion products should be cleared off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the first opportunity consistent with the maintenance schedule (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

NOTE: The treatment of the internal structure described above should be made at the first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in Structural Repair Manual.

SUBTASK 53-11-37-610-024

- (5) The treatment of seat tracks in the galleys and lavatories should be accomplished per Figure 203.

SUBTASK 53-11-37-610-025

- (6) Prevention Treatment



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- (a) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
NOTE: Preferred access to the floor structure is from the lower lobe.
- (b) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.
- (c) Remove floor panels to gain access to bilge areas.
- (d) Remove insulation blankets and liners (if any) from bulkheads in the immediate area below galleys or lavatories.
- (e) Remove ceiling lining for access to main deck floor beams and intercostals.
- (f) Open plugged drains, if any.
- (g) Clear all drain paths.
- (h) Refinish broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems. Use interior finish system with polyurethane enamel topcoat.
- (i) Replace or repair broken or damaged leveling compounds used for drainage.
- (j) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (k) Apply corrosion inhibiting compound, G00009 water displacing corrosion inhibiting compound to all structures under galleys and lavatories. Exposed structure of bulkheads should also be included. Special efforts should be made to apply the corrosion inhibitor to the top of the floor support structure where moisture may be trapped between the floor panel and floor support. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Silicone rubber used on earlier installations may deteriorate due to exposure to hydrocarbons present in corrosion inhibiting compound and should be replaced with nylon twine.

- (l) Allow solvent in the corrosion inhibitor to evaporate before reinstalling insulation blankets.
- (m) Install blankets so they are taut and so that the outboard surfaces of lower blanket overlap the lower blanket.
- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-026

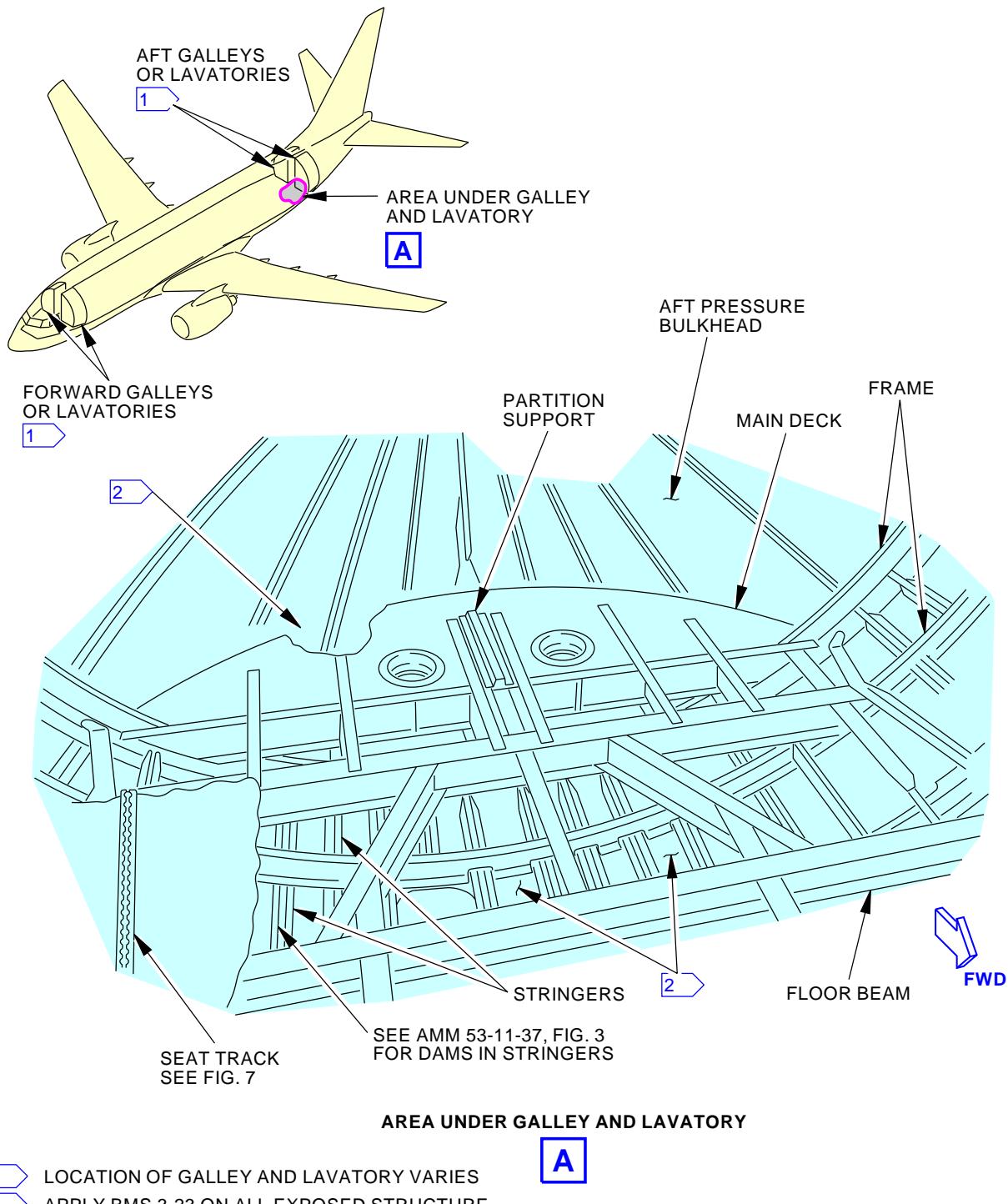
(7) Frequency of Application

- (a) It is recommended that corrosion inhibiting compound, G00009 water displacing corrosion inhibiting compound be applied to the lower lobe structure whenever the area is made accessible, at intervals not to exceed the "D" cneck.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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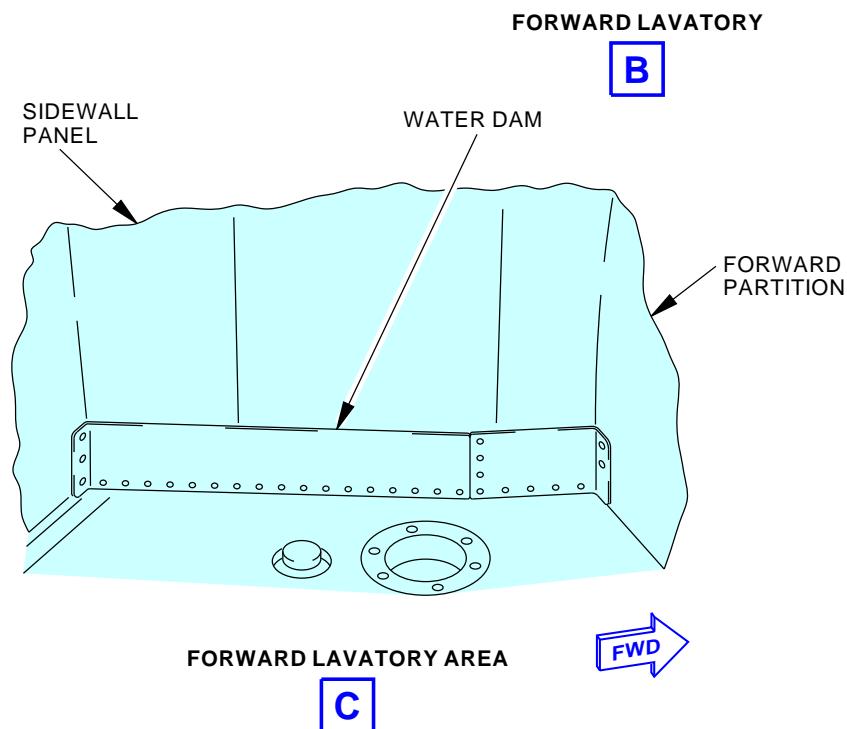
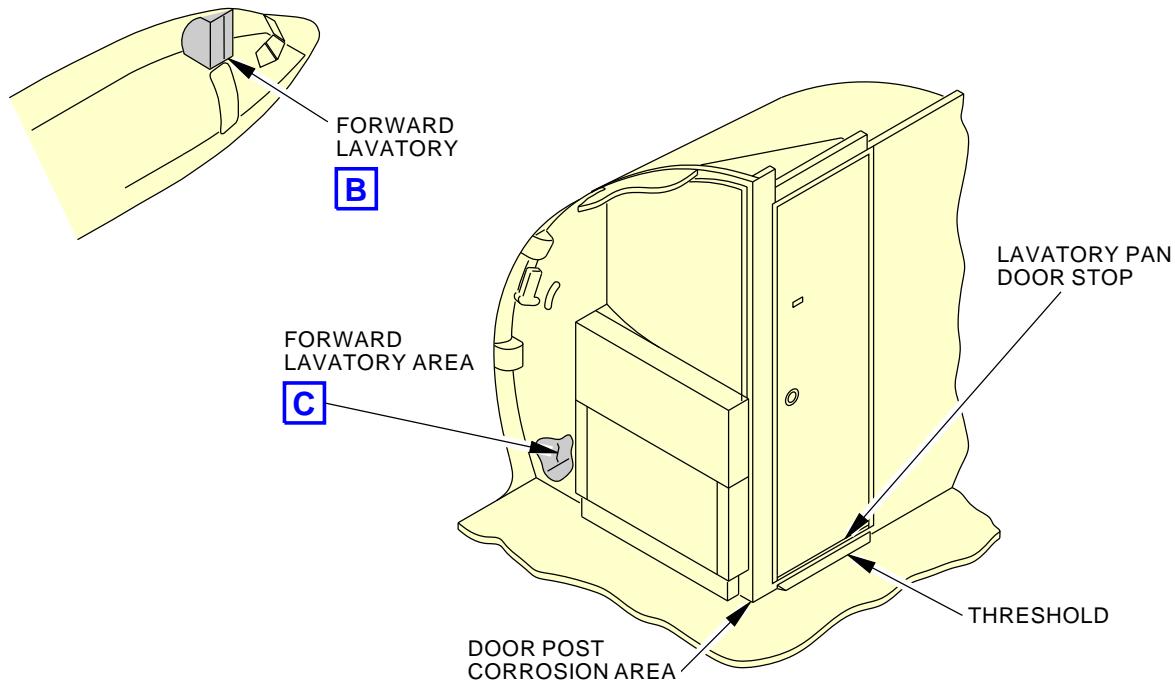
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Galley and Lavatory Areas
Figure 203/53-11-37-990-804 (Sheet 1 of 3)

EFFECTIVITY
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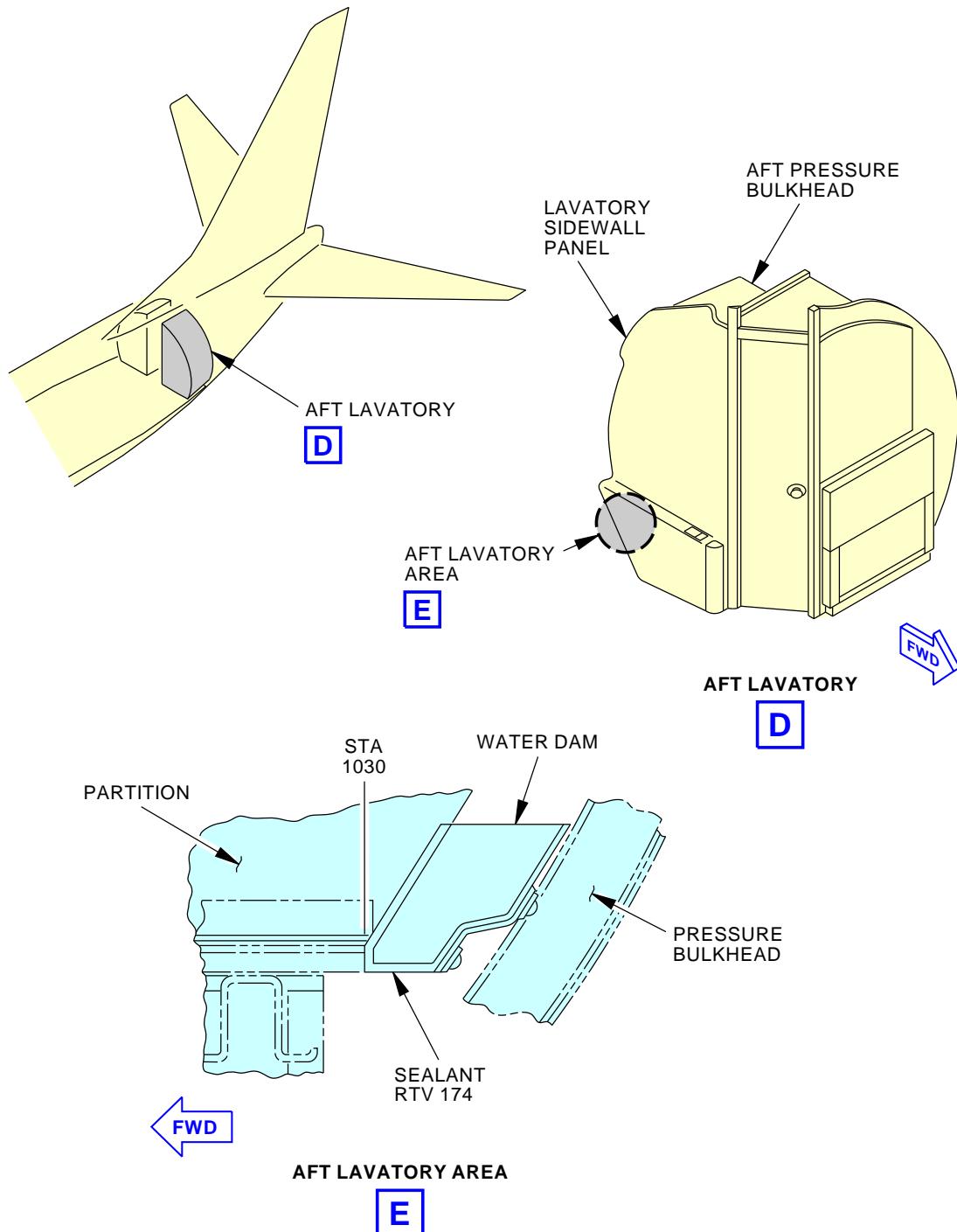


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Galley and Lavatory Areas
Figure 203/53-11-37-990-804 (Sheet 2 of 3)

EFFECTIVITY
 AKS ALL

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Galley and Lavatory Areas
Figure 203/53-11-37-990-804 (Sheet 3 of 3)

EFFECTIVITY	AKS ALL
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TASK 53-11-37-600-805

5. Main Gear Wheel Well and Keel Beam - Corrosion Prevention

Figure 204

A. General

- (1) The main gear wheel well is in the fuselage section aft of the bulkhead at the rear spar of the wing center section. The floor is formed by the wing to body fairing with an opening provided to fit the tire, with the outboard tire providing the closure for the cavity. A keel beam carries the longitudinal stress loads across the cavity. The wheel well in the fuselage extends into the inboard end of the wing trailing edge structure. The wing wheel well houses the greater portion of the landing gear components.
- (2) The surfaces inside the fuselage are exposed to air contaminants and runway splash and are subject to corrosion.
- (3) The wing wheel well should be treated at the same time as the trunnion attach fittings, the landing gear support beam and forward trunnion support structure.
- (4) Stress corrosion cracking has been reported in the horizontal integral ribs of the BS 685 and 706 frames. Cracks occurred at WL192, 202 and 208 on Sta 685 frames and at WL202 on STA 706 frames on both sides of airplanes. Cracks originated at, or passed through holes for fasteners used to attach shear webs to frame ribs. Cracks occurred in frames made from 7079 material.
- (5) Stress corrosion cracks have occurred in the keel beam left and right lower tee chord. They initiated under the splice near the ends of the 7178-T6511 aluminum chords at Sta 743. Corrosion has also occurred between the tee chord and skin.
- (6) Corrosion has been reported on the keel beam lower chord surfaces between STA 520 and STA 540 and aft of STA 727. Stress corrosion cracks have also been reported on the keel beam lower chord at STA 590 and between STA 530 and STA 536.
- (7) Stress corrosion cracking has been reported in the horizontal flange of the forward and aft frame fitting at STA 695. The cracks ran along the line of fasteners common to the stringer S-18A shear beam Figure 204 (Sheet 2).
- (8) Stress corrosion cracks has been reported in both left and right inboard splice tees of the keel beam at the main wheel well aft bulkhead Figure 204 (Sheet 3).
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
29	HYDRAULIC POWER
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23



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D. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

E. Corrosion Prevention

SUBTASK 53-11-37-610-027

(1) General Philosophy

- (a) The basic corrosion prevention philosophy is to make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-028

(2) Corrosion Inspection/Removal

- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads of joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the first opportunity consistent with the maintenance schedule.

SUBTASK 53-11-37-610-029

(3) Application of Corrosion Inhibitors

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.
- (b) Hydraulic tubing, tubing supports and fittings are to be treated per HYDRAULIC POWER, CHAPTER 29.

SUBTASK 53-11-37-610-030

(4) Prevention Treatment

(a) Maintenance Prevention

- 1) At first opportunity consistent with scheduled maintenance activity, corrosion prevention treatment should be accomplished in the wheel well and on the aft keel beam.
- 2) Treatment of the wheel well at the same time as the main gear is recommended.
- 3) Remove runway debris and generally clean the entire wheel well area.
- 4) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.

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- 5) Apply corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surface is recommended.
- 6) Apply water displacing corrosion inhibiting compound to the frames at BS 685 and 706, WL 193 to 208.
- 7) Regrease all grease fittings in the treatment area.
- 8) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

SUBTASK 53-11-37-610-031

(5) Frequency of Application

- (a) Periodic inspection is required to areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— END OF TASK ————

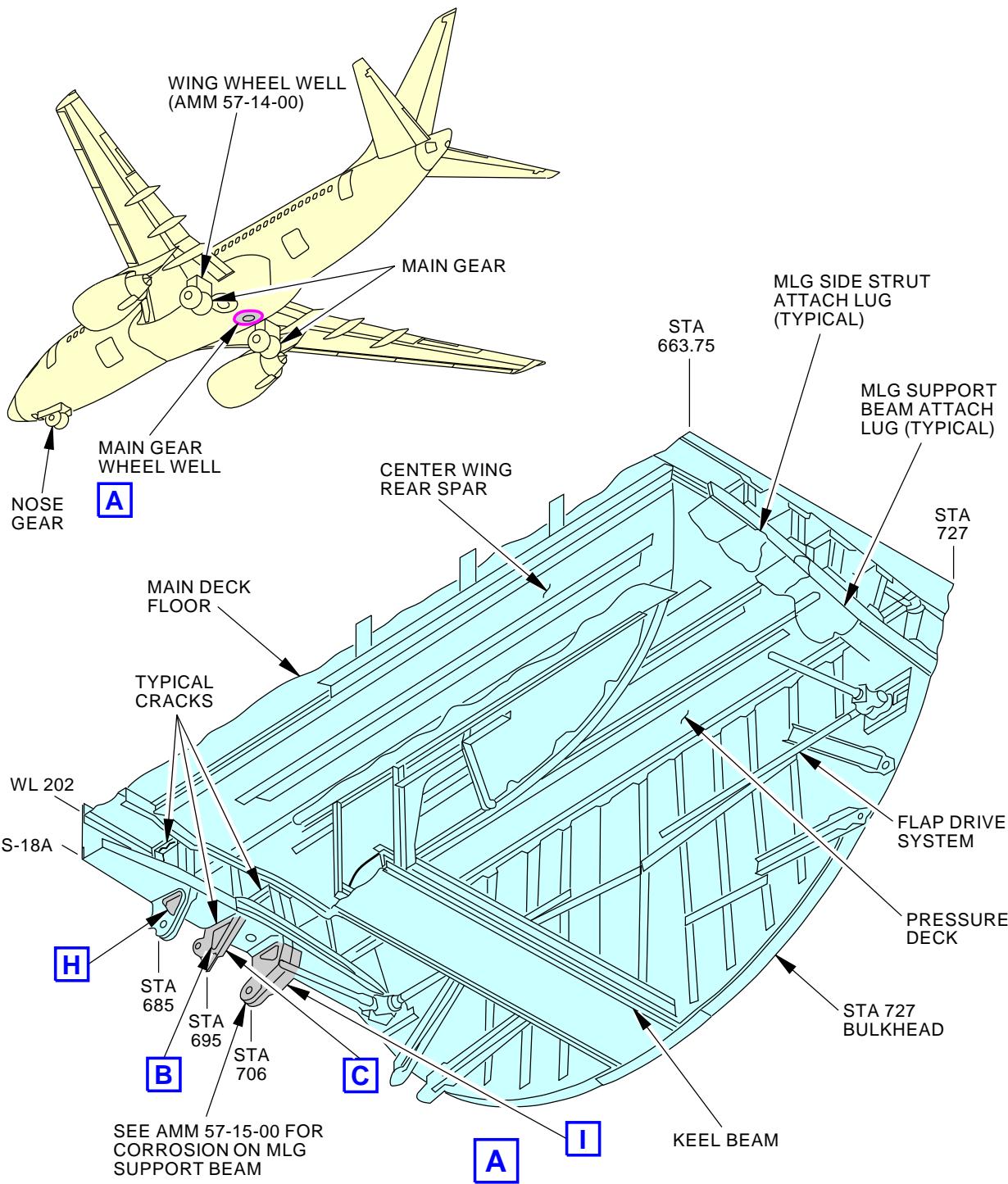
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Main Gear Wheel and Keel Beam
Figure 204/53-11-37-990-805 (Sheet 1 of 5)

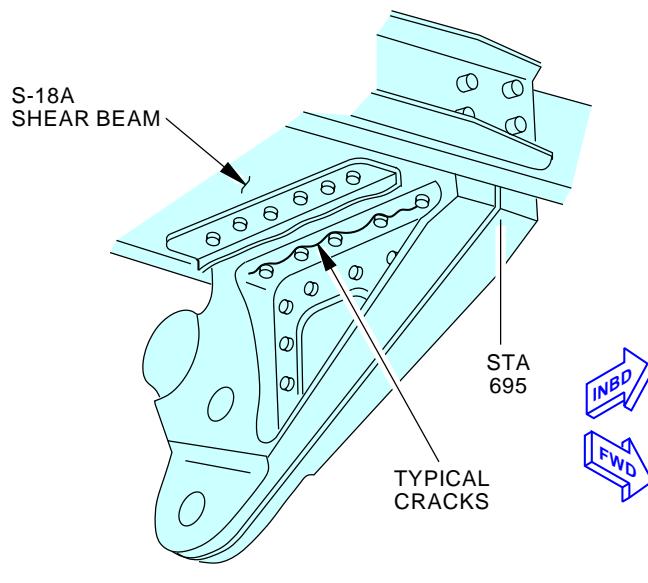
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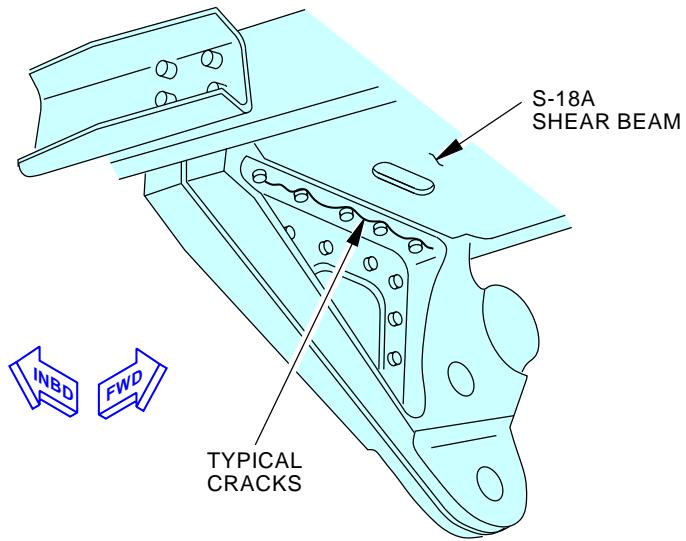
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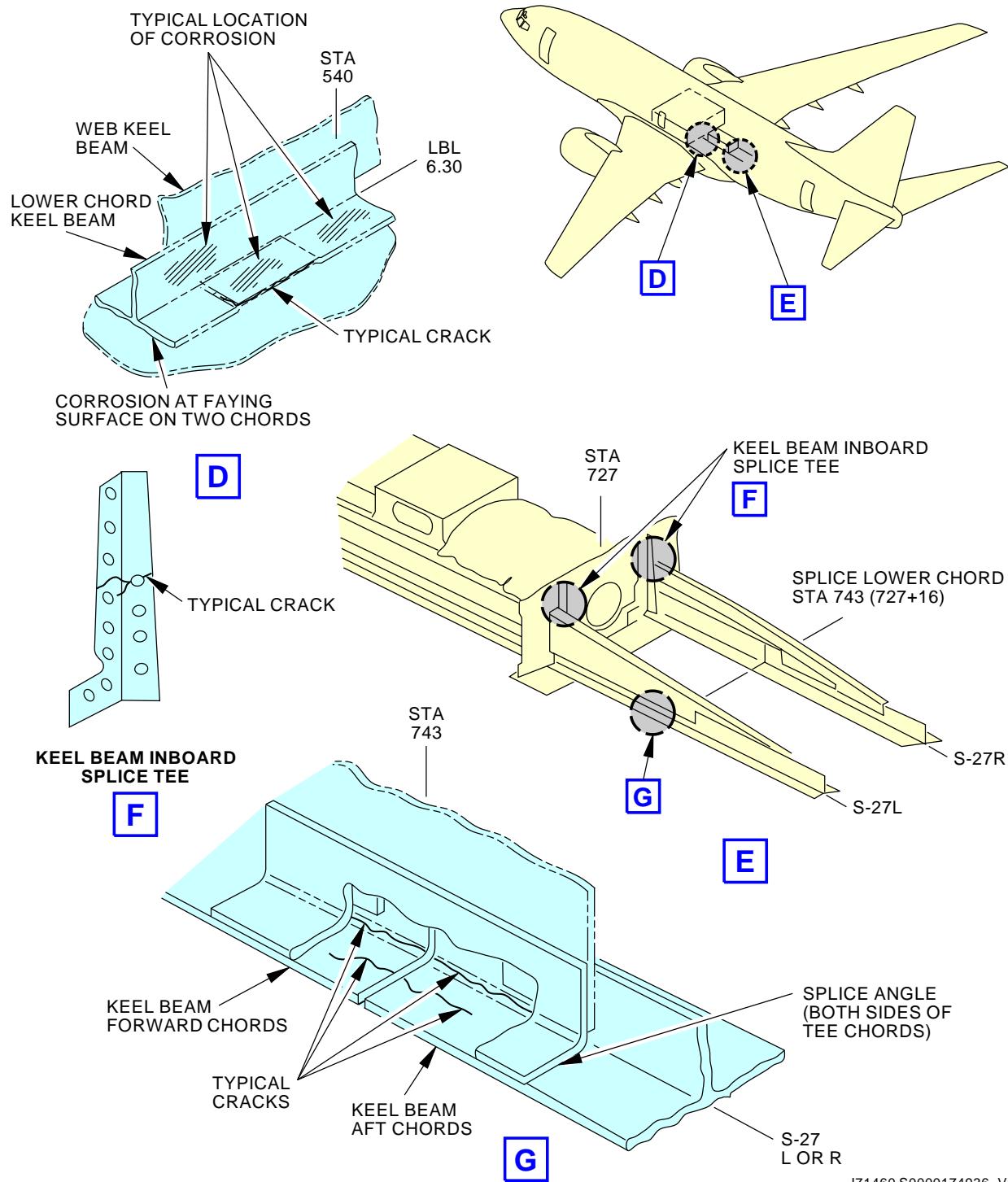
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Main Gear Wheel and Keel Beam
Figure 204/53-11-37-990-805 (Sheet 2 of 5)

EFFECTIVITY
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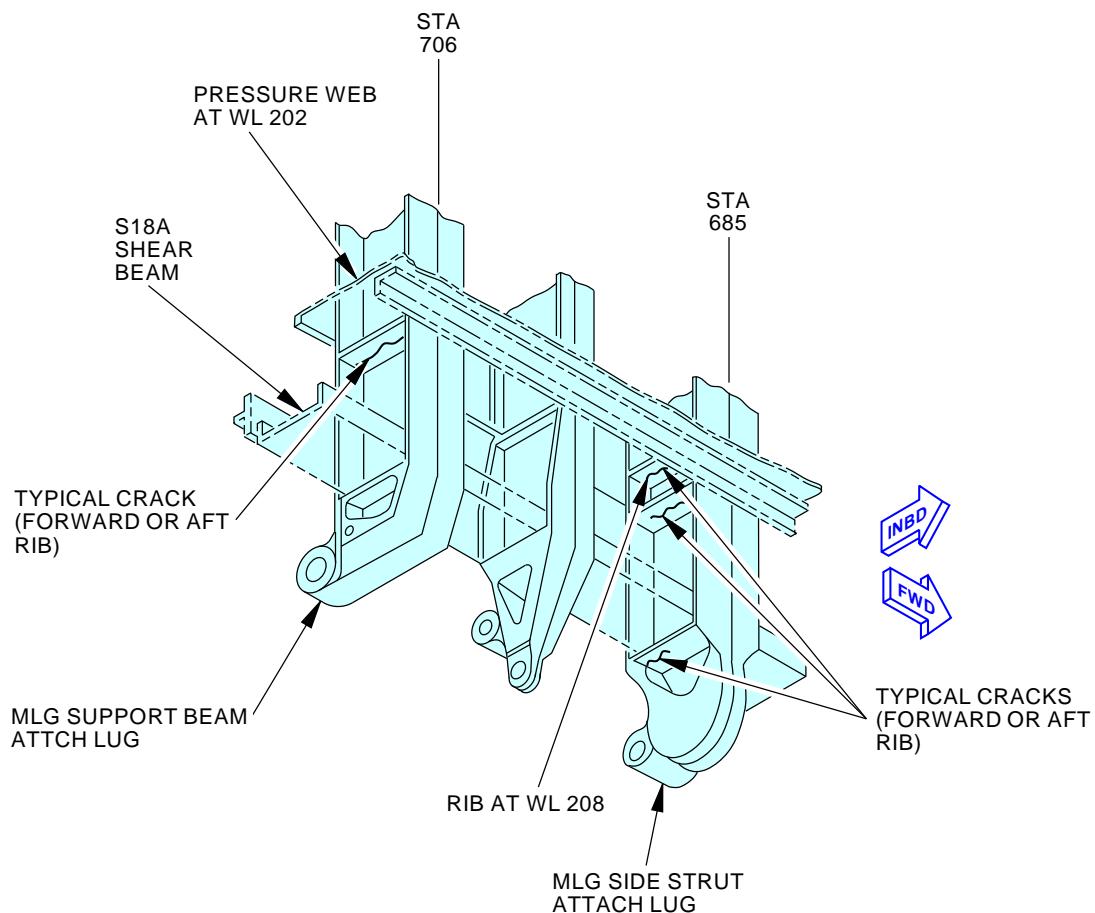
Main Gear Wheel and Keel Beam
Figure 204/53-11-37-990-805 (Sheet 3 of 5)

EFFECTIVITY
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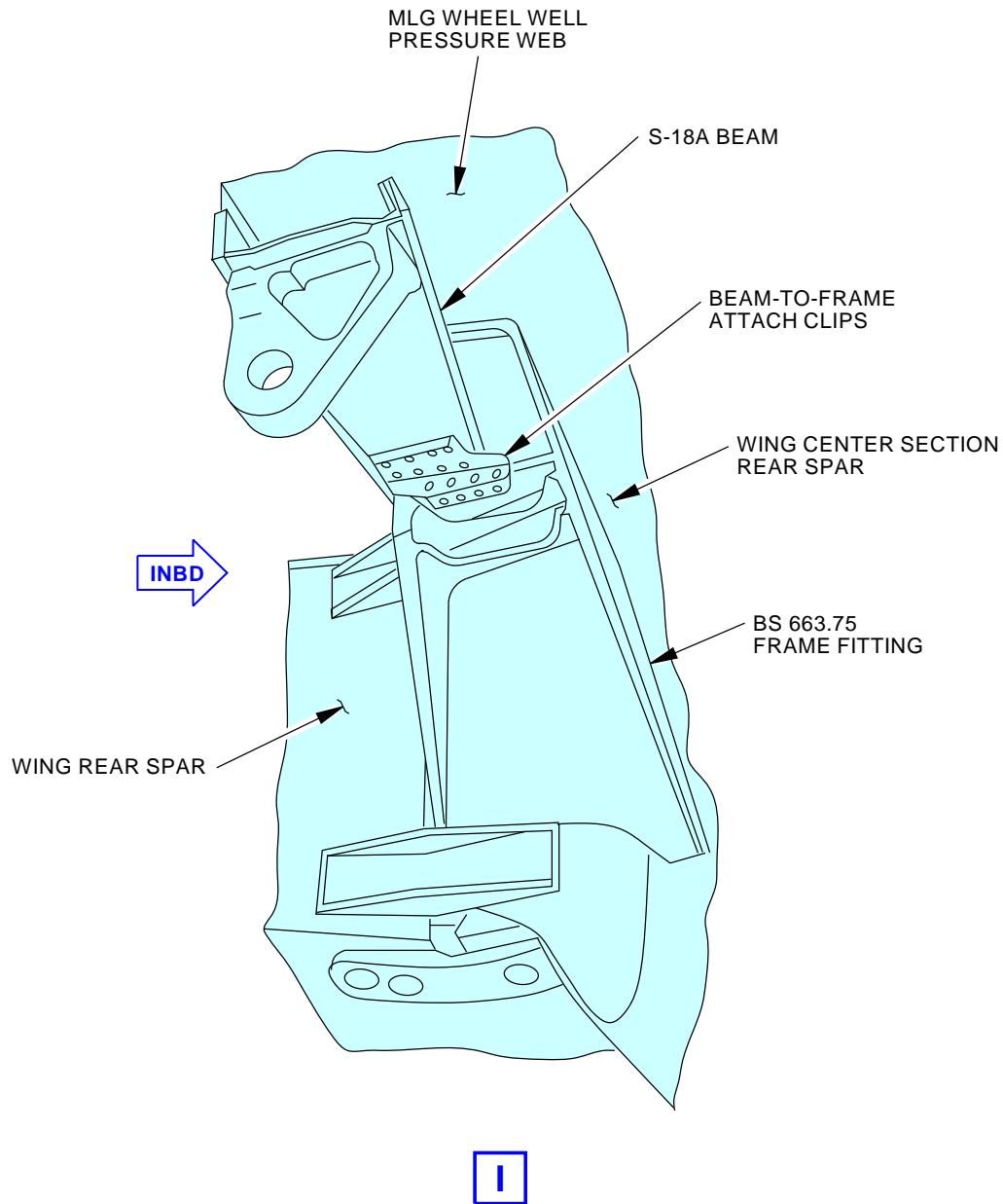
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Main Gear Wheel and Keel Beam
Figure 204/53-11-37-990-805 (Sheet 4 of 5)

EFFECTIVITY
AKS ALL

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Main Gear Wheel and Keel Beam
Figure 204/53-11-37-990-805 (Sheet 5 of 5)

EFFECTIVITY
AKS ALL

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TASK 53-11-37-600-806

6. Nose Gear Wheel Well - Corrosion Prevention

Figure 205

A. General

- (1) The nose gear wheel well is a rigid box structure consisting of a ceiling, two sidewalls, a forward and an aft wall and is located in the forward fuselage. The nose gear attachment fittings are located in the wheel well.
- (2) The surfaces inside the box structure are exposed to air contaminants and runway splash and are subject to corrosion. The nose gear attachment fittings are also found to be susceptible to corrosion.
- (3) Stress corrosion cracking of the aluminum alloy actuator support fitting has been reported. Cracks occurred in the vertical leg midway between the rows of fastener holes. In another instance cracking and failure of the bearing retaining lug was reported.
- (4) Corrosion has been reported on the exterior surfaces of the box, on webs, stiffeners and chords. Cracking of the upper panel web BS 277 stiffener has also been reported.
- (5) Stress corrosion cracks have been reported on the LH and RH lock support fitting to which the strap is riveted. One of the cracks was between the two attach rivet holes and the other extended into the upper flange radius. It was determined that the strap induced clamp-up stresses in the fitting during strap installation. The strap was removed as a crack preventive measure.
- (6) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right



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E. Corrosion Prevention

SUBTASK 53-11-37-610-032

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-033

- (2) Corrosion Inspection/Removal

- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the first opportunity consistent with the maintenance schedule.

SUBTASK 53-11-37-610-034

- (3) Application of Corrosion Inhibitors

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-035

- (4) Prevention Treatment

- (a) At first opportunity consistent with scheduled maintenance activity, corrosion prevention treatment should be accomplished in the wheel well.
- (b) Treatment of the wheel well at the same time as the nose gear is recommended.
- (c) Remove runway debris and generally clean the entire wheel well. Make sure that all drain paths are clear in structural areas at the nose gear wheel well.
- (d) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (e) Apply water displacing corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended.

NOTE: The manual extension release mechanism on the nose landing gear must be protected from corrosion inhibiting compound contamination.

- (f) Apply water displacing corrosion inhibiting compound to nose gear actuator attachment fitting, nose gear trunnion support fittings and miscellaneous other fittings. Ensure that all lugs and lug faces are treated.

EFFECTIVITY
AKS ALL

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- (g) Regrease all grease fittings in the treatment area.
- (h) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

SUBTASK 53-11-37-610-036

(5) Frequency of Application

- (a) Periodic inspection is required to areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

SUBTASK 53-11-37-610-037

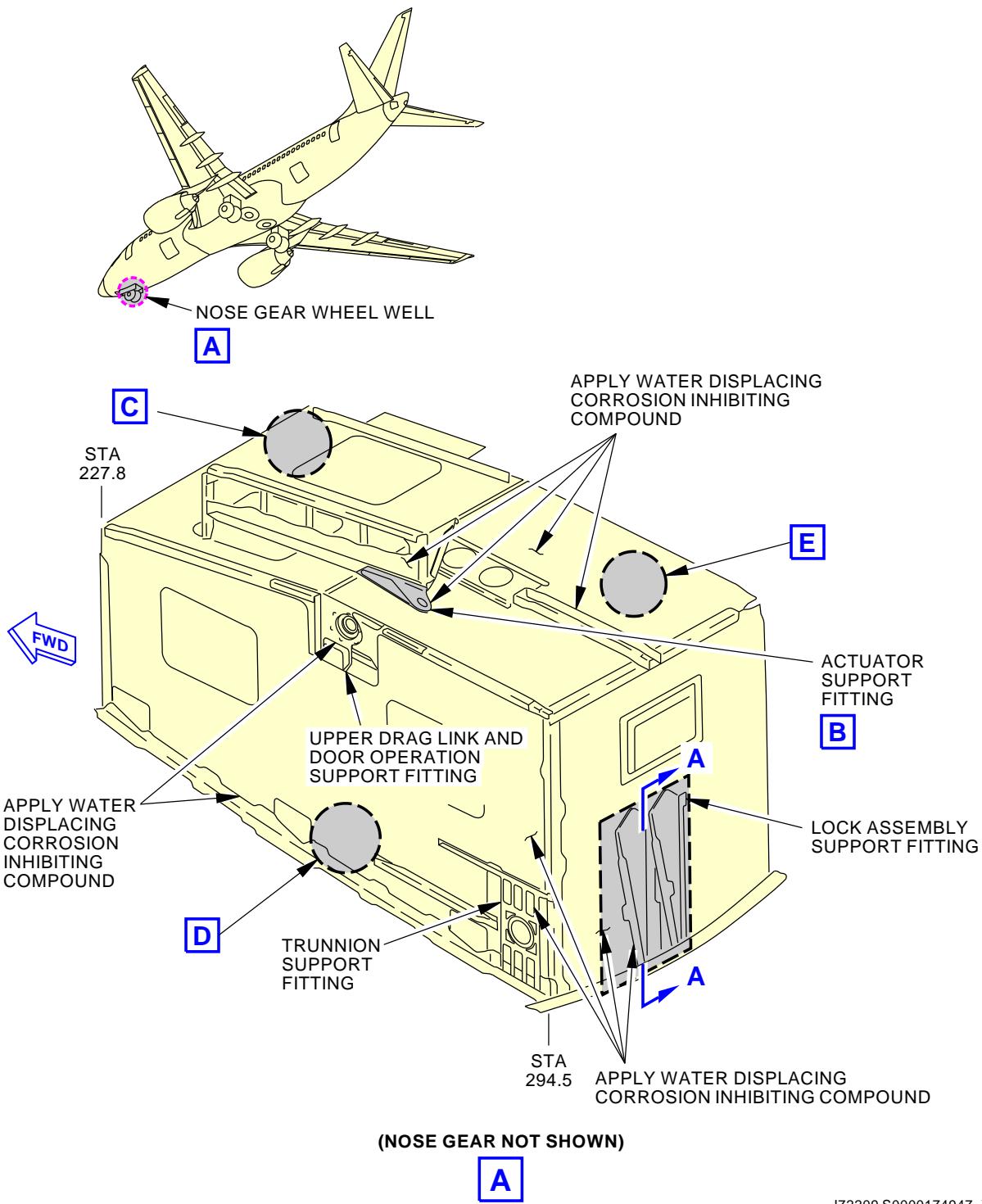
(6) Improved Corrosion Protection

- (a) A layer of corrosion preventive compound, C00755 was added on the corrosion inhibiting compound, G00009 in some areas.

———— END OF TASK ————

EFFECTIVITY
AKS ALL

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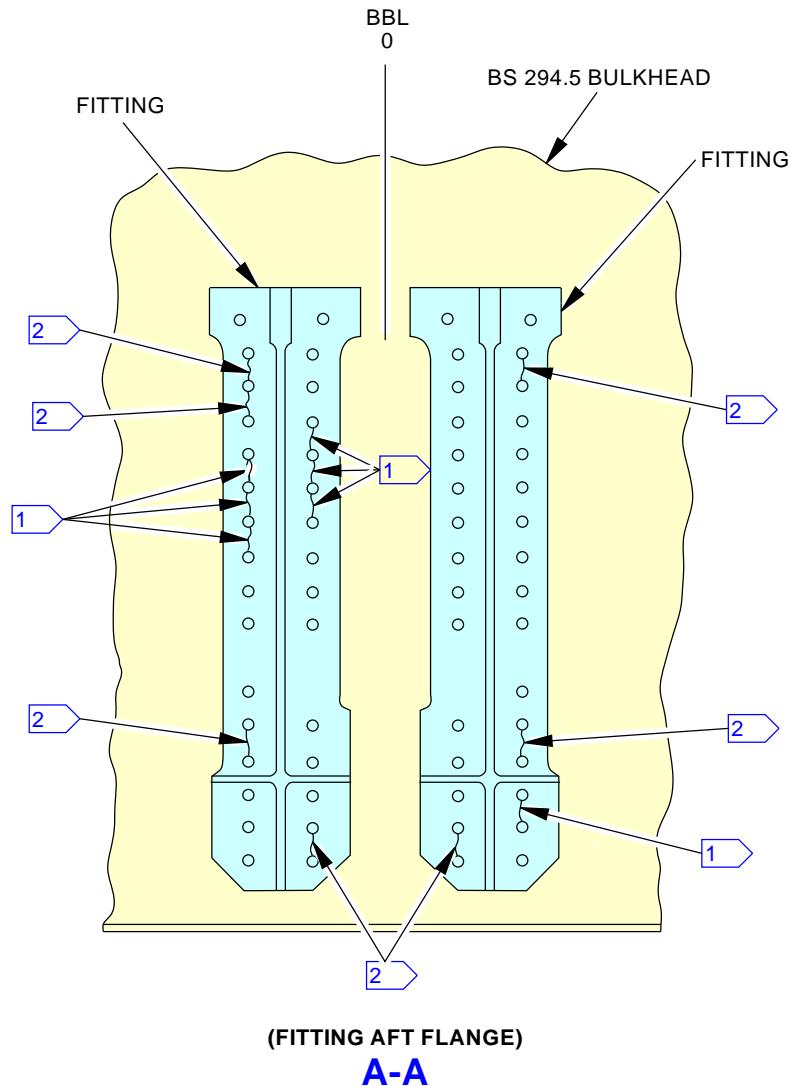
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Nose Gear Wheel Well
Figure 205/53-11-37-990-806 (Sheet 1 of 3)

EFFECTIVITY
AKS ALL

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- 1 CRACK LOCATION ON AIRPLANE WITH 5567 FLIGHT HOURS
2 CRACK LOCATION ON AIRPLANE WITH 5648 FLIGHT HOURS

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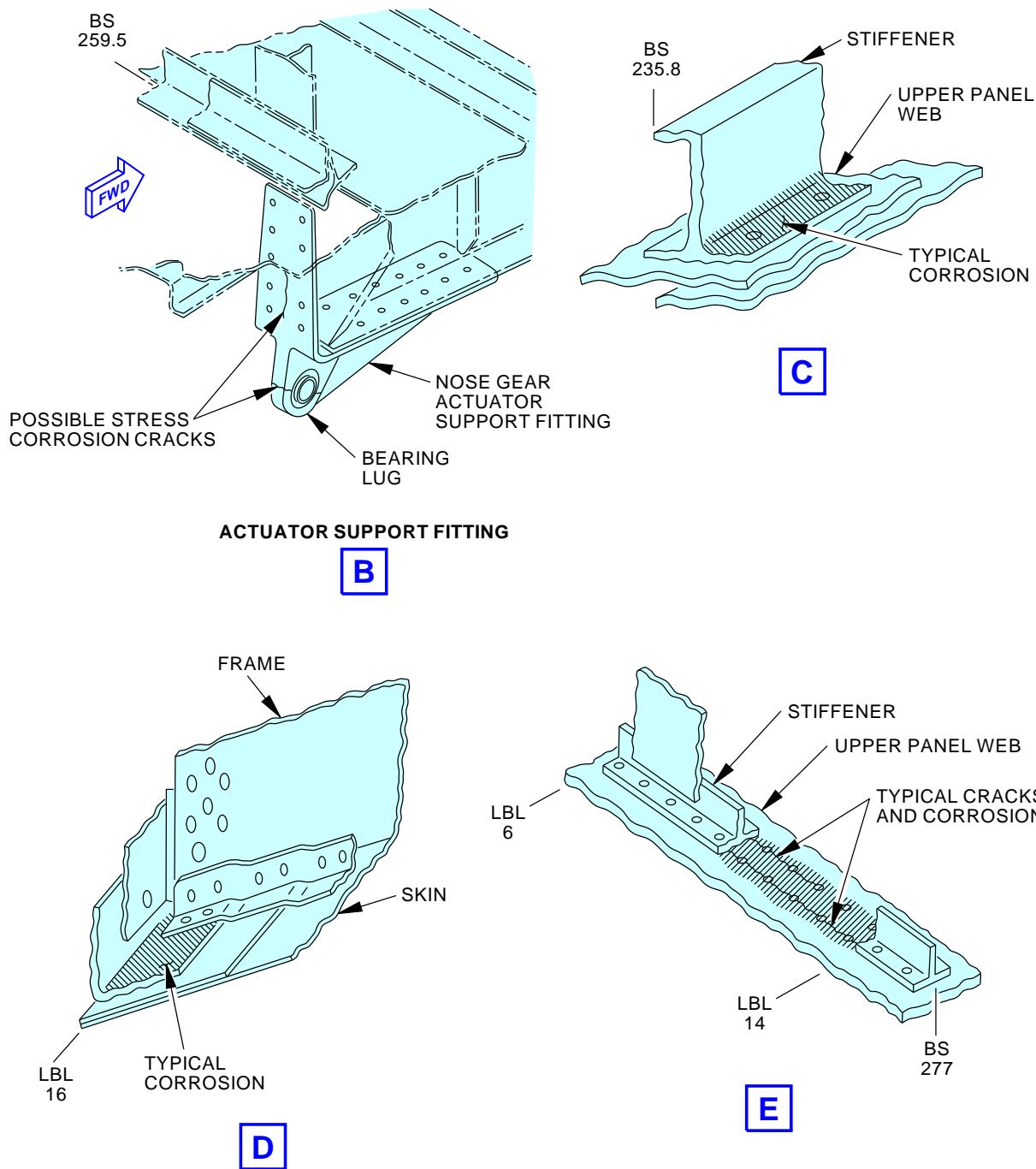
Nose Gear Wheel Well
Figure 205/53-11-37-990-806 (Sheet 2 of 3)

EFFECTIVITY
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Nose Gear Wheel Well
Figure 205/53-11-37-990-806 (Sheet 3 of 3)

EFFECTIVITY
AKS ALL

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TASK 53-11-37-600-808

7. Door Openings - Corrosion Prevention

Figure 206

A. General

- (1) The door openings and surrounding structure in the fuselage section are made up of frames, doublers, fittings, stiffeners and intercostals. In addition, the passenger and/or crew entry doors have reveals and scuff plates.
- (2) The primary corrosion area is under the door sill, floor panels and floor beams. Contaminants are tracked in by passenger, crew members, cargo and service personnel or by driven rain/snow when door is opened. Specific problems have been reported under the corrosion resistant steel plates at the cargo doors.
- (3) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (4) Stress corrosion can cause cracks in the frame at Station 360.
- (5) Some skins and doublers came apart, pulled through the rivets, and tore the skin at the aft edge of the cutout for the aft cargo door. The damage was caused by the water from the main landing gear tires when the runway was wet.
- (6) Refer to the CORROSION PREVENTION, SECTION 51-00 for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door
830	Subzone - Passenger Compartment Doors, Left
835	Main Deck Cargo Door
840	Subzone - Passenger Compartment Doors, Right



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E. Corrosion Prevention

SUBTASK 53-11-37-610-041

- (1) Make the regular inspection of INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop or find the start of corrosion. Missing fasteners, white powdery or any discolored deposits are signs of corrosion.

SUBTASK 53-11-37-610-042

- (2) If you find corrosion (web bulges, missing fasteners or large amounts of discolored deposits at fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

SUBTASK 53-11-37-610-043

- (3) For small amounts of corrosion, to decrease the downtime of the airplane, clean off the corrosion products. Apply a corrosion inhibiting compound into the affected area to stop the corrosion process Ref (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). Repair the finish system when the maintenance schedule permits.

SUBTASK 53-11-37-610-044

(4) Prevention Treatment

- (a) At first opportunity consistent with scheduled maintenance activity corrosion prevention treatment should be accomplished in the door opening area.
- (b) Treatment of the door at the same time as the door opening is recommended.
- (c) Remove traffic debris and generally clean the entire door opening area. Remove reveal and scuff plate where applicable.
- (d) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.
- (e) Remove door reveal, scuff plates and thresholds.
- (f) Remove floor panels to gain access to floor beams and intercostals near the door opening.
- (g) Open plugged drains.
- (h) Make sure that all drain paths are clear at the equipment access doorway, fwd and aft galley and entry doorways and cargo doorway.
- (i) Replace damaged or broken finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish system.
- (j) Apply a coat of epoxy primer, C00259 to the inboard flange surfaces of stringers and allow to dry thoroughly.
- (k) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (l) Apply corrosion inhibiting compound to all immediate structure. Special efforts should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended. Special attention should be given to flanges of floor beams, doorsills and floor beam to fuselage frame splices.
- (m) Replace or repair broken or damaged leveling compounds used for drainage.
- (n) Allow solvent in corrosion inhibiting compound to evaporate before reinstalling insulation blankets.

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- (o) Install blankets so they are tight and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (p) Relubricate all lube points per standard servicing procedures.
- (q) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-045

(5) Frequency of Application

- (a) Regular inspection is required in areas that can get corrosion and should agree with the schedules in the Maintenance Planning Document. Operators must know of problems and areas.
- (b) Regular application of corrosion inhibiting compound, G00009 compound is necessary on areas identified and should agree with the schedule in the Maintenance Planning Document.

SUBTASK 53-11-37-610-046

(6) Improved Corrosion Protection

- (a) On all entry and galley doorway scuff plate support structures, a production change added sealant, A00247 fay surface seals between the scuff plate and support structure and installed the screws through the scuff plate with sealant, A00247.
- (b) A production change applied sealant, A00247, class F, chromate-loaded sealant to inboard flanges of stringers and to the areas of the frames that touch the insulation blankets.
- (c) You can rework insulation blankets by removing the sewn cap strip from the lower edge of the blanket and continuously penetrate the stitch sealing. The blankets to be reworked must be made with water-repellent fillers. All 737 airplanes are known to be delivered with blankets that use water-repellent fillers.
- (d) A production change applied a new insulation blanket installation is used. The tightly sealed covers are replaced with unsealed covers to permit water to enter the blanket and drain equally easily. The blankets become drain paths into the lower lobe drain masts. Water repellent blanket filler is also used.
- (e) Drain holes with drain tubes were added at the forward entry doorway, but the drain tubes can become clogged with dirt and carpet debris. To make it easier to clean the drain lines, a production change added cutouts in the floor mat retainer plate.

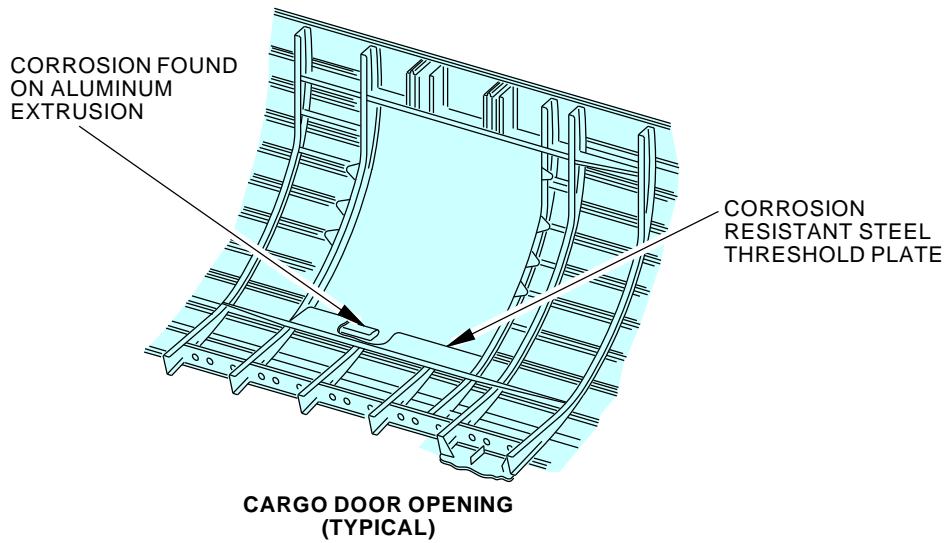
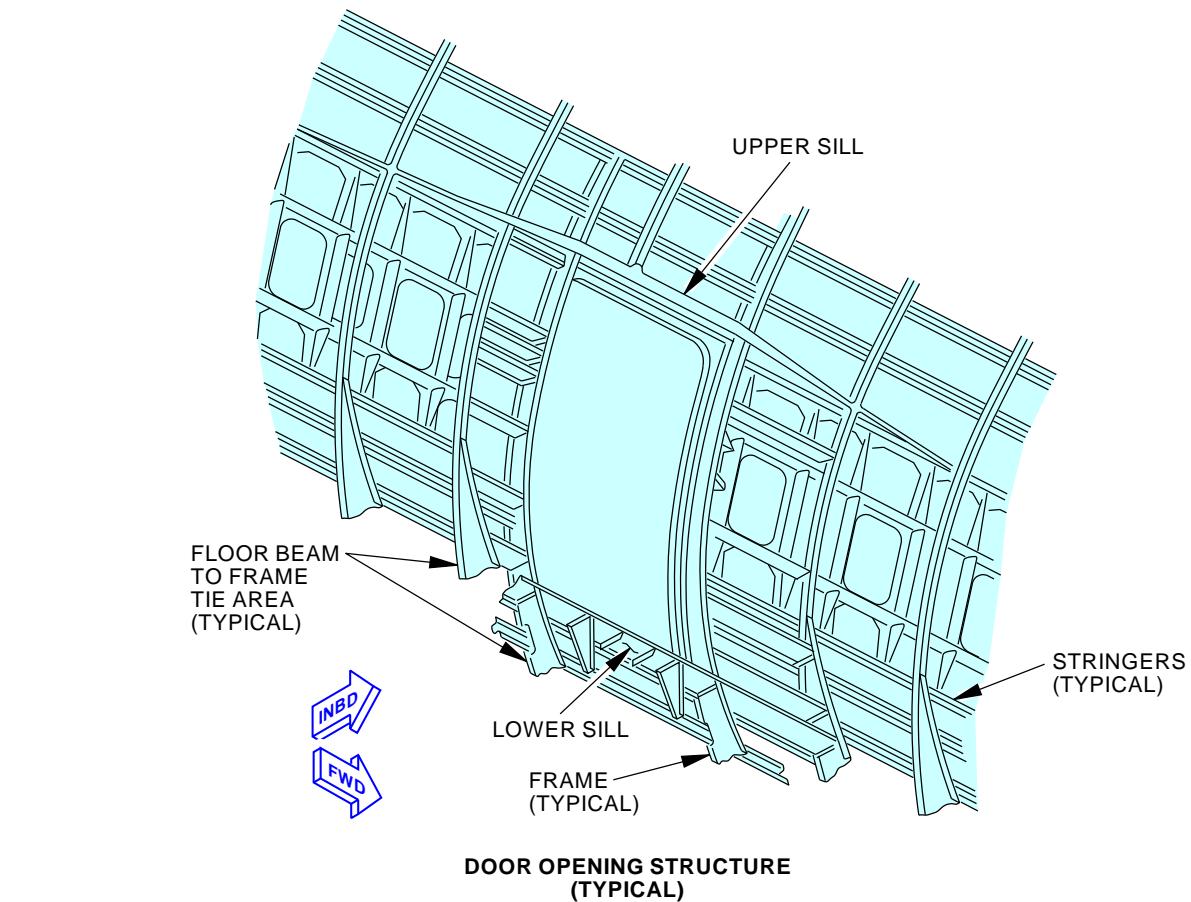
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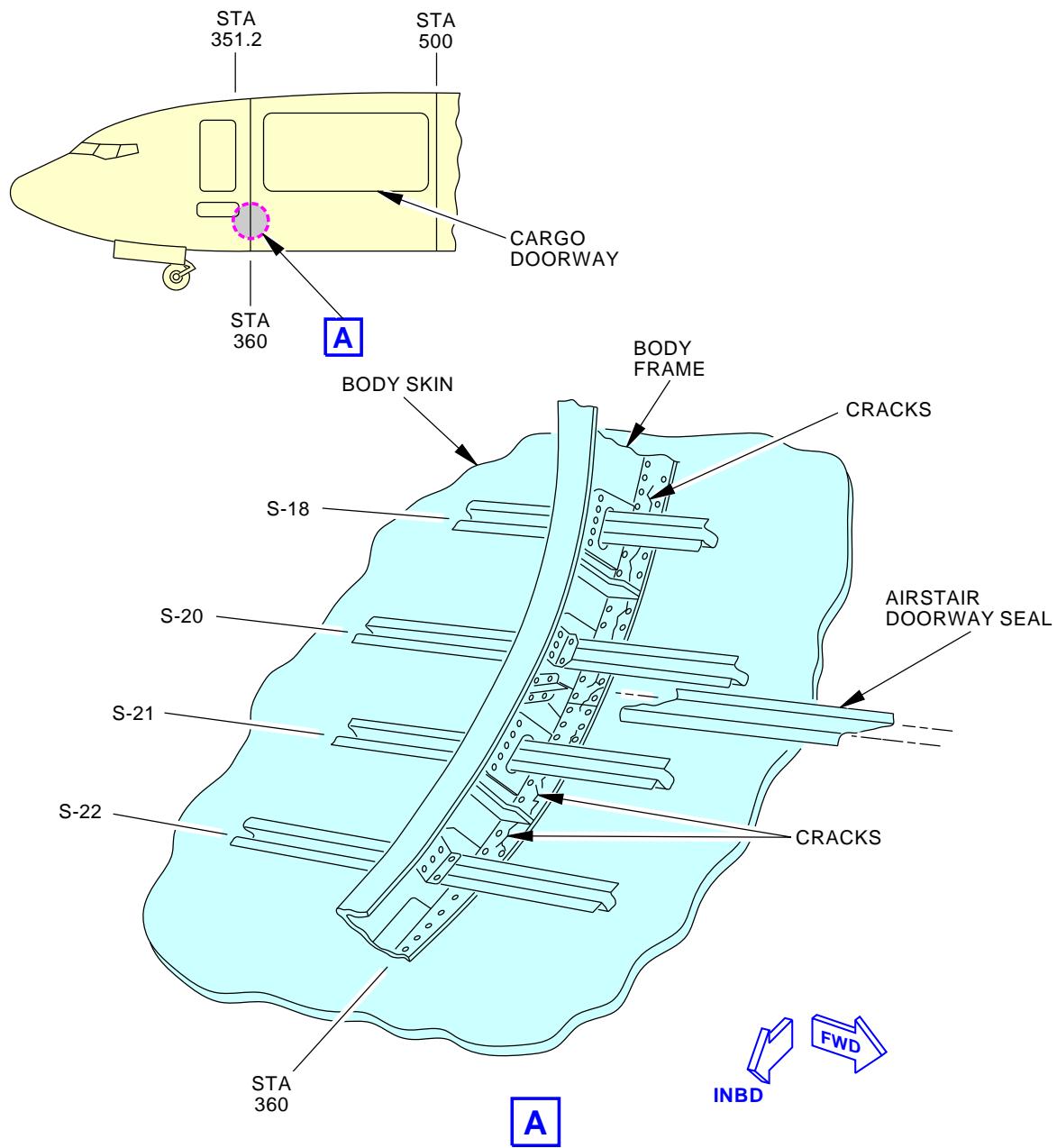
Door Openings
Figure 206/53-11-37-990-808 (Sheet 1 of 4)

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737 CARGO AIRPLANES

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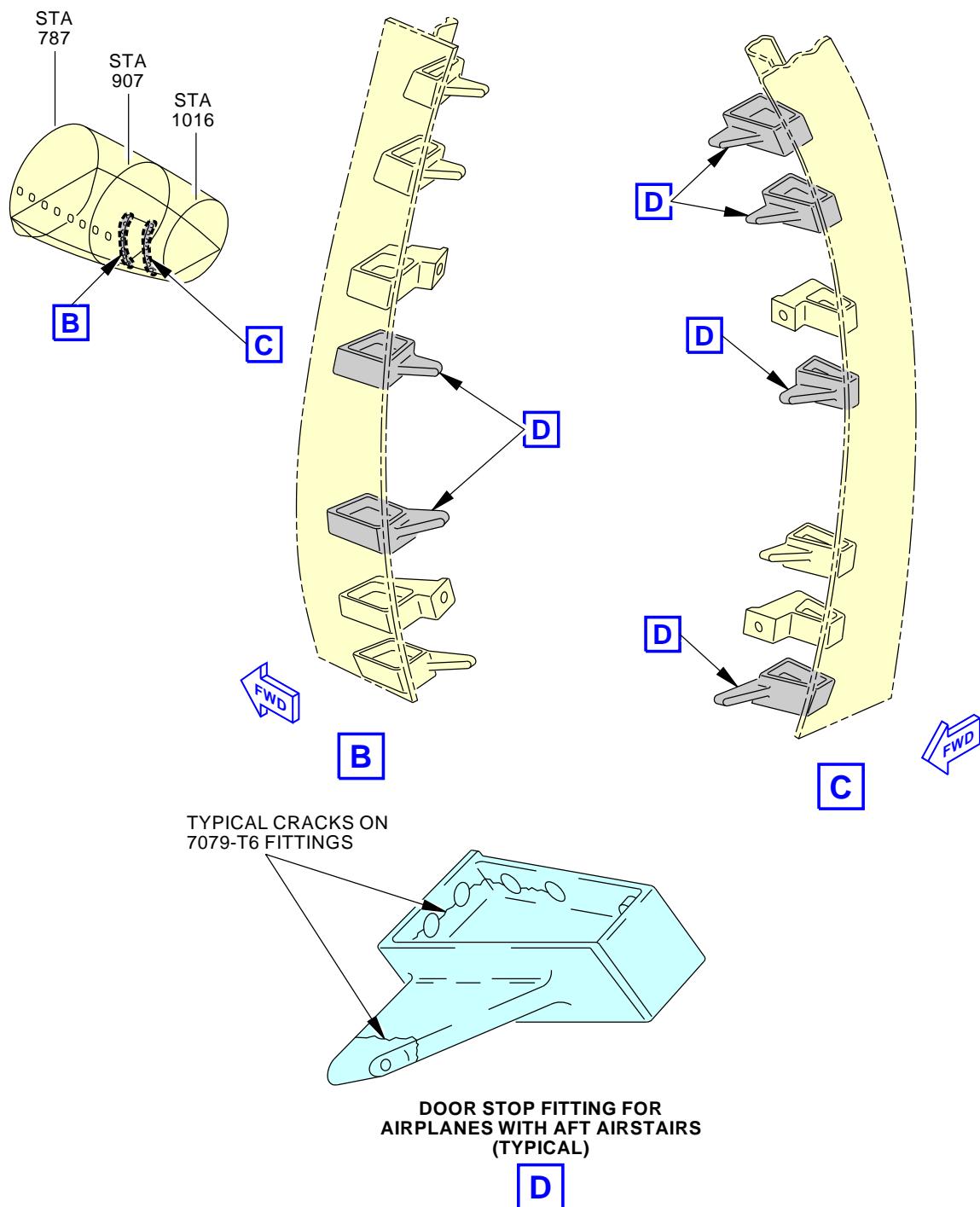
Door Openings
Figure 206/53-11-37-990-808 (Sheet 2 of 4)

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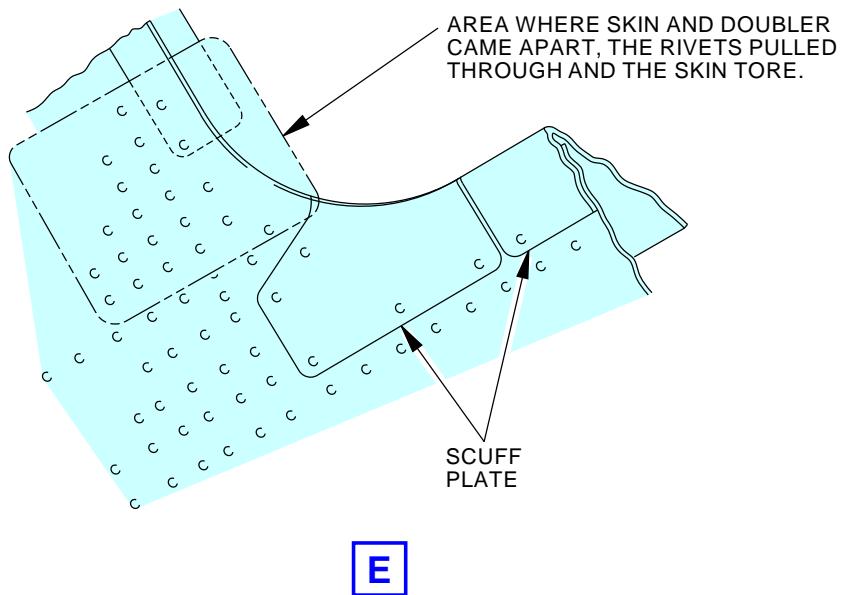
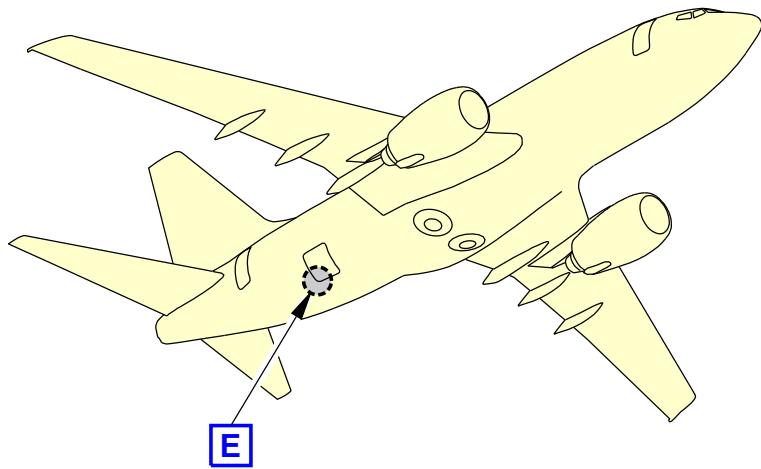
Door Openings
Figure 206/53-11-37-990-808 (Sheet 3 of 4)

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Door Openings
Figure 206/53-11-37-990-808 (Sheet 4 of 4)

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TASK 53-11-37-600-810

8. Upper Lobe Frames, Stringers and Skin - Corrosion Prevention

Figure 207

A. General

- (1) The fuselage is of semimonocoque construction which uses aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated at the same time with the fuselage structure.
- (2) Cracks were found in the areas where the skin and doubler come apart. Cracks come from the fastener holes in the double rivet row in Stringer 17L and 17R between BS 422 to 500A, and BS 727A to BS 747.
- (3) Broken attach bolts were found in the vertical-fin-aft-spar-terminal support fitting at the upper center part of BS 1088 bulkhead. The attach bolts are made from H-11 steel alloy which are susceptible to cracks caused by stress corrosion.
- (4) The main compartment sidewall insulation have pillow blankets installed just inboard of the airplane skin and insulation blankets installed inboard of the pillow blankets. It was found that the pillow catches the moisture against the airplane skin which can add to possible corrosion of the adjacent structure.
- (5) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-37-610-055

- (1) The basic corrosion prevention philosophy is to make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive compounds in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-056

- (2) Where extensive corrosion exists (very noticeable skin bulges, missing fasteners, or large amounts of white deposits at the fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

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SUBTASK 53-11-37-610-057

WARNING: DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

CAUTION: DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-058

- (4) For minor corrosion detected during the periodic inspections and to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process.

SUBTASK 53-11-37-610-059

(5) Prevention Treatment

- (a) At first opportunity when schedule maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
- (b) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
- (c) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (d) Apply a coat of epoxy primer, C00259 to the inboard flange surfaces of stringer and allow to dry thoroughly.
- (e) Apply water displacing corrosion inhibiting compound to all exposed structure. The use of spray equipment with nozzle directed into faying surfaces is recommended.
- (f) Allow solvent to evaporate before reinstalling insulation blankets.
- (g) Reinstall blankets so they are taut and so that the outboard surface of the upper blanket overlaps the lower blanket.
- (h) Reinstall liner and restore airplane to normal.

SUBTASK 53-11-37-610-060

(6) Improved Corrosion Protection

- (a) A production change replaced the H-11 attach bolts used in the vertical-fin-aft-spar-terminal support fitting at BS 1088 bulkhead with Inconel 718 bolts. The Inconel 718 bolt is less susceptible to cracks caused by stress corrosion.

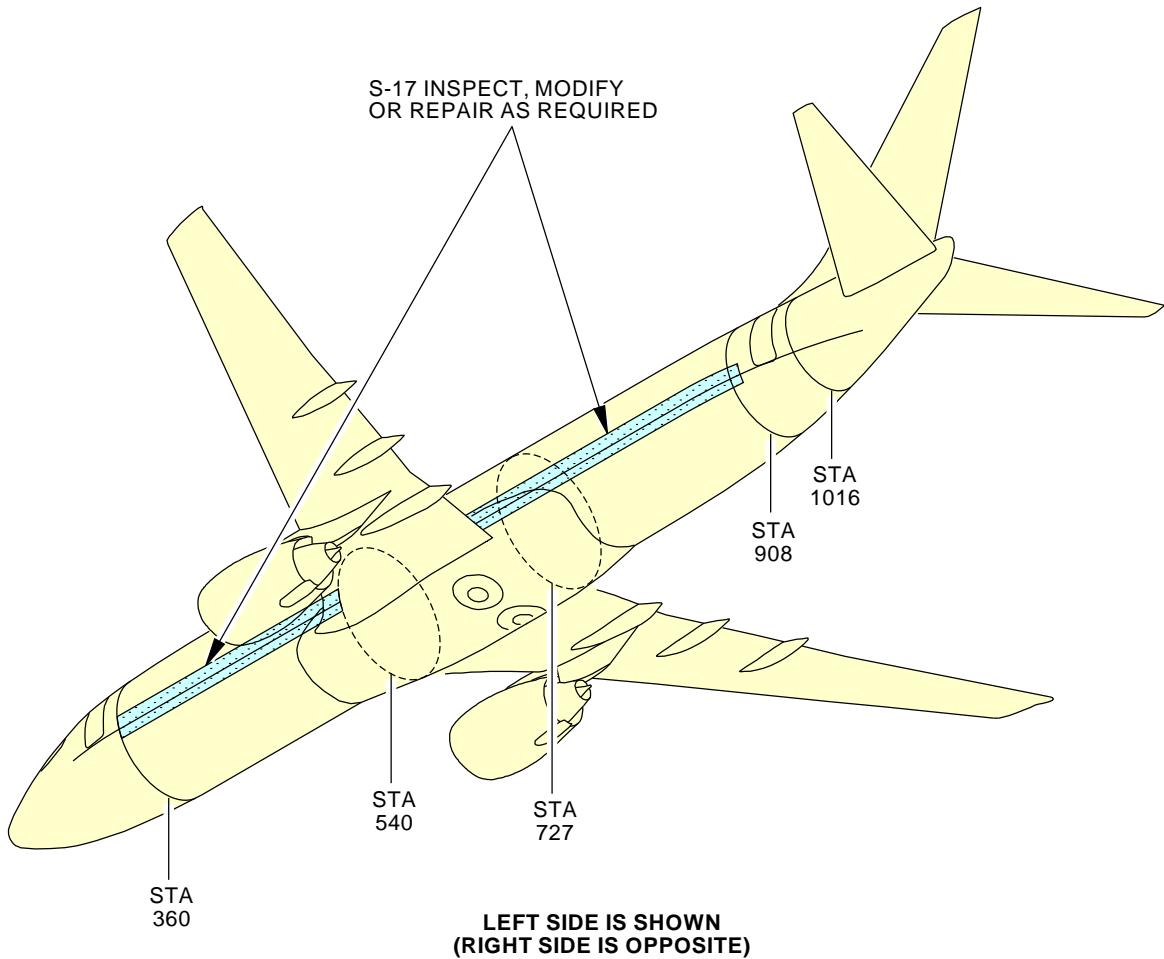
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Upper Lobe Frames, Stringers and Skin
Figure 207/53-11-37-990-810 (Sheet 1 of 3)

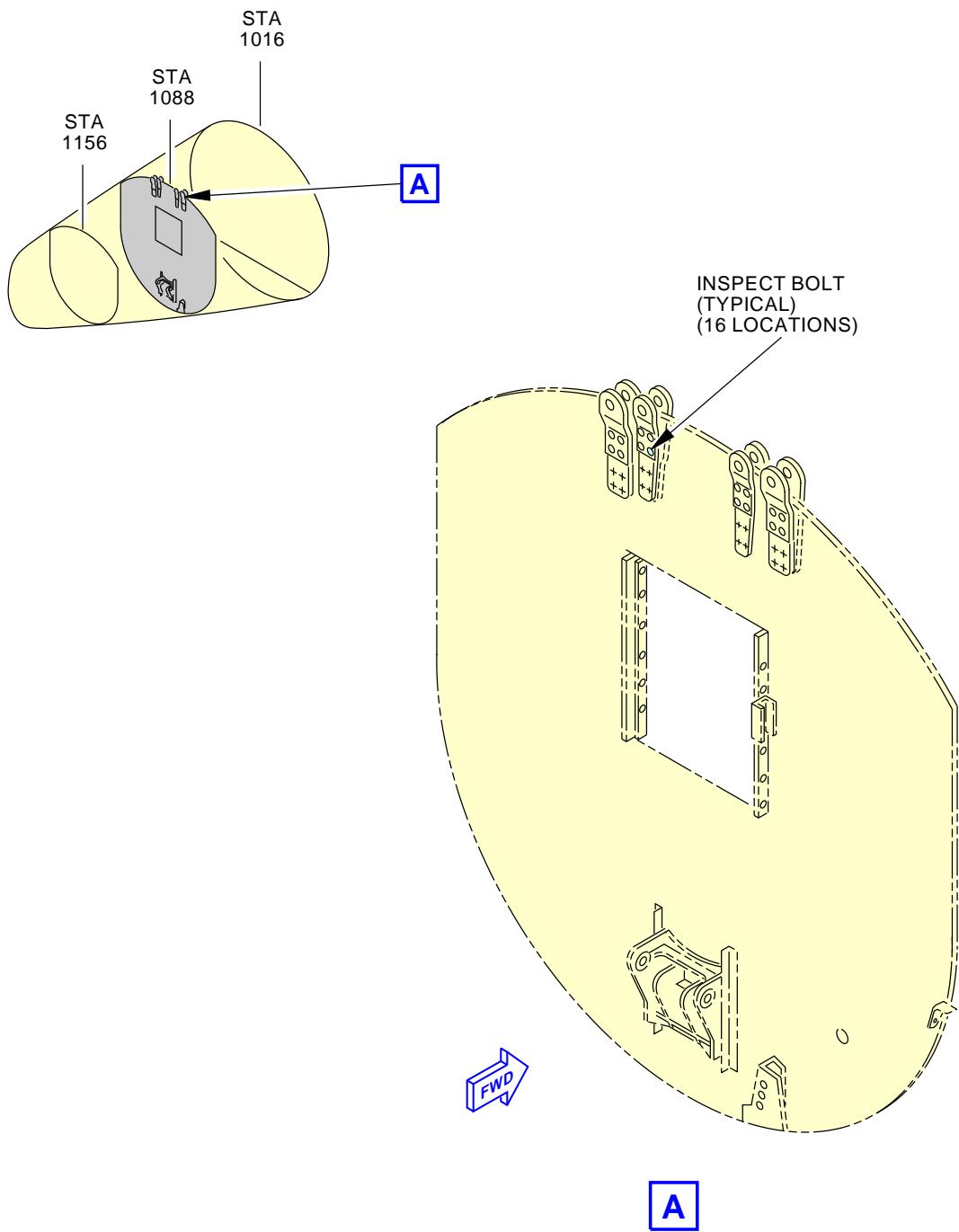
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Upper Lobe Frames, Stringers and Skin
Figure 207/53-11-37-990-810 (Sheet 2 of 3)

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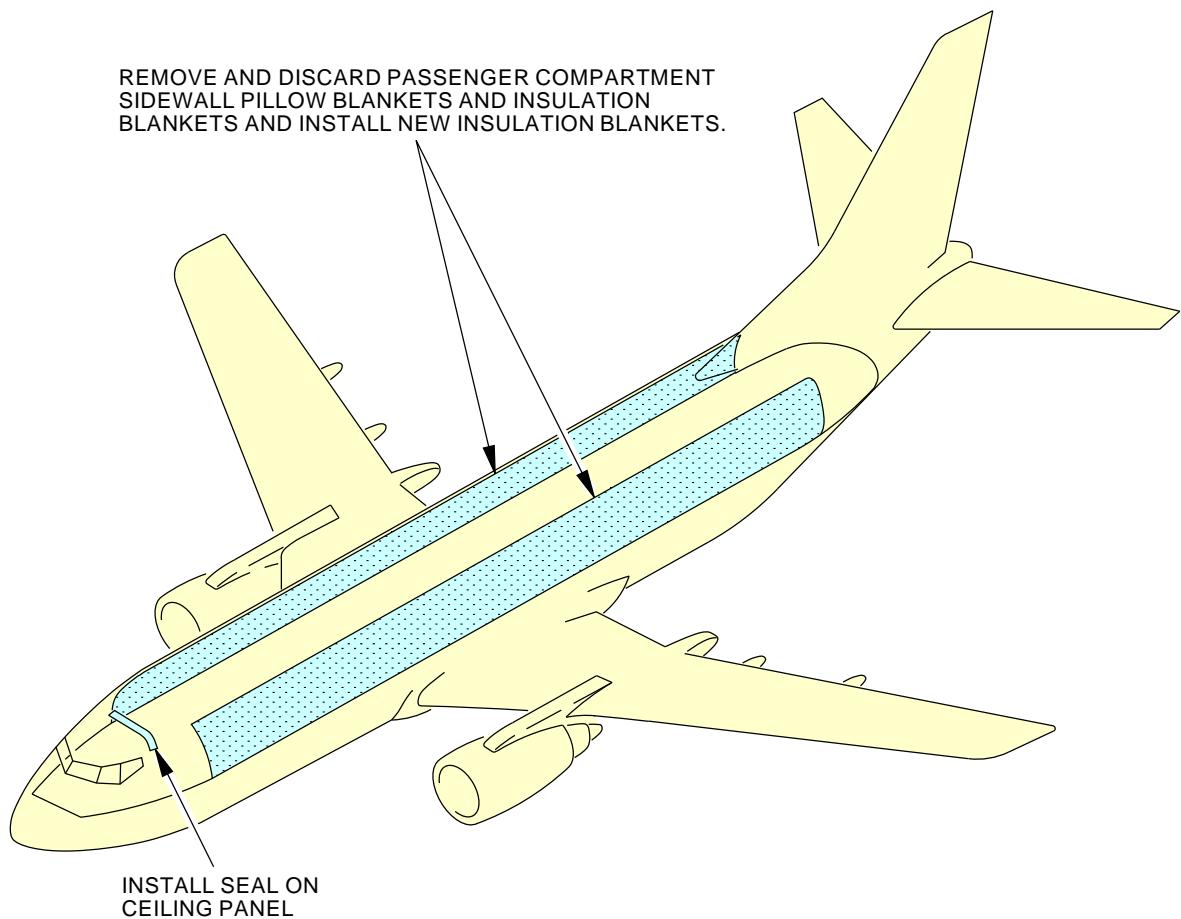
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Upper Lobe Frames, Stringers and Skin
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KEEL BEAM BLOWOUT PANEL - REMOVAL/INSTALLATION

1. General

- A. The blowout panel of the keel beam is on the centerline of the airplane, forward of the main wheel well. The function of the panel is to release the pressure that is too high in the keel beam because of a broken APU duct. The panel is hinged and will blow open when special attach rivets are sheared. The panel has a deflector to keep the panel open in flight. Decals give the replacement rivets.

TASK 53-12-11-400-801

2. Keel Beam Blowout Panel Installation

A. References

Reference	Title
20-30-92-910-801	Final Cleaning Prior to General Sealing (Series 92) (P/B 201)
51-31-00-160-801	Prepare For Sealing (P/B 201)

B. Tools/Equipment

Reference	Description
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B01012	Solvent - Final Cleaning Prior To General Sealing (AMM 20-30-92/201) - Series 92	

D. Location Zones

Zone	Area
129	Keel Beam (Part) Body Station 501.70 to Body Station 540.00

E. Prepare for the Installation

SUBTASK 53-12-11-160-002

- (1) Clean the unwanted material where it is necessary.

SUBTASK 53-12-11-110-001

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. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

- (2) Remove and clean the sealant that remains from the mating surfaces with a hardwood or plastic fillet smoothing spatula, STD-810.

SUBTASK 53-12-11-110-002

- (3) Clean the area with Series 92 solvent, B01012 (TASK 20-30-92-910-801).

SUBTASK 53-12-11-210-001

- (4) Apply the parting agent to external faces of the fairing mating surface (TASK 51-31-00-160-801).



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SUBTASK 53-12-11-620-001

CAUTION: APPLY PRESSURE WITH YOUR HAND TO INSTALL THE PANEL. DO NOT DAMAGE OR PRELOAD THE PANEL DURING THE INSTALLATION. REMOVE ALL THE UNWANTED SEALANT FROM THE INNER AND THE OUTER AREA OF THE PANEL. USE THE MINIMUM SEALANT TO PREVENT A PANEL OUT OF THE FAIR CONDITION.

- (5) Apply the sealant, A00247 to the inner faces of the panel mating surfaces immediately before the panel installation.

NOTE: You can apply the sealant as a continuous or broken seal (Ref 51-31-00/201).

SUBTASK 53-12-11-210-002

- (6) Examine the attachment clips for damage.

SUBTASK 53-12-11-210-003

- (7) Examine the door for free motion at the hinge line.

SUBTASK 53-12-11-420-001

CAUTION: USE THE RECOMMENDED RIVETS TO GET THE CORRECT FUNCTION OF THE BLOWOUT PANEL.

- (8) If the panel has opened due to excess pressure, then re-install the panel to the "T" structure with two rivets.

SUBTASK 53-12-11-420-002

- (9) If the panel has been open for inspection, then attach the panel assembly to airplane with 4 screws.

— END OF TASK —

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NOSE WHEEL WELL ACCESS PANELS - REMOVAL/INSTALLATION

1. **General**

- A. This procedure contains these tasks:
 - (1) The removal of the Nose Wheel Well Access panels.
 - (2) The installation of the Nose Wheel Well Access panels.

TASK 53-14-01-020-801

2. **Nose Wheel Well Access Panels - Removal**

(Figure 401)

A. **References**

Reference	Title
20-10-17-000-801	O-Rings Removal (P/B 401)
32-00-01 P/B 201	LANDING GEAR DOWNLOCK PINS - MAINTENANCE PRACTICES

B. **Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	O-ring seal washer	32-22-11-02-030	AKS ALL
4	Access panel	32-22-11-02-035	AKS ALL
15	Access panel	32-22-11-02-110	AKS ALL
18	Access panel	32-22-11-02-135	AKS ALL

C. **Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

D. **Prepare for the Removal**

SUBTASK 53-14-01-860-001

WARNING: OBEY THE PROCEDURE FOR THE INSTALLATION OF THE DOWNLOCK PINS. IF YOU MOVE THE CONTROL LEVER FOR THE LANDING GEAR TO THE UP POSITION, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Install the downlock pins for the main (LANDING GEAR DOWNLOCK PINS - MAINTENANCE PRACTICES, PAGEBLOCK 32-00-01/201.)

E. **Procedure**

SUBTASK 53-14-01-020-001

- (1) Remove the top access panels [4] and the spring assemblies [20]:
 - (a) Remove the bolts [1], bolts [5] and bolts [6].
 - (b) Remove the washers [9].
 - (c) Remove the o-ring seal washers [3] (O-Rings Removal, TASK 20-10-17-000-801.)
 - (d) Remove the access panel [4] and the spring assembly [20].
 - (e) If necessary, remove the spring assembly [20].
 - 1) Remove the bolts [8], the washers [9] and the nuts [10] from the spring assembly [20] and access panel [4].



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- 2) Remove the spring [7], the filler [12] and the plate [13].

SUBTASK 53-14-01-020-002

- (2) Remove the forward access panels [15] and aft access panels [18]:
- Remove the bolts [14] and bolts [17].
 - Remove the washers [2].
 - Remove the o-ring seal washers [3] (O-Rings Removal, TASK 20-10-17-000-801.)
 - Remove the forward access panels [15] and aft access panels [18].

———— END OF TASK ————

TASK 53-14-01-420-801

3. Nose Wheel Well Access Panels - Installation

(Figure 401)

A. References

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
20-10-17-400-801	O-Rings Installation (P/B 401)
32-00-01 P/B 201	LANDING GEAR DOWNLOCK PINS - MAINTENANCE PRACTICES

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G00268	Brush - Soft Bristle, Paint	

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	O-ring seal washer	32-22-11-02-030	AKS ALL
4	Access panel	32-22-11-02-035	AKS ALL
15	Access panel	32-22-11-02-110	AKS ALL
18	Access panel	32-22-11-02-135	AKS ALL

D. Location Zones

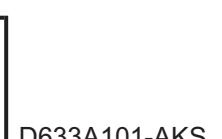
Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

E. Prepare for the Installation

SUBTASK 53-14-01-420-001

WARNING: MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR AND THE TAIL SKID. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT, AND THE TAIL SKID CAN EXTEND. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Install the downlock pins for the main landing gear, (LANDING GEAR DOWNLOCK PINS - MAINTENANCE PRACTICES, PAGEBLOCK 32-00-01/201).





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F. Procedure

SUBTASK 53-14-01-420-002

- (1) Install the forward access panel [15] and aft access panel [18]:
 - (a) Examine the gasket seal [19] and gasket seal [16] for its condition.
 - 1) Replace the gasket seal [19] or gasket seal [16] if necessary.
 - (b) Install the access panel [15] and access panel [18] in their location.
 - (c) Install the new o-ring seal washer [3], washers [2] and the bolts [17], bolts [14].
 - 1) Do this task to install the new o-ring seal washer [3]: O-Rings Installation, TASK 20-10-17-400-801.
 - (d) Tighten the bolts 50 in-lb (6 N·m) to 70 in-lb (8 N·m).
 - (e) Make sure that there are no air leaks, Cabin Pressure Leak Test, TASK 05-51-91-790-801.

SUBTASK 53-14-01-420-003

- (2) Install the top access panels [4] and the spring assemblies [20].
 - (a) If necessary, install the spring assembly [20].
 - 1) Apply sealant, A00247 between the plate [13] and the spring [7].
 - 2) Put the plate [13] on the bottom of the spring [7].
 - 3) Apply sealant, A00247 between the spring [7] and the filler [12].
 - 4) Put the filler [12] on the top of the spring [7].
 - 5) Apply sealant, A00247 between the filler [12] and the access panel [4].
 - 6) Put the access panel [4] above the spring assembly [20].
 - 7) With a brush, G00268, apply sealant, A00247 to the access panel holes before you install the bolts [8].
 - 8) Install the bolts [8].
 - 9) Install the washers [9] and the nuts [10].
 - 10) Tighten the nuts [10], 20 in-lb (2 N·m) to 25 in-lb (3 N·m).
 - (b) Examine the gasket seal [11] for its condition.
 - 1) Replace the gasket if necessary.
 - (c) Install the access panel [4] with the spring assembly [20] in its location.
 - (d) Install the new o-ring seal washer [3], washers [2], and the bolts [6], bolts [5], bolts [1].
 - 1) Do this task to install the new o-ring seal washer [3]: O-Rings Installation, TASK 20-10-17-400-801.
 - (e) Tighten the bolts 50 in-lb (6 N·m) to 70 in-lb (8 N·m).
 - (f) Make sure that there are no air leaks, (Cabin Pressure Leak Test, TASK 05-51-91-790-801).

G. Put the Airplane Back to its Usual Condition

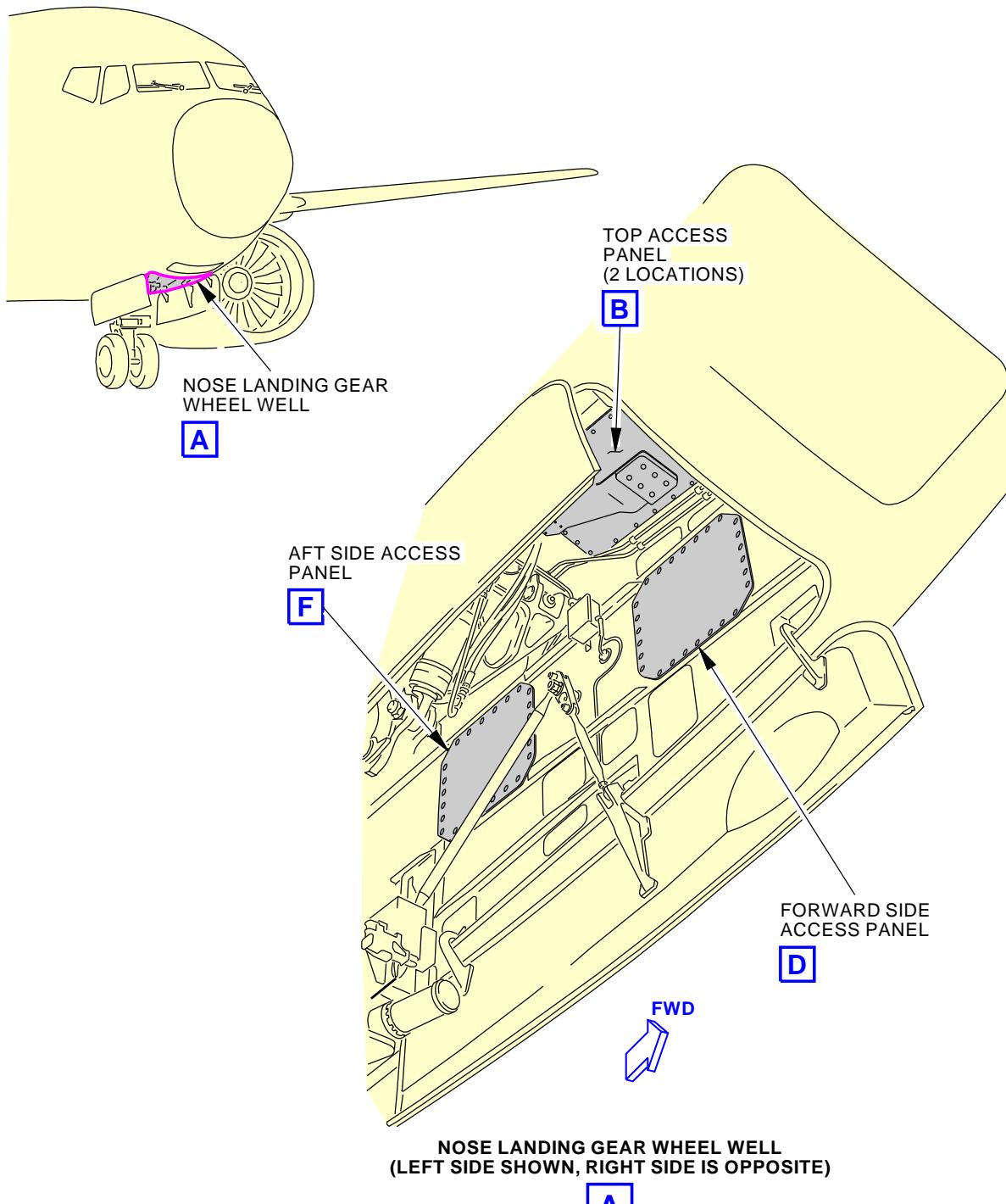
SUBTASK 53-14-01-020-003

- (1) Remove the downlock pins for the main landing gear, (LANDING GEAR DOWNLOCK PINS - MAINTENANCE PRACTICES, PAGEBLOCK 32-00-01/201.)

———— END OF TASK ————

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Nose Wheel Well Access Panels Removal/Installation
Figure 401/53-14-01-990-801 (Sheet 1 of 4)

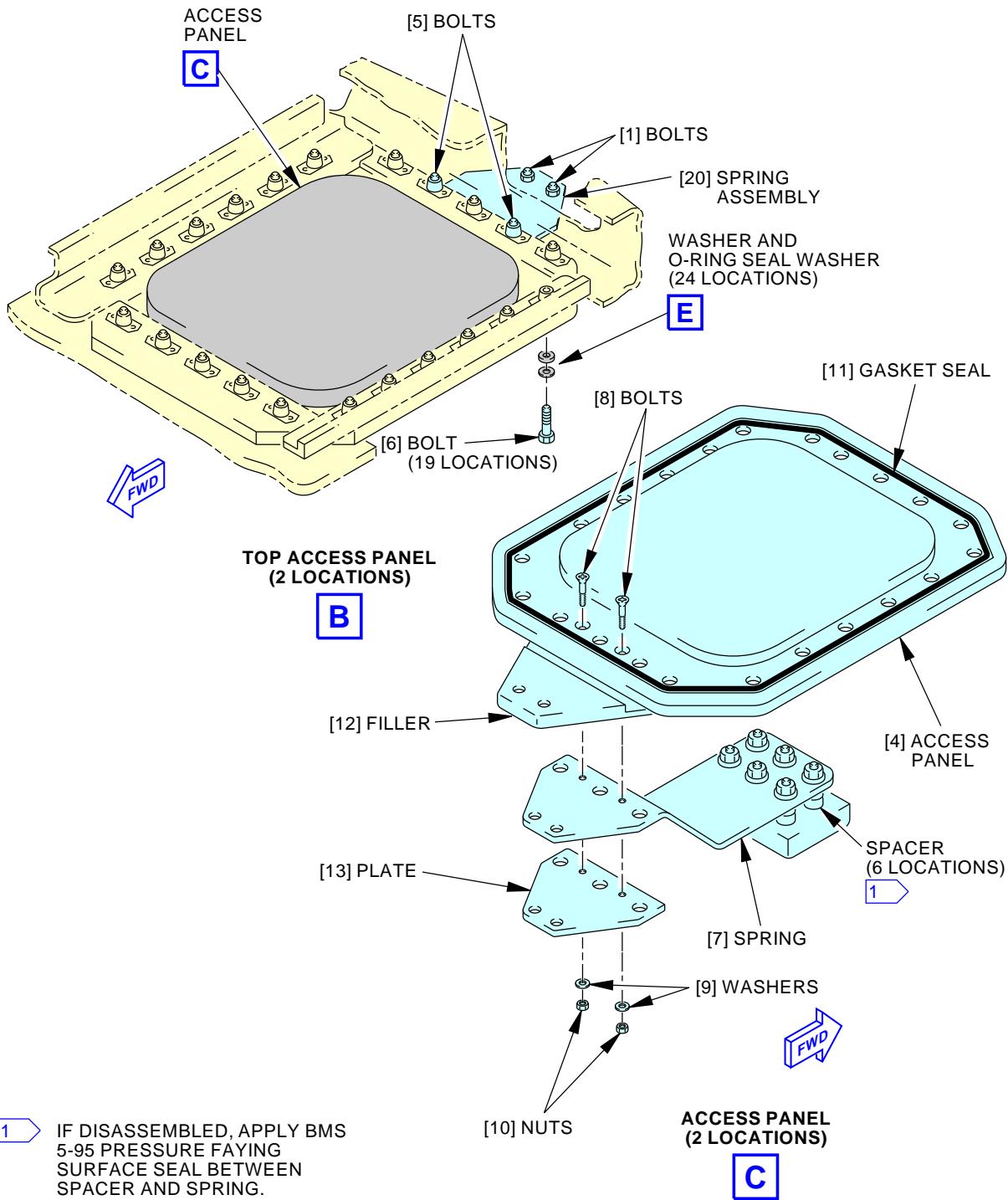
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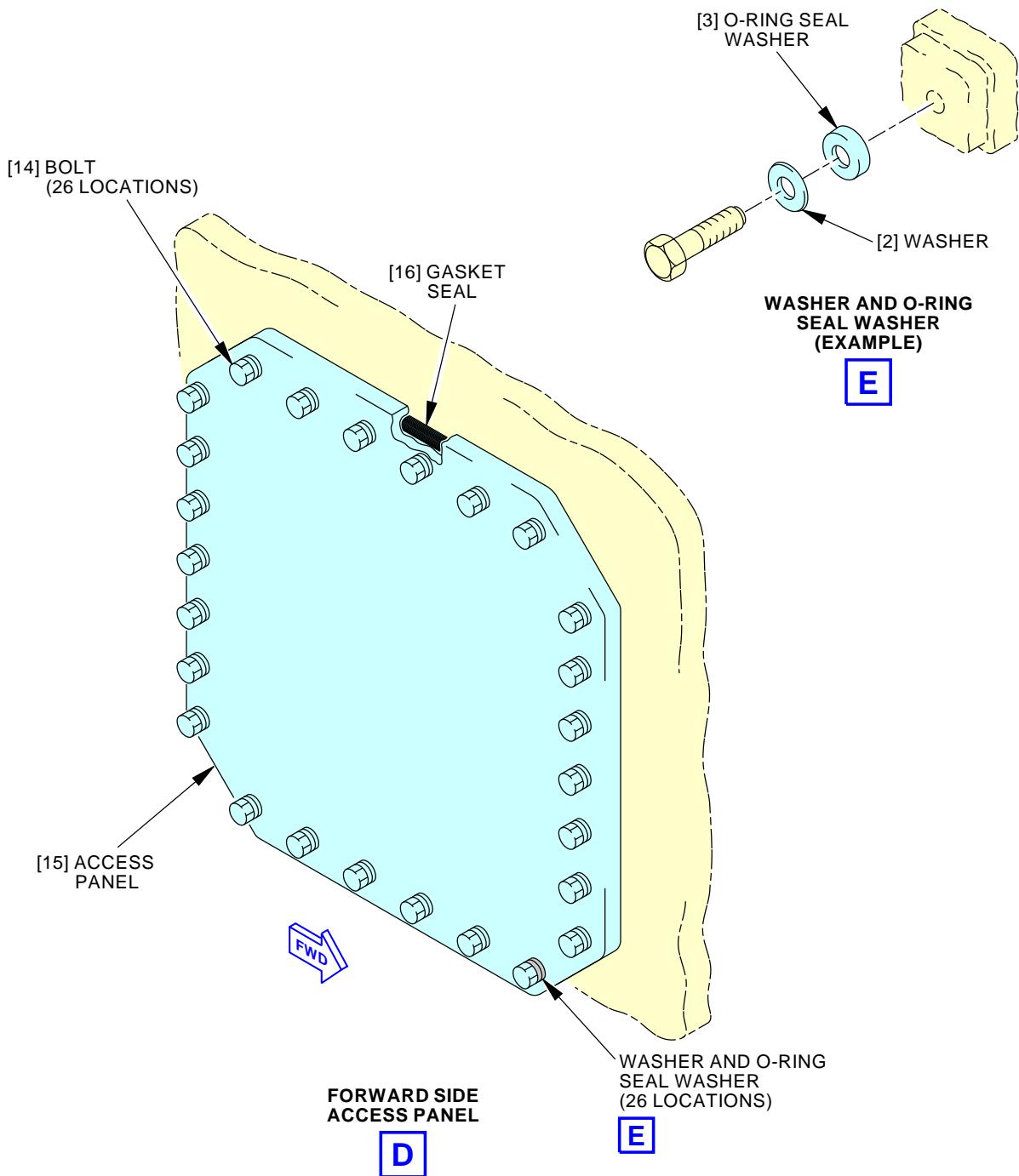
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Nose Wheel Well Access Panels Removal/Installation
Figure 401/53-14-01-990-801 (Sheet 2 of 4)

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**Nose Wheel Well Access Panels Removal/Installation
Figure 401/53-14-01-990-801 (Sheet 3 of 4)**

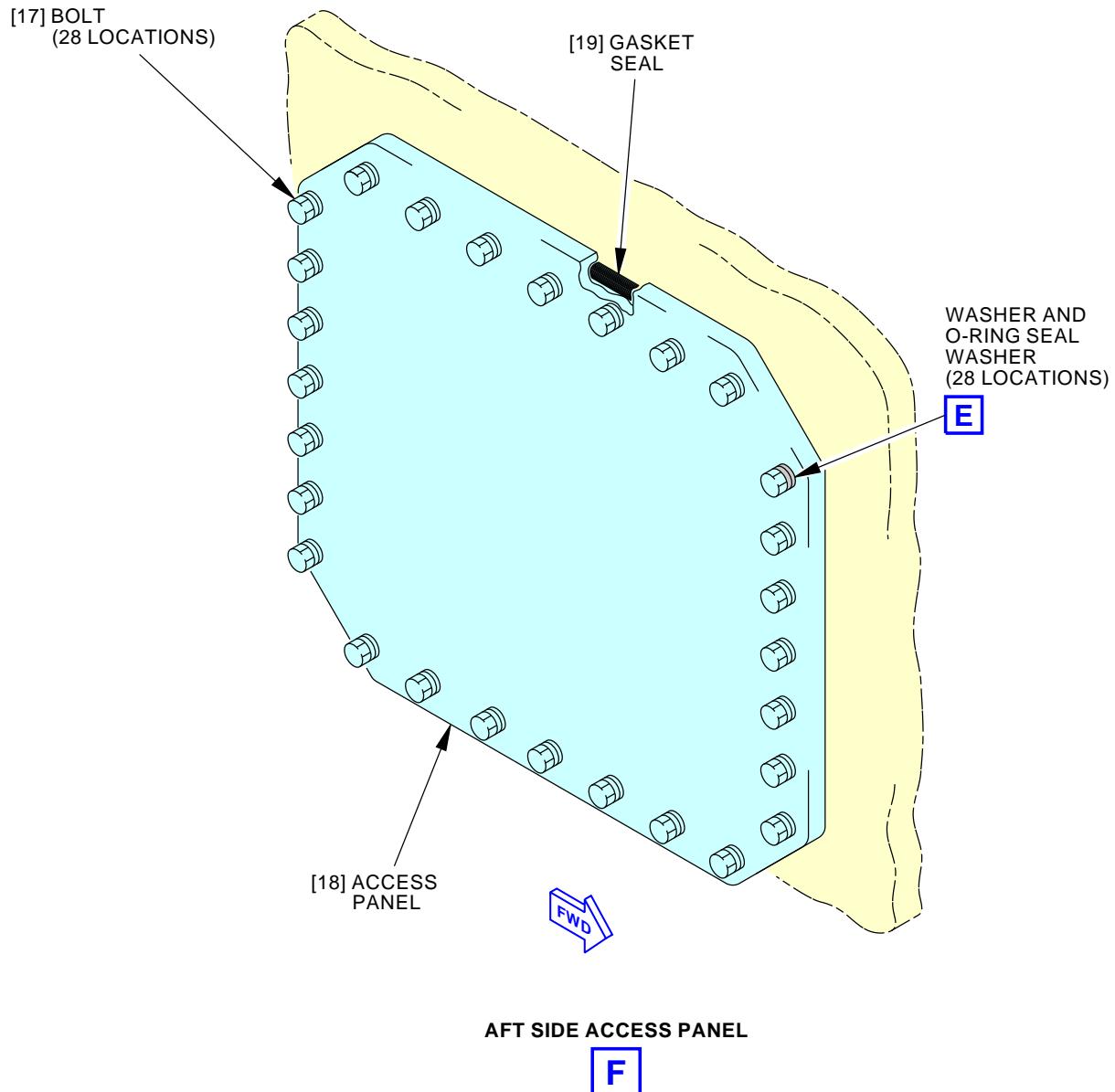
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Nose Wheel Well Access Panels Removal/Installation
Figure 401/53-14-01-990-801 (Sheet 4 of 4)

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PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks:
- (1) The removal of the passenger cabin floor panels.
 - (2) The installation of the passenger cabin floor panels.

TASK 53-21-00-000-801

2. Passenger Cabin Floor Panel Removal

A. General

- (1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

B. References

Reference	Title
25-27-21-000-801	Entry and Service Area Floor Covering - Removal (P/B 401)
28-11-00-211-801	External Wires Over the Center Fuel Tank Inspection (P/B 601)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-11-300-801	Vinyl Water Barrier Repair (P/B 801)

C. Tools/Equipment

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

D. Removal Procedure

SUBTASK 53-21-00-010-001

- (1) Break the panel seals.
 - (a) If the water barrier is installed, get access to the panel fasteners.
 - 1) Do this task: Vinyl Water Barrier Repair, TASK 53-21-11-300-801.
 - (b) If the entry and service area floor covering is installed, get access to the panel fasteners.
 - 1) Do this task: Entry and Service Area Floor Covering - Removal, TASK 25-27-21-000-801.
 - (c) If the nylon cord is installed in the sealant, pull the nylon cord to break the seal.
 - (d) Break the seals without a nylon cord installed with a hard resin phenolic scraper, STD-1064 or a sealant removal tool.

SUBTASK 53-21-00-020-001

- (2) Remove the fasteners.

SUBTASK 53-21-00-020-002

- (3) Remove the panel.

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SUBTASK 53-21-00-010-002

- (4) If you removed the panels over the center fuel tank and do maintenance in the area above the center fuel tank, do these steps:

28-AWL-02: CDCCL

- (a) Make sure you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

28-AWL-02: CDCCL

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Over the Center Fuel Tank Inspection, TASK 28-11-00-211-801

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

———— END OF TASK ————

TASK 53-21-00-400-801

3. Passenger Cabin Floor Panel Installation

A. General

- (1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.

- (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

B. References

Reference	Title
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
28-11-00-211-801	External Wires Over the Center Fuel Tank Inspection (P/B 601)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-00-300-801	Repair the Polyurethane Waterseal (P/B 801)
SOPM 20-30-03	General Cleaning Procedures

C. Tools/Equipment

Reference	Description
STD-449	Gun - Sealant
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic



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D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00306	Resin - Urethane - Flexane-80	
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00953	Primer - Devcon Flexane FL-20	
C50033	Chromated Conversion Coating for Aluminum - Alodine 1200	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02424	Tape - Skyflex Noise Reduction - GUA1057-1, GUA1059-1, GUA1057-144	
G50019	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283 Type I
G50029	Sleeving - Expandable, Braided (Polyester, Tight Weave)	BMS13-52 Type V
G50738	Tape - Flame Retardant Hi-Tak TufSeal, (Av-DEC - HI-TAK HT3000FR-XXX)	

E. Installation Procedure

SUBTASK 53-21-00-210-001

- (1) If you removed the panels over the center fuel tank and do maintenance in the area above the center fuel tank, do these steps:

28-AWL-02: CDCCL

- (a) Make sure you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

28-AWL-02: CDCCL

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Over the Center Fuel Tank Inspection, TASK 28-11-00-211-801.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

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SUBTASK 53-21-00-390-002

- (2) Prepare the fastener holes for the floor panel in the wet areas of the structure as follows:
 - (a) Clean and apply Alodine 1200 coating, C50033, to the bare aluminum surface on the floor support structure.
 - (b) Apply one layer of primer, C00259, to the floor support structure.
 - (c) Apply compound, C00528, (Corrosion Preventive Compound) to the holes.
 - (d) If the clipnuts were removed, install the new clipnuts as follows:
 - 1) Apply a compound, C00528, to the floor support structure at the clipnut locations.
 - 2) To improve corrosion resistance, install new composite torlon clipnuts everywhere on the floor structure at the floor panel attachment locations (preferred BACN11AL, optional BACN10YDG).
- NOTE: Be careful when you install the clipnuts to prevent scratches on the floor support structure.
- (3) Turn the clipnuts clockwise against the floor support structure.

SUBTASK 53-21-00-390-003

- (3) Before you install the floor panels in the wet area, examine the condition of the Hi-Tak TufSeal Tape, G50738 on the floor structure. Examine the GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424 on the floor panels. Do these steps to replace damaged tape:

NOTE: The wet area is between STA 270 and STA 380 and between STA 887 and STA 1016.

- (a) Remove the damaged tape from the panel or the floor support structure if needed.

CAUTION: BE CAREFUL WHEN REMOVING ADHESIVES FROM PRIMARY STRUCTURE. HARSH SCRAPING OR USE OF IMPROPER TOOLS MAY CAUSE SCRIBE DAMAGE TO THE AIRCRAFT, WHICH CAN RESULT IN FATIGUE CRACKING. CONTACT ENGINEERING IF NICKS, SCRATCHES, OR SCRIBE MARKS ARE EVIDENT ON PRIMARY STRUCTURE.

- (b) Clean scuff plates, floor panels and floor panel support structure with an approved plastic scraper and solvent, B00184 or solvent, B00666 (SOPM 20-30-03).
- (c) Apply the corrosion inhibiting compound, G00009 to the floor panel support structure if it is needed.
- (d) Apply the Hi-Tak TufSeal Tape, G50738 on the floor support structure and crease beams if it is needed.
- (e) Apply the GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424 to the floor panels if it is needed.

SUBTASK 53-21-00-400-002

- (4) Before you install floor panels in the dry area, examine the tape, G50019.

NOTE: The dry area is between section 41 and section 47, and more than 20 in. (51 cm) from a galley, lavatory or entry/service door.

SUBTASK 53-21-00-350-001

- (5) If a replacement floor panel is to be installed:

- (a) Make sure that the new floor panel has the same contour and dimensions as the removed floor panel.

SUBTASK 53-21-00-420-004

- (6) Align the floor panel with the holes in the floor support structure.

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SUBTASK 53-21-00-420-002

- (7) Install the screws with wet compound, C00528, until they are smooth with the floor panel.
NOTE: Do not tighten the screws.

SUBTASK 53-21-00-820-001

- (8) Do these steps to torque the floor panel screws:
- Tighten the screws on the panels with the two-piece insert to 22.5 ± 2.5 in-lb (2.5 ± 0.3 N·m).
NOTE: Do a check of the torque before the installation of the floor covering.
 - Tighten the screws on the panels with the one-piece insert to 32.5 ± 2.5 in-lb (3.7 ± 0.3 N·m).
NOTE: Let the panel dish at the fastener -0.005 in. (-0.127 mm) to 0.030 in. (0.762 mm).

SUBTASK 53-21-00-220-001

Figure 401

- (9) Examine the floor panel clearances.

SUBTASK 53-21-00-390-005

- (10) Apply one layer of Scotch Flatback Masking Tape 250, G00270, to the edge of the joints that are adjacent to and along the full length of the clearance at the edges of the panels.

SUBTASK 53-21-00-420-003

- (11) Apply sealant, A00247, or sealant, A02315 (preferred) as follows:
- Apply sealant in the clearance between the floor panel and the crease beam in the wet area that follows:
 - From station 344.00 to station 380.00.
 - Then apply the sealant to the rest of the wet and dry areas as follows:
 - The remaining openings between the floor panels.
 - The seat tracks.
 - The bulkheads.
 - The mounting hard points.
 - The door drain gutter.
 - The mop sill.

SUBTASK 53-21-00-390-006

CAUTION: DO NOT CAUSE A BLOCKAGE WHEN YOU APPLY THE SEALANT NEAR OR AROUND THE FUSELAGE DRAIN HOLES, OR PATHS. THE FUNCTION OF THE DRAIN HOLES IS TO DRAIN CONDENSATION AND FLUIDS OVERBOARD. IF YOU CAUSE A BLOCKAGE, FLUIDS WILL COLLECT IN THE AIRPLANE. THE FLUIDS CAN CAUSE CORROSION TO THE STRUCTURE, OR A FIRE IF THE FLUIDS ARE FLAMMABLE.

- (12) If you apply Flexane-80 resin, A00306, do these steps:
- Install the sleeve, G50029 around the edges of the panel.
 - Apply the Devcon Flexane FL-20 primer, C00953.
 - Apply the Flexane-80 resin, A00306 (alternate), with a sealant gun, STD-449, or hardwood or plastic fillet smoothing spatula, STD-810.
 - Make sure there are no air bubbles when you apply the sealant.

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- (e) Use a hardwood or plastic fillet smoothing spatula, STD-810, to make the seal smooth with the Scotch Flatback Masking Tape 250, G00270.

SUBTASK 53-21-00-390-007

- (13) Make the edges of the seal smooth.
- (a) Remove all of the unwanted compound with hardwood or plastic fillet smoothing spatula, STD-810.
 - (b) Remove the Scotch Flatback Masking Tape 250, G00270, after the seal is smooth or let the Scotch Flatback Masking Tape 250, G00270, stay during the curing time.
 - (c) Install the moisture barrier if it is applicable, do this task: Repair the Polyurethane Waterseal, TASK 53-21-00-300-801.

SUBTASK 53-21-00-400-004

- (14) If the entry and service area floor covering is installed.
- (a) Do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

———— END OF TASK ————

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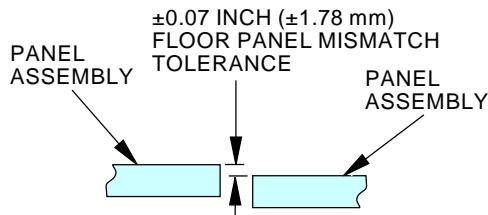
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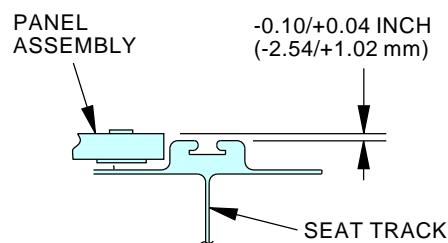
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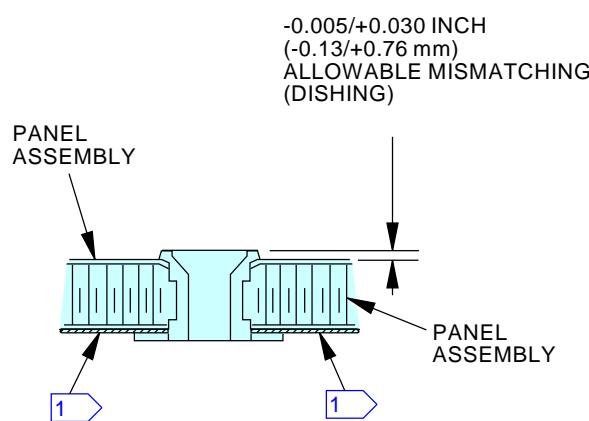
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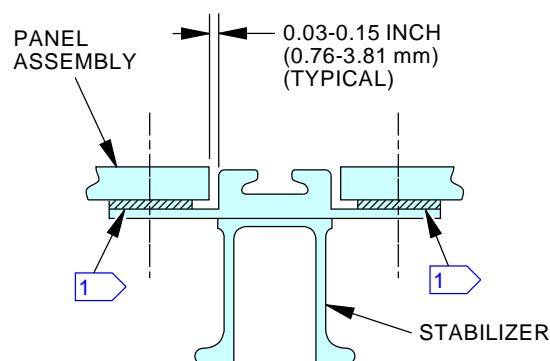
TYPICAL MISMATCH DIMENSION
FOR FLOOR PANEL INSTALLATION



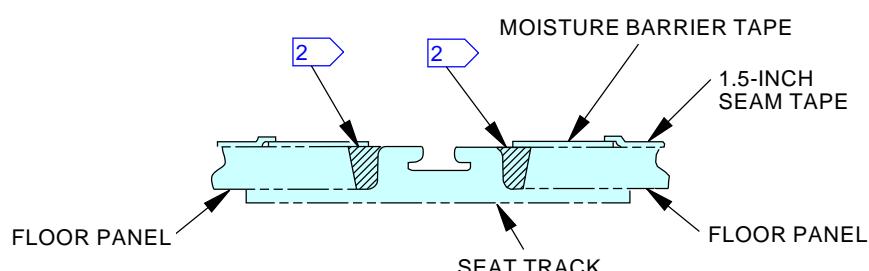
TYPICAL MISMATCH DIMENSION
FOR FLOOR PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION
FOR FLOOR PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION
FOR FLOOR PANEL INSTALLATION



- 1 HI-TAK TAPE
2 SEALANT

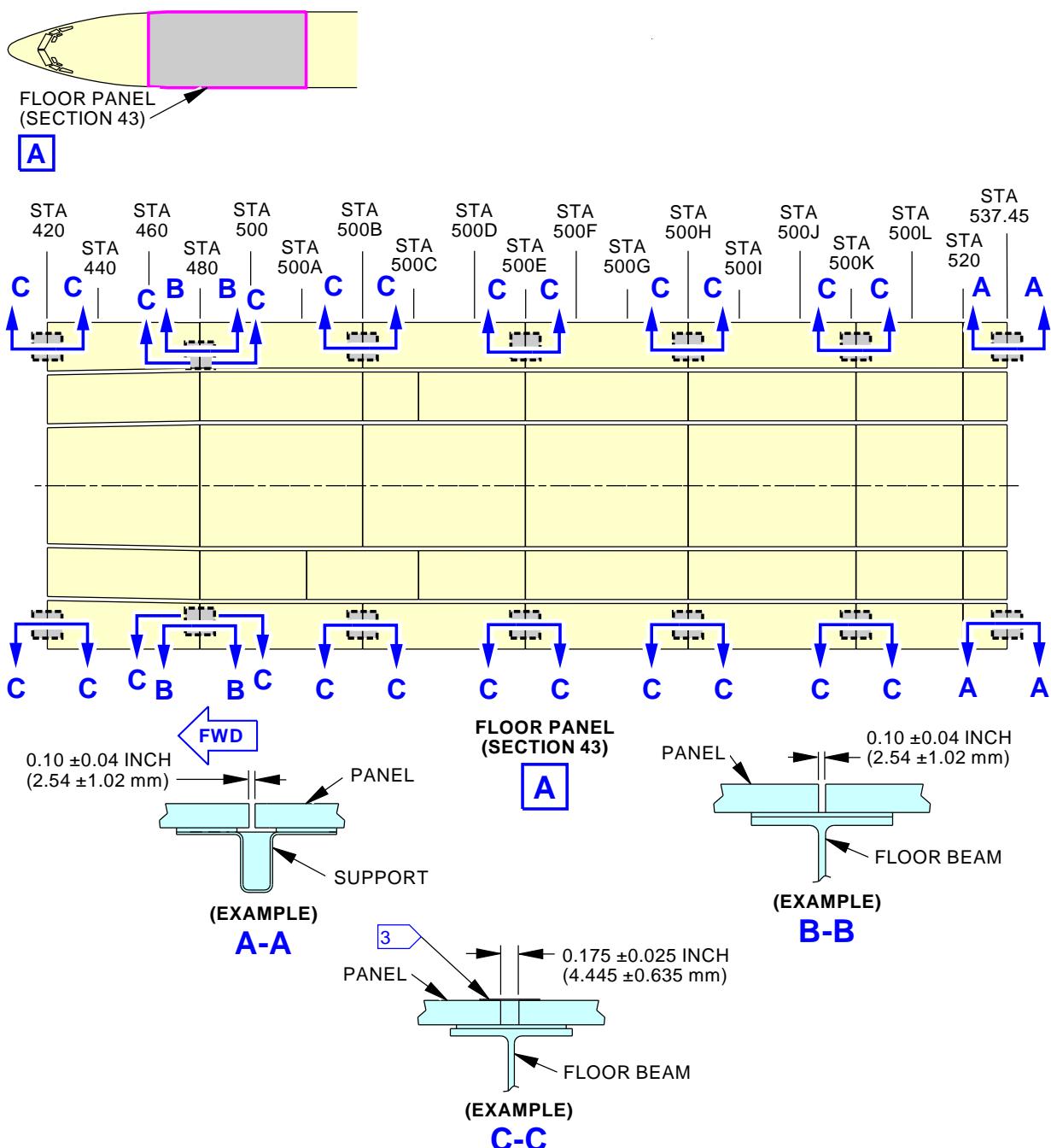
TYPICAL FLOOR PANEL
SEALING AT SEAT TRACKS

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Floor Panel Installation and Sealing
Figure 401/53-21-00-990-803 (Sheet 1 of 2)

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- 3** IF CLEARANCE IS MORE THAN 0.22 INCH (5.59 mm).
INSTALL BACS40R010U190 BETWEEN THE SEATRACKS,
AND INSTALL THE CLEARANCE COVER SHIM
BACS40R010U477 IN AISLE.

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Floor Panel Installation and Sealing
Figure 401/53-21-00-990-803 (Sheet 2 of 2)

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POLYURETHANE WATERSEAL - REPAIRS

1. General

- A. This procedure contains the task to repair polyurethane waterseal on passenger floors in wet areas of the aircraft, which are defined as that part of the floor that is local to doorways, galleys and lavatories.
- B. The waterseal installation is intended to reduce corrosion of floor structure by preventing liquids spilled in wet areas from traveling below floor level.

TASK 53-21-00-300-801

2. Repair the Polyurethane Waterseal

Figure 801

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G02423	Tape - Moisture Barrier - 3 Feet Wide - 3M 8663	
G02500	Tape - Moisture Barrier - 4 inch Wide - 3M 8663DL	
G50179	Tape - Moisture Barrier, Adhesive One-side, Clear Polyurethane	BMS8-346 Type I

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 53-21-00-420-001

- (1) If the tape shows deterioration or damage because of the floor panel removal, install the new polyurethane tape.

SUBTASK 53-21-00-420-005

- (2) Do these steps to install the moisture barrier:

- (a) Make sure the floor panels and the seat tracks are clean according to BAC5750 before you install the moisture barrier.

- (b) Install the polyurethane moisture barrier in the wet areas of the floor structure as follows:

NOTE: The moisture barrier must be, as much as possible, one continuous piece. Do not try to fit the moisture barrier below lavatories or galleys where removal of these fixtures is necessary.

The maximum permitted overlap between two pieces of the moisture barrier is 4 in. (102 mm).

- 1) Center the moisture barrier tape, G50179 on floor panel joint to cover sealant and fasteners/inserts.

NOTE: The moisture barrier tape, G50179 is applied only to joints between two floor panels and not to other structure including seat track, gutters, lavatory and galley mounts, crease beams and partition walls.

- a) Apply the tape against the floor while removing the backing.

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- b) If air bubbles trapped under the tape, re-apply by pulling the tape back off the floor panel and re-smooth it down.
- c) Make sure the tape overlap by a minimum of 0.5 in. (12.7 mm) where you have a splice.
- d) Cut the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.
- 2) Position a section of 3M 8663 tape, G02423 with backing still in place, on the entire wet area laying the tape in forward/aft direction.
 - a) Mark the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.

CAUTION: DO NOT CUT THE WATER SEAL TAPE AGAINST THE FLOOR PANEL, OR OTHER STRUCTURE. DAMAGE TO THE STRUCTURE, OR FINISHES ON THE STRUCTURE WILL OCCUR.

- b) Trim the tape at marked locations.
 - c) Remove the backing from the adhesive side and put the tape on the floor. Cover any flush lavatory/galley mounts or girt bar attach fittings.

NOTE: Be careful not to stretch the tape while smoothing it down.
 - d) If air bubbles trapped under the tape, re-apply by pulling the tape back off the floor panel and re-smoothing it down.
 - e) Remove the backing from the non adhesive side of the tape.
 - 3) Install the adjacent sections of 3M 8663 tape, G02423, overlap onto the existing water seal tape by 1 in. (25 mm) to 3 in. (76 mm).

NOTE: An overlap of 2 in. (51 mm) will cause the edge of the waterseal tape splice and the edge of the seam tape to align. This may show through the galley/entryway mat.
 - 4) If a section of 3M 8663 tape, G02423 must be spliced longitudinally for some reason, do these steps:
 - a) Put down the first section of tape.
 - b) Apply a bead of sealant, A00247 per BAC5000 to the edge of the waterseal tape that will be covered by the second section. This fillet will prevent water from being able to travel under the tape through the small gap left at the edge of the underlying section of waterseal tape.
 - c) Apply the second section of 3M 8663 tape, G02423, overlap the first by 1 in. (25 mm) to 3 in. (76 mm).

NOTE: Too many splices or splices located in the wrong place may cause excessive tape build up that will show through floor coverings
 - 5) Apply 3M 8663DL tape, G02500 to all of the 3M 8663 tape, G02423 splices. The tape must be centered on the overlapping edge of the waterseal tape and shall be continuous, not spliced at any point.
- (3) Do these steps to seal the seat tracks (open track, no filler):
- (a) Apply fillet sealant, A00247 to all waterseal edges where it cut back from the seat track.
 - (b) Put a strip of 3M 8663DL tape, G02500 down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.

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- 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 2) Push the tape down firmly to smooth out the sealant bead.
 - 3) Make sure the seam tape strips is continuous with no splices.
 - 4) Apply fillet sealant, A00247 to the edge of the previous applied seam tape.
- (c) Put a small strip of 3M 8663DL tape, G02500 at the end of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
- 1) Extend the seam tape to overlap onto previous applied seam tape a minimum of 1 in. (25 mm).
 - 2) Push the tape down firmly to smooth out the sealant bead.
- (4) Do these steps to seal seat tracks with no filler (open track): (Alternative methods)
- (a) Method 1
 - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
 - 2) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 3) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
 - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - 5) Remove the backing from the nonadhesive side of the tape.
 - (b) Method 2
 - 1) Install the 3M 8663 tape, G02423 to the floor panel except the seat track.
 - 2) Apply a bead of sealant, A00247 to the edge of the waterseal around the perimeter of the seat track.
 - (c) Method 3
 - 1) Put a strip of 3M 8663DL tape, G02500 down each side of the seat track with one edge along the edge of the seat track crown.
 - a) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
 - c) Apply a bead of sealant, A00247 to the perimeter of the seam tape except the edge next to the seat track.
 - 2) Install the 3M 8663 tape, G02423 , overlap the seam tape.
 - a) Push the tape down firmly to smooth out the sealant bead.
- (5) Do these steps to seal seat tracks with filler:
- (a) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
 - (b) Put a strip of 3M 8663DL tape, G02500 down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
 - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 2) Push the tape down firmly to smooth out the sealant bead.

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- 3) Make sure the seam tape strips is continuous with no splices.
- (c) Center a strip of 3M 8663DL tape, G02500 over the seat track and filler, overlap the previous applied seam tape.
 - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 2) Make sure the seam tape strips is continuous with no splices.
- (6) Do these steps to seal seat tracks with filler: (Alternative methods)
 - (a) Method 1
 - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
 - 2) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 3) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
 - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - 5) Remove the backing from the nonadhesive side of the tape.
 - (b) Method 2
 - 1) Install the 3M 8663 tape, G02423 directly over the seat track without trimming it back around the perimeter.
 - 2) Apply a bead of sealant, A00247 to the edge of the waterseal around the perimeter of the seat track.

NOTE: Do not splice the waterseal tape over the seat track.
 - (c) Method 3
 - 1) Put a strip of 3M 8663DL tape, G02500 down each side of the seat track with one edge along the edge of the seat track crown.
 - a) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
 - c) Apply a bead of sealant, A00247 to the perimeter of the seam tape except the edge next to the seat track.
 - 2) Install the 3M 8663 tape, G02423, overlap the seam tape.
 - a) Push the tape down firmly to smooth out the sealant bead.
 - b) Trim the waterseal tape to the edge of the seat track crown.
 - 3) Center a strip of 3M 8663DL tape, G02500 on the seat track and filler, overlap the previous applied waterseal tape.
 - a) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
- (7) Do these steps to seal lavatory and galley mounts:
 - (a) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to either cover flush mounts or to extend into the radius of protruding mounts.
 - (b) Extend the tape to overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).

EFFECTIVITY
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- (c) Apply fillet sealant, A00247 to all tape edges where it cut back from the edges of the mounts.
 - (d) Apply fillet sealant, A00247 to the edges of any protruding mounts.
 - (e) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - (f) Remove the backing from the non-adhesive side of the tape.
- (8) Do these steps to seal lavatory and galley mounts: (Alternative methods)
- (a) Method 1
 - 1) Apply fillet sealant, A00247 to the edges of any protruding mounts.
 - 2) Apply the 3M 8663 tape, G02423 to either cover flush mounts or to the radius of protruding mounts.
 - 3) Remove the backing from the non-adhesive side of the tape.
 - 4) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to either cover flush mounts or to extend into the radius of protruding mounts.
 - 5) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
 - 6) Remove the backing from the non-adhesive side of the tape.
 - 7) Apply fillet sealant, A00247 to the edges of any protruding mounts.
 - (b) Method 2
 - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to either cover flush mounts or to extend into the radius of protruding mounts.
 - a) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
 - b) Remove the backing from the non-adhesive side of the tape.
 - c) Apply sealant to the outer edges of the patch.
 - 2) Apply the 3M 8663 tape, G02423 to overlap the patch.
 - a) Remove the backing from the non-adhesive side of the tape.
 - b) Apply sealant, A00247 to the inner edges of the tape.
 - 3) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to either cover flush mounts or to extend into the radius of protruding mounts.
 - a) Extend the tape to overlap the previous installed tape by a minimum of 1 in. (25 mm).
 - b) Remove the backing from the non-adhesive side of the tape.
 - c) Apply fillet sealant, A00247 to the edges of any protruding mounts.
- (9) Do these steps to seal the door gutters:
- (a) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 to fit over the gutter and girt bar fitting for forward entry door.
 - (b) Extend the tape a minimum of 1 in. (25 mm) onto the existing waterseal tape.
 - (c) Trim the tape at the edge of the gutter.
 - (d) The forward and aft ends of the patch must extend a minimum of 2 in. (51 mm) past the door edge frames.
 - (e) Apply sealant, A00247 to all waterseal tape edges where it cut back from the edge of the gutter.

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- (f) Apply a bead of sealant, A00247 to the existing sealant at the edge of the gutter and along the side of body crease beam chord.
 - (g) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - (h) Remove the backing from the non-adhesive side of the tape.
- (10) Do these steps to seal the floor panel edges at side of body crease beam:
- (a) Trim the 3M 8663 tape, G02423 to the edge of the floor panels at the side of body.
 - 1) Apply a bead of sealant, A00247 to the existing sealant at the side of body crease beam and fair it smooth.
 - 2) Apply sealant, A00247 to the edge of door gutter patch.
 - (b) Apply the 3M 8663DL tape, G02500 on the sealant at the side of body to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and above the top edge of the side of body crease beam chord.
 - 1) Extend the tape to overlap onto the door gutter patch a minimum of 1 in. (25 mm).
 - 2) Push the seam tape until it touch and stick to the faired sealant.
 - 3) Trim the seam tape to the top edge of the side of body crease beam chord.
- (11) Do these steps to seal the floor panel edges at side of body crease beam: (Alternative method)
- (a) Apply a bead of sealant, A00247 to the existing sealant at the side of body crease beam and fair it smooth.
 - (b) Apply 3M 8663 tape, G02423 on the sealant at the side of body to extend above the top edge of the side of body crease beam chord.
 - (c) Push the waterseal tape until it touch and stick to the faired sealant.
 - (d) Trim the waterseal tape to the top edge of the side of body crease beam chord.
- (12) Do these steps to seal the floor panel edges adjacent to bulkheads:
- (a) Trim the 3M 8663 tape, G02423 to the edge of the floor panels or the bulkhead base at the flight deck partition.
 - 1) Apply a bead of sealant, A00247 to the existing sealant or bulkhead base at the flight deck partition and fair it smooth.
 - (b) Apply 3M 8663DL tape, G02500 on the sealant at the flight deck partition to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and wrap up the flight deck partition a minimum of 2 in. (51 mm).
 - 1) Push the seam tape until it touch and stick to the faired sealant.
- (13) Do these steps to seal the floor panel edges adjacent to flight deck transition:
- (a) Trim the 3M 8663 tape, G02423 to the edge of the floor panels adjacent to the flight deck.
 - (b) Apply 3M 8663DL tape, G02500 on the edge of the waterseal tape extending over the lip and onto the vertical surface adjacent to the flight deck.

SUBTASK 53-21-00-300-001

- (14) Do these steps to repair cuts or air bubbles trapped under moisture barrier tape:

NOTE: Any air bubble must be less than 0.5 in. (12.7 mm) square inches in total area. In the walkway area, bubble must be less than 0.05 in. (1.27 mm) in height and less than 0.1 in. (2.5 mm) in height elsewhere.

NOTE: Air bubbles greater than 0.1 in. (2.5 mm) square inches in area must be limited in number to 10 or less in any 1 ft (305 mm) diameter area.

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- (a) To repair the air bubble, use a sharp blade to cut the tape over the bubble and squeeze the air out. Be careful not to damage the underlying floor panel or structure.
- (b) Apply a small bead of sealant, A00247 on the cut.
- (c) Apply new tape and push down firmly to smooth out the sealant bead.
- (d) Make sure the repair tape overlap the cut by a minimum of 2 in. (51 mm).

———— END OF TASK ————

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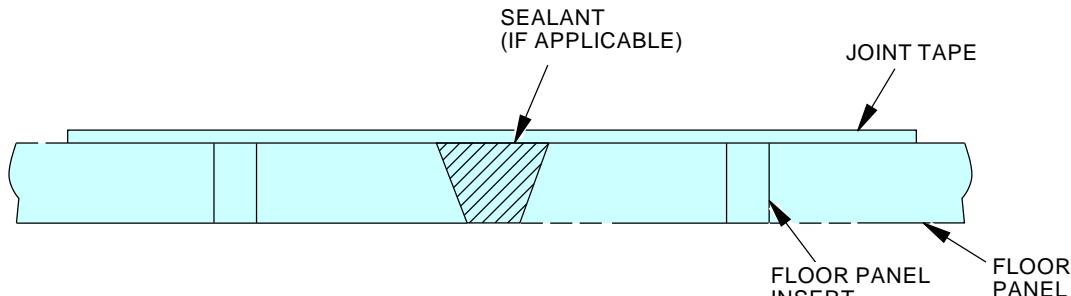
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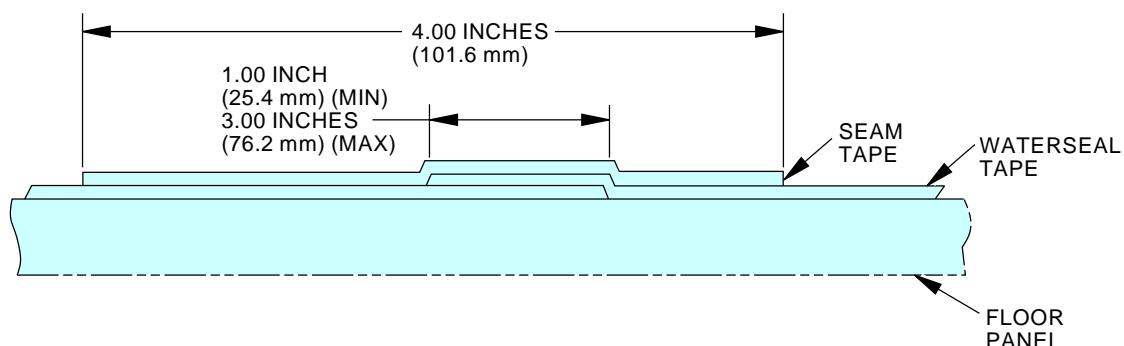
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JOINT TAPE INSTALLATION
(EXAMPLE)



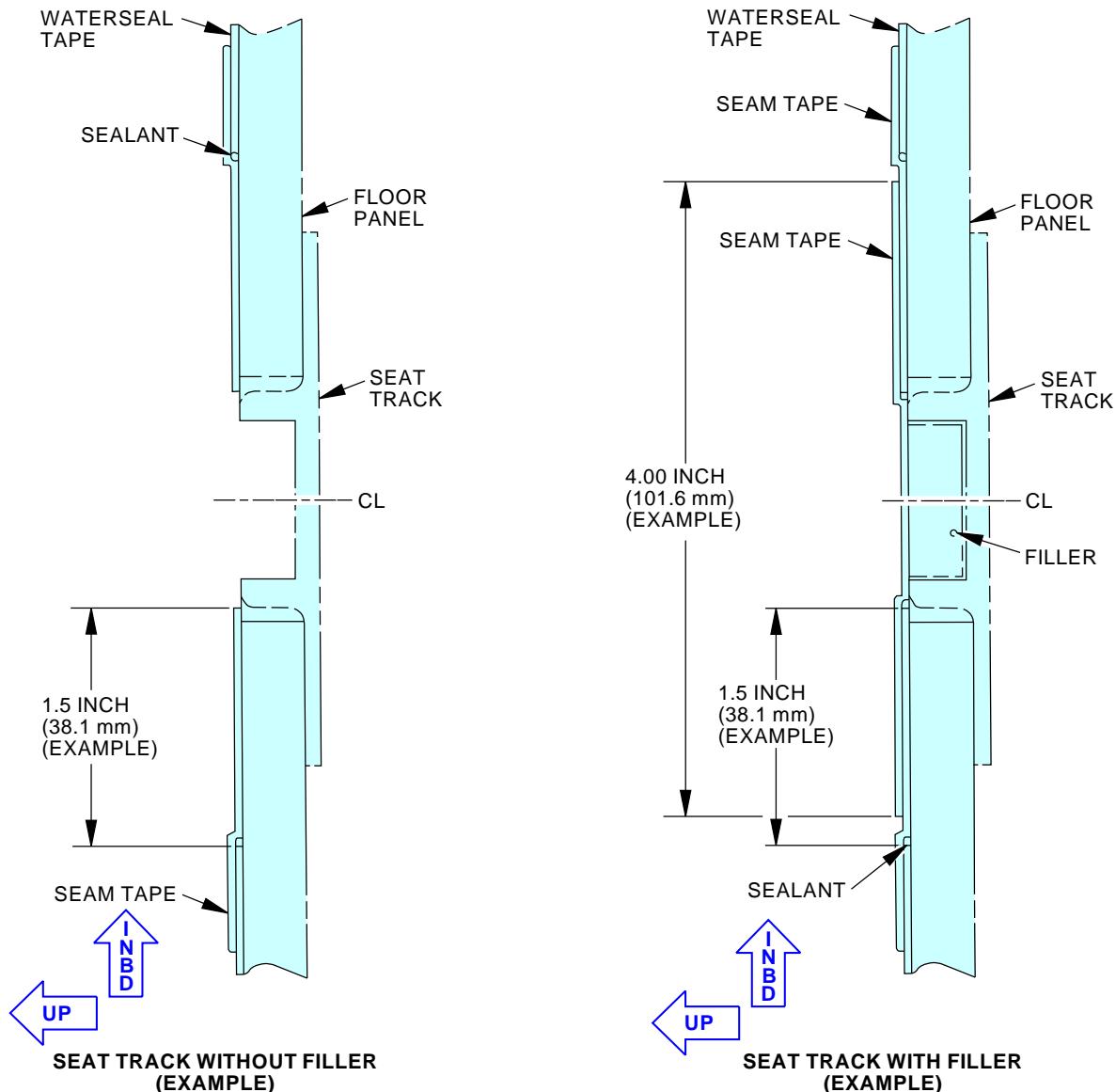
WATERSEAL SPLICE
(EXAMPLE)

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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 1 of 7)

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2179399 S0000481178_V2

Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 2 of 7)

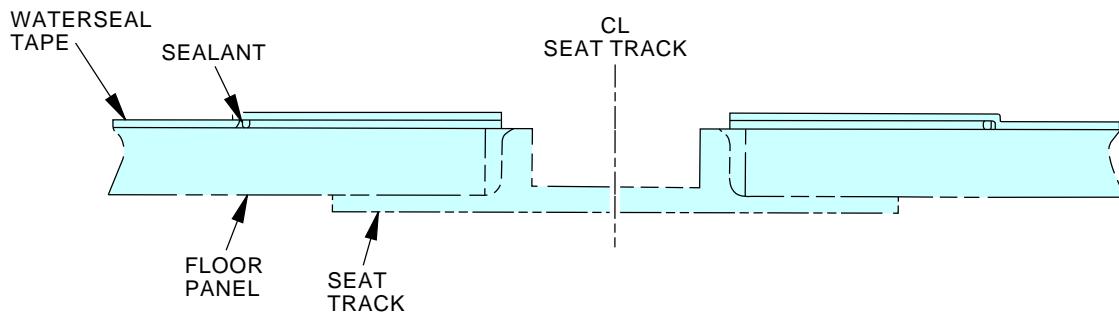
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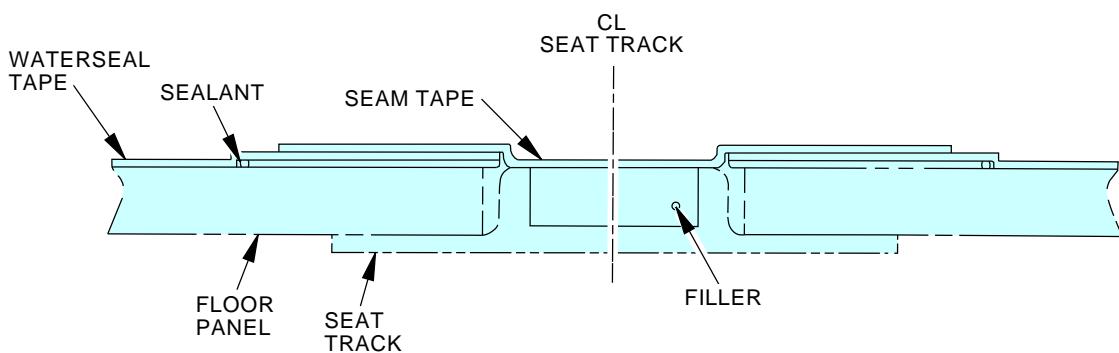
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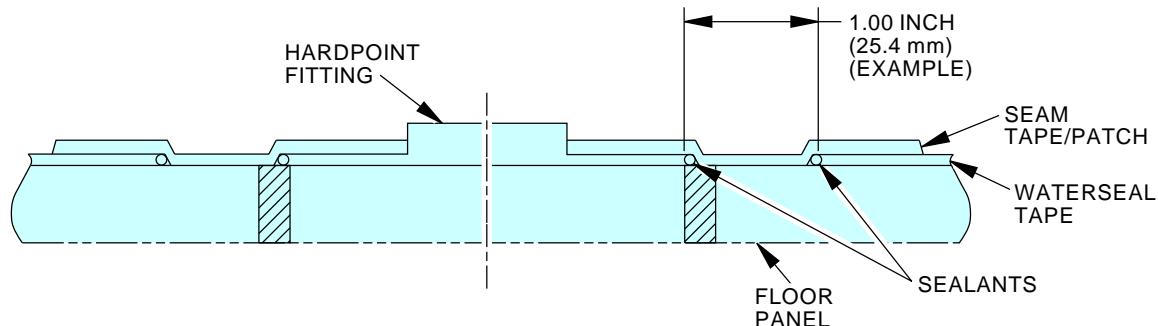
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SEAT TRACK WITHOUT FILLER
(OPTIONAL METHOD 3)



SEAT TRACK WITH FILLER
(OPTIONAL METHOD 3)



LAVATORY AND GALLEY HARDPOINT FITTINGS
(EXAMPLE)

2179827 S0000481179_V2

Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 3 of 7)

EFFECTIVITY
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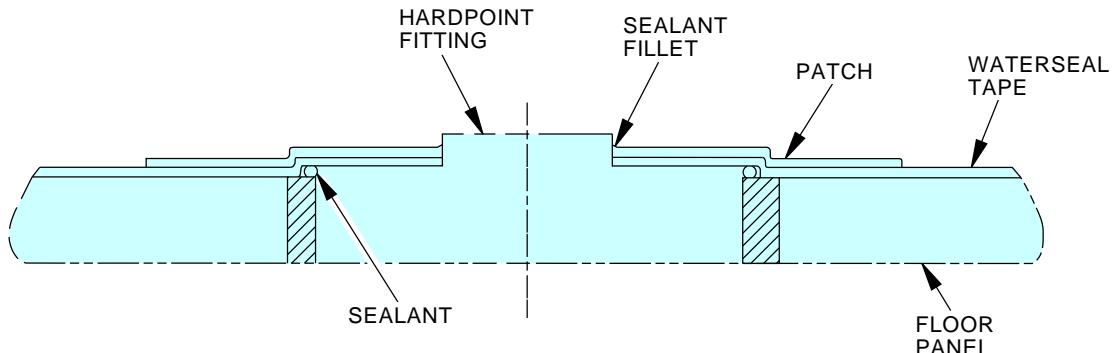
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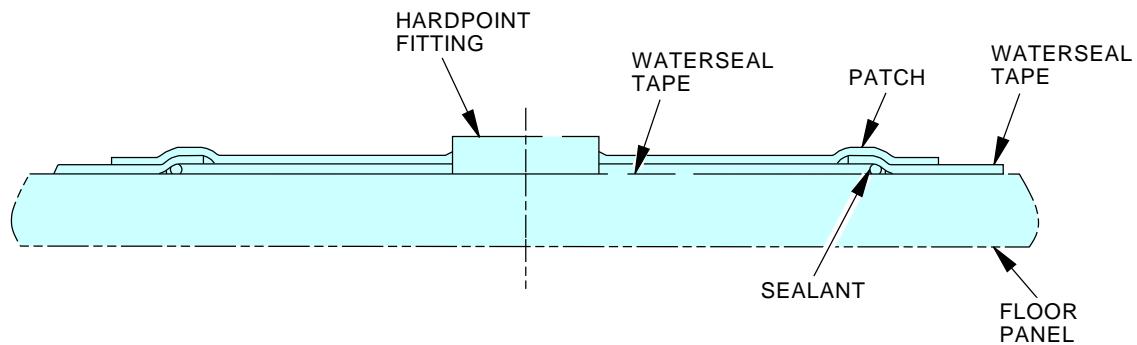
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LAVATORY AND GALLEY HARPOINTER FITTINGS
(OPTIONAL METHOD 1)



LAVATORY AND GALLEY HARPOINTER FITTINGS
(OPTIONAL METHOD 2)

2180025 S0000481180_V2

Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 4 of 7)

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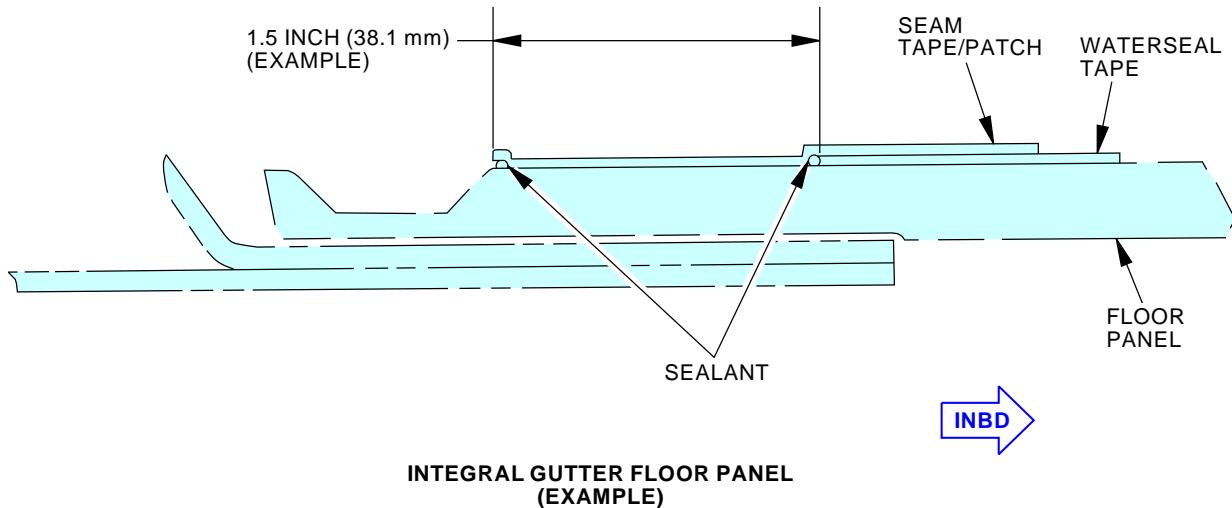
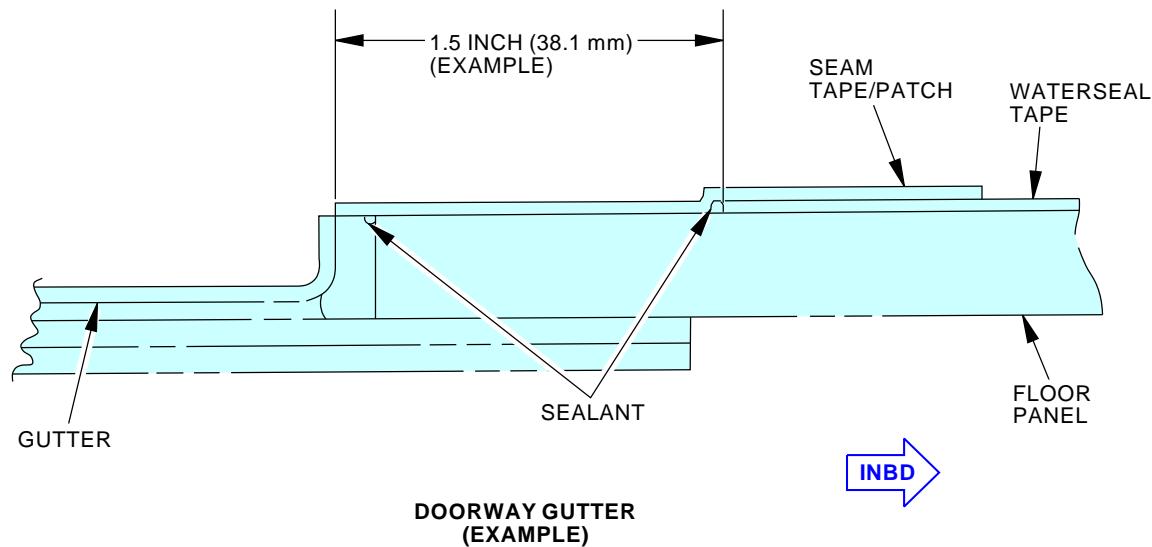
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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 5 of 7)

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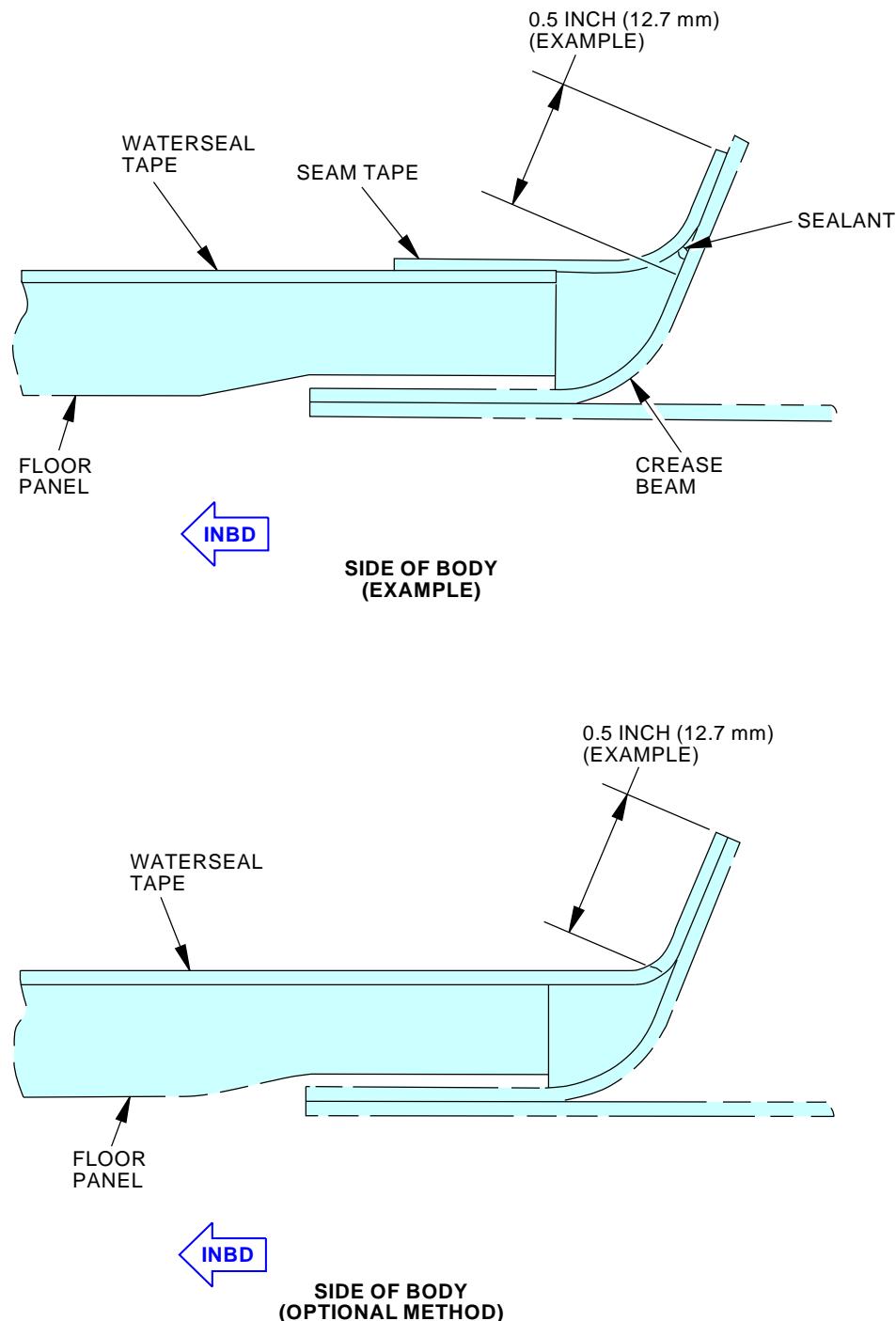
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Water Seal Tape Application
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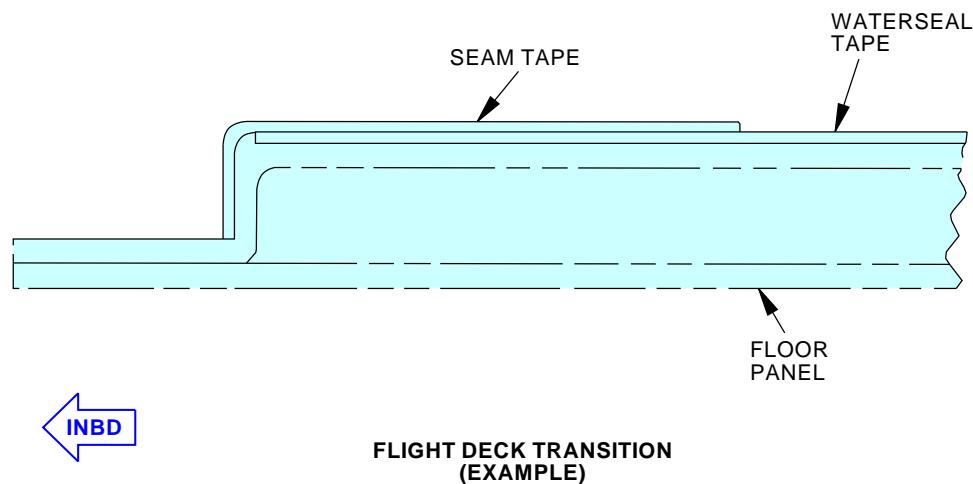
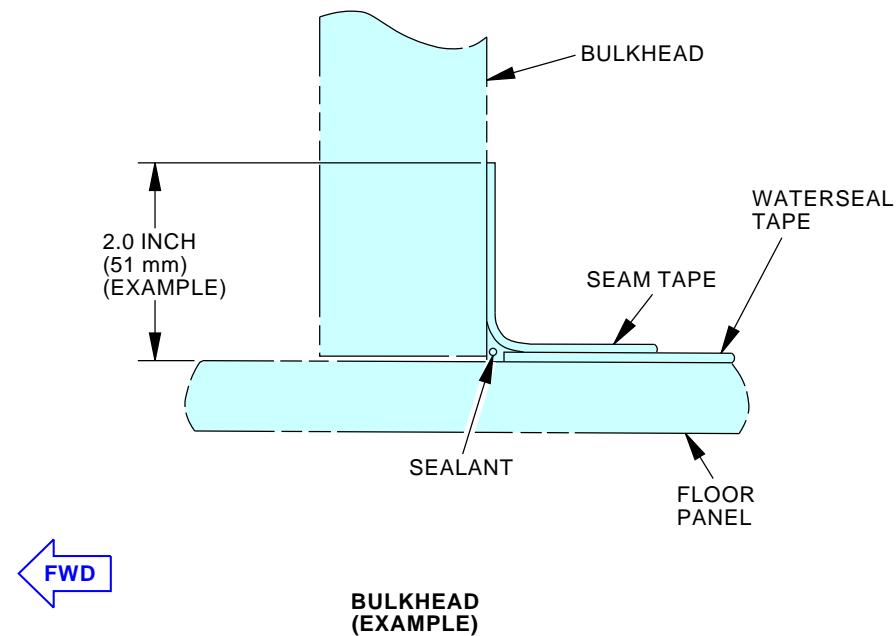
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Water Seal Tape Application
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WATER BARRIER - REPAIRS

1. General

- A. This procedure contains two tasks. The first task is the repair of the vinyl part of the water barrier. The second task is the repair of the mylar part of the water barrier.
- B. The water barrier has mylar sheets (transparent), vinyl sheets (nontransparent) or 18 in. (457 mm) wide strips of tape bonded to the floor panels. This procedure gives instructions on how to cut the water barrier for the removal of a floor panel. It also gives instructions on how to repair the water barrier with the floor panel installed.
- C. The vinyl tape at right angles to the seat tracks with a 1.00 in. (25.40 mm) overlap is the preferred replacement of the water barrier.
- D. Cut through the water barrier around the edges of the floor panel to remove the floor panel. Pull back the vinyl to get to the fasteners for the floor panels. If mylar is on the floor panel fasteners, cut a circular patch for each fastener.

TASK 53-21-11-300-801

2. Vinyl Water Barrier Repair

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G00157	Tape - Nitto P-306L (use until stock depleted)	

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 53-21-11-350-001

- (1) Apply the Nitto P-306L tape, G00157 vinyl tape at right angles to the seat tracks with a minimum of a 1.00 in. (25.40 mm) overlap.

SUBTASK 53-21-11-390-001

- (2) Apply a sealant, A00247 to the tape overlap.

NOTE: You can use 3.00 in. (76.20 mm) wide tape on the edge of the overlap as an alternative to the sealant.

— END OF TASK —

TASK 53-21-11-300-802

3. Mylar Water Barrier Repair

A. References

Reference	Title
53-21-00-400-801	Passenger Cabin Floor Panel Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00156	Adhesive - For Bonding Mylar And Nylon, 2 Part, RT Cure	BMS5-31
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III

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(Continued)

Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00111	Sheet - Mylar	

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Repair of the Mylar Water Barrier

SUBTASK 53-21-11-410-001

- (1) Do this task: Passenger Cabin Floor Panel Installation, TASK 53-21-00-400-801.

SUBTASK 53-21-11-350-002

- (2) Cut strips of mylar sheet, G00111 to make a splice with the edges of the floor panel.

NOTE: The splice must make a 0.75-inch (19 mm) overlap with the fastener line and adjacent floor panel 3/4 inch (19 mm).

SUBTASK 53-21-11-140-001

- (3) Clean the mating surfaces with solvent, B00083.

SUBTASK 53-21-11-350-003

- (4) Mix 100 parts by weight of the adhesive, A00156 Pro-Seal 501 with 30 parts by weight of the Pro-Seal 501-A accelerator. Mix for approximately 5 minutes with a spatula or an equivalent tool. If you mix the adhesive in the original can, cut off the rim of the can to make it easier.

NOTE: Apply the adhesive as soon as it is possible. The heat of the material in a container decreases the work life. The Work life is 20 minutes at 77°F (25°C). Use 50 (± 5) grams for each square foot of the surface that you cover.

E. Repair Procedure

SUBTASK 53-21-11-390-002

- (1) Apply a layer of adhesive to the mating surface of the splice.

SUBTASK 53-21-11-390-003

- (2) Bond the splice to the water barrier.

SUBTASK 53-21-11-140-002

- (3) Remove the unwanted adhesive with a clean cotton wiper, G00034 moist with solvent, B00083.

SUBTASK 53-21-11-350-004

- (4) Put a weight or tape on the edges that show signs of delamination until the adhesive dries.

SUBTASK 53-21-11-860-001

- (5) Let the adhesive dry for a minimum of 2 hours.

NOTE: A minimum of 12 hours is necessary for the adhesive to fully dry.

— END OF TASK —

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NOSE VORTEX GENERATORS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks.
 - (1) The first task is the removal of the nose vortex generators.
 - (2) The second task is the installation of the nose vortex generators.

TASK 53-31-11-000-801

2. Remove the Nose Vortex Generators

(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
COM-2481	Tool - Sealant Removal, BAC5000, PSD 6-184 Approved
	Part #: 1-6390-A Supplier: 63318
	Part #: 10810 Supplier: \$0855
	Part #: 234350 Supplier: \$0857
	Part #: 235072 Supplier: \$0857
	Part #: 235073 Supplier: \$0857
	Part #: 235074 Supplier: \$0857
	Part #: 235075 Supplier: \$0857
	Part #: 235076 Supplier: \$0857
	Part #: 235077 Supplier: \$0857
	Part #: 235078 Supplier: \$0857
	Part #: 235079 Supplier: \$0857
	Part #: 235080 Supplier: \$0857
	Part #: 235081 Supplier: \$0857
	Part #: 311 Supplier: KA861
	Part #: 411B60 Supplier: 3DN12
	Part #: 411B90 Supplier: 3DN12
	Part #: DAD5013 Supplier: \$0856
	Part #: DFD5019 Supplier: \$0856
	Part #: J5-0275-2010 Supplier: 435R8
	Part #: SCD5019 Supplier: \$0856
	Part #: ST982LF-9 Supplier: 3Z323
	Part #: TS1275-4 Supplier: 1DWR5

B. Location Zones

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

C. Procedure - Remove the Nose Vortex Generators

SUBTASK 53-31-11-020-001

- (1) Remove the loose vortex generator [1] with sealant removal tool, COM-2481.

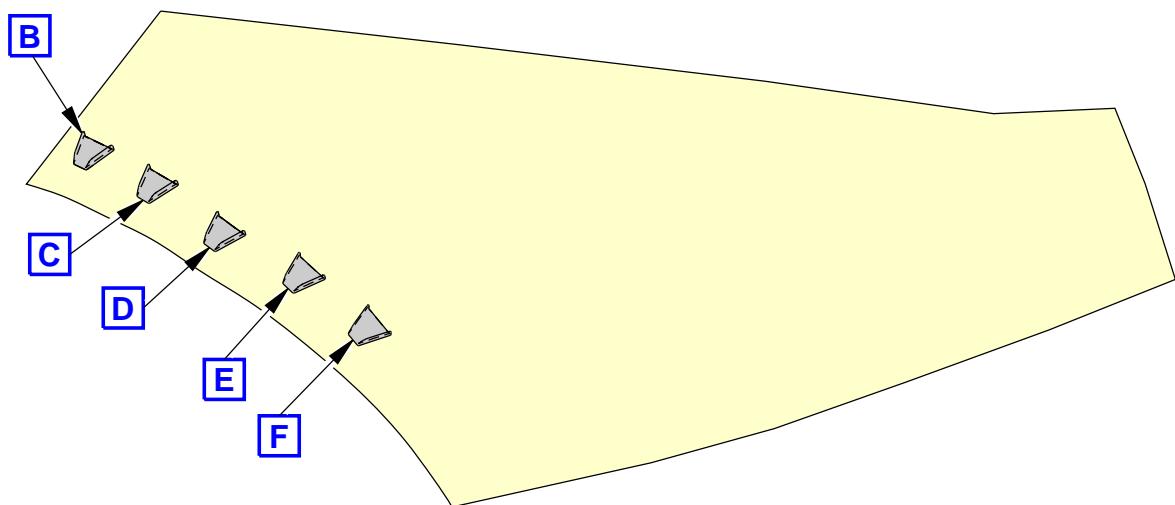
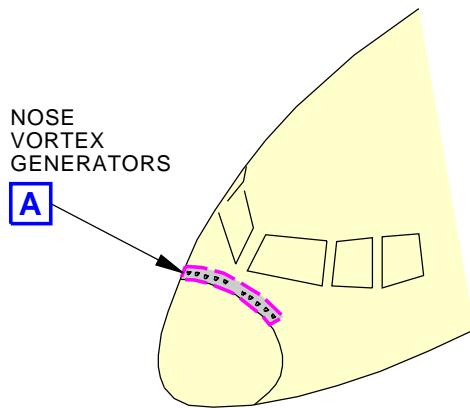
———— END OF TASK ————



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NOSE VORTEX GENERATORS



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Nose Vortex Generators
Figure 401/53-31-11-990-801 (Sheet 1 of 2)

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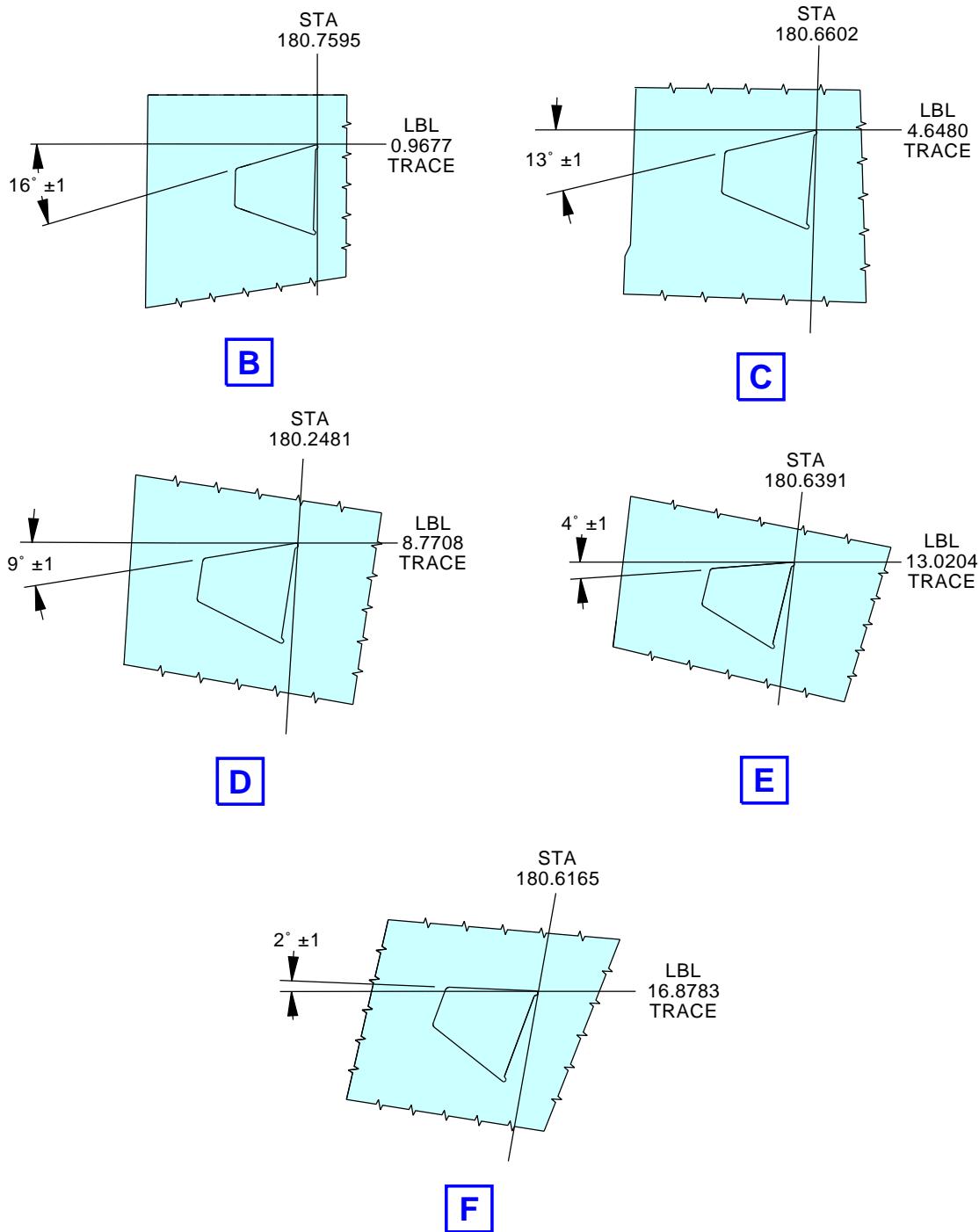
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Nose Vortex Generators
Figure 401/53-31-11-990-801 (Sheet 2 of 2)

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TASK 53-31-11-400-801

3. Install the Nose Vortex Generators

(Figure 401)

A. References

Reference	Title
51-31-00-160-801	Prepare For Sealing (P/B 201)
57-32-00-993-802	Table: Cure Time For BMS 5-44 (Class B), BMS 5-45 (Class B) and PR-1828 (Class B) (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00436	Sealant - Fuel Tank	BMS5-45 (Supersedes BMS5-26)
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)

C. Location Zones

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

D. Procedure - Install the Nose Vortex Generator

SUBTASK 53-31-11-150-001

- (1) Clean the mating surface, do this task: Prepare For Sealing, TASK 51-31-00-160-801

SUBTASK 53-31-11-410-001

- (2) Put the vortex generator [1] in the correct position.

SUBTASK 53-31-11-410-002

- (3) Do the steps that follow to bond the vortex generator to the upper wing surface:

WARNING: DO NOT GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES. PUT ON PROTECTIVE CLOTHING, GOGGLES AND A FACE MASK. USE IN A WELL VENTILATED AREA. DO NOT BREATHE THE GAS. IF YOU GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES, WIPE IT AWAY. GET MEDICAL AID IF YOUR SKIN OR EYES BECOME IRRITATED.

- (a) Mix the base compound for the sealant, A00551 with the activator.

NOTE: Refer to the manufacturer's instructions for the details.

- 1) Do not thin the sealant.

- (b) Apply a thin, constant layer of the adhesive mixture to each mating surface.

- (c) Put the vortex generator on the nose section surface immediately, with sufficient pressure.

NOTE: Make sure that the surfaces are sealed together fully. Make sure that a continuous bead of extruded adhesive is around the edge of the vortex generator. This seals the surfaces together and shows a correct seal.

- (d) Remove the unwanted adhesive around the edges of the vortex generator.

SUBTASK 53-31-11-410-003

- (4) Fillet seal around the vortex generator.

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- (a) Make the fillet seal to 0.03 in. (0.76 mm) by 0.03 in. (0.76 mm).

NOTE: If more sealant is necessary for the fillet seal, use sealant, A00436 Class B.

SUBTASK 53-31-11-410-004

- (5) After the adhesive dries, (Table 57-32-00-993-802), apply paint to the nose section surface if it is necessary.

Table 401/53-31-11-993-801 Cure Time For BMS 5-44 (Class B) and BMS 5-45 (Class B)

Adhesive	Cure Time
BMS 5-44 Class B-1/2	24 hours at standard conditions
BMS 5-44 Class B-2	48 hours at standard conditions
BMS 5-45 Class B-1/2	12 hours at standard conditions
BMS 5-45 Class B-2	24 hours at standard conditions

———— END OF TASK ————

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VORTEX GENERATOR ASSEMBLY - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks:
 - (1) The removal of the vortex generator assembly.
 - (2) The installation of the vortex generator assembly.
- B. The vortex generator assembly is installed on the left and right side of the fuselage above the horizontal stabilizer. The function of the vortex generators are to increase the efficiency of the airflow over the flying surface.

TASK 53-31-21-000-801

2. Vortex Generator Assembly Removal

(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.

<u>Reference</u>	<u>Description</u>
SPL-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin

B. Location Zones

<u>Zone</u>	<u>Area</u>
300	Empennage

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

D. Prepare for the Removal

SUBTASK 53-31-21-010-001

WARNING: MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Use the switches on the control wheel to set the leading edge of the horizontal stabilizer to the full down (airplane nose up) position.

SUBTASK 53-31-21-860-001

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT

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(Continued)

F/O Electrical System Panel, P6-2

Row Col Number Name

D 10 C00840 FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 53-31-21-860-002

- (3) Install the lock, SPL-1672 on the stabilizer trim wheel at the control stand, (Figure 402).
 - (a) Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
 - (b) Install the pin through the yoke.
 - (c) Install the safety pin.

SUBTASK 53-31-21-010-002

- (4) Open this access panel:

Number Name/Location

311BL Stabilizer Trim Access Door

SUBTASK 53-31-21-010-003

- (5) Get access to the vortex generator fasteners from inside the fuselage.

NOTE: The leading edge of the horizontal stabilizer may be moved farther down by turning the handwheel by hand if needed.

- (a) Go on the horizontal stabilizer torque box to reach the fasteners.

E. Removal Procedure

SUBTASK 53-31-21-010-004

- (1) Remove the 13 bolts [2] which hold the vortex generator assembly [1] to the fuselage, (Figure 401).

SUBTASK 53-31-21-020-001

- (2) Remove the generator assembly [1] with a hardwood hard resin phenolic scraper, STD-1064.

———— END OF TASK ————

TASK 53-31-21-400-801

3. Vortex Generator Installation

(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-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III



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C. Location Zones

Zone	Area
300	Empennage

D. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

E. Prepare for the Installation

SUBTASK 53-31-21-140-001

- (1) If there is bonding material on the fuselage skin, remove the bonding material with a hardwood hard resin phenolic scraper, STD-1064.

SUBTASK 53-31-21-110-001

- (2) Use solvent, B00083 to clean the mating surfaces.

F. Installation Procedure

SUBTASK 53-31-21-420-001

- (1) Bond the vortex generator assembly [1] to the fuselage surface.
 - (a) Apply a thin, constant layer of sealant, A00247 to each mating surface.
NOTE: Make sure the sealant will cover all of the mating surfaces.
 - (b) Align the vortex generator assembly [1] to the fuselage (Figure 401).
 - (c) Make a 0.05 inch by 0.05 inch (1.27mm by 1.27 mm) fillet seal around the edge of the assembly.

SUBTASK 53-31-21-420-002

- (2) Attach the vortex generator assembly [1] to the empennage with 13 bolts [2] in the applicable locations.

NOTE: The installation of permanent fasteners will hold the vortex generator assembly in position. You do not have to wait for the full cure of the sealant before you return the airplane to service.

G. Put the Airplane Back to its Usual Condition

SUBTASK 53-31-21-860-003

- (1) Remove the lock, SPL-1672 on the stabilizer trim wheel at the control stand, (Figure 402).

SUBTASK 53-31-21-860-004

- (2) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-1

Row	Col	Number	Name
C	2	C00849	AFCS STABILIZER TRIM

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR



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SUBTASK 53-31-21-010-005

- (3) Close this access panel:

Number Name/Location

311BL Stabilizer Trim Access Door

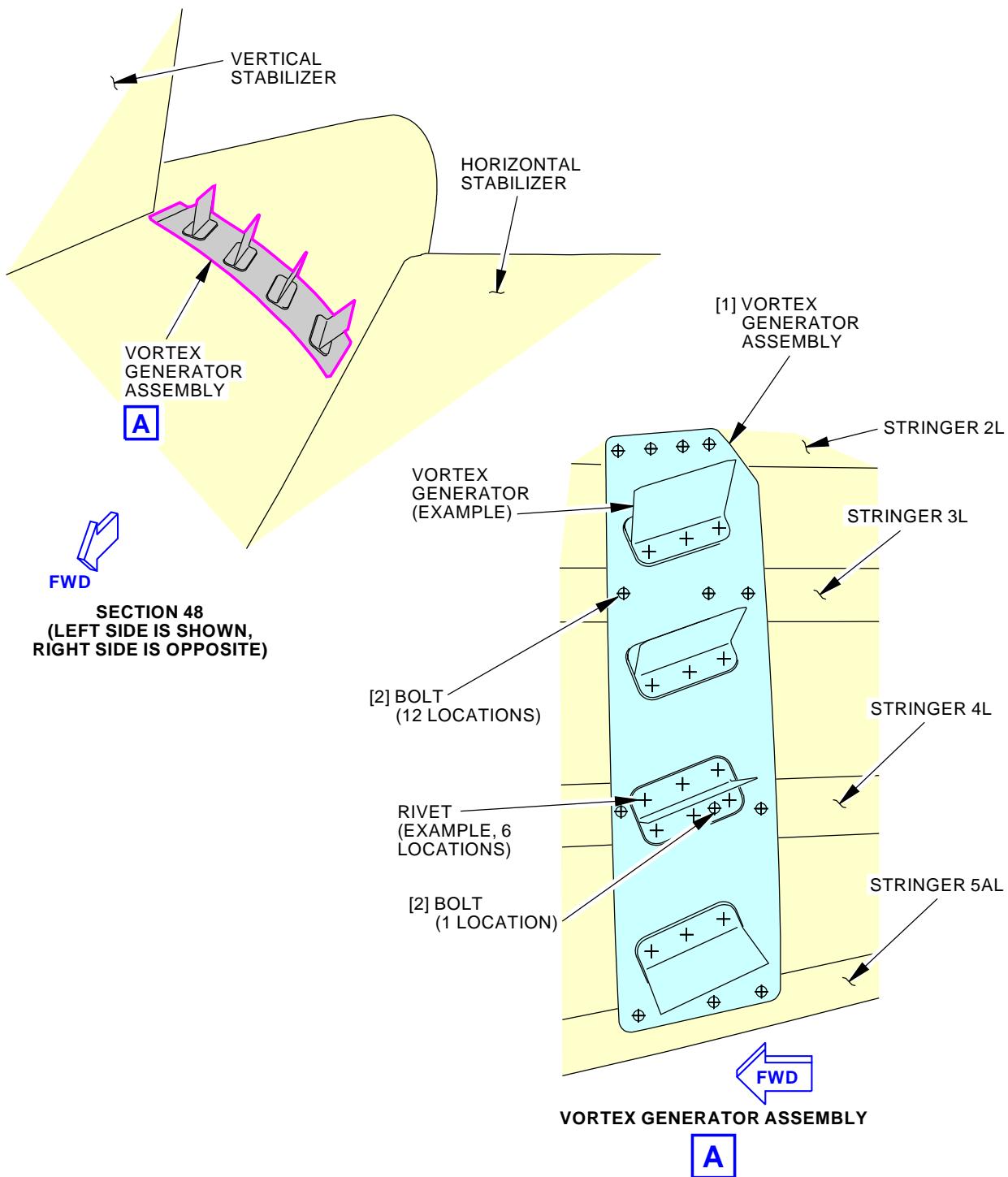
———— END OF TASK ————

EFFECTIVITY
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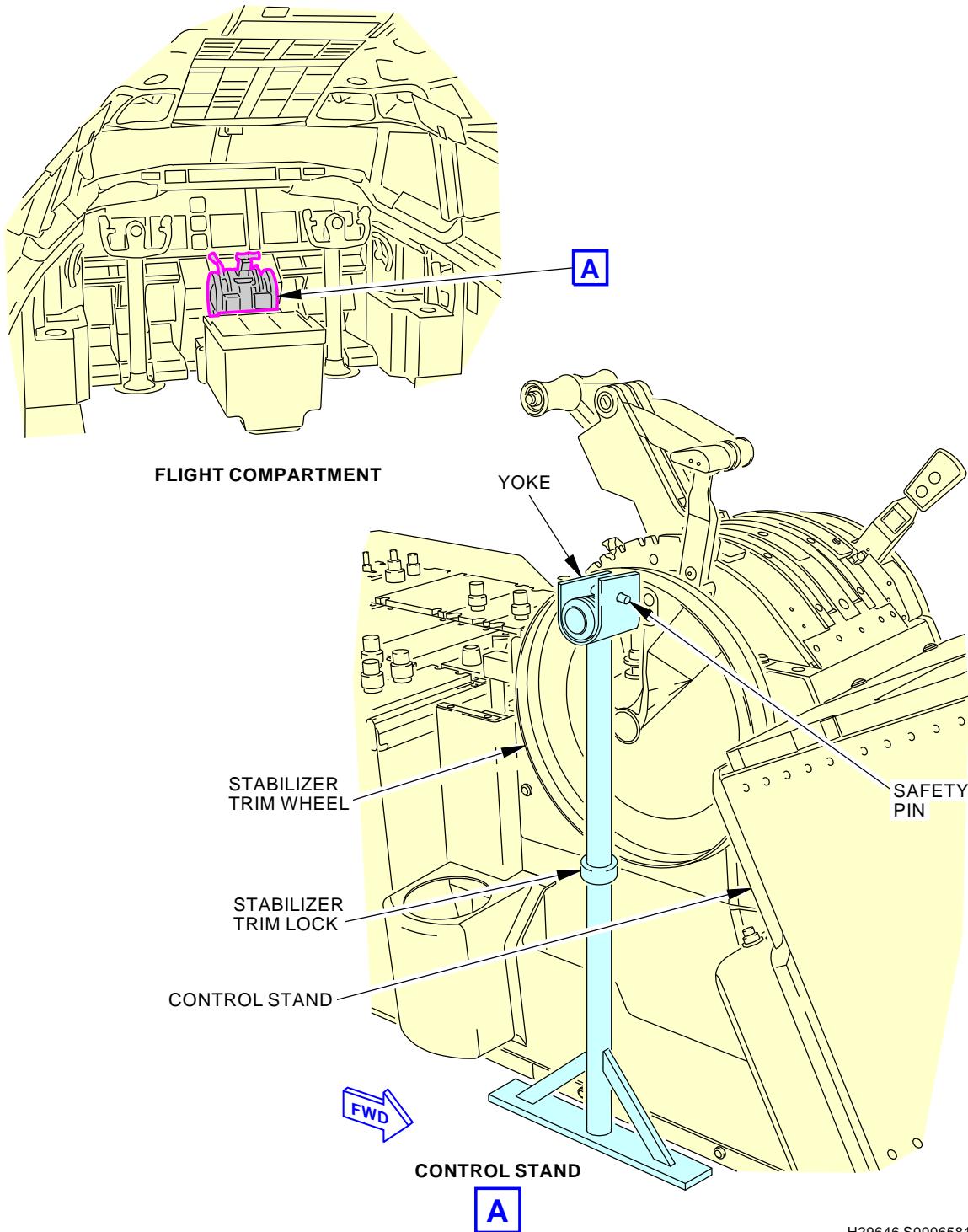
Fuselage Vortex Generator Installation
Figure 401/53-31-21-990-801

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Stabilizer Trim Lock Installation
Figure 402/53-31-21-990-802

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STABILIZER TO BODY FRONT SPAR SLIDING SEAL - REMOVAL/INSTALLATION

1. General

- A. This procedure contains four tasks:
 - (1) The removal of the stabilizer-to-body upper front spar sliding seal.
 - (2) The installation of the stabilizer-to-body upper front spar sliding seal (referred to as the sliding seal).
 - (3) The removal of the stabilizer-to-body lower front spar sliding seal.
 - (4) The installation of the stabilizer-to-body lower front spar sliding seal (referred to as the sliding seal).
- B. The sliding seal closes the opening where the attach fitting of the forward stabilizer moves. You can do the approved repair of the seal when you remove the seal plates and, do this task: Apply The Abrasion-Resistant Teflon Finish, BMS 10-86 Type I, TASK 51-21-81-370-801.

TASK 53-31-31-000-802

2. Stabilizer-to-Body Upper Front Spar Sliding Seal Removal

Figure 401

A. Location Zones

Zone	Area
300	Empennage

B. Removal Procedure

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-020-013

- (1) Remove the upper center track strips [3].

SUBTASK 53-31-31-020-014

- (2) To remove the upper sliding seal plate, move the stabilizer to the full down position.

SUBTASK 53-31-31-020-015

- (3) Remove the pins [4] that connect the link assemblies [5] to the pedestal [6].

SUBTASK 53-31-31-020-016

- (4) Pull out the upper sliding seal plate.

SUBTASK 53-31-31-020-017

- (5) Remove all the hardware from the seal plate.

NOTE: Keep the link assembly and the corner plates for installation.

———— END OF TASK ————

TASK 53-31-31-400-802

3. Stabilizer-to-Body Upper Front Spar Sliding Seal Installation

Figure 401

A. Consumable Materials

Reference	Description	Specification
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	





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B. Location Zones

Zone	Area
300	Empennage

C. Installation Procedure

SUBTASK 53-31-31-420-020

- (1) Adjust the link assembly [5] on the center of the replacement seal plate [1].

SUBTASK 53-31-31-210-005

- (2) Make sure that the tie-bar lugs are clear of the seal plate edges and that the edge distances will be satisfactory.

SUBTASK 53-31-31-210-006

- (3) Make a mark of the location of the tie-bar on the seal plate with a pencil for reference.

SUBTASK 53-31-31-160-004

- (4) Clean the tracks and the area which is near the tracks to remove any contamination or unwanted material.

SUBTASK 53-31-31-420-021

- (5) Temporarily attach the link assembly [5] to the pedestal [6].

NOTE: Do not install the cotter pins.

SUBTASK 53-31-31-420-022

- (6) Wind the protective Mylar tape around the end of the track strip as shown to prevent the seal plate from damage during the installation.

SUBTASK 53-31-31-420-023

- (7) Put the seal plate [1] into the tracks.

NOTE: You must bend the plate in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-024

- (8) Use the index mark to align the seal plate [1] on the link assembly [5].

SUBTASK 53-31-31-420-025

- (9) Lightly attach the seal plate to the tie-bar with a clamp.

SUBTASK 53-31-31-420-026

- (10) You get equal dimensions when you move the seal plate in a longitudinal direction where it is necessary.

NOTE: The dimensions are between the etched line on the seal plate and the edges of the track strip along the full length of the track that you can see.

SUBTASK 53-31-31-950-002

CAUTION: DO THIS STEP CAREFULLY. IF THE PARTICLES GO INTO THE TRACKS, IT CAN CAUSE DAMAGE TO THE TEFLON COATING ON THE SEAL.

- (11) Apply the Permacel P-255 tape, G02480 to all the track openings, so that the drilled chips can not go into the track.

SUBTASK 53-31-31-420-027

- (12) Tighten the clamps.

SUBTASK 53-31-31-420-028

- (13) Back drill, a minimum of two locations through the holes in the tie-bar into the seal plate.



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SUBTASK 53-31-31-420-029

- (14) Install the temporary cleco fasteners in the holes.

SUBTASK 53-31-31-020-018

- (15) Remove the pins [4] that attach the link assembly [5] to the pedestal [6].

SUBTASK 53-31-31-020-019

- (16) Remove the seal plate [1] with the attached link assembly [5].

SUBTASK 53-31-31-420-030

- (17) At the bench, assemble the seal plate [1], the link assembly [5], and the corner plates.

NOTE: Use the holes that are in the tie-bar for the locations to drill.

SUBTASK 53-31-31-210-007

- (18) Make sure that the protective Permacel P-255 tape, G02480 stays around the end of the strip.

SUBTASK 53-31-31-420-031

- (19) Put the seal assembly into the tracks.

NOTE: The plate must be bent in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-032

- (20) Move the seal up and down.

SUBTASK 53-31-31-020-020

- (21) The force to move the seal must not be more than 20 pounds and the seal must move freely.

SUBTASK 53-31-31-420-033

- (22) Attach the link assembly [5] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-034

- (23) Install the cotter pins.

SUBTASK 53-31-31-420-035

- (24) Install the rub guide.

SUBTASK 53-31-31-420-038

- (25) Adjust and trim the ends of the rub guide where it is necessary to keep 0.03 ± 0.01 inch clearance between each end of the rub guide and the track.

SUBTASK 53-31-31-420-037

- (26) Manually put the leading edge of the stabilizer to the full up position.

SUBTASK 53-31-31-210-008

- (27) Make sure that the double flush rivet at the uppermost corner of the seal plates is not out more than 0.003 in. (0.076 mm).

NOTE: If the rivet touches the body structure, cut the driven head until it does not touch the body structure.

D. Put the Airplane to Its Usual Condition

SUBTASK 53-31-31-020-021

- (1) Remove all the protective tapes and the covers.

SUBTASK 53-31-31-160-002

- (2) Clean up the area.



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SUBTASK 53-31-31-420-036

- (3) Install the center track strips [3].

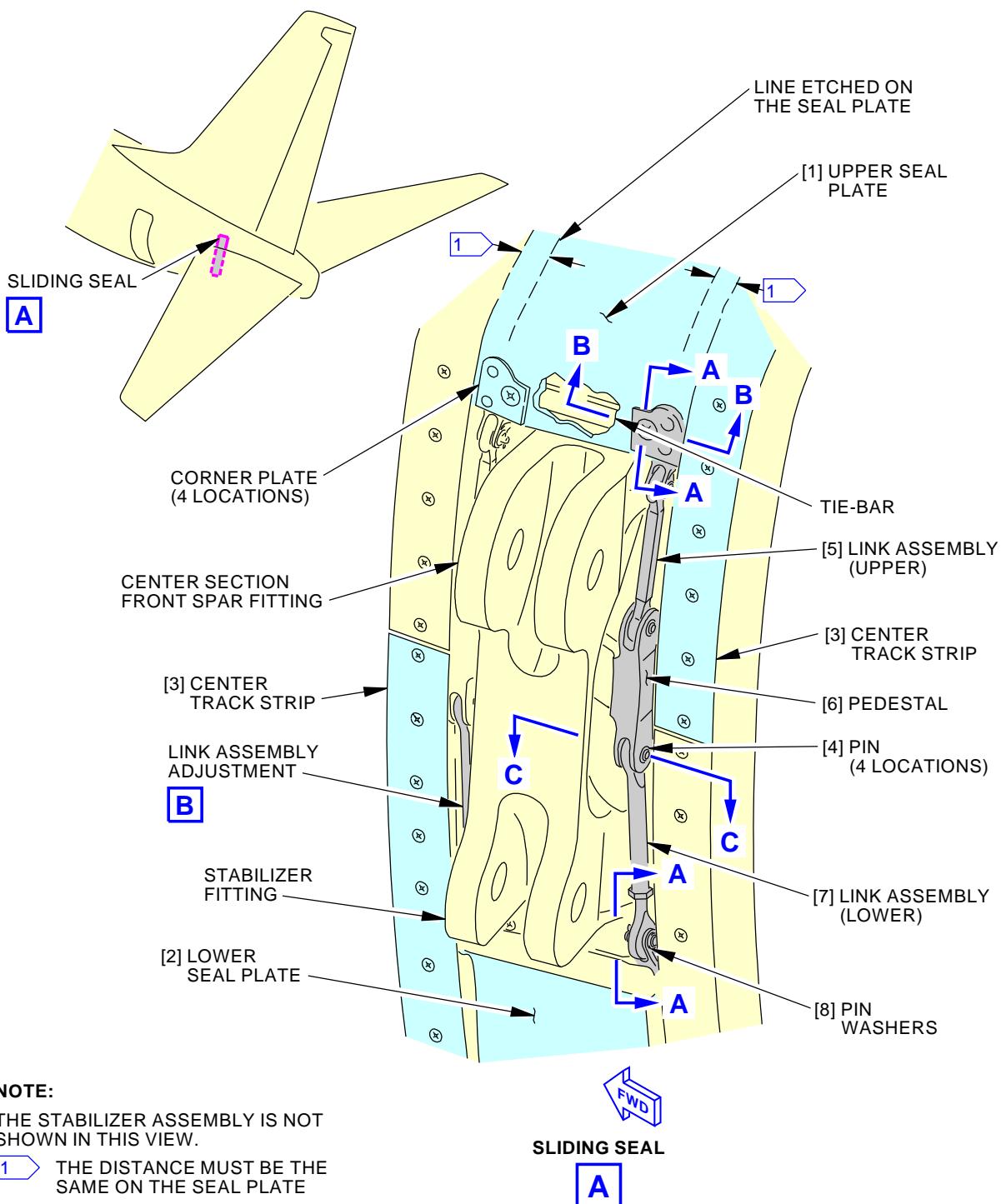
———— END OF TASK ————

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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 1 of 3)

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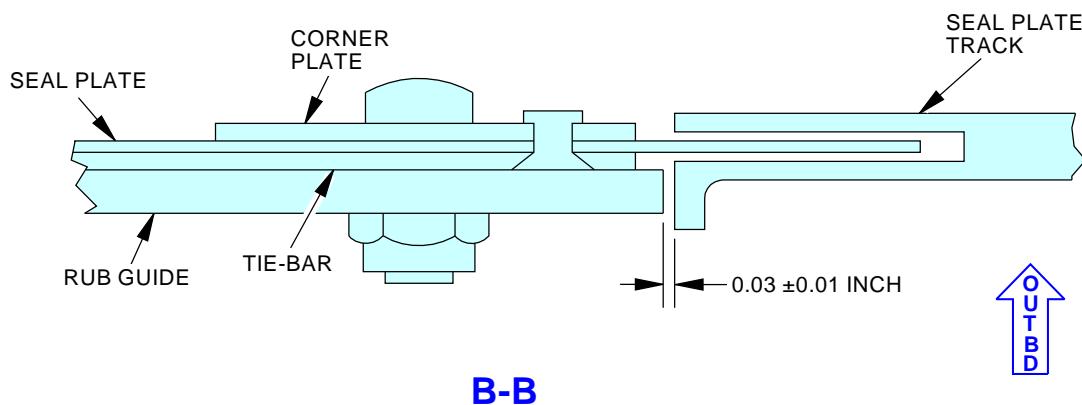
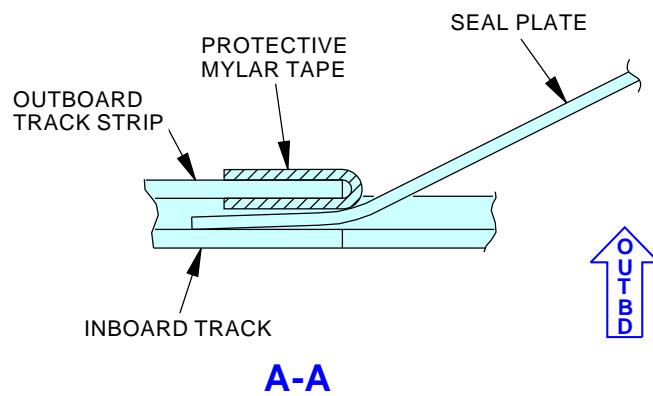
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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 2 of 3)

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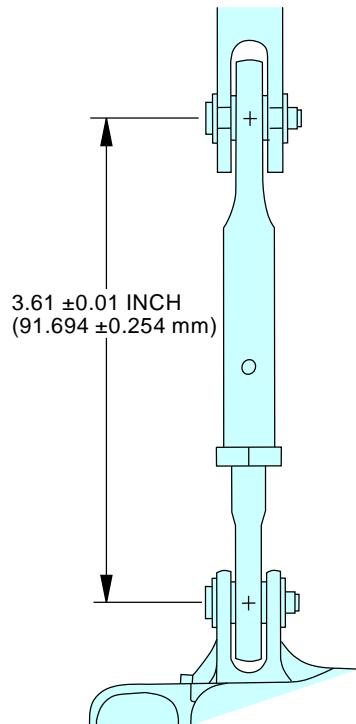
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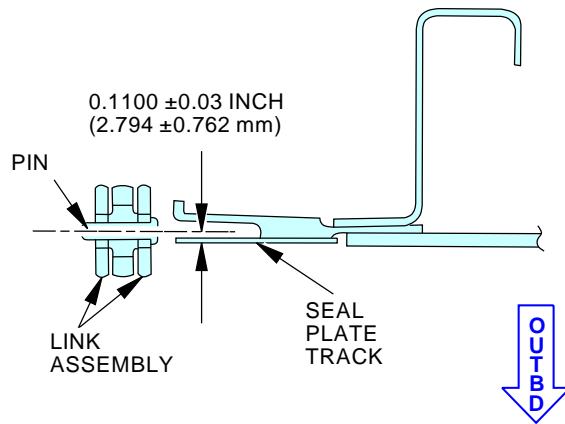


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LINK ASSEMBLY ADJUSTMENT

B



C-C

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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 3 of 3)

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TASK 53-31-31-000-803

4. Stabilizer-to-Body Lower Front Spar Sliding Seal Removal

Figure 401

A. Location Zones

Zone	Area
300	Empennage

B. Removal Procedure

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-020-022

- (1) Remove the lower center track strips [3].

SUBTASK 53-31-31-020-023

- (2) To remove the lower sliding seal plate, move the stabilizer to the full up position.

SUBTASK 53-31-31-020-024

- (3) Remove the pins [4] that connect the link assemblies [7] to the pedestal [6].

SUBTASK 53-31-31-020-025

- (4) Pull out the lower sliding seal plate [2].

SUBTASK 53-31-31-020-026

- (5) Remove the link assemblies [7] and attaching hardware.

NOTE: Keep the link assembly and attaching hardware for installation.

———— END OF TASK ————

TASK 53-31-31-400-803

5. Stabilizer-to-Body Lower Front Spar Sliding Seal Installation

Figure 401

A. Location Zones

Zone	Area
300	Empennage

B. Installation Procedure

SUBTASK 53-31-31-160-003

- (1) Clean the tracks and the area which is near the tracks to remove any contamination or unwanted material.

SUBTASK 53-31-31-420-039

- (2) Wind the protective Mylar tape around the end of the track strip as shown to prevent the seal plate from damage during the installation.

SUBTASK 53-31-31-420-040

- (3) Put the seal plate [2] into the tracks.

NOTE: You must bend the plate in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-041

- (4) Move the seal plate [2] up and down.





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SUBTASK 53-31-31-210-009

- (5) The force to move the seal plate must not be more than 20 pounds and the seal plate must move freely..

SUBTASK 53-31-31-220-001

- (6) Adjust the gap between the link assembly/pedestal centerline mount point and the seat track edge to $.1100 \pm 0.03$ inch.

SUBTASK 53-31-31-420-042

- (7) Attach the link assembly [7] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-043

- (8) Install the cotter pins.

SUBTASK 53-31-31-420-044

- (9) Attach the seal plate [2] to the link assemblies [7] with the pins [8].

SUBTASK 53-31-31-420-045

- (10) Install the cotter pins.

SUBTASK 53-31-31-220-002

- (11) Adjust the forward link assembly length to 3.61 ± 0.01 inch.

SUBTASK 53-31-31-210-010

- | (12) Adjust the aft link assembly length in half turn increments to achieve an equal gap between the rub guide and seal tracks.

C. Put the Airplane to Its Usual Condition

SUBTASK 53-31-31-020-027

- (1) Remove all the protective tapes and the covers.

SUBTASK 53-31-31-160-005

- (2) Clean up the area.

SUBTASK 53-31-31-420-046

- (3) Install the center track strips [3].

———— END OF TASK ————





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PASSENGER CABIN AND CARGO COMPARTMENT TRACKS - CLEANING/PAINTING

1. General

- A. This procedure contains one task. The task is to clean the passenger cabin and cargo compartment tracks.
- B. A minimum quantity of maintenance is necessary for the passenger cabin and cargo compartment tracks if you keep them clean and free of moisture. Use the task that follows when you find corrosion.

TASK 53-42-11-100-801

2. Clean the Passenger Cabin and Cargo Compartment Track

A. References

Reference	Title
SRM 51-20-01	Structural Repair Manual

B. Tools/Equipment

Reference	Description
STD-123	Brush - Soft Bristle

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
B00102	Abrasive - Aluminum Oxide Coated Cloth	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00064	Coating - Aluminum Chemical Conversion	
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26

D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Procedure

SUBTASK 53-42-11-140-001

- (1) Manually clean the track with solvent, B00083.

SUBTASK 53-42-11-210-001

- (2) Make sure you remove oil or grease.

SUBTASK 53-42-11-140-002

- (3) Rub the track with abrasive cloth, B00102 paper to remove the corrosion.

SUBTASK 53-42-11-140-003

- (4) Remove the residue with a soft bristle brush, STD-123.

SUBTASK 53-42-11-140-004

- (5) Clean the surface again with solvent, B00083.

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SUBTASK 53-42-11-110-001

WARNING: DO NOT TOUCH YOUR SKIN WITH THE CHEMICAL CONVERSION COATING. IT CONTAINS CHROMIC ACID AND CAN CAUSE INJURY TO PERSONS.

CAUTION: PUT A COVER ON THE CARPETS WHILE YOU APPLY THE CHEMICAL CONVERSION COATING. IT CAN CAUSE A STAIN ON SOME FABRICS.

- (6) Apply a layer of the chemical conversion coating, C00064 to the surface.

SUBTASK 53-42-11-370-001

- (7) Apply a finish if it is necessary.

SUBTASK 53-42-11-390-001

- (8) Below the galleys, apply a corrosion preventive compound, C00755 in the seat tracks (SRM 51-20-01).

———— END OF TASK ————

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FRONT SPAR TO REAR SPAR UNDERWING PANEL - INSPECTION/REPAIR

1. General

- A. This procedure contains two tasks. The first task is to examine the countersunk of the fastener holes of the front spar to rear spar underwing panel. The second task is the repair the holes if cracks are found.

TASK 53-51-00-200-801

2. Front Spar to Rear Spar Underwing Panel Inspection

Figure 201

A. Location Zones

Zone	Area
100	Lower Half of Fuselage

B. Procedure

SUBTASK 53-51-00-010-001

- (1) Remove the sixteen 0.25 in. (6.35 mm) attach fasteners from the outboard edge of the aft and forward panels on the left and right sides (Figure 201).

SUBTASK 53-51-00-210-001

- (2) Do a visual inspection with a 10X magnifying glass of the countersunk and adjacent area of the hole.

SUBTASK 53-51-00-300-001

- (3) If you find cracks in or adjacent to the countersunk area, do this task: Front Spar to Rear Spar Underwing Panel Repair, TASK 53-51-00-300-801.

SUBTASK 53-51-00-420-002

- (4) If you do not find cracks, or you have made repairs to cracks, install the bolts and washers:
- Measure and record the nutplate for the self-locking torque. The torque should be 3.5 in-lb (0.4 N·m) to 30 in-lb (3 N·m).
 - Add the self-locking torque (5 in-lb (1 N·m) to 10 in-lb (1 N·m)) to calculate the installation torque.
 - Tighten the bolts to the midrange of this torque range.

———— END OF TASK ————

TASK 53-51-00-300-801

3. Front Spar to Rear Spar Underwing Panel Repair

A. References

Reference	Title
SRM 51-70-04	Repair of Damage to the Edgeband of a Honeycomb Panel
SRM 51-70-05	Structural Repair Manual

B. Consumable Materials

Reference	Description	Specification
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)



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C. Location Zones

Zone	Area
100	Lower Half of Fuselage

D. Procedure

SUBTASK 53-51-00-340-003

- (1) If you find cracks only in the countersunk area:
 - (a) Fill the crack with resin, G50400.

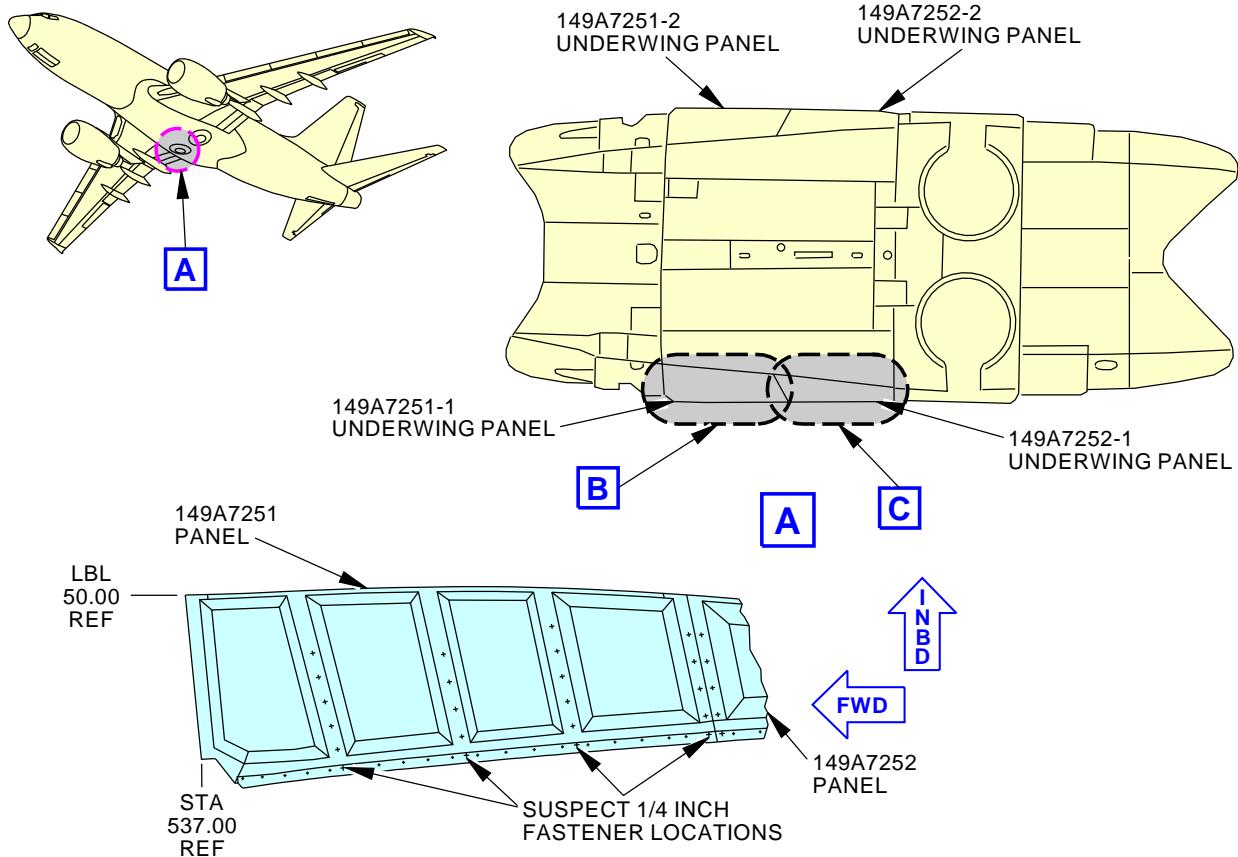
SUBTASK 53-51-00-340-001

- (2) If you find cracks that extend more than the countersunk area, do one of the repair procedures that follow:
 - (a) SRM 51-70-04, Repair 6
 - (b) SRM 51-70-05, Repair 6.

———— END OF TASK ————

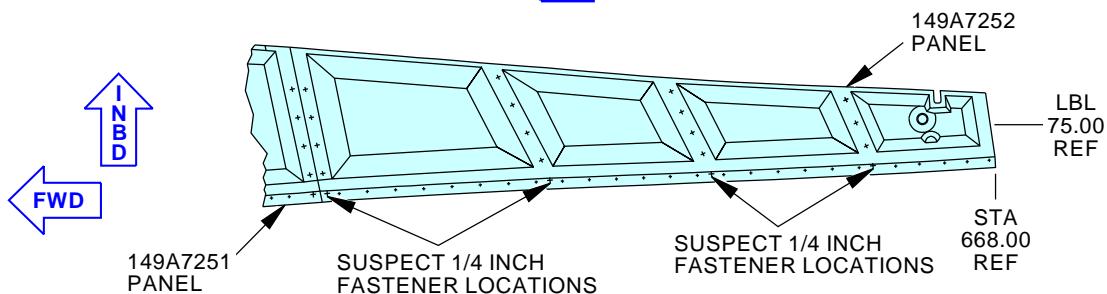


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**FORWARD UNDERWING PANEL, 149A7251, FASTENER LOCATIONS
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**

B



**AFT UNDERWING PANEL, 149A7252, FASTENER LOCATIONS
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**

C

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**Front Spar to Rear Spar Underwing Panel Attachment Fasteners
Figure 201/53-51-00-990-801**

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WING-TO-BODY FAIRING - INSPECTION/CHECK

1. General

- A. This procedure has one task. The task gives instructions to check the electrical resistance of a wing-to-body fairing panel.

TASK 53-51-01-765-801

2. Wing-to-Body Fairing Electrical Resistance Check

A. References

Reference	Title
53-51-21 P/B 401	WING-TO-BODY FAIRING PANELS - 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
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. Consumable Materials

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Alodine 600	

D. Location Zones

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right



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E. Prepare for the Electrical Resistance Check

SUBTASK 53-51-01-200-001

- (1) Identify the fastener locations on each panel that an electrical bond is necessary:

NOTE: There are usually four fasteners per panel with electrical bonds. It is recommended to examine the panel at the corners first. Usually the locations are at or near the corners of the panel. Panel repairs can change the locations of the electrical bonds. It is necessary to examine all the fastener holes to identify locations with an electrical bond.

- (a) Examine the area around each fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel that surrounds the fastener hole Figure 601.

SUBTASK 53-51-01-211-001

- (2) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Remove one fastener and one dimpled washer if installed, from the panel.

NOTE: There are usually four fasteners per panel with electrical bonds. It is recommended to examine the panel at the corners first. Usually the locations are at or near the corners of the panel. Panel repairs can change the locations of the electrical bonds. It is necessary to examine all the fastener holes to identify locations with an electrical bond.

- (b) Examine the area around the fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel that surrounds the fastener hole Figure 601.

- (c) Examine the countersunk area of the fastener hole:

- 1) Examine the countersunk area of the panel below the dimpled washer if installed.

- 2) The countersunk area for each electrically bonded fastener hole will have a coating, C00767 or Alodine 600 coating, C00862.

NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.

- (d) Examine the countersunk mating surface between the dimpled washer if installed, and the panel: Figure 601.

- 1) Make sure that the surfaces without an electrical bond between the dimpled washer and the panel are free from contamination.

- 2) Make sure that the surfaces with an electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.

- (e) Re-install the fastener and dimpled washer if the location is a designated electrical bond.

- (f) Do not re-install the dimpled washer if the location is not a designated electrical bond.

- (g) Do the steps again to find all the designated bond locations.

SUBTASK 53-51-01-000-001

- (3) If installed, remove the fasteners and dimpled washers that are in a designated electrical bond location.

SUBTASK 53-51-01-100-001

- (4) Make sure that the mating surface between the panel conductive surface and the dimpled washer if installed, is clean.

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SUBTASK 53-51-01-100-002

- (5) Make sure that the fasteners and the area around the fastener holes are clean.

F. Check the Electrical Resistance of the Designated Bonds

SUBTASK 53-51-01-400-001

- (1) Install one fastener, and one dimpled washer in a designated bond location in the panel.

SUBTASK 53-51-01-765-001

- (2) Put a dimpled washer only in an adjacent (empty) designated bonded fastener location.

SUBTASK 53-51-01-765-002

- (3) Put one probe of a digital/analog multimeter, COM-1793 on the installed designated bonded fastener head.

SUBTASK 53-51-01-765-003

- (4) Put the second probe on a dimpled washer in the adjacent (empty) designated bonded fastener location.

NOTE: The dimpled washer if installed, completes an electrical bond between the panel conductive surface and the probe.

SUBTASK 53-51-01-765-004

- (5) Make sure that the resistance is not more than in the Table 601.

Table 601/53-51-01-993-801 Panel Conductive Surface Maximum Resistance

Conductive Surface Type	Maximum Resistance (Ohm) ^{*[1]}
Anti-Static Coating	300,000
Aluminum Coated Fiber	10
Expanded Aluminum Foil ^{*[2]}	0.5
Flamespray	0.5

*[1] Some panels will be installed with bonding jumpers. The dimension of the bonding jumper can change the maximum resistance. Refer to the installation procedure for the maximum resistance of panels with bonding jumpers(PAGEBLOCK 53-51-21/401).

*[2] Some panels with the expanded aluminum foil surface can have different maximum resistances. Refer to the installation procedure for panels with different maximum resistances than in this table (PAGEBLOCK 53-51-21/401).

SUBTASK 53-51-01-765-005

- (6) Make sure that the dimpled washer if installed, does not move:

- Remove the probe.
- Install the fastener.

G. Repeat the Check

SUBTASK 53-51-01-765-006

- (1) Repeat the Check of the Electrical Resistance of the Designated Bonds

- Do the check with each subsequently installed designated bond fastener as the start point until all fasteners are installed.

NOTE: It is not necessary to remove or do the resistance check again for the very first fastener installed.

- If the panel does not pass the electrical resistance test:
 - Do the steps again that apply the electrical coating to the panel and do the resistance test again, or replace the panel.



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H. Restore the Fairing to Normal

SUBTASK 53-51-01-390-001

- (1) Apply finish to fairing panel:
 - (a) Apply finish to the fastener heads.
 - (b) Apply finish to areas adjacent to the fasteners on the panel if necessary.

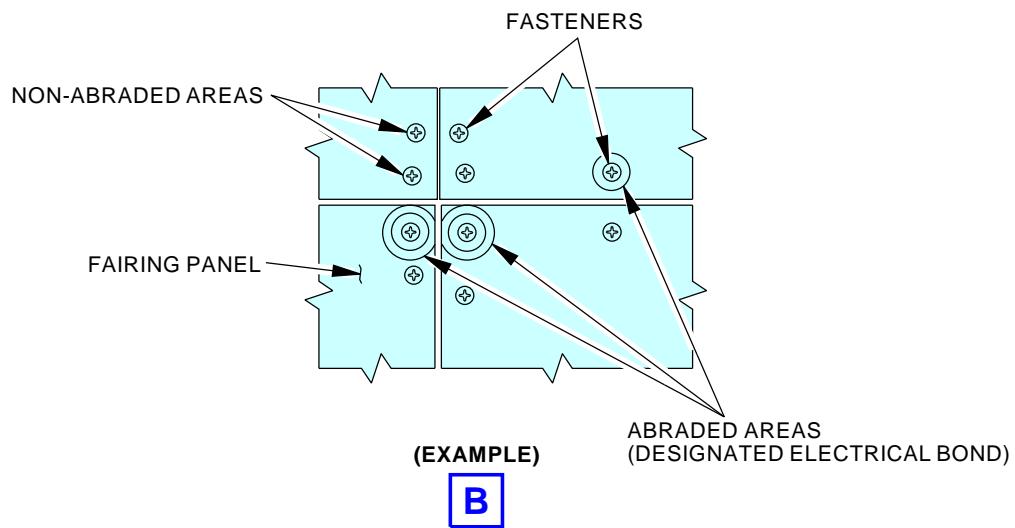
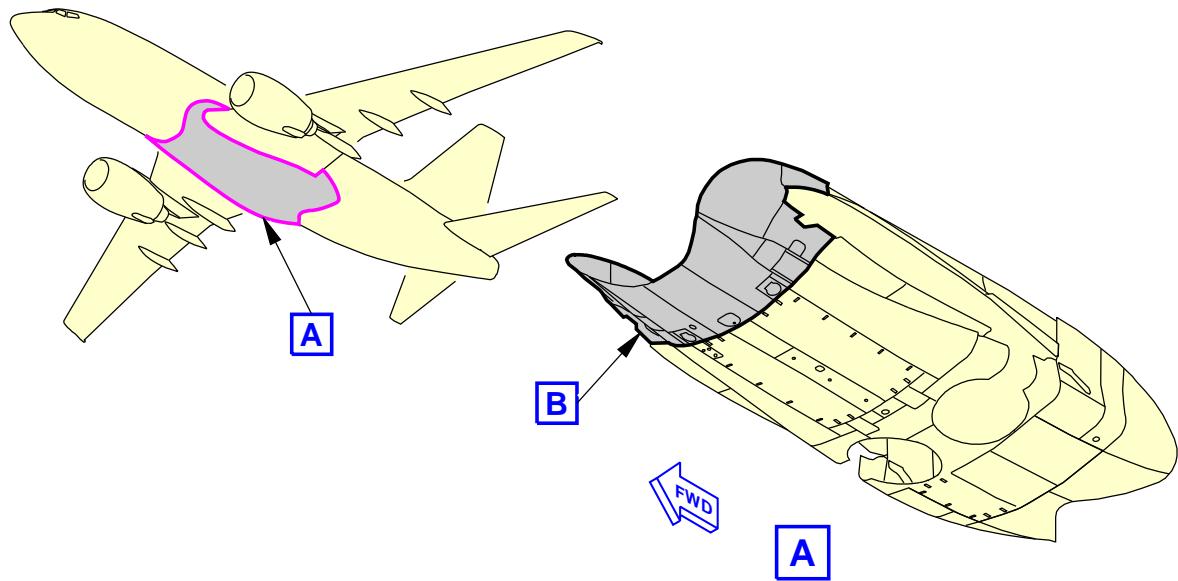
———— END OF TASK ————

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Wing-to-Body Fairing
Figure 601/53-51-01-990-801

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WING-TO-BODY FAIRING BLOWOUT PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks. The first task is the removal of the blowout panel for the wing-to-body fairing. The second task is the installation of the blowout panel for the wing-to-body fairing.
- B. The blowout panels have a hinge on one side. The rivets that go through the clips on the other side hold the blowout panels closed.

TASK 53-51-11-000-801

2. Blowout Panel for the Wing-to-Body Fairing Removal

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 53-51-11-010-001

- (1) If the panel blows out, open the underwing fairing and remove the rivets.

————— END OF TASK ————

TASK 53-51-11-400-801

3. Blowout Panel for the Wing-to-Body Fairing Installation

A. References

Reference	Title
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-31-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)

B. Tools/Equipment

Reference	Description
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 53-51-11-210-001

- (1) Examine the attach clips for damage.

SUBTASK 53-51-11-140-003

- (2) Use a hardwood or plastic fillet smoothing spatula, STD-810 to clean the sealant from the mating surfaces.

SUBTASK 53-51-11-120-002

- (3) Apply an abrasion resistant finish and parting agent to the outer face of the fairing lip (ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING, PAGEBLOCK 51-21-81/701).

SUBTASK 53-51-11-140-004

- (4) Remove the sealant from the clearance between the blowout panel and panel cutout.

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SUBTASK 53-51-11-390-002

CAUTION: BE CAREFUL WHEN YOU APPLY HAND PRESSURE TO PUT THE BLOWOUT PANEL IN THE CORRECT POSITION. TOO MUCH PRESSURE CAN CAUSE DISTORTION OF THE BLOWOUT PANEL.

- (5) Before you install the blowout panel, apply a bead of sealant to the inner face of the panel lip (Non-Removable Faying (Mated) Surface Seal Application, TASK 51-31-00-390-801).

SUBTASK 53-51-11-420-001

- (6) Install the blowout panels with one rivet, 3/32 in. (2.4 mm) diameter, in the aft outboard location and one rivet, 1/8 in. (3.2 mm) diameter, in the forward outboard location.

SUBTASK 53-51-11-860-003

- (7) After the sealant dries, open and close the blowout panel to make sure it does not bond.

SUBTASK 53-51-11-860-002

- (8) Close and latch the blowout panel.

———— END OF TASK ————

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WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the Forward Wing-To-Body fairings panels.
 - (2) An installation of the Forward Wing-To-Body fairings panels.
 - (3) A removal of the Center Wing-To-Body fairings panels.
(a) This includes the Wing-To-Body fairing panels above the wings.
 - (4) An installation of the Center Wing-To-Body fairings panels.
(a) This includes the Wing-To-Body fairing panels above the wings.
 - (5) A removal of the Aft Wing-To-Body fairings panels.
 - (6) An installation of the Aft Wing-To-Body fairings panels.

TASK 53-51-21-000-803

2. Forward Wing-To-Body Fairing Panel Removal

(Figure 401)

A. References

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
33-44	ANTI-COLLISION LIGHTS
51-31-00-160-801	Prepare For Sealing (P/B 201)

B. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

C. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191E	Low Pressure ECS Panel - Forward
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

D. Prepare for Forward Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-020-002

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing.



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- (a) Ram Air Intake (SECTION 21-51)
- (b) Lights (SECTION 33-44)

E. Forward Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-010-001

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-31-00-160-801).

SUBTASK 53-51-21-020-003

- (2) Do these steps to remove the applicable fairing panels:

NOTE: Hold the fairing panel until all the fasteners have been removed.

NOTE: Identify the fasteners to install them in the same locations.

- (a) Zone 191:

- 1) Remove the fasteners for access panel [7]:

Number Name/Location

191AL Forward Wing To Body Fairing Panel - Upper

- 2) Remove the fasteners for access panel [1]:

Number Name/Location

191AR Forward Wing To Body Fairing Panel - Upper

- 3) Remove the fasteners for access panel [6]:

Number Name/Location

191BL Forward Wing To Body Fairing Panel, Ram Air Inlet

- 4) Remove the fasteners for access panel [2]:

Number Name/Location

191BR Forward Wing To Body Fairing Panel, Ram Air Inlet

- 5) Remove the fasteners for access panel [5]:

Number Name/Location

191CL Forward Wing To Body Fairing Panel - Middle

- 6) Remove the fasteners for access panel [3]:

Number Name/Location

191CR Forward Wing To Body Fairing Panel - Middle

- 7) Remove the fasteners for access panel [4]:

Number Name/Location

191D Forward Wing To Body Fairing Panel - Lower

- 8) Remove the fasteners for access panel [11]:

Number Name/Location

191E Low Pressure ECS Panel - Forward

- 9) Remove the fasteners for access panel [9]:

Number Name/Location

191FL Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

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- 10) Remove the fasteners for access panel [13]:

Number Name/Location

191FR Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 11) Remove the fasteners for access panel [8]:

Number Name/Location

191GL Ram Air Actuator Panel - Forward

- 12) Remove the fasteners for access panel [14]:

Number Name/Location

191GR Ram Air Actuator Panel - Forward

- 13) Remove the fasteners for access panel [10]:

Number Name/Location

191HL Ram Air Inlet Lip Panel - Forward

- 14) Remove the fasteners for access panel [11]:

Number Name/Location

191HR Ram Air Inlet Lip Panel - Forward

- (b) Remove the fairing panel from the airplane.

———— END OF TASK ————

TASK 53-51-21-400-803

3. Forward Wing-To-Body Fairing Panel Installation

(Figure 401)

A. General

- (1) This task includes the steps to install access panels:

B. References

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
33-44	ANTI-COLLISION LIGHTS
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-51-00-340-805	Bonded Teflon Rub Pad Repair (P/B 801)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79 Type III



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Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

E. Access Panels

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191E	Low Pressure ECS Panel - Forward
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

F. Prepare for Forward Wing-To-Body Fairing Panel Installation Procedure

SUBTASK 53-51-21-210-006

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

NOTE: Teflon is applied in the mating surface. The teflon is not contamination. It is not necessary to remove the teflon.

SUBTASK 53-51-21-160-003

- (2) Make sure that the teflon mating surface is in good condition.

(a) If necessary, repair the teflon substrip. Refer to this task: Bonded Teflon Rub Pad Repair, TASK 51-51-00-340-805.

SUBTASK 53-51-21-210-005

- (3) Make sure that the designated electrical bonds for the panel are identified.

(a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

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SUBTASK 53-51-21-390-010

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing which touches the structure.

SUBTASK 53-51-21-390-009

CAUTION: DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS THAT DO NOT TOUCH THE FUSELAGE SKIN. IF YOU APPLY SEALANT INCORRECTLY, IT CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS.

- (5) Apply sealant, A00247 to the flanges on the fairing which touches the body skin.

SUBTASK 53-51-21-390-008

- (6) Apply the corrosion inhibiting compound, G00009, to the area on the structure and the body skin which touches the fairing.
(a) If necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

G. Forward Wing-To-Body Fairing Panels Installation Procedure

SUBTASK 53-51-21-400-007

- (1) Install the fasteners that do not have a designated electrical bond on the applicable panel.
(a) Apply primer, C00259 to the hole areas of all fasteners in the structure when necessary.
(b) Let the primer dry.
(c) Put the panel into its position.

- 1) Install the non-designated electrical bond fasteners for this access panel [7]:

Number Name/Location

191AL Forward Wing To Body Fairing Panel - Upper

- 2) Install the non-designated electrical bond fasteners for this access panel [1]:

Number Name/Location

191AR Forward Wing To Body Fairing Panel - Upper

- 3) Install the non-designated electrical bond fasteners for this access panel [6]:

Number Name/Location

191BL Forward Wing To Body Fairing Panel, Ram Air Inlet

- 4) Install the non-designated electrical bond fasteners for this access panel [2]:

Number Name/Location

191BR Forward Wing To Body Fairing Panel, Ram Air Inlet

- 5) Install the non-designated electrical bond fasteners for this access panel [5]:

Number Name/Location

191CL Forward Wing To Body Fairing Panel - Middle

- 6) Install the non-designated electrical bond fasteners for this access panel [3]:

Number Name/Location

191CR Forward Wing To Body Fairing Panel - Middle

- 7) Install the non-designated electrical bond fasteners for this access panel [4]:

Number Name/Location

191D Forward Wing To Body Fairing Panel - Lower



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- 8) Install the non-designated electrical bond fasteners for this access panel [11]:

Number **Name/Location**

191E Low Pressure ECS Panel - Forward

- 9) Install the non-designated electrical bond fasteners for this access panel [9]:

Number **Name/Location**

191FL Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 10) Install the non-designated electrical bond fasteners for this access panel [13]:

Number **Name/Location**

191FR Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 11) Install the non-designated electrical bond fasteners for this access panel [8]:

Number **Name/Location**

191GL Ram Air Actuator Panel - Forward

- 12) Install the non-designated electrical bond fasteners for this access panel [14]:

Number **Name/Location**

191GR Ram Air Actuator Panel - Forward

- 13) Install the non-designated electrical bond fasteners for this access panel [10]:

Number **Name/Location**

191HL Ram Air Inlet Lip Panel - Forward

- 14) Install the non-designated electrical bond fasteners for this access panel [12]:

Number **Name/Location**

191HR Ram Air Inlet Lip Panel - Forward

SUBTASK 53-51-21-400-006

- (2) Install the bonding fasteners for the applicable panel:

- (a) Apply compound, C00528 to the fastener and its hole.

- (b) Measure the maximum electrical resistance for each bonding fastener.

- 1) Refer to this task: Wing-To-Body Fairing Panel Maximum Electrical Resistance Check, TASK 53-51-21-760-801.

- a) Make sure that the resistance for each bonding fastener is not more than 300,000 ohms for these access panels:

- In Zone 191: 191AL, 191AR, 191BL, 191BR, 191FL, 191FR, 191GL, 191GR, 191HL, 191HR

- b) Make sure that the resistance for each bonding fastener is not more than 10 ohms for these access panels:

- In Zone 191: 191CL, 191CR, 191D

- c) Make sure that the resistance for each bonding jumper is not more than 0.5 ohms for this access panel:

- In Zone 191: 191E

- (c) After you install the bonding fasteners, apply one layer of primer, C00175 to the bonding fasteners only.

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SUBTASK 53-51-21-220-003

- (3) Make sure that the distance between panels is in tolerance.
 - (a) Measure the misfair between the fairing panels.
 - 1) If you install access panels 191BL or 191BR, make sure that there is no misfair between the panels and the adjacent panels.
NOTE: These panels make a recess for the Ram Air inlet.
 - 2) If you install access panels 191AL or 191AR, make sure that the misfair for the trailing edge is between 0.07 in. (1.78 mm) and -0.03 in. (-0.76 mm).
NOTE: The trailing edge will be against panel 195AL or 195AR.
 - 3) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
 - (b) Measure the clearance between the fairing panels.
 - 1) Make sure that the clearance between the panels is 0.14 in. (3.56 mm) \pm 0.060 in. (1.524 mm).
 - (c) Measure the flushness between the fasteners and the fairing panels.
 - 1) Make sure that the distance between the fasteners and panels is between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

SUBTASK 53-51-21-390-007

- (4) Apply sealant, A02315 to make a fillet seal where the panel touches the fuselage.
NOTE: This makes an aerodynamic and weather seal.
 - (a) Do not apply sealant on the access doors.

H. Put the Airplane in Its Usual Condition

SUBTASK 53-51-21-410-005

- (1) Connect or install the equipment to the fairing.

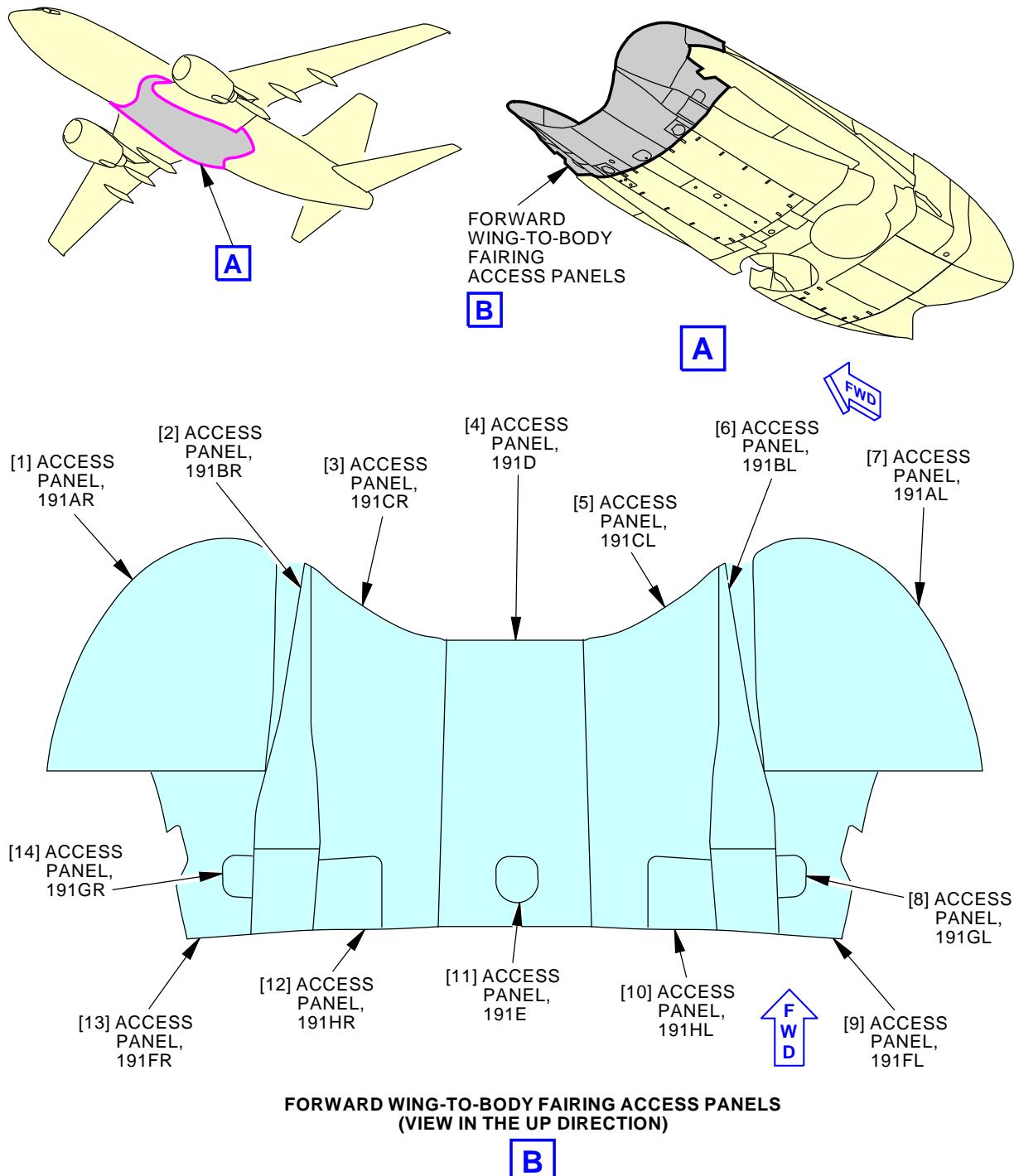
SUBTASK 53-51-21-410-003

- (2) Do an operational test for the disconnected or removed equipment.
 - (a) Ram Air Intake (SECTION 21-51)
 - (b) Lights (SECTION 33-44)

———— END OF TASK ———



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| **Forward Wing-To-Body Fairing Access Panels Installation**
Figure 401/53-51-21-990-803

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TASK 53-51-21-000-802

4. Center Wing-To-Body Fairing Panel Removal

(Figure 402)

A. References

Reference	Title
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
51-31-00-160-801	Prepare For Sealing (P/B 201)
52-48-42-000-801	Environmental Control Systems (ECS) Access Doors - Removal (P/B 401)

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

C. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side





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D. Prepare for Center Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-020-004

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing.
 - (a) DME Antennas (PAGEBLOCK 34-55-11/401).
 - (b) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).

E. Center Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-010-002

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-31-00-160-801).

SUBTASK 53-51-21-020-005

- (2) If you remove Access Panel, 192CL [46] or Access Panel, 192CR [44], do this task:
Environmental Control Systems (ECS) Access Doors - Removal, TASK 52-48-42-000-801.

SUBTASK 53-51-21-020-006

- (3) Do these steps to remove the applicable fairing panels:

NOTE: Hold the fairing panel until all the fasteners have been removed.

NOTE: Identify the fasteners to install them in the same locations.

- (a) Zone 192:
 - 1) Remove the fasteners for this access panel [27]:

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward
 - 2) Remove the fasteners for this access panel [41]:

<u>Number</u>	<u>Name/Location</u>
192AR	Underwing Bolt Cover - Forward
 - 3) Remove the fasteners for this access panel [30]:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
 - 4) Remove the fasteners for this access panel [42]:

<u>Number</u>	<u>Name/Location</u>
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
 - 5) Remove the fasteners for this access panel [45]:

<u>Number</u>	<u>Name/Location</u>
192E	ECS Under Keel Panel - Forward
 - 6) Remove the fasteners for this access panel [28]:

<u>Number</u>	<u>Name/Location</u>
192F	ECS Under Keel Panel - Middle
 - 7) Remove the fasteners for this access panel [26]:

<u>Number</u>	<u>Name/Location</u>
192G	Sump Drain Access Door



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- 8) Remove the fasteners for this access panel [29]:

Number **Name/Location**

192HL Underwing Bolt Cover - Aft

- 9) Remove the fasteners for this access panel [40]:

Number **Name/Location**

192HR Underwing Bolt Cover - Aft

- 10) Remove the fasteners for this access panel [33]:

Number **Name/Location**

192JL Air Conditioning Panel - Aft

- 11) Remove the fasteners for this access panel [39]:

Number **Name/Location**

192JR Air Conditioning Panel - Aft

- 12) Remove the fasteners for this access panel [36]:

Number **Name/Location**

192K Air Conditioning Under Keel Panel - Aft

(b) Zone 193:

- 1) Remove the fasteners for this access panel [31]:

Number **Name/Location**

193AL Wheel Well Panel - Forward Outboard

- 2) Remove the fasteners for this access panel [38]:

Number **Name/Location**

193AR Wheel Well Panel - Forward Outboard

- 3) Remove the fasteners for this access panel [34]:

Number **Name/Location**

193B Wheel Well Panel - Forward Inboard

- 4) Remove the fasteners for this access panel [32]:

Number **Name/Location**

193CL Wheel Well Panel - Aft Outboard

- 5) Remove the fasteners for this access panel [37]:

Number **Name/Location**

193CR Wheel Well Panel - Aft Outboard

- 6) Remove the fasteners for this access panel [35]:

Number **Name/Location**

193D Wheel Well Panel - Aft Inboard

(c) Zone 195:

- 1) Remove the fasteners for this access panel [20]:

Number **Name/Location**

195AL Wing To Body Fairing - Left Side



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- 2) Remove the fasteners for this access panel [21]:

Number Name/Location

195BL Wing To Body Fairing - Left Side

- 3) Remove the fasteners for this access panel [22]:

Number Name/Location

195CL Wing To Body Fairing - Left Side

- (d) Zone 196:

- 1) Remove the fasteners for this access panel [23]:

Number Name/Location

195AR Wing To Body Fairing - Right Side

- 2) Remove the fasteners for this access panel [24]:

Number Name/Location

195BR Wing To Body Fairing - Right Side

- 3) Remove the fasteners for this access panel [25]:

Number Name/Location

195CR Wing To Body Fairings - Right Side

- (e) Remove the fairing panel from the airplane.

———— END OF TASK ————

TASK 53-51-21-400-802

5. Center Wing-To-Body Fairing Panel Installation

(Figure 402)

A. General

- (1) This task includes the steps to install access panels:

B. References

Reference	Title
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-51-00-340-805	Bonded Teflon Rub Pad Repair (P/B 801)
52-48-42-400-801	Environmental Control Systems (ECS) Access Door - Installation (P/B 401)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II



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(Continued)

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

E. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side



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F. Prepare for Center Wing-To-Body Fairing Panel Installation Procedure

SUBTASK 53-51-21-210-003

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

NOTE: Teflon is applied in the mating surface. The teflon is not contamination. It is not necessary to remove the teflon.

SUBTASK 53-51-21-160-002

- (2) Make sure that the teflon mating surface is in a good condition.
 - (a) If necessary, repair the teflon substrip. Refer to this task: Bonded Teflon Rub Pad Repair, TASK 51-51-00-340-805.

SUBTASK 53-51-21-210-004

- (3) Make sure that the designated electrical bonds for the panel are identified.
 - (a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

SUBTASK 53-51-21-390-004

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing which touches the structure.

SUBTASK 53-51-21-390-005

CAUTION: DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS THAT DO NOT TOUCH THE FUSELAGE SKIN. IF YOU APPLY SEALANT INCORRECTLY, IT CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS.

- (5) Apply sealant, A00247 to the flanges on the fairing which touches the body skin.

SUBTASK 53-51-21-390-006

- (6) Apply the corrosion inhibiting compound, G00009, to the area on the structure and the body skin which touches the fairing.
 - (a) If necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

G. Center Wing-To-Body Fairing Panels Installation Procedure

SUBTASK 53-51-21-400-003

- (1) If you install access panels, 192CL,192CR or 192DR do this task: Environmental Control Systems (ECS) Access Door - Installation, TASK 52-48-42-400-801.

SUBTASK 53-51-21-400-004

- (2) Install the fasteners that do not have a designated electrical bond on the applicable panel.
 - (a) Apply primer, C00259 to the hole areas of all fasteners in the structure if necessary.
 - (b) Let the primer dry.
 - (c) Put the applicable panel into its position.

1) Zone 192:

- a) Install the non-designated electrical bond fasteners for this access panel [27]:

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward

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- b) Install the non-designated electrical bond fasteners for this access panel [41]:

Number **Name/Location**

192AR Underwing Bolt Cover - Forward

- c) Install the non-designated electrical bond fasteners for this access panel [30]:

Number **Name/Location**

192BL ECS Ram Air Inlet Mixing Duct Panel - Forward

- d) Install the non-designated electrical bond fasteners for this access panel [42]:

Number **Name/Location**

192BR ECS Ram Air Inlet Mixing Duct Panel - Forward

- e) Install the non-designated electrical bond fasteners for this access panel [45]:

Number **Name/Location**

192E ECS Under Keel Panel - Forward

- f) Install the non-designated electrical bond fasteners for this access panel [28]:

Number **Name/Location**

192F ECS Under Keel Panel - Middle

- g) Install the non-designated electrical bond fasteners for this access panel [26]:

Number **Name/Location**

192G Sump Drain Access Door

- h) Install the non-designated electrical bond fasteners for this access panel [29]:

Number **Name/Location**

192HL Underwing Bolt Cover - Aft

- i) Install the non-designated electrical bond fasteners for this access panel [40]:

Number **Name/Location**

192HR Underwing Bolt Cover - Aft

- j) Install the non-designated electrical bond fasteners for this access panel [33]:

Number **Name/Location**

192JL Air Conditioning Panel - Aft

- k) Install the non-designated electrical bond fasteners for this access panel [39]:

Number **Name/Location**

192JR Air Conditioning Panel - Aft

- l) Install the non-designated electrical bond fasteners for this access panel [36]:

Number **Name/Location**

192K Air Conditioning Under Keel Panel - Aft

- 2) Zone 193:

- a) Install the non-designated electrical bond fasteners for this access panel [31]:

Number **Name/Location**

193AL Wheel Well Panel - Forward Outboard

- b) Install the non-designated electrical bond fasteners for this access panel [38]:

Number **Name/Location**

193AR Wheel Well Panel - Forward Outboard

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- c) Install the non-designated electrical bond fasteners for this access panel [34]:

Number **Name/Location**

193B Wheel Well Panel - Forward Inboard

- d) Install the non-designated electrical bond fasteners for this access panel [32]:

Number **Name/Location**

193CL Wheel Well Panel - Aft Outboard

- e) Install the non-designated electrical bond fasteners for this access panel [37]:

Number **Name/Location**

193CR Wheel Well Panel - Aft Outboard

- f) Install the non-designated electrical bond fasteners for this access panel [35]:

Number **Name/Location**

193D Wheel Well Panel - Aft Inboard

- 3) Zone 195:

- a) Install the non-designated electrical bond fasteners for this access panel [20]:

Number **Name/Location**

195AL Wing To Body Fairing - Left Side

- b) Install the non-designated electrical bond fasteners for this access panel [21]:

Number **Name/Location**

195BL Wing To Body Fairing - Left Side

- c) Install the non-designated electrical bond fasteners for this access panel [22]:

Number **Name/Location**

195CL Wing To Body Fairing - Left Side

- 4) Zone 196:

- a) Install the non-designated electrical bond fasteners for this access panel [23]:

Number **Name/Location**

195AR Wing To Body Fairing - Right Side

- b) Install the non-designated electrical bond fasteners for this access panel [24]:

Number **Name/Location**

195BR Wing To Body Fairing - Right Side

- c) Install the non-designated electrical bond fasteners for this access panel [25]:

Number **Name/Location**

195CR Wing To Body Fairings - Right Side

SUBTASK 53-51-21-400-005

- (3) Install the bonding fasteners for the applicable panel:

- (a) Apply compound, C00528 to the fastener and its hole.

- (b) Measure the maximum electrical resistance for each bonding fastener.

- 1) Refer to this task: Wing-To-Body Fairing Panel Maximum Electrical Resistance Check, TASK 53-51-21-760-801.

- a) Make sure that the maximum resistance for each bonding fastener is not more than 300,000 ohms for these access panels:

- In Zone 192: 192AL, 192AR, 192HL, 192HR

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- In Zone 193: 193AR, 193B, 193CL, 193CR, 193D
 - In Zone 195: 195AL, 195BL, 195CL
 - In Zone 196: 195AR, 195BR, 195CR
- b) Make sure that the maximum resistance for each bonding jumper is not more than 100 ohms for these access panels:
- In Zone 192: 192CL, 192CR
- c) Make sure that the maximum resistance for each bonding fastener is not more than 10 ohms for these access panels:
- In Zone 193: 193AL
- d) Make sure that the maximum resistance for each bonding fastener is not more than 0.5 ohms for these access panels:
- In Zone 192: 192BL, 192BR, 192E, 192F, 192JL, 192JR, 192K
- e) Make sure that the maximum resistance for each bonding fastener is not more than 0.001 ohms for this access panel:
- In Zone 192: 192G
- (c) After you install the bonding fasteners, apply one layer of primer, C00175 to the bonding fasteners only.

SUBTASK 53-51-21-220-002

- (4) Make sure that the distance between panels is in tolerance.
- (a) Measure the misfair between the fairing panels.
- 1) If you install access panels 192CL or 192CR, make sure that the misfair is less than 0.010 in. (0.254 mm).
 - 2) If you install access panels 192DR, make sure that there the misfair is 0.00 ± 0.06 in. (0.000 ± 1.524 mm).
 - 3) If you install access panels 195AL or 195AR, make sure that the misfair for the leading edge is between 0.07 in. (1.78 mm) and -0.03 in. (-0.76 mm).
NOTE: The leading edge will be against panel 191AL or 191AR.
 - 4) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
- (b) Measure the clearance between the fairing panels.
- 1) Make sure that the clearance between the panels is 0.14 in. (3.56 mm) ± 0.060 in. (1.524 mm).
 - 2) If you install 192CL or 192CR, make sure that the clearance between the two sides of each hinge is less than 0.088 in. (2.235 mm).
 - 3) If you install 192DR, make sure that the clearance is less than 0.10 in. (2.54 mm).
- (c) Measure the flushness between the fasteners and the fairing panels.
- 1) Make sure that the distance between the fasteners and panels is between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

SUBTASK 53-51-21-910-004

- (5) Apply sealant, A02315 to make a fillet seal where the panel touches the fuselage.

NOTE: This makes an aerodynamic and weather seal.

- (a) Do not apply sealant on the access doors.

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H. Put the Airplane in Its Usual Condition

SUBTASK 53-51-21-410-004

- (1) Connect or install the equipment to the fairing.

SUBTASK 53-51-21-410-002

- (2) Do an operational test for the disconnected or removed equipment.
 - (a) DME Antennas (PAGEBLOCK 34-55-11/401).
 - (b) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).

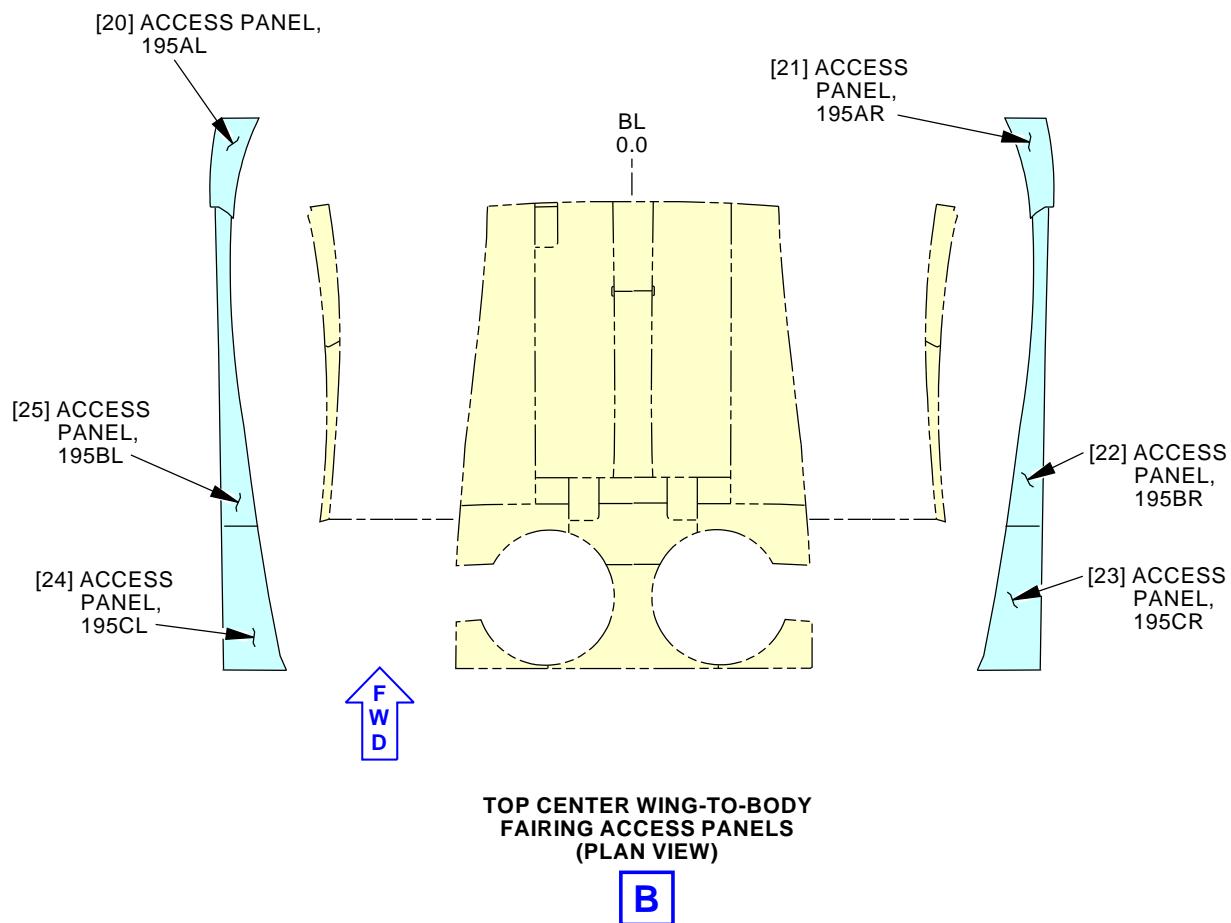
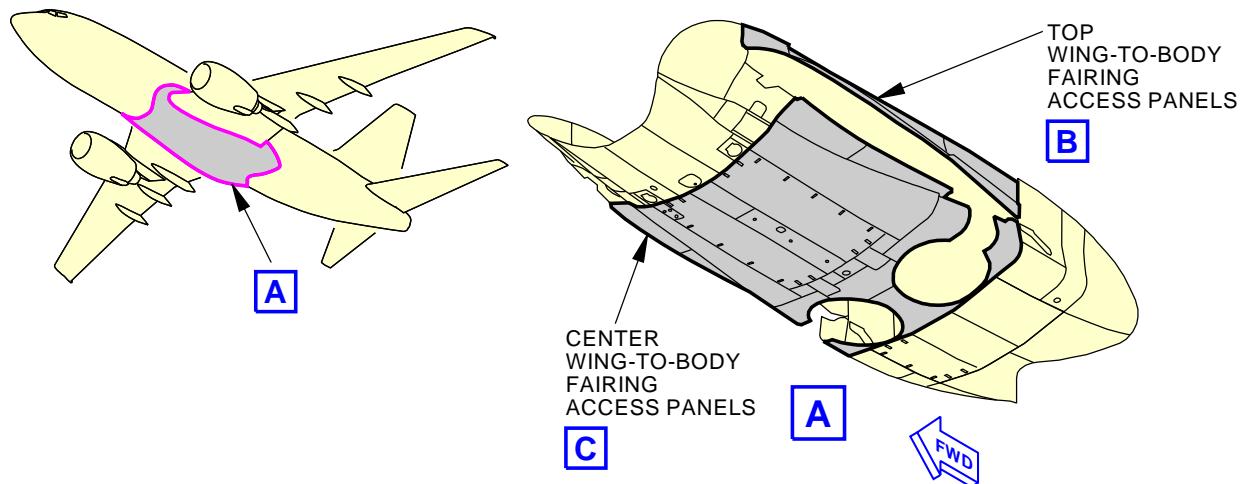
———— END OF TASK ————

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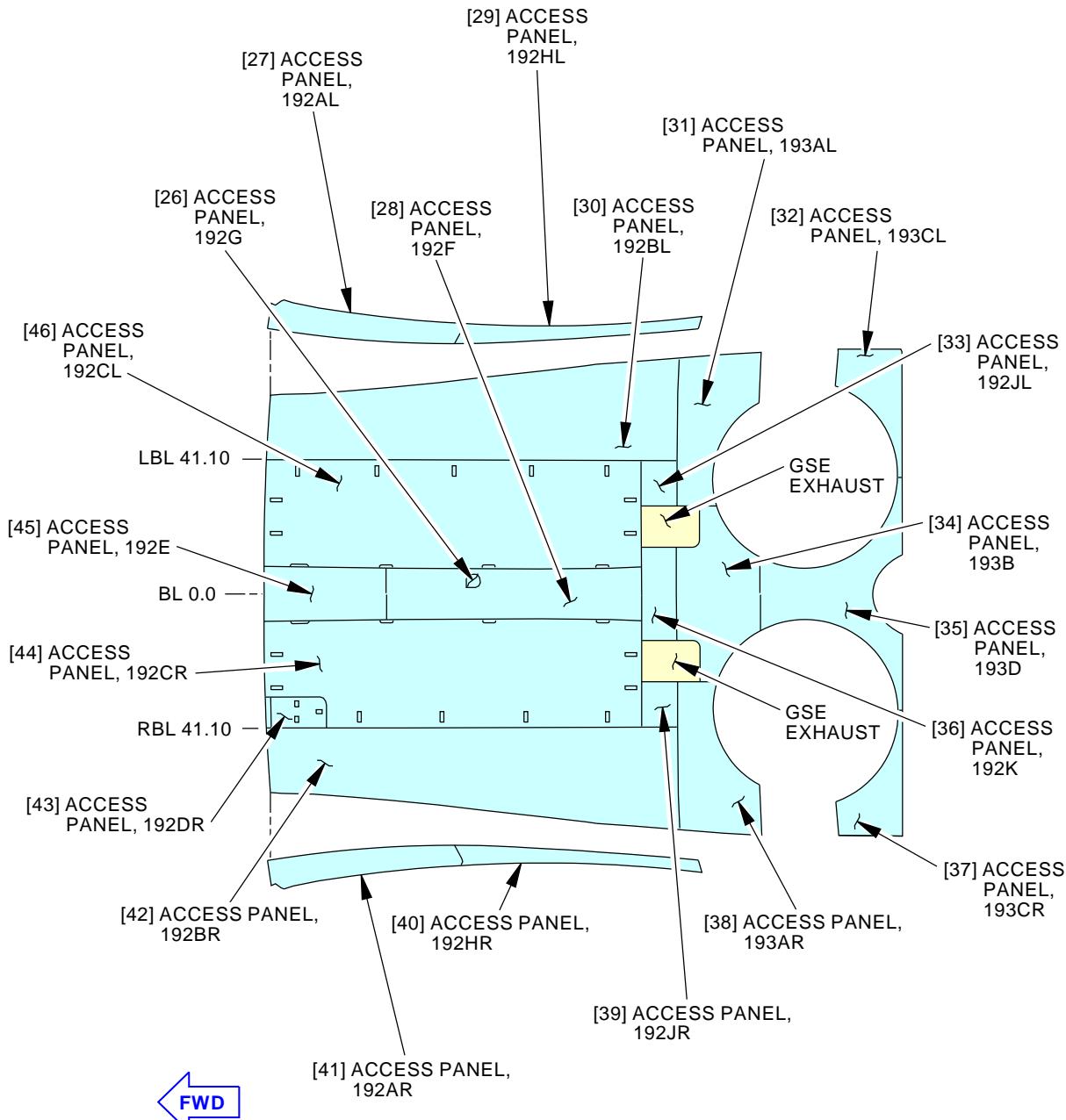
Center Wing-To-Body Fairing Panels
Figure 402/53-51-21-990-802 (Sheet 1 of 2)

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**Center Wing-To-Body Fairing Panels
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TASK 53-51-21-000-801

6. Aft Wing-To-Body Fairing Panel Removal

(Figure 403)

A. References

Reference	Title
28-25-07 P/B 401	APU FUEL FEED LINE SHROUD DRAIN MAST - REMOVAL/INSTALLATION
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
51-31-00-160-801	Prepare For Sealing (P/B 201)

B. Location Zones

Zone	Area
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

D. Prepare for Aft Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-020-007

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing.
 - (a) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).
 - (b) APU Drain Mast (PAGEBLOCK 28-25-07/401).

E. Aft Wing-To-Body Fairing Panels Removal Procedure

SUBTASK 53-51-21-020-001

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-31-00-160-801).

SUBTASK 53-51-21-020-008

- (2) Do these steps to remove the applicable fairing panels:

NOTE: Hold the fairing panel until all the fasteners have been removed.

NOTE: Identify the fasteners to install them in the same locations.

- (a) Zone 194:

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- 1) Remove the fasteners for access panel [57]:

Number **Name/Location**

194AL Aft Wing To Body Fairing Panel

- 2) Remove the fasteners for access panel [50]:

Number **Name/Location**

194AR Aft Wing To Body Fairing Panel

- 3) Remove the fasteners for access panel [56]:

Number **Name/Location**

194BL Flap Track Lubrication Panel - Aft

- 4) Remove the fasteners for access panel [51]:

Number **Name/Location**

194BR Flap Track Lubrication Panel - Aft

- 5) Remove the fasteners for access panel [64]:

Number **Name/Location**

194CL Aft Wing To Body Fairing Panel

- 6) Remove the fasteners for access panel [52]:

Number **Name/Location**

194CR Aft Wing To Body Fairing Panel

- 7) Remove the fasteners for access panel [55]:

Number **Name/Location**

194DL Aft Wing To Body Fairing Panel

- 8) Remove the fasteners for access panel [53]:

Number **Name/Location**

194DR Aft Wing To Body Fairing Panel

- 9) Remove the fasteners for access panel [54]:

Number **Name/Location**

194E Aft Wing To Body Fairing Panel

- 10) Remove the fasteners for access panel [58]:

Number **Name/Location**

194FL Aft Wing To Body Fairing Panel

- 11) Remove the fasteners for access panel [62]:

Number **Name/Location**

194FR Aft Wing To Body Fairing Panel

- 12) Remove the fasteners for access panel [59]:

Number **Name/Location**

194GL Aft Wing To Body Fairing Panel

- 13) Remove the fasteners for access panel [63]:

Number **Name/Location**

194GR Aft Wing To Body Fairing Panel



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- 14) Remove the fasteners for access panel [60]:

Number Name/Location

194HL Aft Wing To Body Fairing Panel

- 15) Remove the fasteners for access panel [61]:

Number Name/Location

194HR Aft Wing To Body Fairing Panel

- (b) Remove the fairing panel from the airplane.

———— END OF TASK ————

TASK 53-51-21-400-801

7. Aft Wing-To-Body Fairing Panel Installation

(Figure 403)

A. General

- (1) This task includes the steps to install access panels:

B. References

Reference	Title
27-51-00-820-801	Trailing Edge Flap Control System Adjustment and Test (P/B 501)
28-25-07 P/B 401	APU FUEL FEED LINE SHROUD DRAIN MAST - REMOVAL/INSTALLATION
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-51-00-340-805	Bonded Teflon Rub Pad Repair (P/B 801)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23



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D. Location Zones

Zone	Area
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

E. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

F. Prepare for Aft Wing-To-Body Fairing Panel Installation Procedure

SUBTASK 53-51-21-210-001

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

NOTE: Teflon is applied in the mating surface. The teflon is not contamination. It is not necessary to remove the teflon.

SUBTASK 53-51-21-160-001

- (2) Make sure that the teflon mating surface is in good condition.
 - (a) If necessary, repair the teflon substrip. Refer to this task: Bonded Teflon Rub Pad Repair, TASK 51-51-00-340-805.

SUBTASK 53-51-21-210-002

- (3) Make sure that the designated electrical bonds for the panel can be identified.
 - (a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

SUBTASK 53-51-21-390-001

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing which touches the structure.

SUBTASK 53-51-21-390-002

CAUTION: DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS THAT DO NOT TOUCH THE FUSELAGE SKIN. IF YOU APPLY SEALANT INCORRECTLY, IT CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS.

- (5) Apply sealant, A00247 to the flanges on the fairing which touches the body skin.



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SUBTASK 53-51-21-390-003

- (6) Apply the corrosion inhibiting compound, G00009, to the area on the structure and the body skin which touches the fairing.
(a) If necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

G. Aft Wing-To-Body Fairing Panels Installation Procedure

SUBTASK 53-51-21-400-001

- (1) Install the fasteners that do not have a designated electrical bond on the applicable panel.

CAUTION: DO NOT APPLY, CORROSION PREVENTIVE COMPOUND, C00308 TO THE BONDING FASTENERS AND THEIR HOLES. THIS COMPOUND INTERFERES WITH THE CONDUCTIVITY CONTACT OF THE BONDING BOLT. THERE MUST BE SUFFICIENT CONDUCTIVE CONTACT BETWEEN A BONDING BOLT HEAD AND THE COUNTERSUNK SURFACE THAT THE BOLT HEAD GOES INTO. BONDING BOLTS HELP PREVENT POTENTIAL DAMAGE DUE TO LIGHTNING. IF BONDING BOLTS ARE NOT INSTALLED CORRECTLY, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Apply primer, C00259 to the hole of all non-designated electrical bond fasteners in the structure as necessary.
(b) Let the primer to dry.
(c) Put the panel into its position.

- 1) Install the non-designated electrical bond fasteners for this access panel [57]:

Number Name/Location

194AL Aft Wing To Body Fairing Panel

- 2) Install the non-designated electrical bond fasteners for this access panel [50]:

Number Name/Location

194AR Aft Wing To Body Fairing Panel

- 3) Install the non-designated electrical bond access fasteners for this panel [56]:

Number Name/Location

194BL Flap Track Lubrication Panel - Aft

- 4) Install the non-designated electrical bond fasteners for this access panel [51]:

Number Name/Location

194BR Flap Track Lubrication Panel - Aft

- 5) Install the non-designated electrical bond fasteners for this access panel [64]:

Number Name/Location

194CL Aft Wing To Body Fairing Panel

- 6) Install the non-designated electrical bond fasteners for this access panel [52]:

Number Name/Location

194CR Aft Wing To Body Fairing Panel

- 7) Install the non-designated electrical bond fasteners for this access panel [55]:

Number Name/Location

194DL Aft Wing To Body Fairing Panel

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- 8) Install the non-designated electrical bond fasteners for this access panel [53]:

Number Name/Location

194DR Aft Wing To Body Fairing Panel

- 9) Install the non-designated electrical bond fasteners for this access panel [54]:

Number Name/Location

194E Aft Wing To Body Fairing Panel

- 10) Install the non-designated electrical bond fasteners for this access panel [58]:

Number Name/Location

194FL Aft Wing To Body Fairing Panel

- 11) Install the non-designated electrical bond fasteners for this access panel [62]:

Number Name/Location

194FR Aft Wing To Body Fairing Panel

- 12) Install the non-designated electrical bond fasteners for this access panel [59]:

Number Name/Location

194GL Aft Wing To Body Fairing Panel

- 13) Install the non-designated electrical bond fasteners for this access panel [63]:

Number Name/Location

194GR Aft Wing To Body Fairing Panel

- 14) Install the non-designated electrical bond fasteners for this access panel [60]:

Number Name/Location

194HL Aft Wing To Body Fairing Panel

- 15) Install the non-designated electrical bond fasteners for this access panel [61]:

Number Name/Location

194HR Aft Wing To Body Fairing Panel

CAUTION: IF YOU NEED TO REPLACE A PANEL THAT HAS A DOUBLER (194AL, 194BL, 194AR, OR 194BR), YOU MUST INSTALL A NEW PANEL WITH A NEW DOUBLER. MAKE SURE THAT YOU INSTALL IT CORRECTLY. IF DOUBLERS ARE NOT INSTALLED CORRECTLY, PANEL LOSS MAY OCCUR OR LATERAL TRIM MAY BE AFFECTED.

- (d) If access panels 194AL, 194AR, 194BL, or 194BR are replaced and have a doubler, do the following:

NOTE: The same thickness doubler and nylon liner should be used and edges sealed with sealant. This makes an aerodynamic and a weather seal.

- 1) Install a new doubler and nylon at STA 727.
- 2) Fay seal doubler to fairing panel.
- 3) Make sure that the seal compression is within limits of operation and trailing edge flaps are within limits (TASK 27-51-00-820-801).
- 4) Apply sealant, A02315 to make a fillet seal around edge of doubler.

SUBTASK 53-51-21-400-002

- (2) Install the designated bonding fasteners for the applicable panel.

- (a) Apply compound, C00528 to the fastener and its hole.

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- (b) Measure the maximum electrical resistance for each bonding fastener.
 - 1) Refer to this task: Wing-To-Body Fairing Panel Maximum Electrical Resistance Check, TASK 53-51-21-760-801.
 - a) Make sure that the resistance for each bonding fastener is not more than 300,000 ohms for these access panels:
 - In Zone 194: 194AL, 194AR, 194BL, 194BR, 194CL, 194FL, 194FR
 - b) Make sure that the resistance for each bonding fastener is not more than 0.5 ohms for these access panels:
 - In Zone 194: 194CR, 194DL, 194DR, 194E, 194GL, 194GR, 194HL, 194HR
 - (c) After you install the bonding fasteners, apply one coat of primer, C00175 as needed to the bonding fasteners only.

SUBTASK 53-51-21-220-001

- (3) Make sure that the distance between panels is in tolerance.
 - (a) Measure the misfair between the panels.
 - 1) If you install access panels 194AL, 194AR, 194CL, 194CR, 194FL, or 194FR, make sure that the joint misfair is within the range of 0.0600 in. (1.524 mm) +0.0400 in. (1.016 mm) or -0.1000 in. (-2.5400 mm).
 - 2) For all other access panel joints, make sure that the joint misfair is less than or equal to 0.0400 in. (1.016 mm).
 - (b) Measure the gap between the fairing panels.
 - 1) Make sure that the gap between the access panels is 0.1400 in. (3.556 mm) ± 0.0600 in. (1.524 mm).
 - (c) Measure the flushness between the fasteners and the fairing panels.
 - 1) Make sure that the fasteners are flush to the fairing panel between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

SUBTASK 53-51-21-910-003

CAUTION: DO NOT APPLY SEALANT BETWEEN THE FAIRING ACCESS PANELS OR DOORS. SEALANT IN THE INCORRECT LOCATION CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS DURING FLIGHT.

- (4) Apply sealant, A02315 to make a fillet seal where the panel touches the fuselage.

NOTE: This makes an aerodynamic and a weather seal.

H. Put the Airplane in Its Usual Condition

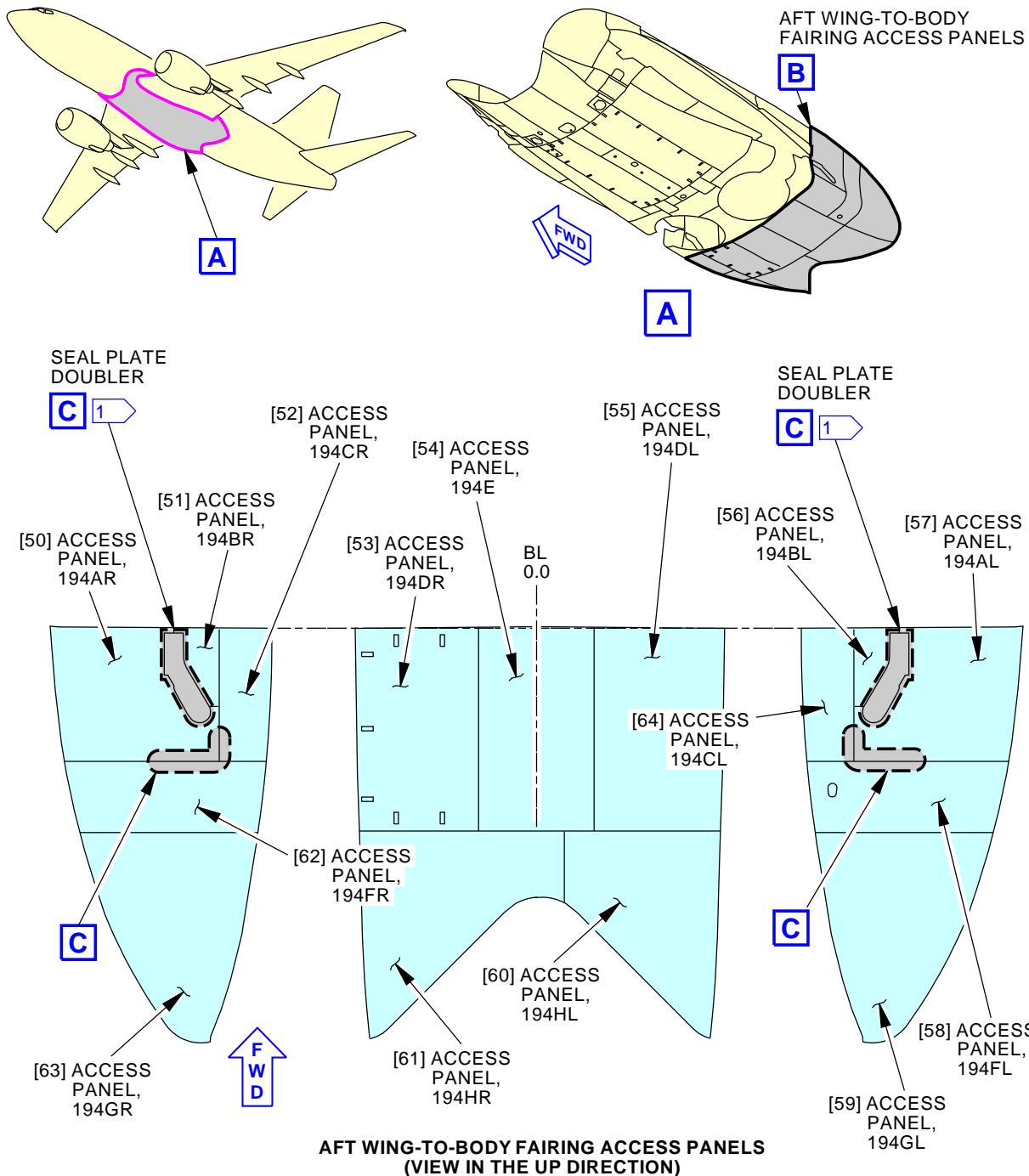
SUBTASK 53-51-21-410-001

- (1) Connect or install the equipment to the fairing and do an operational test if the equipment was disconnected or removed.
 - (a) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).
 - (b) APU Drain Mast (PAGEBLOCK 28-25-07/401).

———— END OF TASK ——



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Aft Wing-To-Body Fairing Access Panels Installation
Figure 403/53-51-21-990-801 (Sheet 1 of 2)

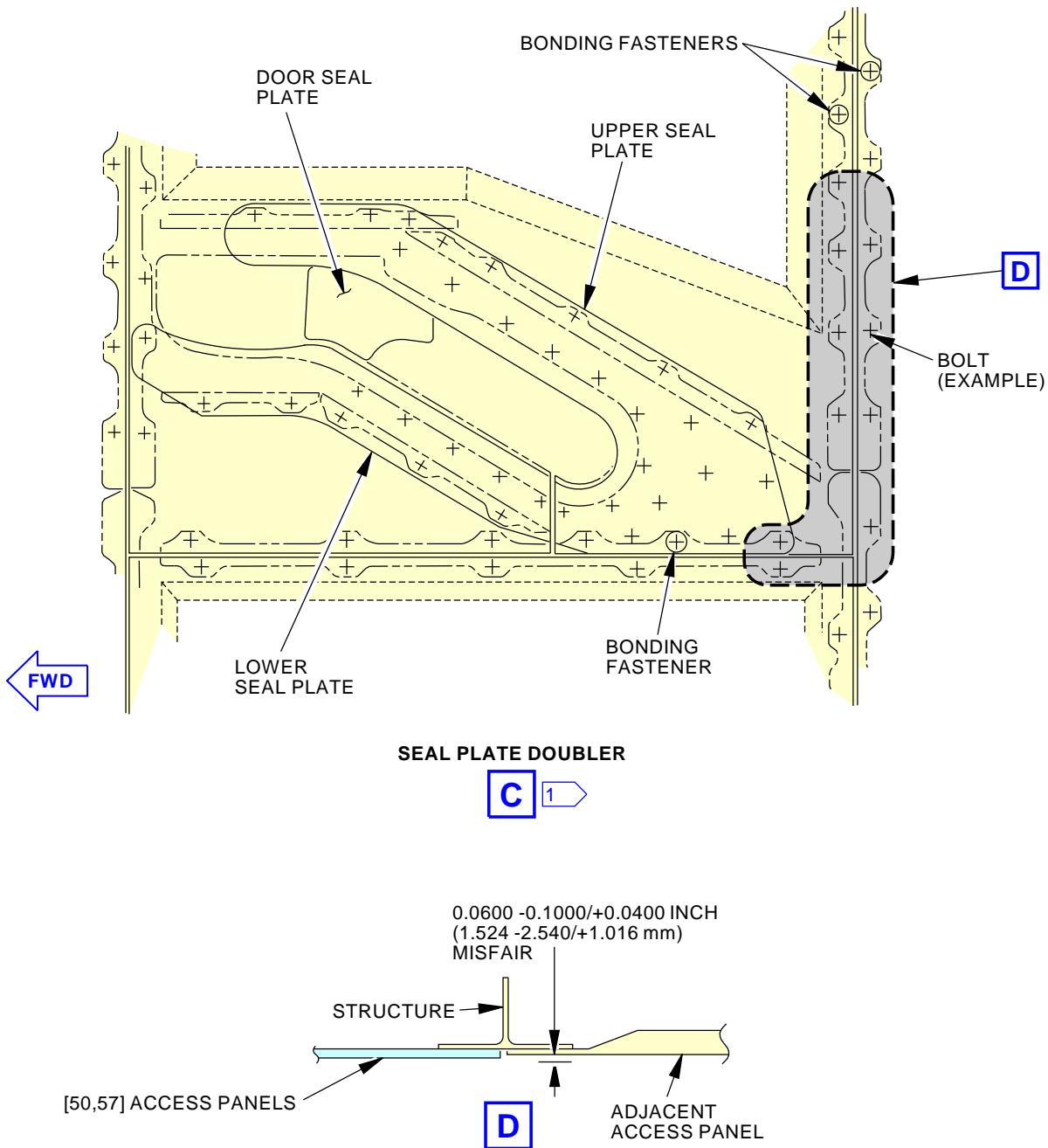
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Aft Wing-To-Body Fairing Access Panels Installation
Figure 403/53-51-21-990-801 (Sheet 2 of 2)

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WING-TO-BODY FAIRING PANELS - INSPECTION/CHECK

1. General

- A. This procedure has these tasks:
 - (1) Wing-To-Body Fairing Panel maximum electrical resistance check.
 - (2) Wing-To-Body Fairing Panel designated electrical bond visual inspection.
- B. This task is not specified to a zone or panel. It applies to all panels in the Forward, Center, and Aft sections of the fillet fairings.

TASK 53-51-21-760-801

2. Wing-To-Body Fairing Panel Maximum Electrical Resistance Check

(Figure 601)

A. General

- (1) This task covers the maximum electrical resistance checks for all designated bonds for panels located in the Wing-To-Body Fairing section.

B. References

Reference	Title
53-51-21 P/B 401	WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION
SWPM 20-20-00	Electrical Bonding Processes

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-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

D. Consumable Materials

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

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(Continued)

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Alodine 600	

E. Location Zones

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

F. Prepare for the Maximum Electrical Resistance Check

SUBTASK 53-51-21-211-002

- (1) Make sure that the fastener locations for the designated bonds are identified.
 - (a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

G. Check the Maximum Electrical Resistance of the Designated Bonds

SUBTASK 53-51-21-910-005

- (1) Make sure that one fastener and one dimpled washer is installed in a designated bond location in the panel.
 - (a) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.
 - (b) Make sure that the flushness for the fastener and the panel is 0.000 ± 0.003 in. (0.0000 ± 0.0762 mm).

SUBTASK 53-51-21-800-001

- (2) Put a dimpled washer in an adjacent designated bonded fastener location.
 - (a) Do not install the fastener at the adjacent designated bonded fastener location.

SUBTASK 53-51-21-200-001

- (3) Connect the digital/analog multimeter, COM-1793 to examine the electrical resistance:
 - (a) Put one probe of a digital/analog multimeter, COM-1793 on the installed designated bonded fastener head.
 - (b) Put the second probe on a dimpled washer in the adjacent designated bonded fastener location.

NOTE: The dimpled washer completes an electrical bond between the panel conductive surface and the probe. There must not be a fastener at this location.

SUBTASK 53-51-21-200-002

- (4) Make sure that the resistance is not more than in the Table 601.



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Table 601/53-51-21-993-801 Panel Conductive Surface Maximum Resistance

Conductive Surface Type	Maximum Resistance (Ohm) ^{*[1]}
Anti-Static Coating	300,000
Aluminum Coated Fiber	10
Expanded Aluminum Foil ^{*[2]}	0.5
Flamespray	0.5

*[1] Some panels will be installed with bonding jumpers. The dimension of the bonding jumper can change the maximum resistance. Refer to the installation procedure for the maximum resistance of panels with bonding jumpers (PAGEBLOCK 53-51-21/401).

*[2] Some panels with the expanded aluminum foil surface can have different maximum resistances. Refer to the installation procedure for panels with different maximum resistances than in this table (PAGEBLOCK 53-51-21/401).

NOTE: The maximum resistance data for each panel can be found in the installation procedures (PAGEBLOCK 53-51-21/401).

- (a) If the designated electrical bond is not in the limits, then do these steps:
 - 1) Apply a layer of coating on the countersunk area of the panel.
 - a) Use coating, C00767 on panels with an anti-static coating conductive surface type.
 - b) Use Alodine 600 coating, C00862 on panels with an aluminum conductive surface type.
 - 2) Measure the maximum resistance again.

SUBTASK 53-51-21-400-008

- (5) If the maximum resistance is in the limits, then make sure that the dimpled washer does not move:
 - (a) Remove the probe.
 - (b) Install the fastener.
 - 1) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.

H. Repeat the Electrical Resistance of the Designated Bonds Check

SUBTASK 53-51-21-200-003

- (1) Do the "Check of the Electrical Resistance of the Designated Bonds" steps again until all designated bonds are examined.
 - (a) Do the check with each subsequently installed designated bond fastener as the start point until all fasteners are installed.

NOTE: It is not necessary to remove or do the resistance check again for the first fastener installed.

- 1) If the designated electrical bond is not in the limits, then do these steps:
 - a) Apply a layer of coating on the countersunk area of the panel.
 - <1> Use coating, C00767 on panels with an anti-static coating conductive surface type.
 - <2> Use Alodine 600 coating, C00862 on panels with an aluminum conductive surface type.
 - b) Measure the maximum resistance for the fastener again.

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I. Restore the Fairing Panel to Its Usual Condition

SUBTASK 53-51-21-390-011

- (1) Apply finish to the fairing panel after all the fasteners have been examined and installed.
 - (a) Apply one layer of primer, C00175 as necessary to the bonding fasteners only.
 - (b) Apply compound, C00528 to all the fasteners for non-designated bonds and their holes.
 - (c) Apply primer, C00259 to all the fasteners for non-designated bonds and their holes.

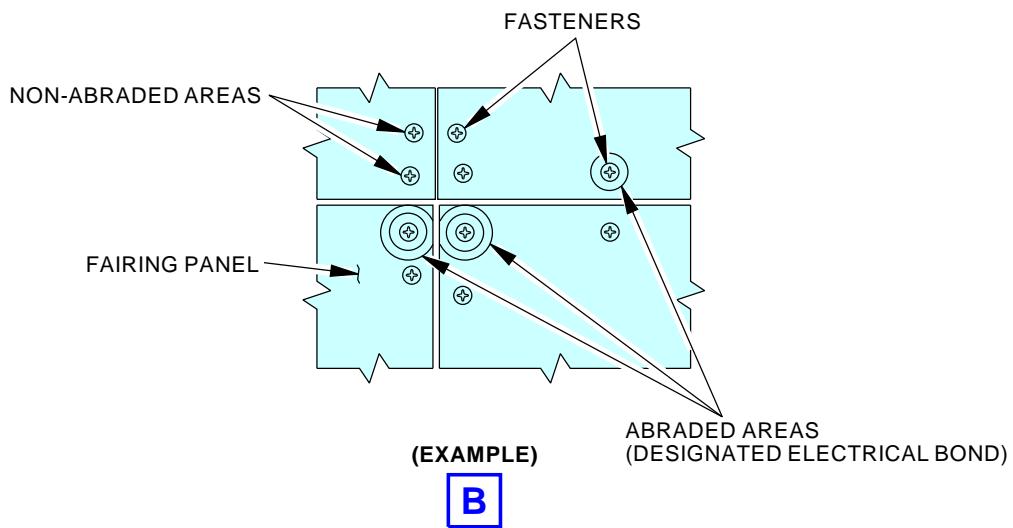
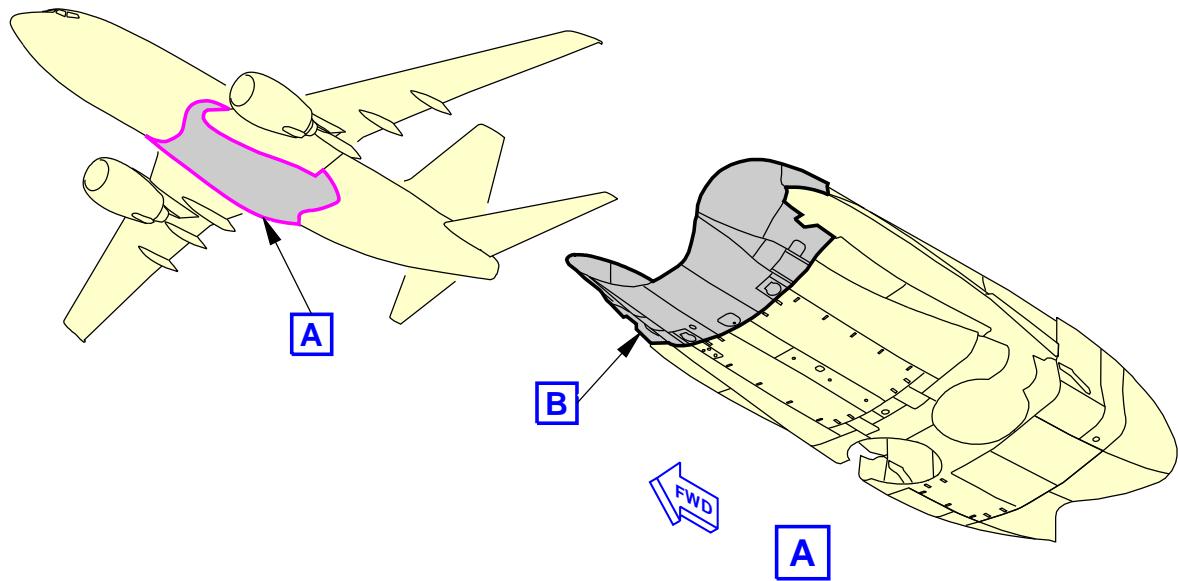
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Wing-to-Body Fairing Inspection
Figure 601/53-51-21-990-804

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TASK 53-51-21-211-801

3. Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection

(Figure 601)

A. General

- (1) This task covers the visual inspection of the designated electrical bonds for the panels located in the Wing-To-Body Fairing section.

B. Consumable Materials

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Alodine 600	

C. Location Zones

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

D. Visually Examine the Designated Electrical Bonds on the Wing-To-Body Fairing Panels

SUBTASK 53-51-21-211-001

- (1) Identify the fastener locations on each panel that an electrical bond is necessary to identify fastener locations for electrical bonds:

NOTE: There are usually four fasteners per panel with electrical bonds.

- (a) Examine the area around each fastener hole to identify electrical bond locations.
 - 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
 - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.
 - 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.

SUBTASK 53-51-21-300-001

- (2) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Remove one fastener and one dimpled washer, if installed, from the panel.

NOTE: There are usually four fasteners per panel with dimpled washers.

- (b) Examine the area around the fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
 - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.

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- 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.
- (c) Examine the countersunk area of the fastener hole:
NOTE: The countersunk area of the panel will be below the dimpled washer, if installed.
 - 1) The countersunk area for each electrically bonded fastener hole will have a coating, C00767 or an Alodine 600 coating, C00862.
NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.
- (d) Examine the countersunk mating surface between the dimpled washer (if installed) and the panel (Figure 601).
 - 1) Make sure that the surfaces without an electrical bond between the dimpled washer and the panel are free from contamination.
 - 2) Make sure that the surfaces with an electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.
- (e) If necessary, install the fastener if the location is not a designated electrical bond.
NOTE: It is not necessary to do this step if the removal and installation procedure is being done until it is necessary in the installation procedure.
 - 1) Do not install the dimpled washer if the location is not a designated electrical bond.
- (f) Do the steps again to find all the designated bond locations.
NOTE: The only fasteners not installed will be fasteners for a designated electrical bond.

———— END OF TASK ————

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FILLET FAIRINGS CORROSION - MAINTINENCE PRACTICES

1. General

- A. This procedure contains 1 task:
- (1) Corrosion Prevention of the Wing to Body Fairing Cavity.

TASK 53-51-37-600-801

2. Wing to Body Fairing Cavity - Corrosion Prevention

Figure 201

A. General

- (1) The upper wing-to-body fairing is attached to the upper wing surface and fuselage skin along the wing to fuselage joints. The lower lobe fairing houses the ambient air inlets to the ram air system during pack cooling fan operation. The lower lobe fuselage skin under the fairing extends to the bulkhead below the front spar of the center wing section. The cavity formed by the lower lobe fairing and fuselage skin is the area of concern and is the subject of this figure. Aft of this area the fairing covers the center wing section.
- (2) Service experience has shown the revised finish system has been effective in controlling the corrosion problem. Corrosion damage is due to the accumulation of moisture from the ambient air as it enters the cavity during pack cooling fan operation.
- (3) Corrosion was reported on the fuselage skin and the external doubler on the wing upper surface under the wing to body fairing. The body surfaces under the fairing is treated with a water displacing corrosion inhibiting compound in production.
- (4) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
100	Lower Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-51-37-610-001

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to ensure that the protective finishes provided at manufacture remain intact. Access for inspections can be made through service doors and access panels in the fairing. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.



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SUBTASK 53-51-37-610-002

CAUTION: DO NOT APPLY THE CORROSION-INHIBITING COMPOUND TO SILICONE RUBBER, RUBBER SEALS, OR RUBBER CUSHIONS. THE CORROSION-INHIBITING COMPOUND CAN CAUSE SEALS, AND CUSHIONS TO BECOME LARGER, AND CAN CAUSE THE DETERIORATION OF THEM.

- (2) Use corrosion inhibiting compound, G00009 where extensive corrosion exists (noticeable skin bulges, missing fasteners or large amounts of discolored deposits of fastener heads or faying surfaces), refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-51-37-610-003

- (3) Where corrosion is not evident, apply corrosion inhibiting compound in all metallic areas of the cavity.

NOTE: For details of water displacing corrosion inhibiting compound, corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-51-37-610-004

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of corrosion inhibiting compound on the affected area to retard the corrosion process and into the entire cavity area noted in part C. The finish system should be restored at the first opportunity consistent with the maintenance schedule Ref (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 and SRM 737-678).

SUBTASK 53-51-37-610-005

- (5) Frequency of Application
(a) Inspect the area at regular maintenance intervals and reapply corrosion inhibitor as necessary.

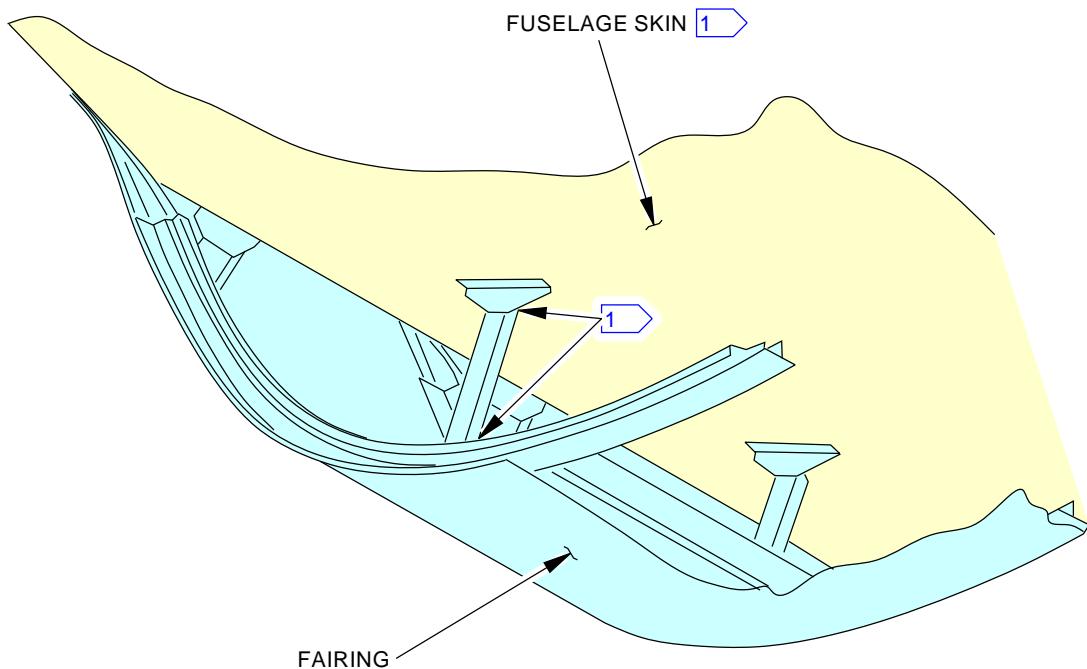
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TYPICAL FAIRING CAVITY STRUCTURE

NOTE:

APPLY BMS 3-23 CORROSION INHIBITOR

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Wing to Body Fairing Cavity
Figure 201/53-51-37-990-801



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NOSE RADOME - MAINTENANCE PRACTICES

1. General

- A. This section contains these tasks:
- (1) A task to open the nose radome.
 - (2) A task to close the nose radome.
 - (3) The removal of the nose radome protective boot.
 - (4) The installation of the nose radome protective boot.

TASK 53-52-00-010-802

2. Nose Radome - Open

A. General

- (1) This task has the steps to open the Nose Radome.

B. Location Zones

Zone	Area
111	Radome

C. Prepare to Open the Nose Radome

SUBTASK 53-52-00-040-001

- (1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

D. Open the Nose Radome

SUBTASK 53-52-00-010-002

- (1) Remove the screws that attach the aft edge of the radome to the clips on the fuselage bulkhead.

SUBTASK 53-52-00-010-003

WARNING: DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (2) Open the radome.
(a) Hold the radome in the open position.

SUBTASK 53-52-00-020-012

- (3) Remove the radome [1] support rods from the stowed position.

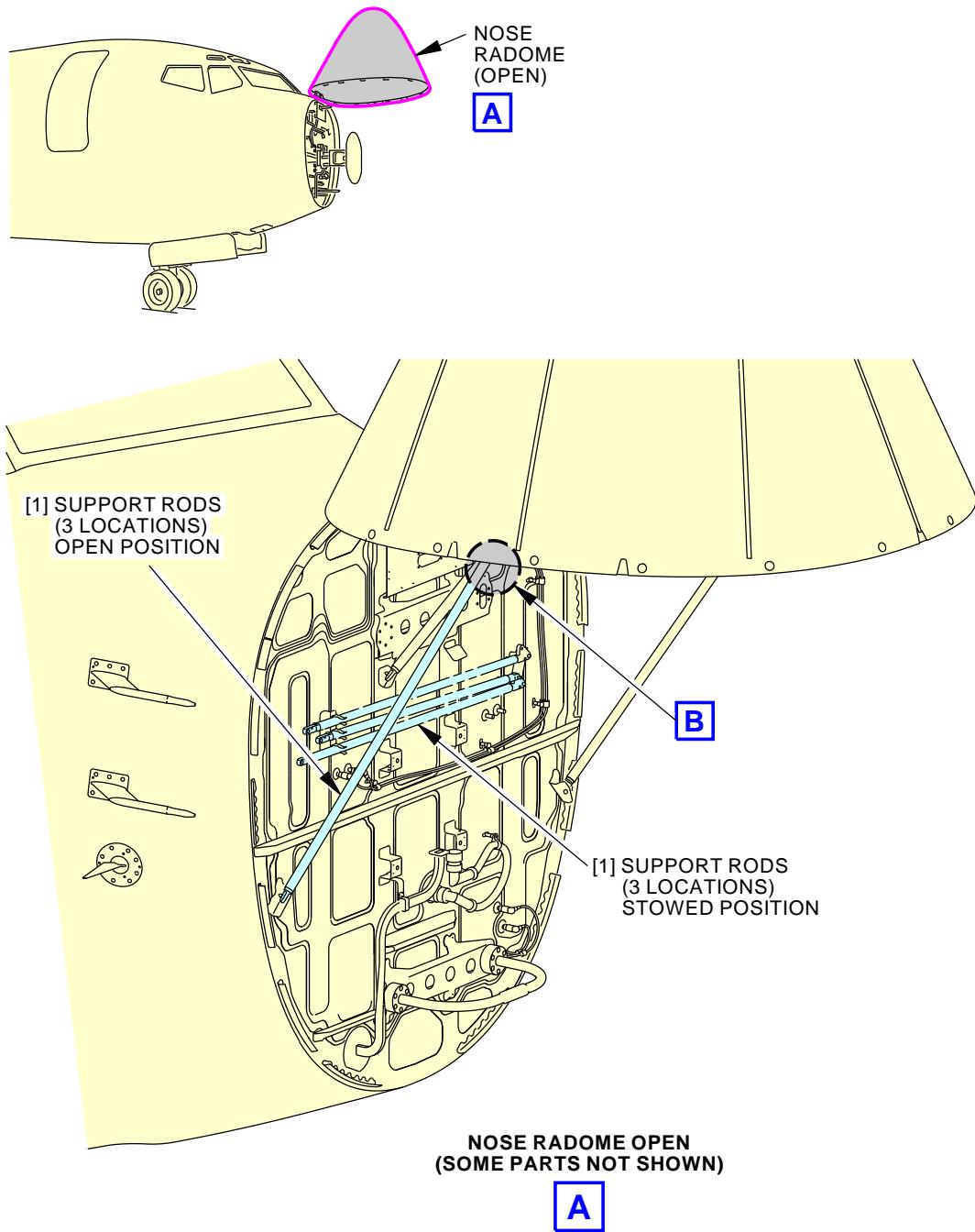
SUBTASK 53-52-00-420-010

- (4) Install the radome [1] support rods on the [3] studs to hold the radome in the open position.

———— END OF TASK ————



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Nose Radome Open/Close Procedure
Figure 201/53-52-00-990-806 (Sheet 1 of 2)

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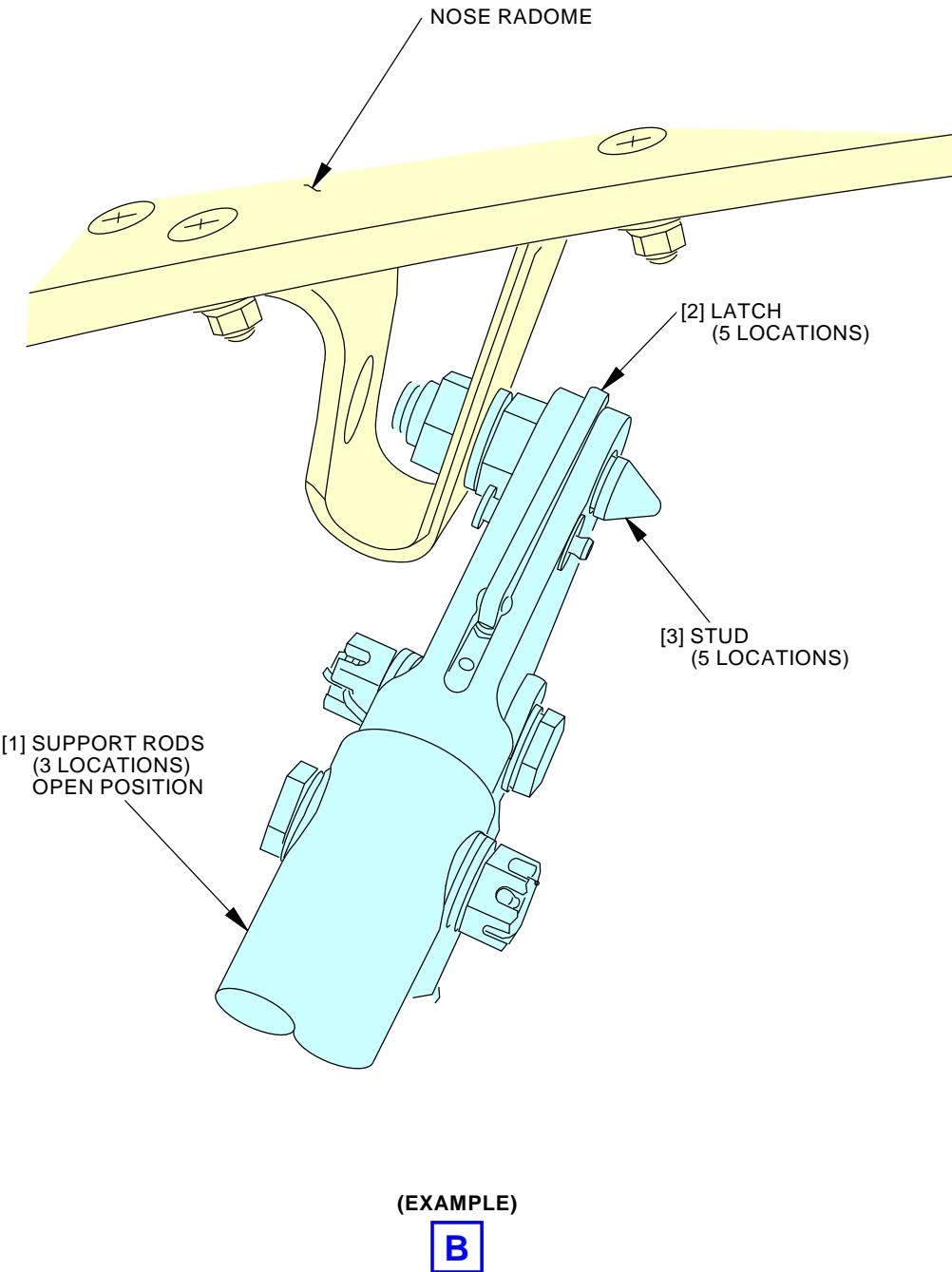
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Nose Radome Open/Close Procedure
Figure 201/53-52-00-990-806 (Sheet 2 of 2)

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TASK 53-52-00-410-802

3. Nose Radome - Close

Figure 201

A. General

- (1) This task has the steps to close the Nose Radome.

B. Consumable Materials

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28

C. Location Zones

Zone	Area
111	Radome

D. Prepare to Close the Nose Radome

SUBTASK 53-52-00-040-002

- (1) Make sure that this circuit breaker is open and has safety tag:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

E. Close the Nose Radome

SUBTASK 53-52-00-410-004

- (1) Hold the radome while you remove the radome [1] support rods.

SUBTASK 53-52-00-410-005

- (2) Remove the radome [1] support rods.

- (a) Lift the [2] latch to remove the [1] support rods from the [3] studs.

SUBTASK 53-52-00-410-006

- (3) Install the radome [1] support rods in the stowed position.

SUBTASK 53-52-00-410-007

- (4) Lower the radome.

SUBTASK 53-52-00-410-008

- (5) Install the screws with compound, D50004 in the aft edge of the radome.

- (a) Torque screws to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-017

- (6) Make sure that the seal engages correctly.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 53-52-00-440-001

- (1) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

— END OF TASK —

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TASK 53-52-00-000-802

4. Nose Radome Protective Boot Removal

A. References

Reference	Title
53-52-00-370-801	Nose Radome - Cleaning/Painting (P/B 701)

B. Location Zones

Zone	Area
111	Radome

C. Procedure

SUBTASK 53-52-00-000-002

CAUTION: USE CARE WHEN USING KNIFE TO PREVENT DAMAGE TO LAMINATIONS OF RADOME.

- (1) Lightly cut the radome boot into 4 pieces with a knife or a razor blade.

SUBTASK 53-52-00-000-003

- (2) Remove the 4 radome boot pieces:

- (a) Lift an edge slowly.
 - (b) Remove the radome boot piece slowly at an angle of 90° to 180°.

NOTE: When removing the radome boot pieces, the speed and angle may affect how much adhesive residue is left and how much paint is removed from the nose radome. Remove the radome boot pieces slowly to avoid adhesive residue and removed paint.

- (c) Do the procedure again until all 4 pieces are removed.

SUBTASK 53-52-00-000-004

- (3) Remove the adhesive residue.

SUBTASK 53-52-00-100-004

- (4) Clean the radome boot area.

SUBTASK 53-52-00-300-001

- (5) Repair areas of removed paint:

- (a) Do this task: Nose Radome - Cleaning/Painting, TASK 53-52-00-370-801.

———— END OF TASK ————

TASK 53-52-00-400-802

5. Nose Radome Protective Boot Installation

A. Tools/Equipment

Reference	Description
STD-821	Squeegee - Plastic

B. Consumable Materials

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	

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C. Location Zones

Zone	Area
111	Radome

D. Procedure

SUBTASK 53-52-00-100-005

- (1) Clean the nose radome area for the radome boot installation.

NOTE: Use a clean cloth to clean the area to keep from contamination.

SUBTASK 53-52-00-400-001

- (2) Cut the radome boot 0.25 in. (0.64 cm) above the cut line. The cut line (end line) is at STA 138.6.

NOTE: Make the cuts as smooth as possible and avoid jagged edges.

SUBTASK 53-52-00-400-002

- (3) Put the radome boot on the nose radome.

(a) Align the radome boot to the center of the nose radome.

SUBTASK 53-52-00-400-003

- (4) Apply Scotch Brand No.471 tape, G02219 at 3 locations on the nose radome and the radome boot (Figure 202).

NOTE: The markings will be used to align the radome boot to the same location after the protective lining is removed.

SUBTASK 53-52-00-400-004

- (5) Apply the wet solution to the radome boot.

NOTE: The wet solution is made from 25% isopropyl alcohol, 75% water, and 1 teaspoon of a dishwashing liquid per 1 gallon (3.8 liters).

NOTE: The wet solution prevents the adhesive from sticking to itself.

SUBTASK 53-52-00-400-005

- (6) Turn the inner surface of the radome boot out.

SUBTASK 53-52-00-400-006

- (7) Put the radome boot back on the nose radome.

SUBTASK 53-52-00-000-005

- (8) Remove the protective lining:

(a) Slowly and carefully remove the protective lining.

(b) Apply the wet solution to the nose radome adhesive during the lining removal.

NOTE: The wet solution is made from 25% isopropyl alcohol, 75% water, and 1 teaspoon of a dishwashing liquid per 1 gallon (3.8 liters).

NOTE: The wet solution prevents the adhesive from sticking to itself.

SUBTASK 53-52-00-400-007

- (9) Turn the inner surface of the radome boot out again.

NOTE: The adhesive side of the radome boot should be facing the nose radome.

SUBTASK 53-52-00-400-008

- (10) Align the 3 marks on the radome boot to the 3 correct locations on the nose radome.

SUBTASK 53-52-00-400-009

- (11) Apply the wet solution to the radome boot.

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SUBTASK 53-52-00-400-010

- (12) Use the plastic squeegee, STD-821 to make the radome boot smooth.
- Start at the center of the radome boot.
 - Slowly remove the trapped air bubbles and the wet solution with the plastic squeegee, STD-821.

SUBTASK 53-52-00-400-011

- (13) If there are trapped air bubbles:

NOTE: Small bubbles less than 0.125 in. (0.318 cm) will evaporate by themselves in less than one week.

- Slowly and carefully remove the radome boot.
- Apply the wet solution to the area.
- Slowly remove the trapped air bubbles and the wet solution with the plastic squeegee, STD-821.

SUBTASK 53-52-00-400-012

- (14) Dry the surface of the radome boot.
- Allow the radome boot to dry for one hour at 70°F (21°C).

SUBTASK 53-52-00-400-013

- (15) Paint the nose radome boot if applicable:
- Clean the nose radome boot with the solvent, B00148.
 - Paint the nose radome boot.

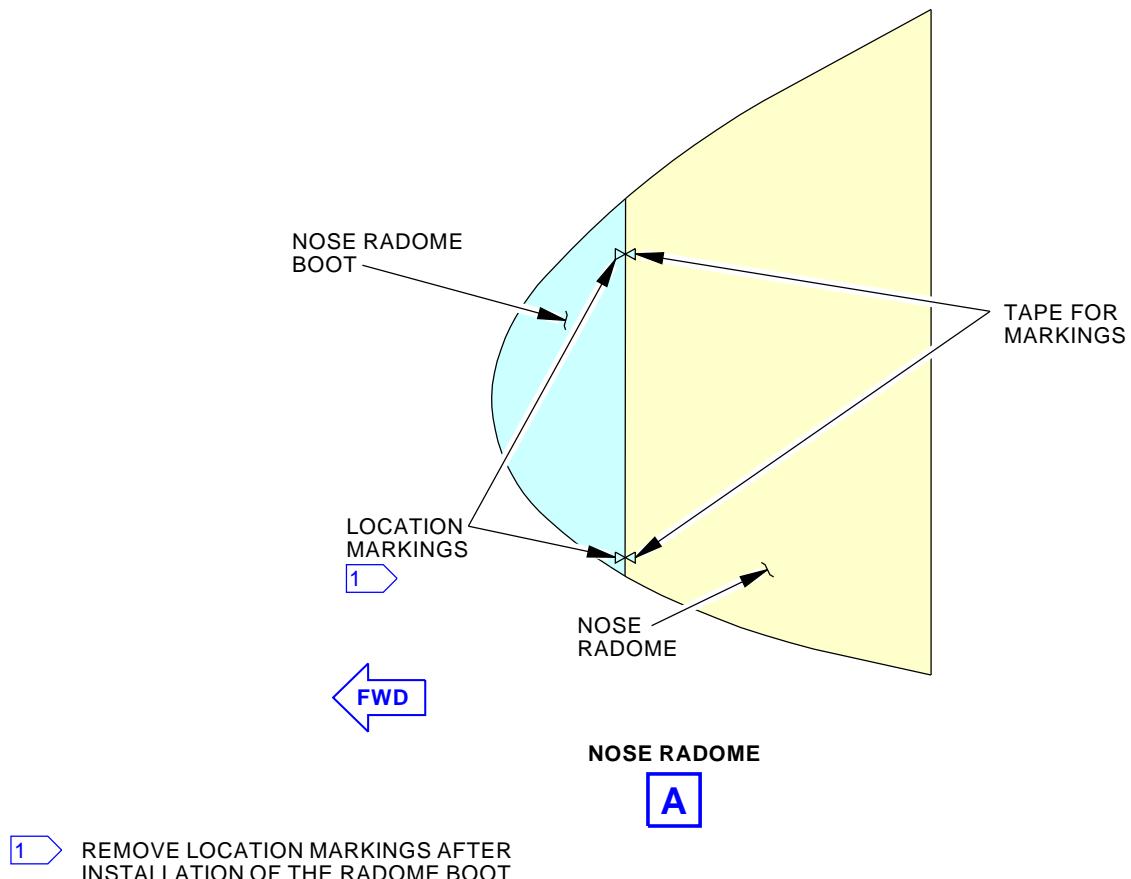
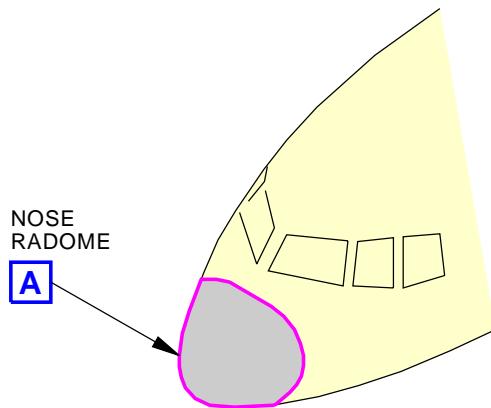
———— END OF TASK ————

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Radome Boot Installation
Figure 202/53-52-00-990-804



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NOSE RADOME - REMOVAL/INSTALLATION

1. General

- A. This section contains two tasks:
- (1) The removal of the nose radome.
 - (2) The installation of the nose radome.

TASK 53-52-00-000-801

2. Nose Radome Removal

(Figure 401)

A. Location Zones

Zone	Area
111	Radome

B. General

SUBTASK 53-52-00-940-001

- (1) Because of the weight of the nose radome, two mechanics are necessary to do this task.

C. Procedure

SUBTASK 53-52-00-860-001

- (1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-00-020-001

- (2) Remove the bolts that attach the aft edge of the radome to the clips on the fuselage bulkhead.

SUBTASK 53-52-00-010-001

WARNING: DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (3) Open the radome and hold it in the open position by the installation of the support rods on each side.

SUBTASK 53-52-00-020-002

- (4) Disconnect the end of the bonding jumper that is connected to the clip on the fuselage bulkhead.

SUBTASK 53-52-00-020-003

WARNING: GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (5) Use two mechanics to do this step.



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- (a) Remove the bolts that attach the hinge arms to the hinge fittings on the radome and remove the radome from the fuselage.

NOTE: When you remove the bolts, prepare to catch the shims that are installed between the hinge arms and the hinge fittings. Look at the installed positions of the shims to help the installation of the same radome.

————— END OF TASK ————

TASK 53-52-00-400-801

3. Nose Radome Installation

(Figure 401)

A. References

Reference	Title
20-30-89-910-801	Final Cleaning of All Organic Coatings Prior to Non-structural Bonding (Series 89) (P/B 201)

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-614	Bonding Meters - Non-Intrinsically Safe (Used in non-hazardous locations) Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Opt Part #: 247001 Supplier: 00426
COM-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: C15292 (MODEL T477W) Supplier: 01014 Part #: M1 Supplier: 3AD17 Opt Part #: M1B Supplier: 3AD17

C. Consumable Materials

Reference	Description	Specification
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010 Type 79)
A00335	Adhesive - Silicone Rubber, 2 Part, RTV	BAC5010 Type 68
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B01009	Solvent - Final Cleaning Of All Organic Ctgs Before Non-Structural Bonding (AMM20-30-89/201) - Series 89	
B50073	Alcohol - Isopropyl	ASTM D 770
D50004	Compound - Antiseize	BMS3-28
G50262	Wiper - Cleaning	BMS15-5
G51032	Sandpaper - Aluminum Oxide, 80 Grit	

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D. Location Zones

Zone	Area
111	Radome

E. General

SUBTASK 53-52-00-940-002

- (1) Because of the weight of the nose radome, two mechanics are necessary to do this task.

F. Prepare for the Installation

SUBTASK 53-52-00-110-001

- (1) Install the erosion protection and the lightning diverter strips where it is necessary.

SUBTASK 53-52-00-420-008

- (2) Install the hinge brackets, the serrated plates, and the fillers on the radome with the screws, and install the brackets (New radome only).

NOTE: These brackets can push on the flange of the reinforcement angle.

SUBTASK 53-52-00-420-009

- (3) Tighten the bolts.

SUBTASK 53-52-00-210-016

- (4) Make sure that you open all WEATHER RADAR circuit breakers on the P6-1 breaker panel.

NOTE: See the Weather Radar data for the airplane.

SUBTASK 53-52-00-860-002

WARNING: GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (5) Use two mechanics to install the radome.

- (6) Hold the radome adjacent to the fuselage bulkhead until the hinge brackets can be engaged with the hinge arms on the bulkhead.

SUBTASK 53-52-00-420-003

- (7) Install the shims, where it is necessary, between the hinge brackets and the hinge arms, and install the hinge attachment bolts.

G. Procedure

SUBTASK 53-52-00-410-001

CAUTION: YOU MUST BE CAREFUL WHEN YOU LOWER THE RADOME TO THE CLOSED POSITION AFTER THE INSTALLATION OF THE HINGE. IF YOU ARE NOT CAREFUL WHEN YOU LOWER THE RADOME, THE TOP AFT EDGE OF THE RADOME CAN HIT THE FUSELAGE SKIN AND CAUSE DAMAGE.

- (1) Remove the radome support rods, if used.

- (2) Install the support rods in their storage clips on the forward pressure bulkhead.

- (3) Lower the radome carefully to the closed position.

SUBTASK 53-52-00-210-007

- (4) Make sure that the top aft edge does not hit the fuselage skin.



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SUBTASK 53-52-00-020-005

- (5) If you find an interference, do these steps:

NOTE: Make sure that the seal ends do not touch at the bottom of the bulkhead. There must be an opening of 8.3 in. (21.1 cm) to 8.7 in. (22.1 cm) at the bottom of the bulkhead to let the radome drain.

- (a) Lift and hold the radome in an open position.
- (b) Loosen the attachment screws of the hinge bracket.
- (c) Move the brackets forward and tighten the screws.

SUBTASK 53-52-00-210-008

- (6) Examine the nose radome seal for rough and damaged areas.

SUBTASK 53-52-00-210-009

- (7) Make sure that the seal is bonded to the bulkhead 7 in. (18 cm) on the two sides of the airplane centerline and 2 in. (5 cm) that align each end of the seal.

SUBTASK 53-52-00-020-007

- (8) Replace the seal if it is necessary as follows:

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. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

- (a) Clean the mating surfaces on the bulkhead with solvent, B00148, or Series 89 solvent, B01009 (TASK 20-30-89-910-801).
- (b) Apply adhesive, A00335 to the bulkhead 7 in. (18 cm) on the two sides of the airplane centerline and 2 in. (5 cm) that align each end of the seal.

NOTE: It is permitted to use Dow Corning 3145 RTV adhesive, A00281 (BAC5010, TYPE 79) as an alternative adhesive.

- (c) Apply adhesive, A00335 to the flat align part of the seal and install with the flat surface against the bulkhead.

NOTE: It is permitted to use Dow Corning 3145 RTV adhesive, A00281 (BAC5010, TYPE 79) as an alternative adhesive.

- (d) Let the adhesive, A00335 or Dow Corning 3145 RTV adhesive, A00281 dry for 24 hours.

SUBTASK 53-52-00-210-012

- (9) Examine the clips on the fuselage bulkhead as follows:

- (a) Carefully examine the areas adjacent to the hinges for binding on the radome when you move the radome to the closed position.
- (b) If binding was noted, the clips need to be adjusted.

SUBTASK 53-52-00-020-008

- (10) If an adjustment is necessary at clips where a bonding jumper is not installed, do these steps:

- (a) Loosen the fuselage bulkhead attachment bolts on the applicable clips where binding was noted and move the clips inboard.
 - 1) Move the clips inboard just enough so that the nose radome no longer binds when it is lowered into position.
- (b) Lower the radome to the closed position.

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- (c) Apply compound, D50004, to the threads of the countersunk bolt and install the bolt.
- (d) Tighten the countersunk bolt sufficiently to pull the clip into contact with the inner face of the radome, and then remove the bolt.
- (e) Open the radome carefully to prevent movement of the adjusted clip.
- (f) Tighten the bolts that attach the clip to the fuselage bulkhead to 100 in-lb (11.3 N·m) - 125 in-lb (14.1 N·m).

SUBTASK 53-52-00-820-001

- (11) If an adjustment is necessary at clips where a bonding jumper is installed, do these steps:
 - (a) Loosen the attachment bolts on the applicable clips where binding was noted and move the clips inboard:
 - 1) Move the clips inboard just enough so that the nose radome no longer binds when it is lowered into position.

CAUTION: WHEN LOWERING RADOME, BULB SEAL MAY BECOME PINCHED BETWEEN RADOME AND FUSELAGE SKIN CAUSING THE BULB SEAL TO TEAR OR BE PULLED OUT OF POSITION. WHILE THE RADOME IS BEING LOWERED, CAREFULLY WORK THE BULB SEAL INTO PROPER POSITION USING A FLAT NON-METALLIC SPATULA.

- (b) Lower the radome to the closed position.
- (c) Apply compound, D50004, to the threads of the countersunk bolts and install them.
- (d) Tighten the countersunk bolts sufficiently to put the clips into contact with the inner face of the radome, and then remove the bolts.
- (e) Open the radome carefully to prevent movement of the adjusted clips.
- (f) Tighten the bolts that attach the clip to the fuselage bulkhead to 100 in-lb (11.3 N·m) - 125 in-lb (14.1 N·m).
- (g) Do a check of the electrical resistance between the radome bonding jumper and the radome clip.
- (h) Make sure the electrical resistance is not greater than 0.01 ohm.
- (i) If the electrical resistance is greater than 0.01 ohm, the contact surfaces of the clip, shims, radome, bonding jumper and the fuselage bulkhead must be cleaned and treated to meet the bonding requirement as follows:
 - 1) Remove the three bolts that attach the clip to the radome and the fuselage bulkhead.
 - 2) Remove any shims there were installed.
 - 3) Prepare the radome clip surfaces where the countersunk bolt is installed and the radome bonding jumper surface as follows:
 - a) Clean all surfaces with 80 grit aluminum oxide sandpaper, G51032, until all surface finishes are removed and a bright aluminum bonding surface is visible.
 - b) Wipe the surfaces with a wiper, G50262, saturated with alcohol, B00065, or alcohol, B50073.
 - c) Continue to wipe the surfaces with a clean wiper, G50262 until there are no traces of contamination on the wiper.
 - 4) Prepare the surfaces where the two bolts are installed that attach the clip to the fuselage bulkhead as follows:

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- a) Wipe the surfaces with a wiper, G50262, saturated with alcohol, B00065, or alcohol, B50073.
- b) Continue to wipe the surfaces with a clean wiper, G50262 until there are no traces of contamination on the wiper.
- 5) Install the clips, shims (if installed previously), bonding jumper, washers and bolts as previously noted.
- (j) Do a check of the electrical resistance between the radome bonding jumper and the radome clip:
 - 1) Use an intrinsically safe approved bonding meter, COM-1550 or non-intrinsically safe bonding meter, COM-614 to measure the resistance between the bonding jumper and the radome clip.
 - 2) Make sure the electrical resistance is not greater than 0.01 ohm.

SUBTASK 53-52-00-210-014

- (12) With the radome in a closed position, make sure that the screw holes of the radome attachment are aligned with the holes in the attachment clips.

SUBTASK 53-52-00-420-005

CAUTION: DO NOT USE TOO MUCH FORCE TO ALIGN THE HOLES. YOU CAN CAUSE DAMAGE TO THE CLIPS AND THE RADOME.

- (13) If the adjustment is necessary, use manual force to adjust the radome position to align the screw holes.

SUBTASK 53-52-00-420-006

- (14) Install the countersunk bolts with the compound, D50004 in the aft edge of the radome then torque screws to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-015

- (15) Make sure that the seal engages correctly and the radome clearances are correct.

SUBTASK 53-52-00-860-004

- (16) Remove the safety tag and close this circuit breaker:

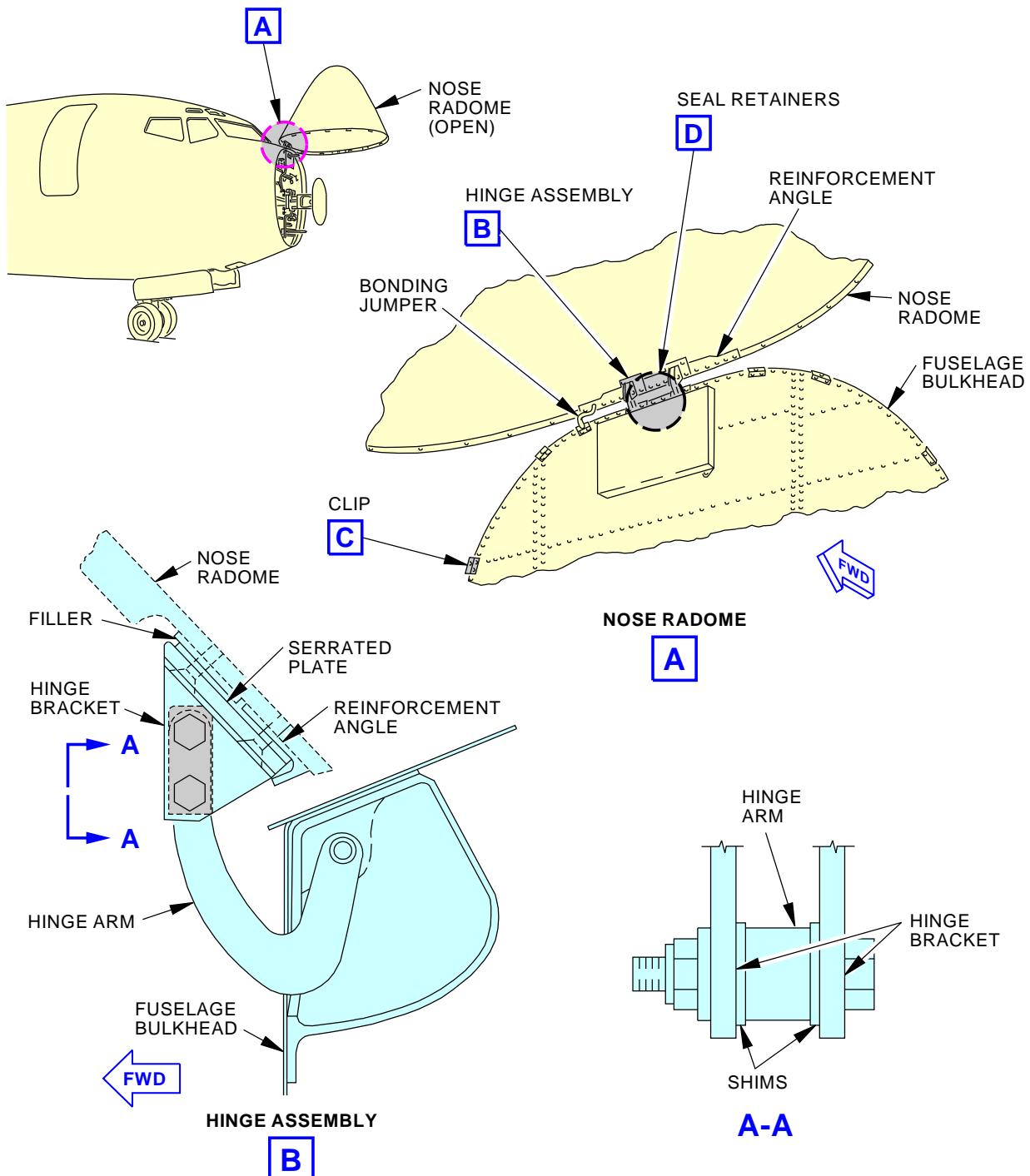
F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

———— END OF TASK ————

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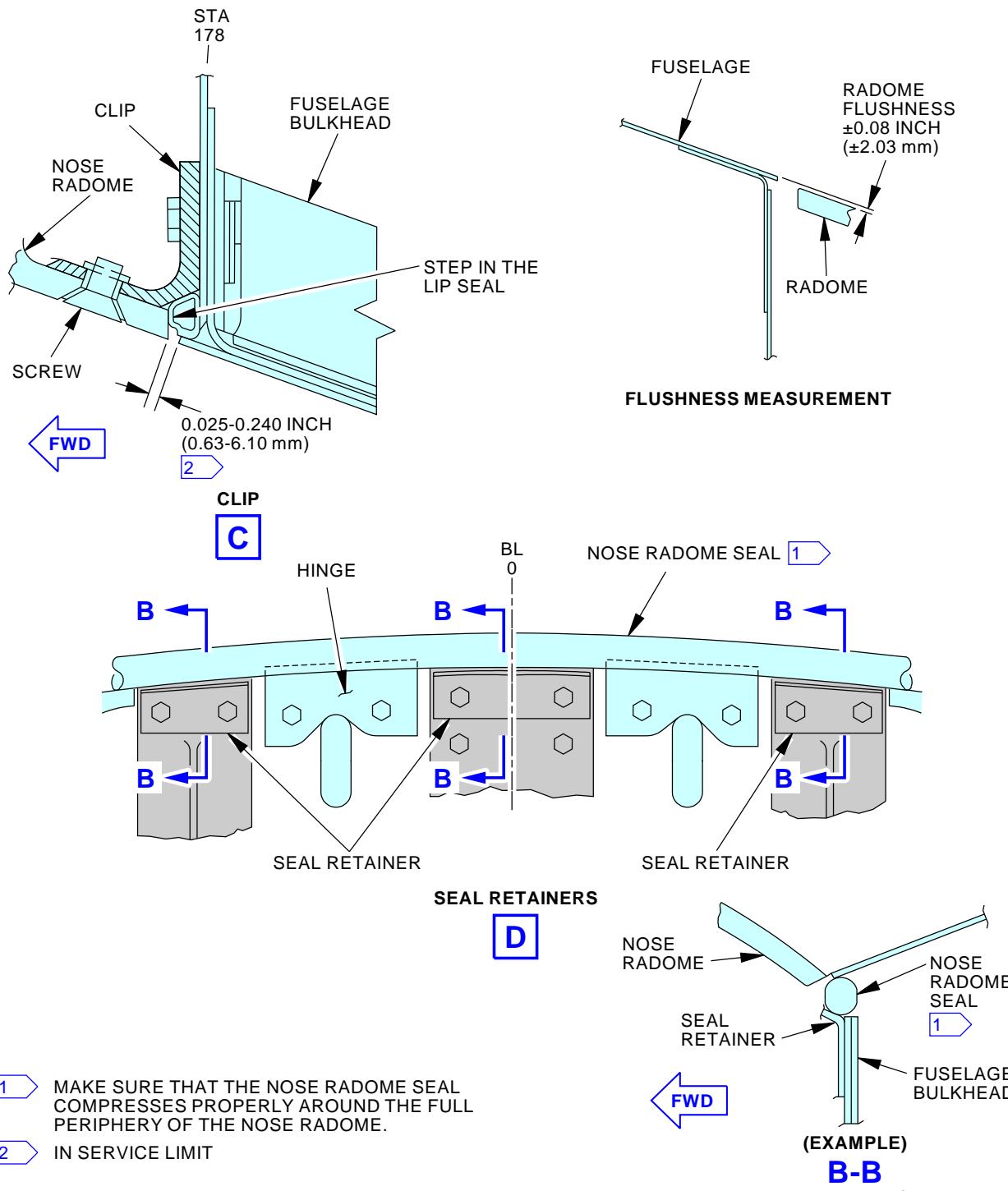
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Figure 401/53-52-00-990-802 (Sheet 1 of 3)

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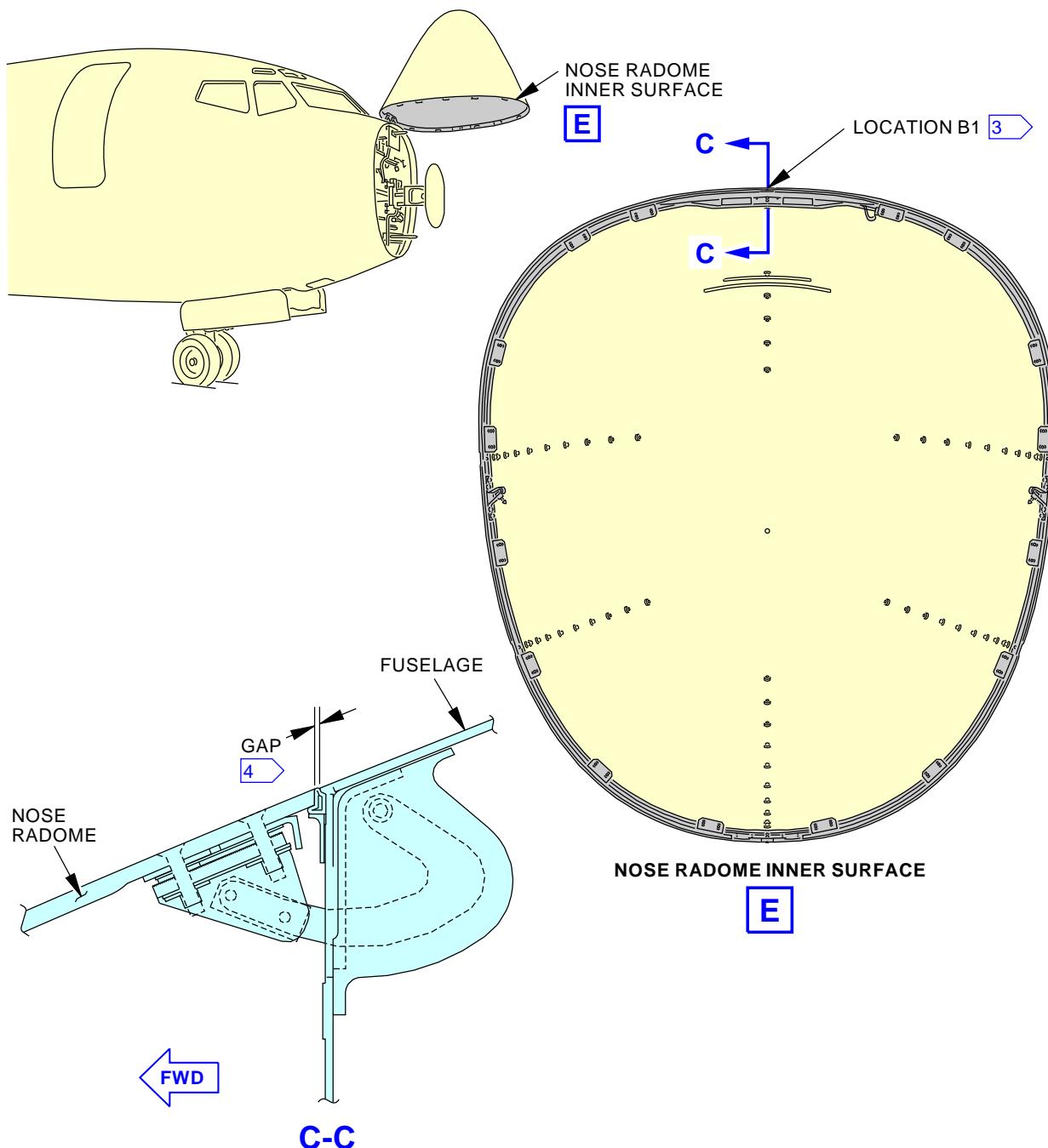


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Figure 401/53-52-00-990-802 (Sheet 2 of 3)

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- 3** GAP AT LOCATION B1 IS 0.046 TO 0.216 INCH (1.70 TO 5.49 mm)
4 ONLY MEASURE THE GAP WHEN NOSE RADOME IS FULLY CLOSED.

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Nose Radome Installation
Figure 401/53-52-00-990-802 (Sheet 3 of 3)

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NOSE RADOME - INSPECTION/CHECK

1. General

- A. This procedure contains one task. This task is the check of the nose radome.

TASK 53-52-00-200-801

2. Do a Check of the Nose Radome

A. References

Reference	Title
05-51-19-210-801	Examine External and Internal Areas for Lightning Strike Damage (P/B 201)
53-52-00-000-801	Nose Radome Removal (P/B 401)
53-52-00-400-801	Nose Radome Installation (P/B 401)
53-52-03-990-801	Figure: Lightning Diverter Strip (P/B 201)
53-52-31-000-801	Glide Slope Director Bar Removal (P/B 401)
53-52-31-400-801	Glide Slope Director Bar Installation (P/B 401)
737 NDT Part 9, 51-00-01	Inspection for Water or Ice in Honeycomb Parts
SRM 51-00-01	Fuselage- Repair Nose Radome
SRM 53-10-72	Repair General - Nose Radome

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-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: C15292 (MODEL T477W) Supplier: 01014 Part #: M1 Supplier: 3AD17 Opt Part #: M1B Supplier: 3AD17
COM-2010	Equipment - Moisture Indicator/Register, RADOME Part #: MRC005574 Supplier: OCT97 Part #: MRC006507 Supplier: OCT97

C. Location Zones

Zone	Area
111	Radome

D. Procedure - Do a Check of the Nose Radome

SUBTASK 53-52-00-210-001

- (1) You must do a check of the nose radome to see if there are lightning strikes (Examine External and Internal Areas for Lightning Strike Damage, TASK 05-51-19-210-801).

SUBTASK 53-52-00-210-002

- (2) Do a check for damage such as holes, scuffs, cracks, blisters, and delamination.

NOTE: You can locate the delamination if you lightly hit the radome skin with a small metal object such as a short socket extension and listen for changes in the sound.



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SUBTASK 53-52-00-280-001

- (3) Do a check for moisture.
 - (a) Moisture that enters the honeycomb cells of a radome can cause the radar transmission to decrease. Periodic radome inspection is necessary to ensure sufficient radar transmission. Water that is entrapped in the honeycomb cells can be detected with the three methods that follow.
 - (b) There are three radome moisture inspection methods. The recommended method 1 is the moisture meter inspection method. Two alternative methods are electronic thermography inspection method and liquid crystal sheets method. (737 NDT Part 9, 51-00-01 and SRM 51-00-01).
- (4) Use the moisture indicator/register RADOME equipment, COM-2010 to do a check for moisture as follows:

NOTE: The moisture indicator/register RADOME equipment, COM-2010 indicates pockets in aircraft radomes by measuring the radio frequency dielectric power loss of the material in contact with the moisture indicator/register RADOME equipment, COM-2010 gun. The radio frequency depth of penetration is approximately 2.5 in. (6.4 cm). Any conductive materials such as water, aluminum, or metallic fasteners within 3 in. (7.6 cm) from the gun will cause the meter to read high. It is important that all metallic parts be removed from the area on the radome that is being tested for moisture content.

- (a) Hold the gun part of the moisture indicator/register RADOME equipment, COM-2010 a minimum of 3 in. (7.6 cm) from each part.
- (b) Push the ON-OFF switch on the case to the ON position.
- (c) Put the sensor head on the inner surface of the radome.
 - 1) Make sure that all the electrodes contact the radome surface.
 - 2) If necessary, apply light force to make sure the sensor head contacts the radome surface.
- (d) Move the sensor head over all of the inner surface of the radome. The sensor head must touch the full inner surface of the radome. To perform an adequate inspection, the sensor must be indexed at an interval of 1 in. (25 mm) or less.
- (e) In areas that cause a meter reading of 20 or greater, put the sensor head away from the center of the indication (in an adjacent area with a reading of less than 20) Monitor the meter reading as you move the sensor head toward the of the area.
- (f) To identify the area of entrapped water, make marks on the radome at the position of the electrodes closest to the entrapped water when the meter reading increases to 20.
- (g) You must dry and then seal all of the areas where you find moisture.
 - 1) Do these steps until the boundary of the entrapped water is marked.
- (h) If there is moisture, dry the radome and refer to SRM 53-10-72 to remove the moisture and seal it.



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Table 601/53-52-00-993-802 RADOME CONDITION NUMERICAL SCALE

RADOME CONDITION	COLOR	NUMERICAL SCALE	ALLOWABLE SURFACE AREA of WATER
Good	Green	0 to 5	4 in. (102 mm) diameter or equivalent area
Fair	Yellow	5 to 10	
Poor	Orange	10 to 20	

NOTE: Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.

- (5) Electronic Thermography (alternative) Inspection Method
 - (a) Refer to the 737 NDT Part 9, 51-00-01 for equipment, calibration and inspection instructions.
NOTE: The inspection can be performed from either side of the radome.
 - (b) Examine the entire surface of the radome.
NOTE: Areas that contain entrapped water will appear cold.
 - (c) Monitor the surface of the radome with the infrared camera while you use a marker to put a mark at the boundary of the entrapped water.
 - (d) If the area that you marked is greater than the allowable area shown in Table 2, remove the moisture in the marked area and seal it (SRM 53-10-72).
- (6) Liquid Crystal (alternative) Inspection Method
 - (a) Refer to the 737 NDT Part 9, 51-00-01 for equipment, calibration and inspection instructions.
NOTE: The inspection can be performed from either side of the radome.
 - (b) Examine the entire surface of the radome.
NOTE: Areas that contain entrapped water will appear cold.
 - (c) Monitor the surface of the radome with the liquid crystal sheets while you use a marker to put a mark at the boundary layer of the entrapped water on the transparent template.
 - (d) If the area that you marked is greater than the allowable area shown in Table 602, remove the moisture in the marked area and seal it (SRM 53-10-72).

Table 602/53-52-00-993-803 Table 2. RADAR CONDITION MOISTURE ACCEPTANCE CRITERIA

TABLE 2	
Moisture Meter Reject Level	Allowable Surface Area of Water
20	(4 in. (102 mm) diameter or equivalent area)

NOTE: Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.

E. Procedure - Do a Check of the Conductor Strips and Diverter Strips

SUBTASK 53-52-00-210-003

- (1) Do the visual check that follows:
 - (a) Examine the conductor strips for tears, loose areas, burned areas, and general deterioration.

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- (b) Examine the aluminum diverter strips for loose fasteners, burned areas, and corrosion.

NOTE: Sharp corners, or points on the conductive strip can cause radio interference.

SUBTASK 53-52-00-280-002

- (2) Do the steps that follow to measure the conductivity with an intrinsically safe approved bonding meter, COM-1550:

- (a) With the radome open, measure the resistance between the ends of the diverter strips.

- 1) Make sure that the resistance is 0.01 ohms or less.

NOTE: Use a test probe with a sharp point to go through the paint or epoxy on the strip.

- (b) Measure the electrical resistance between the points in Figure 53-52-03-990-801.

- (c) With the radome closed, measure the resistance between the diverter strips on the radome and body structure skin.

- 1) Make sure that the resistance is 0.01 ohms or less.

- (d) Measure the electrical resistance between the diverter strip and airframe.

- 1) Make sure that the resistance is less than 0.03 ohms.

SUBTASK 53-52-00-210-004

- (3) If there is damage, replace the radome.

- (a) Do this task: (Nose Radome Removal, TASK 53-52-00-000-801)

- (b) Do this task: (Nose Radome Installation, TASK 53-52-00-400-801)

F. Procedure - Do a Check of the Director Bar for the Glide Slope Antenna

SUBTASK 53-52-00-210-005

- (1) Do a check for damage of the director bar for the glide slope antenna.

NOTE: The antenna director bar is a 13 in. (33 cm) continuous strip of aluminum foil tape. The strip is installed horizontally across the centerline on the inner surface of the nose radome.

SUBTASK 53-52-00-210-006

- (2) Make sure the attachment of the director bar is satisfactory.

SUBTASK 53-52-00-960-001

- (3) If you find damage or an unsatisfactory bond of the director bar for the glide slope antenna replace the director bar.

- (a) Do this task: (Glide Slope Director Bar Removal, TASK 53-52-31-000-801).

- (b) Do this task: (Glide Slope Director Bar Installation, TASK 53-52-31-400-801).

———— END OF TASK ————

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NOSE RADOME - CLEANING/PAINTING

1. General

A. This procedure contains these tasks:

- (1) Nose Radome Cleaning/Painting.

NOTE: A nose radome protective boot can be used in place of the BMS 10-60 Type II, enamel coating, C50075.

TASK 53-52-00-370-801

2. Nose Radome - Cleaning/Painting

A. References

Reference	Title
51-21-11 P/B 701	PAINT STRIPPING - CLEANING/PAINTING
51-21-21-100-802	Cleaning and Preparation of Internal and External Plastic Surfaces (P/B 701)
51-21-71-370-802	Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces (P/B 701)
51-21-71-370-803	Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces (P/B 701)
51-21-72-370-802	BMS10-103, Type 1, Primer - Application (P/B 701)
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)

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
SPL-7885	Probe - Surface Resistivity Measurement Part #: ST895A-3-1 Supplier: 81205



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Reference	Description
SPL-10361	Probe - Film Resistance Measure Part #: F70328-1 Supplier: 81205 Opt Part #: ST895A-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
C00841	Coating - Anti-Static Coating	BMS10-21 Type II
C50075	Coating - Protective Enamel (BAC 707 Gray Color)	BMS10-60 Type II
C50219	Coating - Anti-Static Coating	BMS10-21 Type IV
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	
G50509	Tape - Masking (3M Scotch Fine Line Tape 218)	AMS-T-21595
G50630	Tape - Copper Foil With Conductive Adhesive (3M 1181 Tape)	

D. Location Zones

Zone	Area
111	Radome

E. Prepare to Paint the Nose Radome

SUBTASK 53-52-00-000-006

- (1) Remove the lightning diverter strips from the radome, do this task: Remove the Lightning Diverter Strips, TASK 53-52-03-000-801.
 - (a) Identify the lightning diverter strips for re-installation.

SUBTASK 53-52-00-370-032

- (2) Use Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219 to mask-off the holes from the removed lightning diverter strips and the conductor straps on the radome.
 - (a) Make sure the BMS 10-21, Type II coating, C00841 or BMS 10-21, Type IV coating, C50219 does not enter the holes from the removed lightning diverter strips.

SUBTASK 53-52-00-150-001

- (3) Remove the existing paint (PAINT STRIPPING - CLEANING/PAINTING, PAGEBLOCK 51-21-11/701).

SUBTASK 53-52-00-100-002

- (4) Clean and prepare the surface of the nose radome, do this task: Cleaning and Preparation of Internal and External Plastic Surfaces, TASK 51-21-21-100-802.

F. Paint the Nose Radome

SUBTASK 53-52-00-370-004

- (1) Apply BMS10-21, Type II anti-static coating, C00841, or BMS10-21, Type IV coating, C50219 to the entire nose radome surface (Figure 702, Figure 703).
 - (a) To apply BMS10-21, Type II coating, C00841, do this task: Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-802.

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- (b) To apply BMS10-21, Type IV coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.

SUBTASK 53-52-00-860-013

- (2) Measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using one of the following methods:
- (a) To measure the surface resistance using the square method, do the steps that follow:
- 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630 with conductive adhesive each of length "L" (Figure 704).
 - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$ percent" and parallel to each other (Figure 704).
 - 3) Press the two pieces of tape firmly against the anti-static coating.
 - 4) Connect the Ohmmeter probes to the tape (Figure 704).
 - 5) Read the number for resistance.
 - 6) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
 - 7) Make sure that the resistance is between 1 and 100 megohms per square (square of any dimension).
 - a) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the BMS10-21, Type II or Type IV, anti-static paint.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the BMS10-21, Type II or Type IV, anti-static paint.
 - <4> Measure the resistance again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
 - b) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is more than 100 megohms per square, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Measure the resistance again.
 - <3> If the resistance is not between 1 and 100 megohms repeat the resolution steps.
 - 8) Remove copper tape after completion of the measurement.
- (b) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793 to the surface resistivity measurement probe, SPL-7885 (Figure 705).
 - 2) Place surface resistivity measurement probe, SPL-7885 on the conductive coating.
 - 3) Read the number for the resistance.
 - 4) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
 - 5) Make sure that the resistance is between 1 and 100 megohms per square.

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- a) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the BMS10-21, Type II or Type IV, anti-static paint.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the BMS10-21, Type II or Type IV, anti-static paint.
 - <4> Measure the resistance again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
- b) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is more than 100 megohms, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Measure the resistance again.
 - <3> If the resistance is not between 1 and 100 megohms repeat the resolution steps.
- (c) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 706).

 - 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows: (Figure 707)
 - a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.
 - b) Put the digital/analog multimeter, COM-1793 with the film resistance measure probe, SPL-10361 in direct contact with the bonding fastener and the conductive finish.
 - <1> Put the film resistance measure probe, SPL-10361 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 707).
 - c) Record the value of the resistivity shown on the multimeter.
 - <1> The minimum allowable resistivity is 1 megohm per square.
 - <2> The maximum allowable resistivity is 100 megohm per square.
- (d) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

 - 1) Make sure the conductive coating shows in the fastener location.
 - 2) Clean the area with solvent, B00083.

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- 3) Install one temporary fastener at each fastener location to be measured (Figure 707).
NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.
- 4) Connect the digital/analog multimeter, COM-1793 probes at the two fastener locations (Figure 707).
- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
 - a) The minimum allowable resistivity is 1 megohm per square.
 - b) The maximum allowable resistivity is 100 megohm per square.
- 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-840-004

- (3) Install the six lightning diverter strips, do this task: Install the Lightning Diverter Strip, TASK 53-52-03-400-801.

SUBTASK 53-52-00-950-011

- (4) Use Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219 to mask-off the exterior surface of the radome, except for a 5 in. (12.7 cm) vertical band from STA. 138.6 to STA. 143.6 (Figure 701).

SUBTASK 53-52-00-370-035

- (5) Apply a second coat of BMS10-21, Type II anti-static coating, C00841, or BMS10-21, Type IV coating, C50219 to the exposed vertical band area (Figure 703).
 - (a) To apply BMS10-21, Type II coating, C00841, do this task: Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-802.
 - (b) To apply BMS10-21, Type IV coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.

SUBTASK 53-52-00-860-014

- (6) Measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using one of the following methods:
 - (a) To measure the surface resistance using the square method, do the steps that follow:
 - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630 with conductive adhesive each of length "L" (Figure 704).
 - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$ percent" and parallel to each other (Figure 704).
 - 3) Press the two pieces of tape firmly against the anti-static coating.
 - 4) Connect the Ohmmeter probes to the tape (Figure 704).
 - 5) Read the number for resistance.
 - 6) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
 - 7) Make sure that the resistance is between 1 and 100 megohms.
 - a) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the BMS10-21, Type II or Type IV, anti-static paint.
 - <2> Clean and prepare the surface.

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- <3> Re-apply the BMS10-21, Type II or Type IV, anti-static paint.
 - <4> Measure the resistance again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
 - b) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is more than 100 megohms, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Measure the resistance again.
 - <3> If the resistance is not between 1 and 100 megohms repeat the resolution steps.
 - 8) Remove copper tape after completion of the measurement.
- (b) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793 to the surface resistivity measurement probe, SPL-7885 (Figure 705).
 - 2) Place surface resistivity measurement probe, SPL-7885 on the conductive coating.
 - 3) Read the number for the resistance.
 - 4) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
 - 5) Make sure that the resistance is between 1 and 100 megohms.
 - a) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the BMS10-21, Type II or Type IV, anti-static paint.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the BMS10-21, Type II or Type IV, anti-static paint.
 - <4> Measure the resistance again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
 - b) If the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV is more than 100 megohms, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Measure the resistance again.
 - <3> If the resistance is not between 1 and 100 megohms repeat the resolution steps.
 - (c) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 706).

 - 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows: (Figure 707)

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- a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.
NOTE: If it is necessary, the probes can be pushed through the outer coating.
 - b) Put the digital/analog multimeter, COM-1793 with the film resistance measure probe, SPL-10361 in direct contact with the bonding fastener and the conductive finish.
 - <1> Put the film resistance measure probe, SPL-10361 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 707).
 - c) Record the value of the resistivity shown on the multimeter.
 - <1> The minimum allowable resistivity is 1 megohm per square.
 - <2> The maximum allowable resistivity is 100 megohm per square.
- (d) To measure the surface resistance of the BMS10-21, Type II, or BMS10-21, Type IV, using the Fastener-to-Fastener Test Method, do the steps that follow:
NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.
- 1) Make sure the conductive coating shows in the fastener location.
 - 2) Clean the area with solvent, B00083.
 - 3) Install one temporary fastener at each fastener location to be measured (Figure 707).
NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.
 - 4) Connect the digital/analog multimeter, COM-1793 probes at the two fastener locations (Figure 707).
 - 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
 - a) The minimum allowable resistivity is 1 megohm per square.
 - b) The maximum allowable resistivity is 100 megohm per square.
 - 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-370-034

- (7) Remove the Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219.

SUBTASK 53-52-00-950-001

- (8) Use Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219 to mask-off a 5 in. (12.7 cm) vertical band from STA. 138.6 to STA. 143.6 (Figure 701).

SUBTASK 53-52-00-370-029

- (9) Apply 0.3 - 0.8 mils of BMS10-103 primer, C00766 from the radome tip to STA 138.6 and from STA 143.6 to the aft edge of the radome (Figure 702).

NOTE: When BMS10-21 Type IV coating, C50219 is used as a conductive coating, BMS10-103 primer, C00766 is not required.

- (a) To apply the BMS10-103 primer, C00766, do this task: BMS10-103, Type 1, Primer - Application, TASK 51-21-72-370-802.

SUBTASK 53-52-00-370-030

- (10) Apply 1.4 - 2.4 mils of BMS10-60, Type II coating, C50075 from the radome tip to STA 138.6 and from STA 143.6 to the aft edge of the radome (Figure 702).

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SUBTASK 53-52-00-950-012

- (11) Use Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219 to mask-off the area from STA 143.6 to the aft edge of the radome (Figure 701).

NOTE: A nose radome protective boot can be used in place of the BMS 10-60 Type II, enamel coating, C50075.

SUBTASK 53-52-00-370-031

- (12) Apply 8 - 10 mils of BMS10-60, Type II coating, C50075 from the radome tip to STA 138.6 (Figure 702).

NOTE: A nose radome protective boot can be used in place of the BMS 10-60 Type II, enamel coating, C50075.

SUBTASK 53-52-00-950-013

- (13) Remove the Tape - Masking, G50509 or Scotch Brand No.471 tape, G02219.

NOTE: A nose radome protective boot can be used in place of the BMS 10-60 Type II, enamel coating, C50075.

SUBTASK 53-52-00-370-019

- (14) Apply decorative paint to the entire surface of the radome, do this task: (Decorative Exterior Paint System Application, TASK 51-21-99-300-801).

NOTE: Refer to your livery drawing requirements.

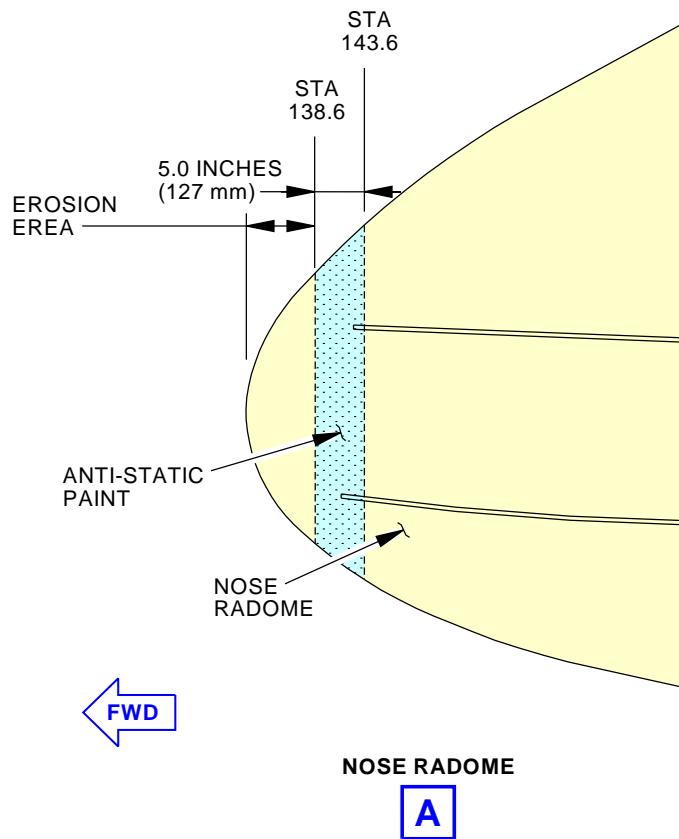
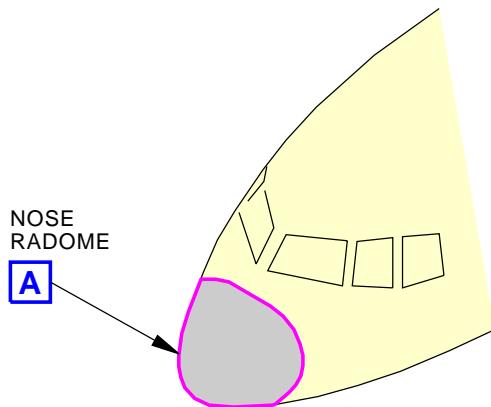
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Nose Radome Anti-Static Band
Figure 701/53-52-00-990-803

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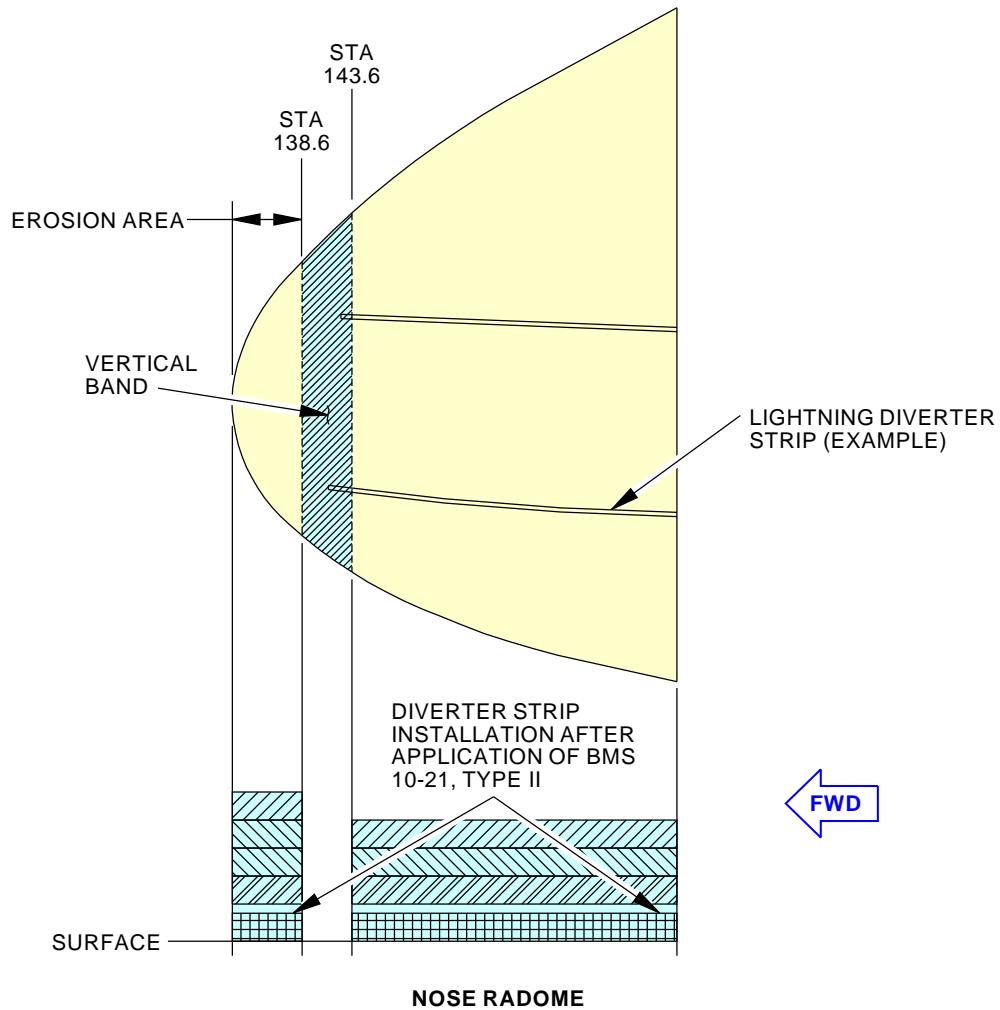
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LEGEND:

- BMS 10-72 DECORATIVE COATING (TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT
- BMS 10-60 TYPE II ENAMEL COATING
- BMS 10-103 TYPE I PRIMER
- BMS 10-21 TYPE II ANTI-STATIC COATING OR BMS 10-21 TYPE IV ANTI-STATIC COATING

2245834 S0000503249_V4

Nose Radome Painting - Nose Tip to STA 138.6 and STA 143.6 to Aft Edge
Figure 702/53-52-00-990-807

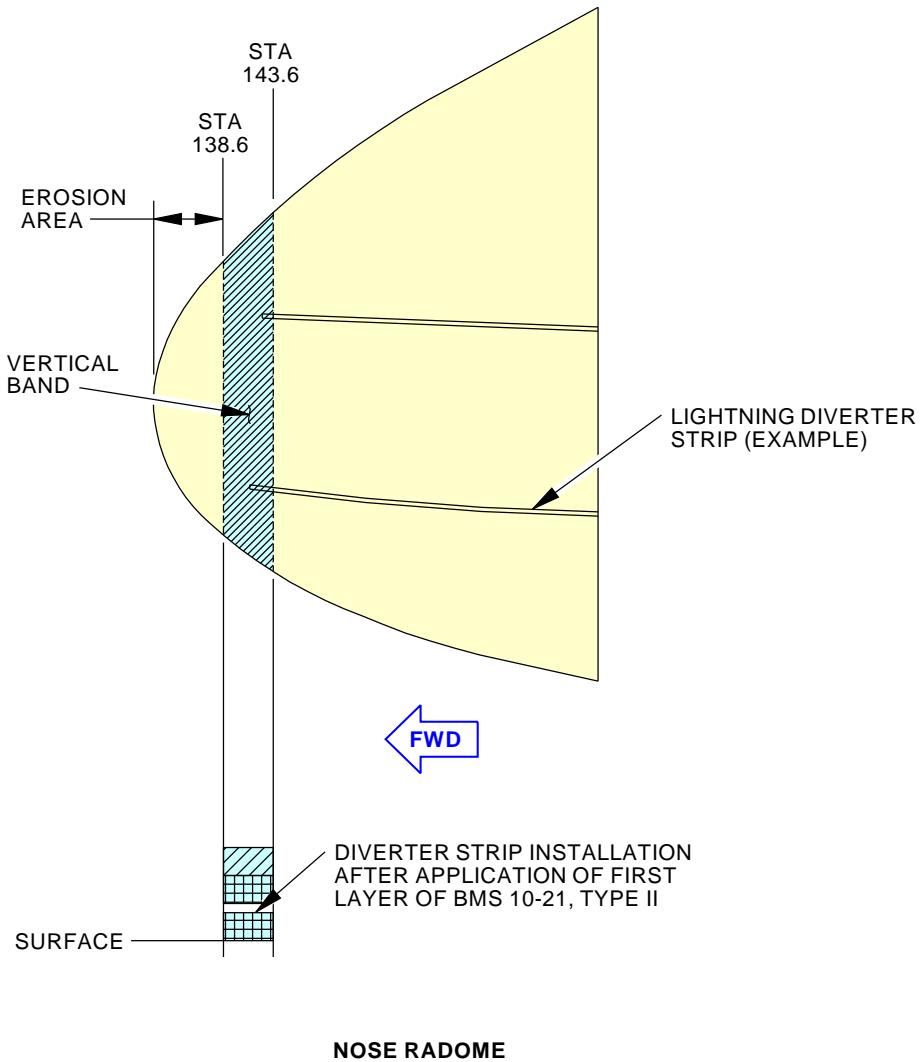
EFFECTIVITY
AKS ALL

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LEGEND:

- BMS 10-72 DECORATIVE COATING (TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT
- BMS 10-21 TYPE II ANTI-STATIC COATING OR BMS 10-21 TYPE IV ANTI-STATIC COATING

2246034 S0000503251_V3

Nose Radome Painting - STA 138.6 to STA 143.6
Figure 703/53-52-00-990-808

EFFECTIVITY
AKS ALL

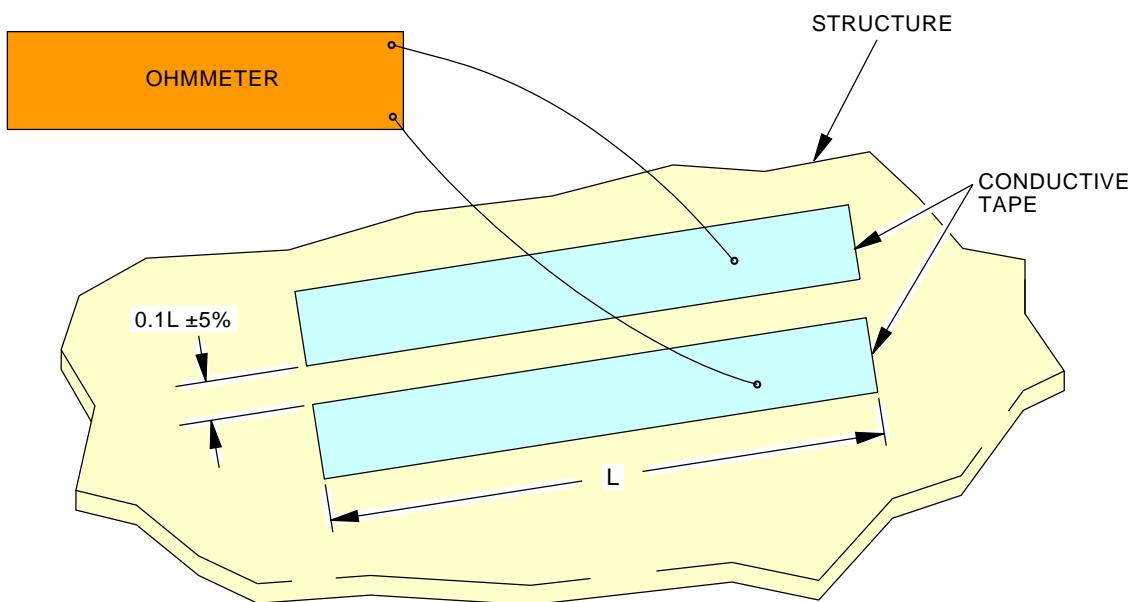
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2337201 S0000532390_V2

Resistance Measurement Using Square Method
Figure 704/53-52-00-990-809

EFFECTIVITY
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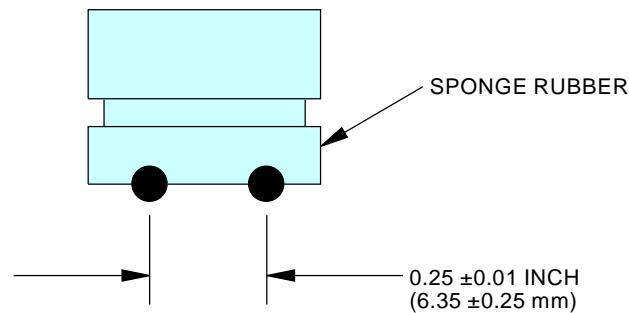
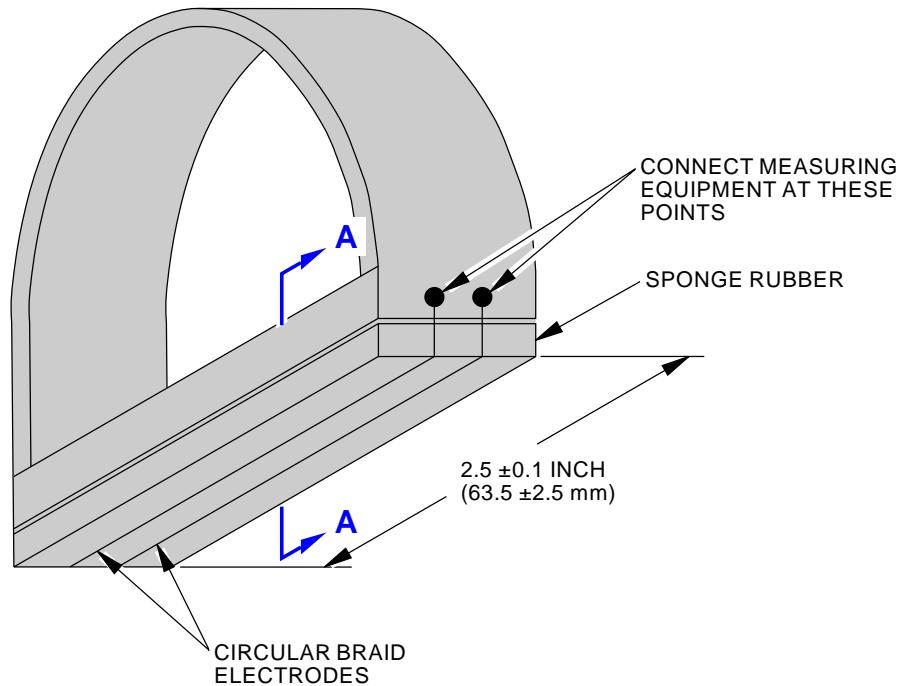
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PROBE CROSS SECTION
A-A

2337246 S0000532389_V2

ST895A-3 Resistivity Probe
Figure 705/53-52-00-990-810

EFFECTIVITY
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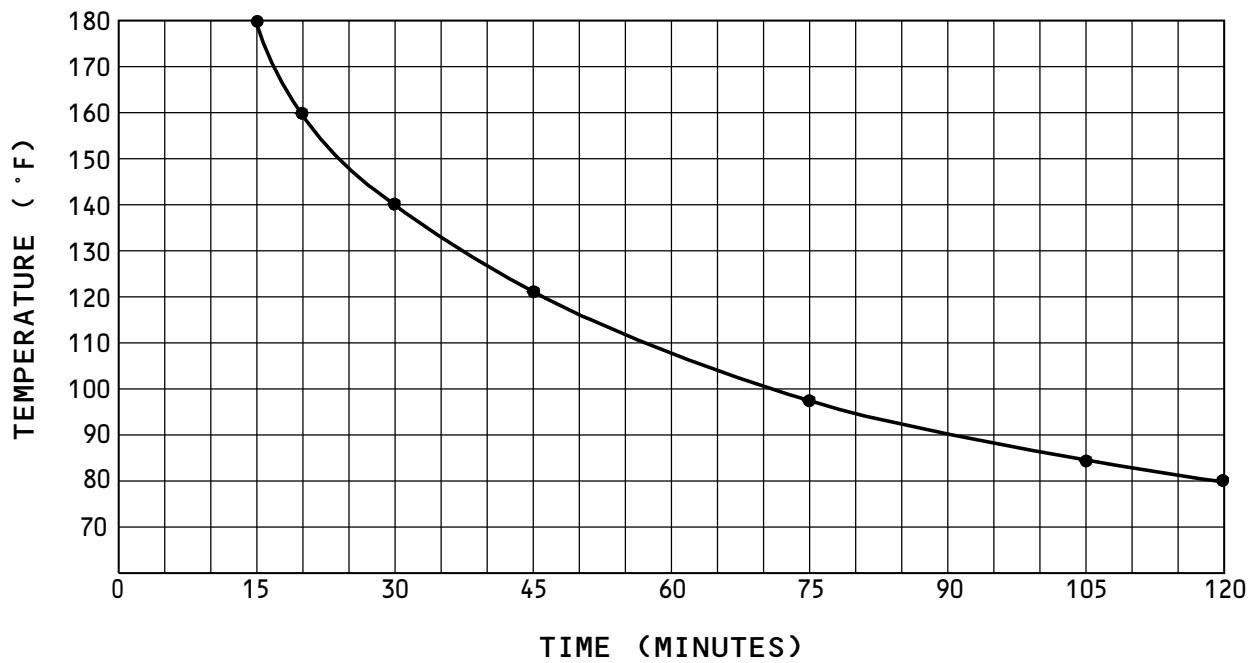
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F34247 S0006579527_V1

Conductive Coating Increased Cure Times
Figure 706/53-52-00-990-811

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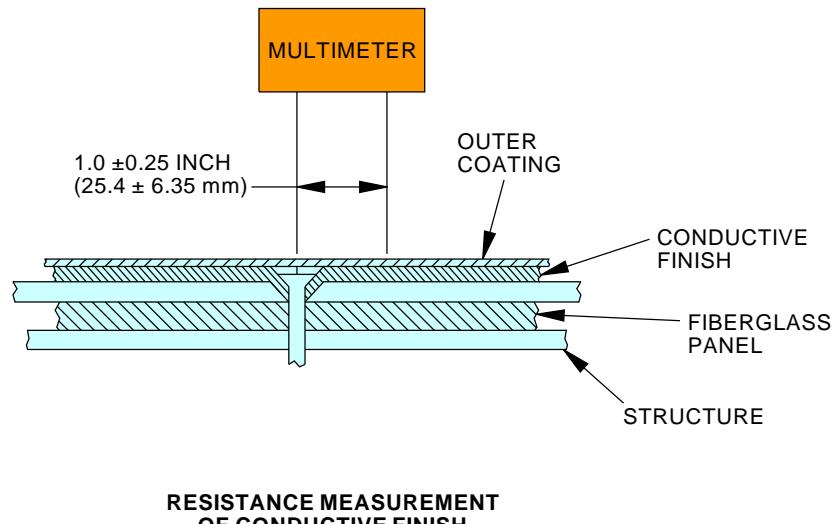
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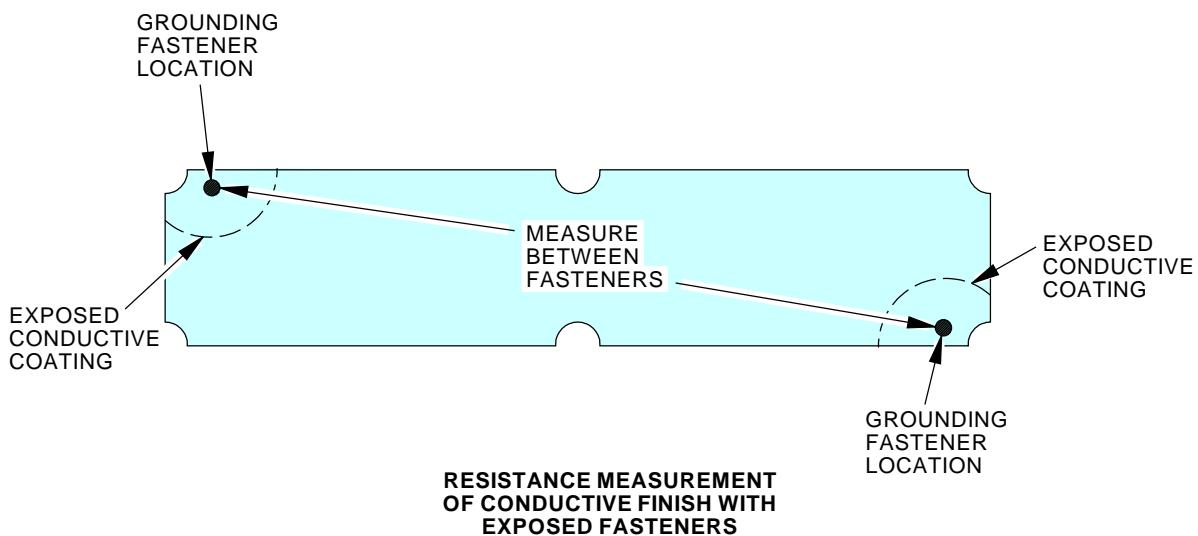
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RESISTANCE MEASUREMENT
OF CONDUCTIVE FINISH



RESISTANCE MEASUREMENT
OF CONDUCTIVE FINISH WITH
EXPOSED FASTENERS

F34237 S0006579528_V3

Resistance Measurement of Conductive Finish
Figure 707/53-52-00-990-812



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LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES

1. General

- A. This procedure contains three tasks:
 - (1) The first task is the removal of the lightning diverter strips.
 - (2) The second task is the installation of the lightning diverter strips.
 - (3) The third task is the adjustment/test of the lightning diverter strips.
- B. You must repair the damaged radome surface before you install the new lightning diverter strips.

TASK 53-52-03-000-801

2. Remove the Lightning Diverter Strips

(Figure 201)

A. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

B. Location Zones

Zone	Area
111	Radome

C. Procedure

SUBTASK 53-52-03-010-001

- (1) Open the nose radome and keep it in the open position, or fully remove the nose radome.

SUBTASK 53-52-03-020-001

- (2) Remove the screws that attach the diverter strips to the nose radome (Figure 201).

SUBTASK 53-52-03-020-002

- (3) Remove the diverter strip from the nose radome.

SUBTASK 53-52-03-100-001

- (4) Remove all unwanted material from the nose radome surface.

SUBTASK 53-52-03-100-002

- (5) Clean the nose radome surface with a cotton wiper, G00034 that is moist with solvent, B00083.

———— END OF TASK ————

TASK 53-52-03-400-801

3. Install the Lightning Diverter Strip

(Figure 202)

A. References

Reference	Title
51-21-99-300-802	Decorative Exterior Paint System Repair (P/B 701)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

EFFECTIVITY	AKS ALL
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(Continued)

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III

C. Location Zones

Zone	Area
111	Radome

D. Procedure

SUBTASK 53-52-03-370-001

- (1) Repair the nose radome surface if the protective finish is damaged, do this task: (Decorative Exterior Paint System Repair, TASK 51-21-99-300-802).

SUBTASK 53-52-03-100-003

- (2) Clean the mating surfaces of the diverter plate and the diverter strip for a satisfactory electrical bond.

SUBTASK 53-52-03-390-001

- (3) Seal the nose radome lightning diverter strip attach inserts.

- (a) Clean insert surface with a rag moistened with solvent, B00083 and let dry.
- (b) Clean radome surface around insert hole with a rag moistened with solvent, B00083 and let dry.
- (c) Apply sealant, A00247 on and around the insert hole in the nose radome and the mating surface of the insert. Completely coat the honeycomb core cells with sealant (Figure 202).
- (d) Install the insert immediately before the sealant has a chance to set-up.
- (e) Make sure there is squeeze out of the sealant all round the insert on both surfaces of the nose radome. The sealant squeeze out on the aerodynamic surface of the nose radome needs to be flush with the surface. This is to accommodate the fit-up of the diverted strips.
- (f) Apply a 0.12 inch fillet seal of sealant, A00247 around the flange of the diverter strip insert that is exposed to the interior side of the nose radome.

NOTE: It is important to make sure that the diverter strip attach inserts are completely sealed to prevent moisture from entering into the nose radome honeycomb core.

SUBTASK 53-52-03-420-001

- (4) Put the diverter strip in position and install the screws.

SUBTASK 53-52-03-410-001

- (5) Install the nose radome if it was removed.

SUBTASK 53-52-03-210-001

- (6) Make sure there are no clearances between the diverter strip and the nose radome.

SUBTASK 53-52-03-860-001

- (7) Do a lightning diverter strips test.

SUBTASK 53-52-03-410-002

- (8) Close the nose radome.

———— END OF TASK ————

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TASK 53-52-03-820-801

4. Lightning Diverter Strips - Test

(Figure 201), (Figure 202)

A. General

- (1) This procedure gives the instructions to do a dc continuity test for all parts that are related to the lightning diverter strips. You must do this test after you install the new diverter strips or when the inspection shows deterioration. The deterioration of the lightning diverter strips can cause radio noise interference.

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-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: C15292 (MODEL T477W) Supplier: 01014 Part #: M1 Supplier: 3AD17 Opt Part #: M1B Supplier: 3AD17

C. Location Zones

Zone	Area
111	Radome

D. Procedure

SUBTASK 53-52-03-010-002

- (1) Open the nose radome.

SUBTASK 53-52-03-210-002

- (2) Measure the electrical resistance between the points shown in (Figure 201) with an intrinsically safe approved bonding meter, COM-1550 and make sure the resistance does not exceed .01 ohms for strips that have been in service. The maximum resistance for new strips is .001 ohms.

SUBTASK 53-52-03-410-003

- (3) Close the nose radome.

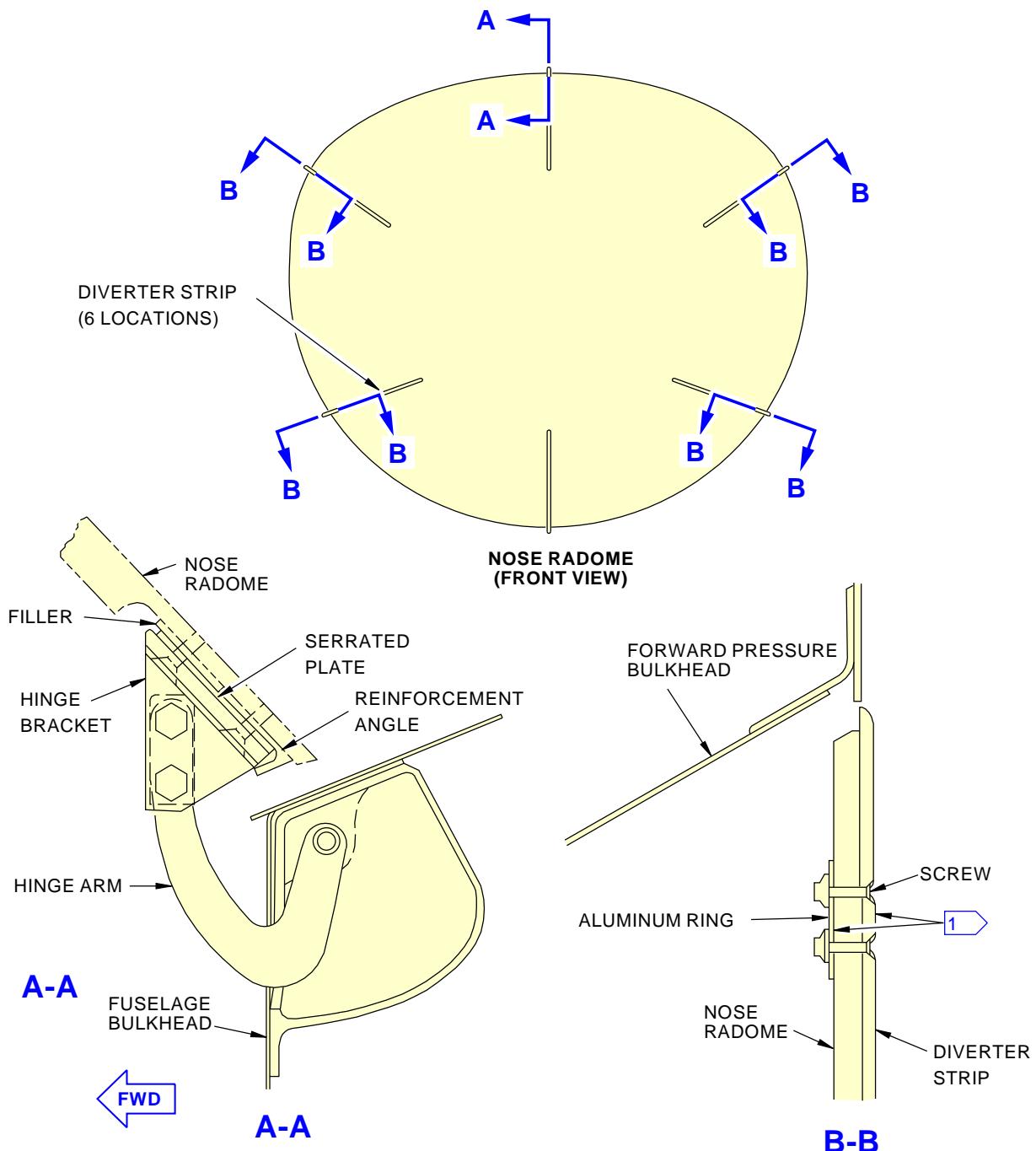
SUBTASK 53-52-03-210-003

- (4) Measure the electrical resistance between the diverter strip and the airframe with an intrinsically safe approved bonding meter, COM-1550, and make sure the resistance is less than 30 milliohms.

— END OF TASK —



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L14040 S0006581069_V3

Lightning Diverter Strip
Figure 201/53-52-03-990-801

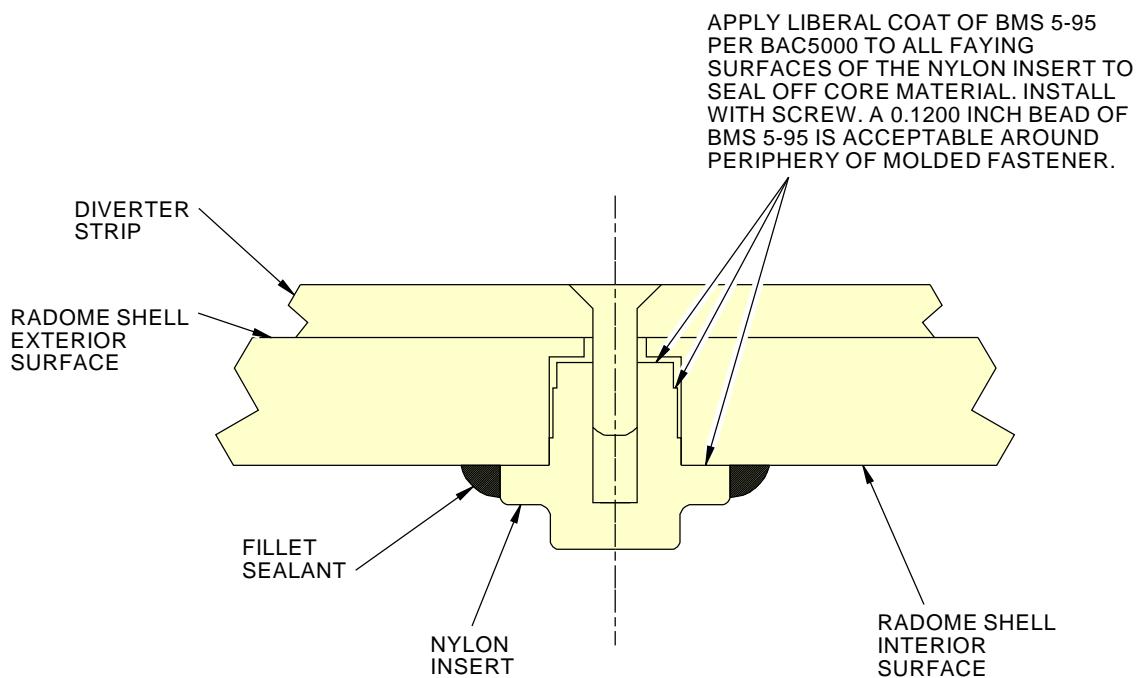
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L13925 S0006581070_V2

Insert/Sealant Installation
Figure 202/53-52-03-990-802

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LIGHTNING DIVERTER STRIPS - REPAIRS

1. General

A. This procedure has one task:

CAUTION: DO NOT OPERATE THE AIRPLANE FOR LONG PERIODS OF TIME WITH MISSING, OR DAMAGED DIVERTER STRIPS. REPAIR THE DIVERTER STRIPS QUICKLY. THE RISK OF DAMAGE TO THE RADOME, AND OTHER EQUIPMENT FROM LIGHTNING STRIKES INCREASES WHILE THERE ARE MISSING, OR DAMAGED STRIPS.

- (1) A temporary repair of the Lighting Diverter Strips.
- (2) Because of the possible effects on the ILS antenna pattern, the number of missing or damaged strips must be at a minimum and missing/removed in a symmetrical pattern. It is possible to remove strips on BL 0 independently.
- (3) The number of diverter strips missing/damaged must not be more than 40% of the total number of diverter strips. (For example, on radomes with 6 diverter strips, there must be no more than 2 diverter strips in symmetrical pairs missing or damaged at one time. Radomes with 10 diverter strips there must be no more than 4 diverter strips in symmetrical pairs missing or damaged.)
- (4) Sections of diverter strips not connected to the grounding plate can cause interference with communications equipment.

TASK 53-52-03-300-801

2. Lightning Diverter Strip Temporary Repair

A. References

Reference	Title
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)

B. Consumable Materials

Reference	Description	Specification
G50012 [P05-278]	Tape - Protective Polyurethane - 3M 8672	
G50361	Tape - Mylar, Permacel P-280	
G50362	Tape - 3M Polyester Tape 853 (Formerly 3M No. 853 Tape)	

C. Location Zones

Zone	Area
111	Radome

D. Procedure

SUBTASK 53-52-03-350-001

- (1) For damaged diverter strips:
 - (a) Remove all loose pieces of the lightning diverter strip, (Remove the Lightning Diverter Strips, TASK 53-52-03-000-801).
 - (b) Make sure that the remaining section of the damaged strip is safely held.
 - (c) Make sure that the ground plate is not damaged.
 - (d) Make sure that there is a continuous connection with the remaining section of the damaged strip and the ground plate.

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SUBTASK 53-52-03-350-002

- (2) For missing or removed diverter strips
 - (a) Seal openings from missing bolts with speed tape (3M 853 tape, G50362, Permacel P-280 tape, G50361, 3M 8672 tape, G50012 [P05-278] or equivalent).
 - (b) Make sure that all tape edges are flush with the surface of the radome.

———— END OF TASK ————

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GLIDE SLOPE ANTENNA DIRECTOR BAR - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks. The first task is the removal of the director bar for the glide scope antenna. The second task is the installation of the director bar for the glide scope antenna.
- B. The director bar for the glide slope antenna is an aluminum foil pressure-sensitive strip of tape. The director bar is attached to the inner surface of the nose radome. It changes the radiation signals for the glide slope antenna.

TASK 53-52-31-000-801

2. Glide Slope Director Bar Removal

(Figure 401)

A. Location Zones

<u>Zone</u>	<u>Area</u>
111	Radome

B. Procedure

SUBTASK 53-52-31-860-001

- (1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-31-010-001

- (2) Open the nose radome.

- (a) Remove the screws which attach the radome to the clips on the fuselage.

CAUTION: DO NOT OPEN THE RADOME IF THE WIND SPEED IS MORE THAN 15 KNOTS. THIS CAN CAUSE DAMAGE TO THE RADOME.

- (b) Open the radome.

- (c) Install the support rod to hold the radome open.

SUBTASK 53-52-31-020-001

- (3) Remove the director bar [1].

———— END OF TASK ————

TASK 53-52-31-400-801

3. Glide Slope Director Bar Installation

(Figure 401)

A. References

<u>Reference</u>	<u>Title</u>
53-52-00-400-801	Nose Radome Installation (P/B 401)

B. Consumable Materials

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
B00083	Solvent - VM&P Naphthas	ASTM D-3735 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

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(Continued)

Reference	Description	Specification
G00291	Tape - Aluminum Foil, Scotch 425	AMS-T-23397 / L-T-80

C. Location Zones

Zone	Area
111	Radome

D. Procedure

SUBTASK 53-52-31-110-001

- (1) Clean the nose radome surface where you will install the director bar with solvent, B00083.

SUBTASK 53-52-31-370-001

- (2) Apply one layer of the primer, C00259 to the surface where you will install the director bar.

SUBTASK 53-52-31-110-002

- (3) Clean the surface with the solvent, B00083.

SUBTASK 53-52-31-420-001

- (4) Do these steps to make and install the director bar.

(a) Cut a 13 in. (33 cm) long strip of the Scotch 425 Aluminum Foil Tape, G00291.

(b) Install the tape as shown in (Figure 401).

(c) Push the Scotch 425 Aluminum Foil Tape, G00291 correctly into its location.

SUBTASK 53-52-31-420-002

- (5) Install the M1458 decal on the radome as shown in (Figure 401) if it is not installed.

SUBTASK 53-52-31-410-001

- (6) Do this task: (Nose Radome Installation, TASK 53-52-00-400-801).

SUBTASK 53-52-31-860-002

- (7) Remove the safety tag and close this circuit breaker:

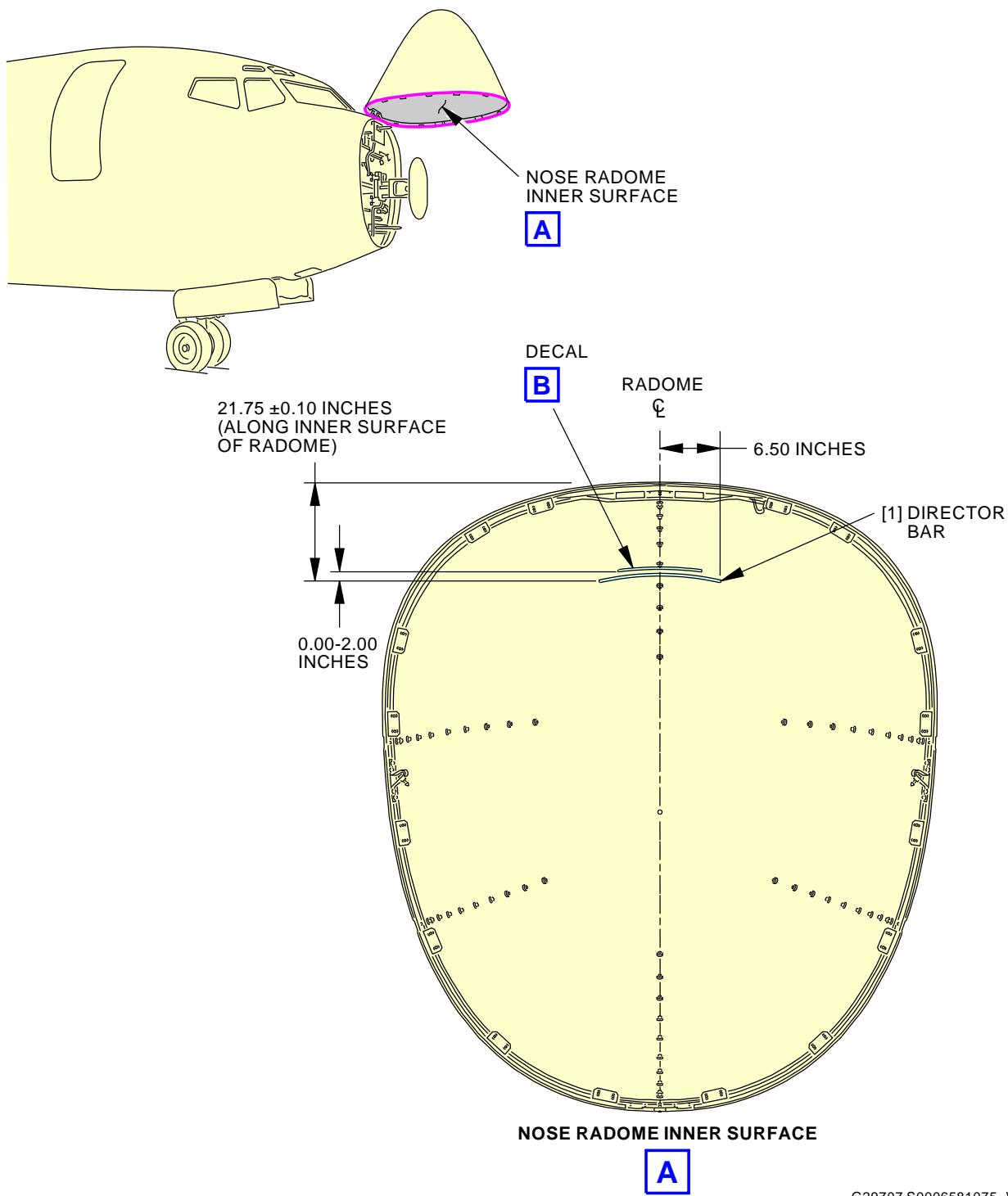
F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

———— END OF TASK ————



53-52-31



G29707 S0006581075_V2

Director Bar - Glide Slope Antenna Installation
Figure 401/53-52-31-990-801 (Sheet 1 of 2)

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GLIDESLOPE ANTENNA DIRECTOR BAR -M1458

DECAL



G29713 S0006581076_V2

Director Bar - Glide Slope Antenna Installation
Figure 401/53-52-31-990-801 (Sheet 2 of 2)

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TAILCONE - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Tailcone Removal
 - (2) Tailcone Installation

TASK 53-53-00-000-801

2. Tailcone Removal

A. References

Reference	Title
27-21-17-000-801	Rudder Index Plate Removal (P/B 401)
27-31-00-800-801	Elevator Hydraulic System A and B - Pressurization (P/B 201)
27-31-00-800-802	Remove Pressure from the Elevator Hydraulic Systems A and B (P/B 201)
27-31-11-000-801	Elevator - Removal (P/B 401)
27-31-81-000-801	Elevator Index Plate Removal (P/B 401)
27-41-11-000-801	Horizontal Stabilizer Removal (P/B 401)
49-91-71-000-801	Eductor Inlet Duct 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
SPL-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205

C. Location Zones

Zone	Area
315	APU Compartment - Left
316	APU Compartment - Right

D. Access Panels

Number	Name/Location
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

E. Prepare to Remove the Tailcone

SUBTASK 53-53-00-860-005

- (1) Use a non-permanent marker to make alignment marks on the tailcone and fuselage.

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SUBTASK 53-53-00-480-001

- (2) Move the stabilizer and elevator to a position that will let the elevator control pushrods be disconnected (Elevator - Removal, TASK 27-31-11-000-801).

SUBTASK 53-53-00-040-001

WARNING: MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Make sure that the horizontal stabilizer will not move (Horizontal Stabilizer Removal, TASK 27-41-11-000-801):

- Do this task: (Remove Pressure from the Elevator Hydraulic Systems A and B, TASK 27-31-00-800-802).
- Set the stabilizer trim cutout switches to the CUTOUT position.
NOTE: The stabilizer trim cutout switches are on the control stand.
- Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

- (d) Install the lock, SPL-1672, on the stabilizer trim wheel at the control stand:
- Turn the trim wheel to put the handle at the top of the wheel.
 - Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
 - Install the pin through the yoke.
 - Install the safety pin.

SUBTASK 53-53-00-010-005

- (4) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

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(Continued)

<u>Number</u>	<u>Name/Location</u>
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 53-53-00-010-006

- (5) Remove these parts to get access to the tailcone fasteners (Figure 401):
 - (a) Remove one top and three bottom screws [7] that attach the vertical blade seal to the structure.
 - (b) Remove the lower track assembly.
 - (c) Remove the upper track assembly.

NOTE: The forward fastener can stay installed and the upper track assembly turned up to get access to tailcone fasteners.
 - (d) Remove the rub strip [5].
 - (e) Do this task: Eductor Inlet Duct Removal, TASK 49-91-71-000-801.
 - (f) Disconnect the electrical connector, D148, from the strobe light.
 - 1) Remove the clamps from the wire harness, W7152, that attach harness to the tailcone.
- (6) Install a plastic shield on the tailcone [1] to prevent damage.

NOTE: When the tailcone is removed, it will touch the horizontal stabilizer.
- (7) Remove the tailcone fasteners that are inboard of the horizontal stabilizer.

NOTE: Access is not sufficient to remove all fasteners. When the horizontal stabilizer is moved, these fasteners will have access.
- (8) Use the steps from the elevator removal procedure to disconnect the elevator control pushrod from the elevator (Elevator - Removal, TASK 27-31-11-000-801).
- (9) Start the horizontal stabilizer:
 - (a) Remove the lock, SPL-1672, from the stabilizer trim wheel at the control stand.
 - (b) Set the stabilizer trim cutout switches to the NORMAL position.

NOTE: The stabilizer trim cutout switches are on the control stand.
 - (c) Do this task: Elevator Hydraulic System A and B - Pressurization, TASK 27-31-00-800-801.
 - (d) Close these circuit breakers:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

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F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

- (10) Set flight control surfaces to remove the tailcone:
 - (a) Move the stabilizer trailing edge to the fully up position.
 - (b) Move the rudder trailing edge fully left or right.
 - (c) Move the elevator trailing edge to the fully up position.
 - (d) Make sure that the horizontal stabilizer will not move.

F. Tailcone Removal Procedure

SUBTASK 53-53-00-020-001

- (1) Use these procedures to remove the tailcone:

- (a) Remove the fasteners and washers that attach the tailcone to the structure.

NOTE: Some of the tailcone fasteners do not have washers. If it is necessary, put marks at the locations of the fastener holes that do not have washers.

NOTE: Tailcone fasteners inboard of the horizontal stabilizer can have access. If it is necessary, move the horizontal stabilizer to get access to tailcone fasteners.

CAUTION: WHEN YOU REMOVE THE TAILCONE, IT CAN TOUCH EQUIPMENT ON THE AFT BULKHEAD. IF YOU APPLY TOO MUCH FORCE TO THE TAILCONE, DAMAGE TO EQUIPMENT ON THE AFT BULKHEAD CAN OCCUR.

- (b) When you remove the tailcone [1], make sure that it does not cause damage to equipment on the aft bulkhead.

- (c) Turn and lower the tailcone [1] away from the aft bulkhead.

NOTE: The bottom forward edge of the tailcone will be forward of the aft bulkhead for a short time during this step.

- (d) If it is necessary, lightly push the forward end of the tailcone [1] together to clear flight surfaces.

- (e) If you will install a new tailcone or a tailcone from a different airplane, do this task: (Elevator Index Plate Removal, TASK 27-31-81-000-801).

- (f) If you will install a new tail cone or a tailcone from a different airplane, do this task: (Rudder Index Plate Removal, TASK 27-21-17-000-801).

— END OF TASK —

TASK 53-53-00-400-801

3. Tailcone Installation

A. References

Reference	Title
27-21-17-400-801	Rudder Index Plate Installation (P/B 401)

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(Continued)

Reference	Title
27-31-00-800-802	Remove Pressure from the Elevator Hydraulic Systems A and B (P/B 201)
27-31-11-400-801	Elevator - Installation (P/B 401)
27-31-81-400-801	Elevator Index Plate Installation (P/B 401)
27-41-11 P/B 401	HORIZONTAL STABILIZER - REMOVAL/INSTALLATION
27-41-11-400-801	Horizontal Stabilizer Installation (P/B 401)
49-91-71-400-801	Eductor Inlet Duct Installation (P/B 401)
51-31-00-160-801	Prepare For Sealing (P/B 201)
51-31-00-390-806	Aerodynamic Smoother Application (P/B 201)

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-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: C15292 (MODEL T477W) Supplier: 01014 Part #: M1 Supplier: 3AD17 Opt Part #: M1B Supplier: 3AD17
SPL-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-10684	Plastic Sheet - Protective

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

D. Location Zones

Zone	Area
315	APU Compartment - Left
316	APU Compartment - Right

E. Access Panels

Number	Name/Location
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

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F. Prepare To Install The Tailcone

SUBTASK 53-53-00-040-002

- (1) Make sure that the horizontal stabilizer will not move (HORIZONTAL STABILIZER - REMOVAL/INSTALLATION, PAGEBLOCK 27-41-11/401):
 - (a) If it is necessary, do this task: Remove Pressure from the Elevator Hydraulic Systems A and B, TASK 27-31-00-800-802.
 - (b) Make sure that the stabilizer trim cutout switches are set to the CUTOUT position.
NOTE: The stabilizer trim cutout switches are on the control stand.
 - (c) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

- (d) Make sure that the lock, SPL-1672 on the stabilizer trim wheel at the control stand is installed.

SUBTASK 53-53-00-100-001

- (2) Remove the aerodynamic sealant and clean the area of aft bulkhead where the tailcone attaches, do this task Prepare For Sealing, TASK 51-31-00-160-801.

SUBTASK 53-53-00-950-001

- (3) Install a protective plastic sheet, STD-10684 on the tailcone [1] to prevent damage.

G. Tailcone Installation Procedure

SUBTASK 53-53-00-400-002

- (1) Install the tailcone:

CAUTION: WHEN YOU REMOVE THE TAILCONE, IT CAN TOUCH EQUIPMENT ON THE AFT BULKHEAD. IF YOU APPLY TOO MUCH FORCE TO THE TAILCONE, DAMAGE TO EQUIPMENT ON THE AFT BULKHEAD CAN OCCUR.

- (a) When you instal the tailcone, make sure that it does not cause damage to equipment on the aft bulkhead.
- (b) Make sure that the elevator control rods are outboard of the tailcone.
- (c) Turn and lift the tailcone [1] into its position on the aft bulkhead.

NOTE: The bottom forward edge of the tailcone will be forward of the aft bulkhead at the beginning of this step.



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- (d) If it is necessary, lightly push the forward end of the tailcone together to clear flight surfaces.
- (e) Make sure that the alignment marks are aligned.
- (f) Install but do not tighten the tailcone attachment fasteners.
- (g) Snug up opposite fasteners all around, then tighten opposite fasteners all around to the necessary torque.
NOTE: Some fasteners will not have access. When the horizontal stabilizer is moved, these fasteners will have access.
- (h) Do the steps to start the horizontal stabilizer (HORIZONTAL STABILIZER - REMOVAL/INSTALLATION, PAGEBLOCK 27-41-11/401).
- (i) Move the stabilizer and elevator to a position that will let the elevator control pushrods be connected.

WARNING: MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (j) Make sure that the horizontal stabilizer will not move.
- (k) Install and tighten remaining tailcone fasteners that are inboard of the horizontal stabilizer.
- (l) Remove the protective plastic sheet, STD-10684.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-53-00-410-005

- (1) Use these steps to put the airplane back to its usual condition Figure 401:
 - (a) Use the steps from the elevator installation procedure to connect the elevator control pushrods to the elevator (Elevator - Installation, TASK 27-31-11-400-801).
 - (b) If you installed a new tailcone [1] or a tailcone from a different airplane, do this task: Rudder Index Plate Installation, TASK 27-21-17-400-801.
 - (c) If you installed a new tailcone or a tailcone from a different airplane, do this task: Elevator Index Plate Installation, TASK 27-31-81-400-801.
 - (d) Install the rub strip [5].
 - (e) Install the lower track assembly.
 - (f) Install the upper track assembly.
 - (g) Install the fasteners that attach the vertical blade seal to structure.
 - (h) Install the clamps to attach wire harness, W7152, to the tailcone.
 - 1) Connect the electrical connector, D148, to the strobe light.
 - (i) With the electrical bonding (intrinsically safe approved bonding meter, COM-1550), make sure the resistance between the metal components of the anticolision light housing and the APU eductor fairing surface measures no more than 0.001 ohms.
 - (j) Do this task: Eductor Inlet Duct Installation, TASK 49-91-71-400-801.
 - (k) Close this access panel:

Number Name/Location

333AB Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

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- 1) Make sure that the blade seal is installed correctly into the forward track channel.
- (l) Close this access panel:

Number	Name/Location
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
- 1) Make sure that the blade seal is installed correctly into the forward track channel.
- (m) Close these access panels:

Number	Name/Location
318BR	Tailcone Access Door
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
- (n) Use the steps from Horizontal Stabilizer Installation, TASK 27-41-11-400-801 to adjust the stabilizer-to-body seals.
- (o) Remove the alignment marks.
- (p) Apply sealant, A02315 between the tailcone and fuselage skin (Aerodynamic Smoother Application, TASK 51-31-00-390-806).
- (q) Start the horizontal stabilizer.
- (r) Do an operational check of the stabilizer, rudder and elevators.

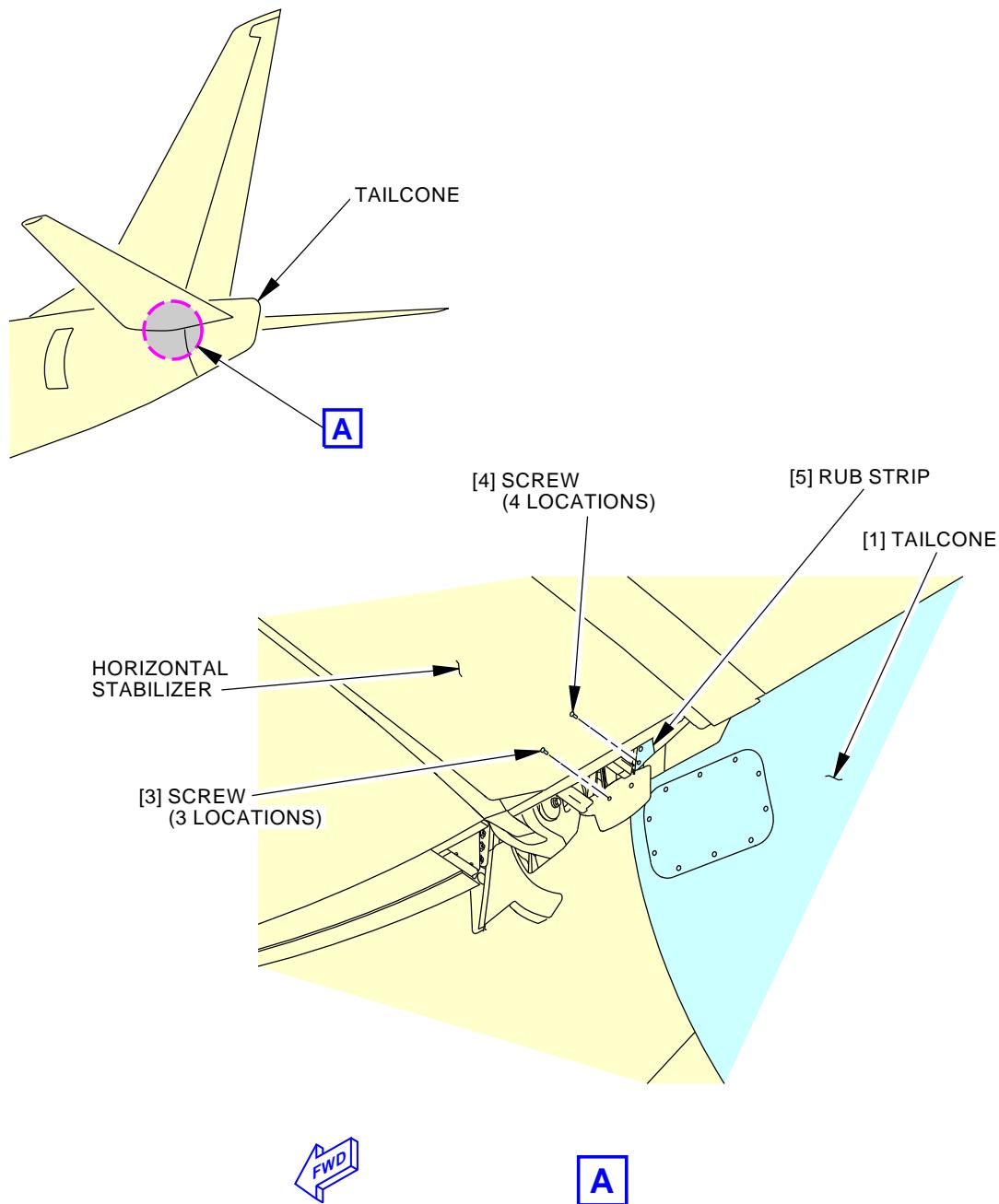
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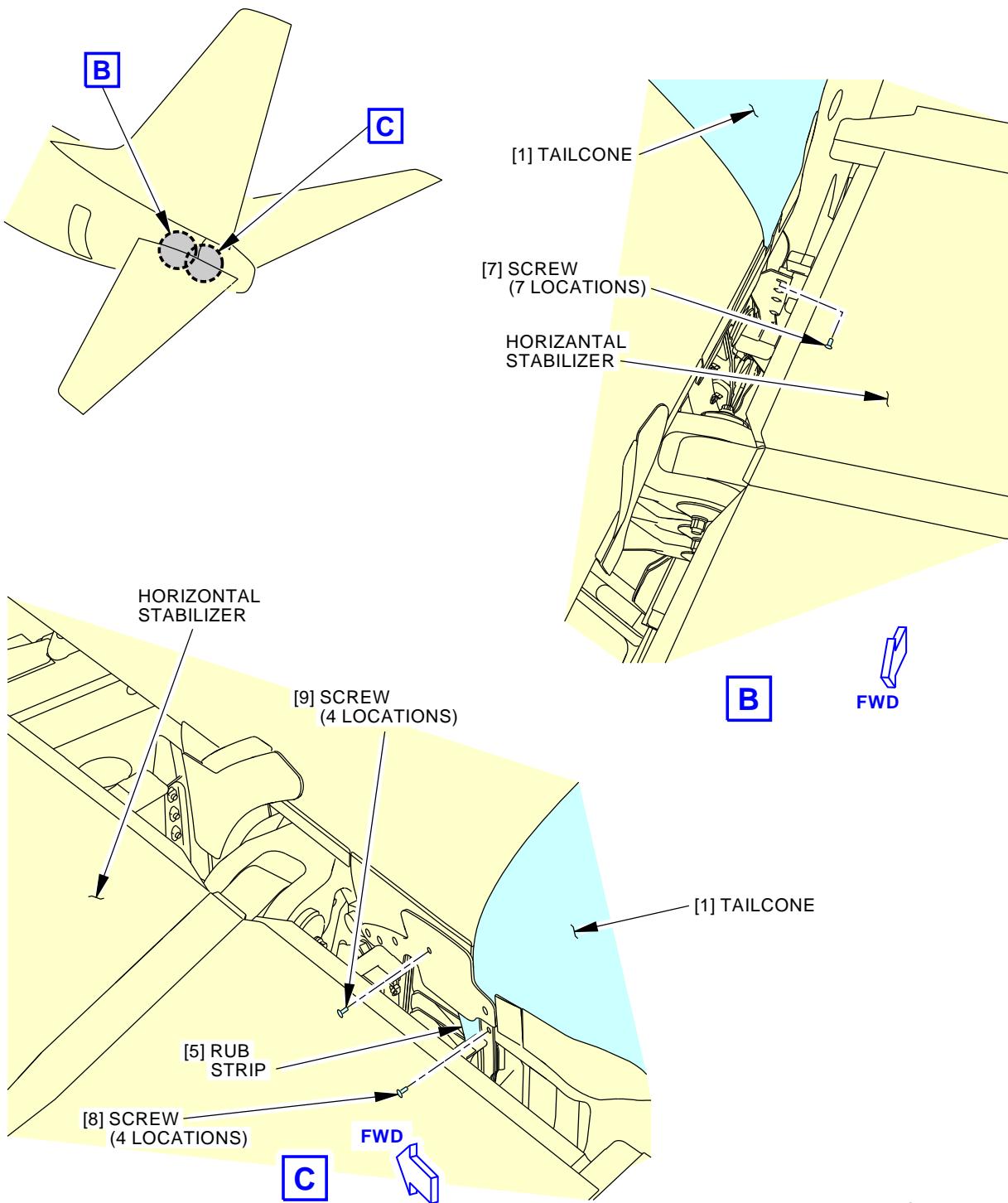


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Tailcone Removal / Installation
Figure 401/53-53-00-990-801 (Sheet 1 of 2)

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Tailcone Removal / Installation
Figure 401/53-53-00-990-801 (Sheet 2 of 2)

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BROADBAND RADOME - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the broadband radome.
 - (2) An installation of the broadband radome.
- B. There is one broadband radome. The radome is installed on the antenna adapter plate, which is located on top of the airplane fuselage. The adapter plate is mounted on the airplane center line, between stations 727D and 727H.

TASK 53-54-00-000-801

2. Broadband Radome Removal

(Figure 401)

A. References

Reference	Title
44-35-00-040-801-001	Global Communications Suite - Deactivation (P/B 201)

B. Removal Procedure

SUBTASK 53-54-00-860-001

- (1) Remove power from the CBB system. To remove power, do this task: Global Communications Suite - Deactivation, TASK 44-35-00-040-801-001

SUBTASK 53-54-00-860-002

- (2) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
A	9	C01956	ANTENNA/WAP PWR DC

SUBTASK 53-54-00-020-001

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY.
INJURIES TO PERSONS CAN OCCUR.

- (3) Remove the broadband radome:

NOTE: You can use two persons or a hoist to lift the broadband radome from the antenna adapter plate. The broadband radome weighs approximately 42 lb (19 kg).

- (a) Disconnect the two radome bonding jumpers [9]. To disconnect the straps, do these steps:

- 1) Open the radome blow-out door. To open the door, do these steps:

- a) Insert a flat head screwdriver or equivalent type tool into the slot on the blow-out door latch and pull aft.
 - b) Pull the latch in the aft direction.
 - c) Lift the blow-out door assembly in a forward direction.

- 2) Remove the bolt [7] and washers [8] that attach each of the bonding jumpers [9] to the adapter plate [6].

- (b) Do these steps if you use a hoist to lift the radome [5] from the antenna adapter plate [6]:

- 1) Attach the sling [1] to the four radome hoist points [2].
 - 2) Attach the sling [1] to the hoist.

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- (c) Remove the sixty-eight (68) bolts [3] and dimpled washers [4] that attach the broadband radome [5] to the antenna adapter plate [6].
- (d) Remove the broadband radome [5] from the antenna adapter plate [6].
- (e) If the radome was removed to get access to the receive/transmit antenna, then the procedure is complete.
- (f) If the radome was removed to replace a damaged radome with a serviceable radome, do these steps:
 - 1) Remove the bolt [11], washers [12] and nut [13] that attach the two bonding jumpers to the radome.
 - 2) Retain the bolt, washers, nut and bonding jumpers for installation on the new radome.

———— END OF TASK ————

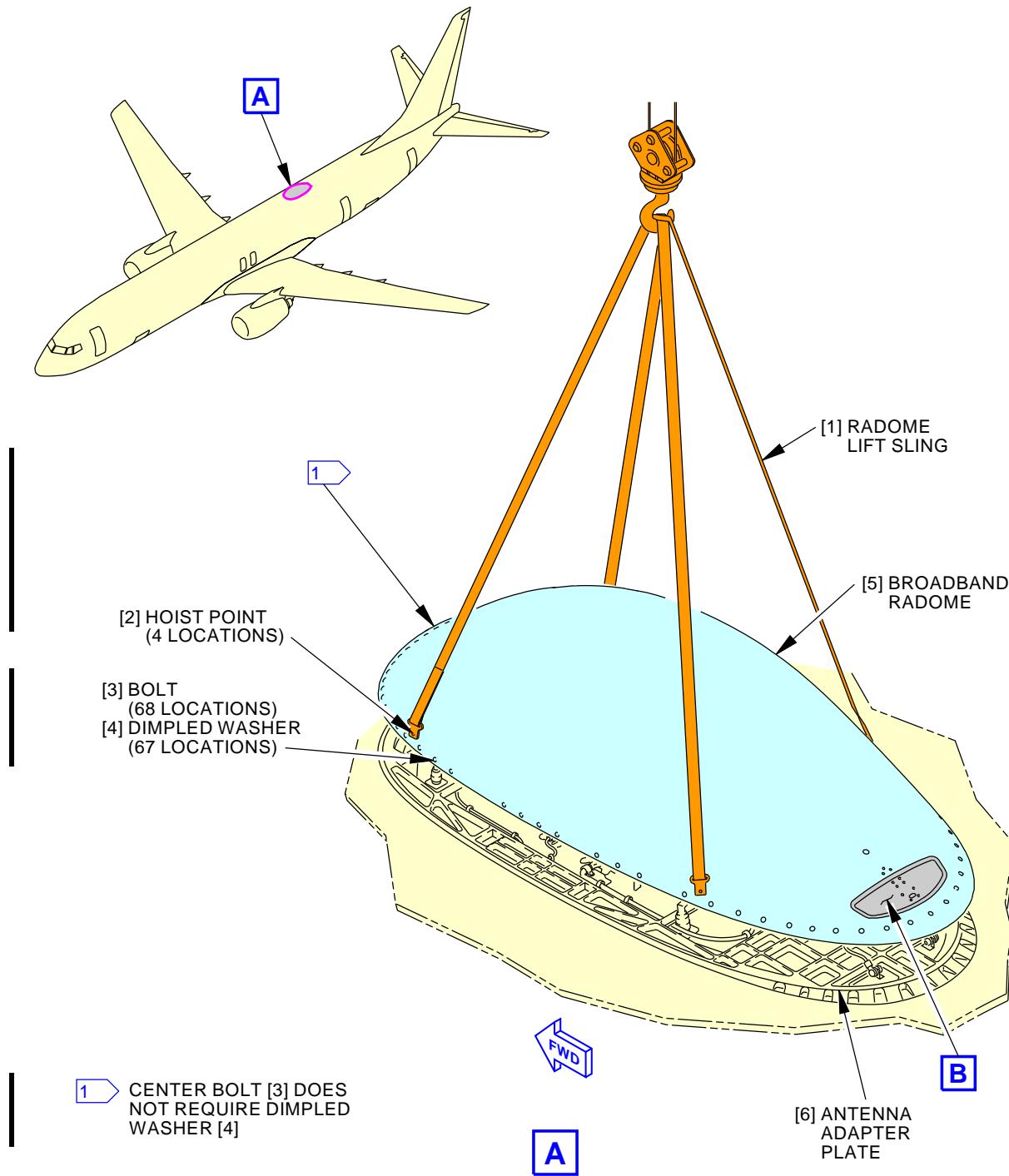
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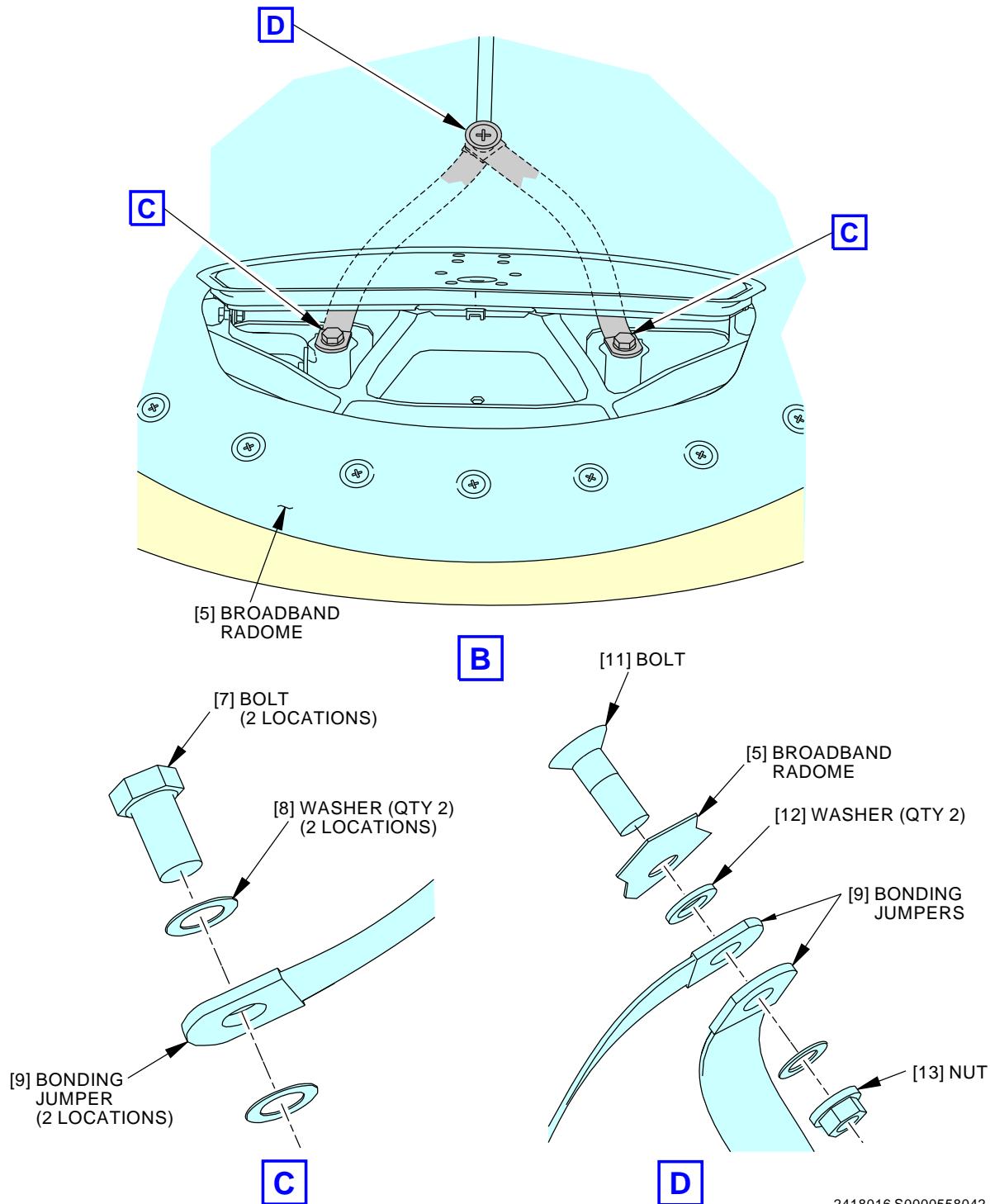
Broadband Radome Installation
Figure 401/53-54-00-990-801 (Sheet 1 of 2)

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Broadband Radome Installation
Figure 401/53-54-00-990-801 (Sheet 2 of 2)

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TASK 53-54-00-400-801

3. Broadband Radome Installation

(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
COM-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: C15292 (MODEL T477W) Supplier: 01014 Part #: M1 Supplier: 3AD17 Opt Part #: M1B Supplier: 3AD17

B. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00130	Alcohol - Isopropyl	TT-I-735

C. Installation Procedure

SUBTASK 53-54-00-860-003

- (1) Make sure that this circuit breaker is open and has safety tag:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
A	9	C01956	ANTENNA/WAP PWR DC

SUBTASK 53-54-00-420-001

- (2) If applicable, prepare the new radome for installation on the airplane.

- (a) Attach the two bonding jumpers [9] to the new radome. To attach the straps, do these steps:

- 1) Clean the radome [5] surface and the washer [12] with alcohol, B00130.
- 2) Insert the bolt [11] and the washer [12] into the hole in the aft end of the lightning diverter strip.
 - a) Fay seal both sides of the washer [12] and between the bonding jumpers [9] with adhesive, A01076.
 - b) Put the washer [12] on the bolt [11].
 - c) Put the two bonding jumpers [9] on the bolt [11].
 - d) Put the remaining washer [12] and the locking nut [13] on the bolt [11].

- (b) Position the bonding jumpers [9] so that:

- 1) The unconnected end of the bonding jumpers [9] are to the rear of the radome [5].
- 2) The two bonding jumpers [9] are at 90 degrees to each other.
- 3) The bonding jumpers [9] are aligned on the radome centerline.

- (c) Tighten the locking nut [13] to 200 ± 20 in-lb (23 ± 3 N·m).

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- 1) Apply a fillet seal on the nut [13] and the washer [12] with adhesive, A01076.
- (d) Use the intrinsically safe approved bonding meter, COM-1550 to examine the resistance between the ground strap and the dimpled washer on the exterior of the radome. Make sure the maximum resistance is 0.00175 ohm or less.
- (e) Make sure that the blow-out door is open. If it is closed, do these steps:
 - 1) Insert a flat head screwdriver or equivalent type tool into the slot on the blow-out door latch and pull aft.
 - 2) Pull the latch in the aft direction.
 - 3) Lift the blow-out door assembly in a forward direction.

SUBTASK 53-54-00-420-002

WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY.
INJURIES TO PERSONS CAN OCCUR.

- (3) Install the broadband radome:

NOTE: You can use two persons or a hoist to lift the radome on to the antenna adapter plate.
The broadband radome weighs approximately 42 lb (19 kg).

- (a) Do these steps if you use a hoist to lift the broadband radome [5] on to the antenna adapter plate [6]:
 - 1) Attach the sling [1] to the four radome hoist points [2].
 - 2) Attach the sling [1] to the hoist.
- (b) Lift the broadband radome [5] in its position on the antenna adapter plate [6].
- (c) Clean the washers [8] and the bonding jumpers [9] with alcohol, B00130.
- (d) Fay surface seal both sides of the washers [8] and the underside of the bonding jumpers [9] with adhesive, A01076.
- (e) Use a bolt [7] and washers [8] to attach each of the antenna radome bonding jumpers [9] to the antenna adapter plate [6].
- (f) Apply a fillet seal over the washers [8] and the bolt [7] with adhesive, A01076.
- (g) Use the intrinsically safe approved bonding meter, COM-1550 to examine the resistance between the ground strap and the bolt head. Make sure that the maximum resistance is 0.0001 ohm or less.
- (h) Clean the sixty-seven (67) dimpled washers [4] and the radome surface with alcohol, B00130.
- (i) Loosely install the sixty-eight (68) bolts [3] and sixty-seven (67) dimpled washers [4] that attach the broadband radome [5] to the antenna adapter plate [6].
 - 1) Install bolt [3] at the forward center location.
 - 2) Install one bolt and washer near the middle of the radome on one side, then install the second bolt near the middle of the radome on the other side.
 - 3) Alternate bolts and washers from one side of the radome to the other until all bolts are loosely installed.
- (j) Tighten each bolt to 150 +20 / -0 in-lb (17 +2 / -0 N·m) in the same pattern as they were installed.
 - 1) Use the intrinsically safe approved bonding meter, COM-1550 to measure the bonding resistance between the forward center bolt and the airplane structure. Make sure the maximum resistance is 0.0007 ohm or less.

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- (k) Close and latch the blowout door.
- (l) Do these steps if a hoist was used to lift the broadband radome from the antenna adapter plate:
 - 1) Remove the sling [1] from the four radome hoist points [2].
 - 2) Remove the sling [1] from the hoist.

SUBTASK 53-54-00-860-004

- (4) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C01956	ANTENNA/WAP PWR DC

———— END OF TASK ————

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BROADBAND RADOME - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) Inspection of the broadband radome.

TASK 53-54-00-211-801

2. Broadband Radome Inspection

A. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-300-801	Broadband Radome Blow-out Door Hinge Repair (P/B 801)
53-54-00-300-802	Broadband Radome Blow-out Door Latch Repair (P/B 801)
53-54-00-300-803	Broadband Radome Blow-out Door Opening Edge Protector Repair (P/B 801)
53-54-00-300-804	Broadband Radome Blow-out Door Seal Repair (P/B 801)
53-54-00-300-805	Broadband Radome Exterior Coating Repair (P/B 801)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

B. Procedure

SUBTASK 53-54-00-211-001

- (1) Exterior Coating Damage:
 - (a) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that do not penetrate the coating.
 - (b) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that penetrate the coating, but do not expose underlying coating primer or laminate.
 - (c) Visually inspect the radome and door assembly exterior for scuffs, cuts or scratches that penetrate the coating, and expose underlying coating primer and/or laminate.
 - (d) Visually inspect the antistatic topcoat for loss of adhesion to the elastomeric base coat. The indications are loose, bubbled or lost coating.
 - (e) Perform the inspection as required.
 - (f) If the damage does not penetrate the coating, no repair is required.
 - (g) If the coating is penetrated but the primer or laminate is not exposed, no repair is required.
 - (h) If the coating is penetrated and the primer or laminate is exposed, evaluate the damage against the criteria that follows:
 - 1) In the forward-exposed region of the radome, immediately repair individual damaged areas of coating primer or laminate larger than 0.25 square inches.
 - 2) In the forward-exposed region of the radome, no more than five areas of non-repaired damage smaller than 0.25 square inch are allowed. Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
 - 3) In the non-forward exposed region of the radome, if a damaged area is smaller than 1 square inch, no repair is required.

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- 4) In the non-forward exposed region of the radome, no more than five areas of non-repaired damage smaller than 1 square inch are allowed. Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
 - (i) If the antistatic topcoat exhibits loss of adhesion to the elastomeric base coat, evaluate the damage against the criteria that follows:
 - 1) In the forward-exposed region of the radome, no damage area greater than 4 square inches is allowed.
 - (j) If coating repair is required, do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

SUBTASK 53-54-00-211-002

- (2) Radome Shell and Radome Blow-out Door Laminate Damage:
 - (a) Inspect the radome shell and radome blow-out door for lamination damage.
 - (b) Perform the inspection as required.
 - (c) In the forward-exposed region of the radome (Figure 601), no damage of any size is allowed. If lamination damage exists, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).
 - (d) In the aft attachment region (Figure 601), evaluate the damage against the criteria that follows:
 - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:
 - a) A maximum of 0.50 inches in diameter or across the longest dimension.
 - b) A maximum of 0.008 inches in depth.
 - c) Located above the row of attachment fasteners (as defined by a line connecting fastener centerlines).
 - d) Located a minimum of 1 inch away from any fastener center.
 - e) Located at least 2 times the dent diameter away from any other damage location.
 - (e) In all other areas of the radome (Figure 601), evaluate the damage against the criteria that follows:
 - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:
 - a) A maximum of 0.50 inches in diameter or across the longest dimension.
 - b) A maximum of 0.008 inches in depth.
 - c) Located a minimum of 1 inch away from the blow-out door.
 - d) Located at least 2 times the dent diameter away from any other damage location.
 - (f) If the damage exceeds the criteria above, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-003

- (3) Lightning Diverter Strip Damage:
 - (a) Visually inspect the lightning diverter strip for missing lightning diverter strip segments or "buttons".
 - (b) Visually inspect the lightning diverter strip for an unbonded or damaged lightning diverter strip.

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- (c) Perform the inspection as required.
- (d) If either condition exists, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-004

(4) Hoist Point Hardware Damage:

- (a) Visually inspect for damage (damaged threads or bent nutplate base) of hoist point hardware (nutplate), that prevents normal removal and installation of hoist point screw.
- (b) Perform the inspection as required.
- (c) If damage exists, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-005

(5) Blow-out Door Edge Protector Damage:

- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that prevents normal opening and closing of door.
- (b) Perform the inspection as required.
- (c) If the blow-out door edge protector damage does not prevent blow-out door normal operation, repair the blow-out door edge protector. Do this task: (Broadband Radome Blow-out Door Opening Edge Protector Repair, TASK 53-54-00-300-803).
- (d) If blow-out door edge protector damage exists that prevents blow-out door normal operation. replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-006

(6) Leading Edge Protector Damage:

- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that interferes with installation of radome on aircraft.
- (b) Perform the inspection as required.
- (c) If damage exists, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-007

(7) Blow-out Door Hinge Damage:

- (a) Visually inspect for damage, including bending of hinge arm or brackets, that interferes with normal opening and closing of blow-out door.
- (b) Perform the inspection as required.
- (c) If the blow-out door hinge damage does not prevent blow-out door normal operation, repair the blow-out door hinge. Do this task: (Broadband Radome Blow-out Door Hinge Repair, TASK 53-54-00-300-801).
- (d) If blow-out door hinge damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

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SUBTASK 53-54-00-211-008

(8) Blow-out Door Latch Damage:

- (a) Visually inspect for damage, including jamming of latch mechanism, that interferes with normal opening and closing of latch of blow-out door.
- (b) Perform the inspection as required.
- (c) If the blow-out door latch damage does not prevent blow-out door normal operation, repair the blow-out door latch. This is the task: (Broadband Radome Blow-out Door Latch Repair, TASK 53-54-00-300-802).
- (d) If blow-out door latch damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-009

(9) Blow-out Door Seal Damage:

- (a) Visually examine the blow-out door for damage (disbonding, seal tearing) that prevents normal operation of the blow-out door.
- (b) Visually inspect for a torn or missing seal, or section of seal.
- (c) Perform the inspection as required.
- (d) If the blow-out door seal damage does not prevent blow-out door normal operation, repair the blow-out door seal. Do this task: (Broadband Radome Blow-out Door Seal Repair, TASK 53-54-00-300-804).
- (e) If blow-out door seal damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

———— END OF TASK ————

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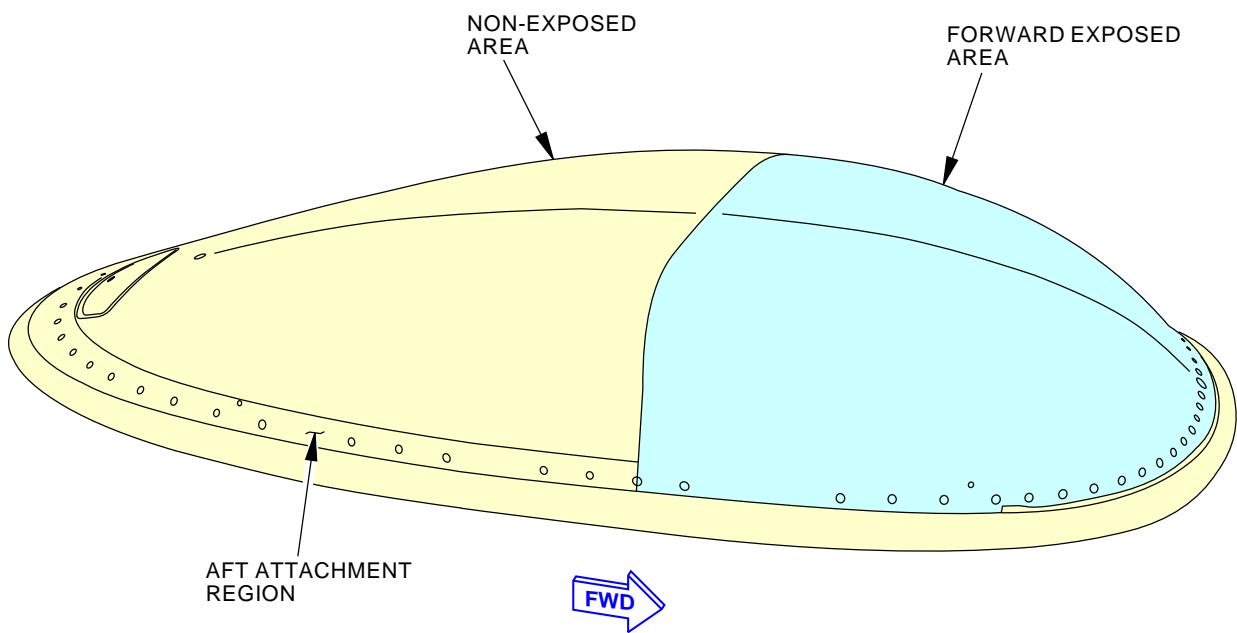
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Radome Area Definition
Figure 601/53-54-00-990-802

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BROADBAND RADOME - REPAIRS

1. General

- A. This procedure contains these tasks:
- (1) A repair of the Blow-out Door Hinge
 - (2) A repair of the Blow-out Door Latch
 - (3) A repair of the Blow-out Door Opening Edge Protector
 - (4) A repair of the Blow-out Door Seal
 - (5) A repair of the Hoist Point Nutplate
 - (6) A repair of the Leading Edge Protector
 - (7) A repair of the Lighting Diverter Strip
 - (8) A repair of the Radome Exterior Coating.

TASK 53-54-00-300-801

2. Broadband Radome Blow-out Door Hinge Repair

A. General

- (1) The blow-out door hinge repair consists of replacing the damaged hinge with a new hinge.

B. Blow-out Door Hinge Repair

SUBTASK 53-54-00-300-001

- (1) To replace a damaged blow-out door hinge, do these steps:
 - (a) Remove all of the fasteners that attach the hinge to the radome and blow-out door:
 - 1) Hold the fasteners using a 5/64" hex wrench.
 - 2) Turn the collar (nut) with grip-type pliers.
 - (b) Remove the damaged hinge.
 - (c) Attach the new hinge to the radome:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar / nut with a common 5/16" wrench.
 - (d) Attach the hinge to the blow-out door:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar / nut with a common 5/16" wrench.
- (2) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

———— END OF TASK ————

TASK 53-54-00-300-802

3. Broadband Radome Blow-out Door Latch Repair

A. General

- (1) The blow-out door latch repair consists of replacing the damaged latch with a new latch.

B. Blow-out Door Latch Repair

SUBTASK 53-54-00-300-002

- (1) To replace a damaged blow-out door latch, do these steps:

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- (a) Remove all of the fasteners that attach the latch to the radome and blow-out door:
 - 1) Hold the fasteners using a 5/64" hex wrench.
 - 2) Turn the collar (nut) with grip-type pliers.
 - (b) Remove the damaged latch.
 - (c) Put the new latch in position on the blow-out door.
 - (d) Attach the new latch to the blow-out door:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar (nut) with a common 5/16" wrench.
- (2) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task:
(Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

————— END OF TASK ————

TASK 53-54-00-300-803

4. Broadband Radome Blow-out Door Opening Edge Protector Repair

A. General

- (1) The blow-out door opening edge protector repair consists of replacing the damaged edge protector with a new edge protector.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

E. Blow-out Door Opening Edge Protector Repair

SUBTASK 53-54-00-020-002

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task:
(Broadband Radome Removal, TASK 53-54-00-000-801).

SUBTASK 53-54-00-300-003

- (2) To repair the blow-out door opening edge protector, do these steps:
 - (a) Open the blow-out door.

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- (b) Mask the coated radome surface surrounding blow-out door edge protector.
- (c) Use a broad blade putty knife, STD-549 to carefully disbond and remove door opening edge protector.
- (d) Use sandpaper, G50260 to scuff sand the door opening edge protector bond region.
- (e) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove loose particles left by the sanding.
- (f) Wipe the new edge protector with another cotton wiper, G00034 moistened with alcohol, B00130.
- (g) Apply adhesive, A01076 or sealant, A00247 to the bond surface of the door opening edge protector.
- (h) Apply adhesive, A01076 or sealant, A00247 to the door opening edge protector bond surface of the radome.
- (i) Put the door opening edge protector in the radome door opening and press into position.
- (j) Use a cotton wiper, G00034 that is moist with solvent, B00062 to remove excess adhesive.
NOTE: Use only the amount of solvent required to remove excess adhesive.
- (k) Close the radome blow-out door assembly and latch the door in the closed position. This allows the door and door seal to press against door opening edge protector to hold the edge protector in position while the adhesive cures.
- (l) Let the adhesive cure for 24 hours at $80 \pm 10^{\circ}\text{F}$ ($27 \pm 6^{\circ}\text{C}$).

———— END OF TASK ————

TASK 53-54-00-300-804

5. Broadband Radome Blow-out Door Seal Repair

A. General

- (1) The blow-out door seal repair consists of replacing the damaged seal with a new seal.

B. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade
STD-761	Scissors

C. Consumable Materials

Reference	Description	Specification
A00562	Adhesive - High Strength Silicone Rubber, One-Part - RTV157	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

D. Blow-out Door Seal Repair

SUBTASK 53-54-00-300-004

- (1) To replace a damaged blow-out door seal, do these steps:
 - (a) Open the blow-out door.
 - (b) Use a broad blade putty knife, STD-549 to remove the damaged blow-out door seal.
 - (c) Use sandpaper, G50260 to scuff sand the outer door flange surface to remove remaining seal adhesive.

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- (d) Use sandpaper, G50260 to scuff sand the inner door flange surface to remove remaining seal adhesive.
- (e) Use sandpaper, G50260 to scuff sand the edge of door flange surface to remove remaining seal adhesive.
- (f) Use scissors, STD-761 to cut the seal at the seal centerline on the latch side of the seal.
- (g) Use scissors, STD-761 to cut the seal on the hinge side of the seal, 2" to 3" to either the left or right side of the centerline.
- (h) "Dry fit" the seal to the blow-out door. Trim excess seal length to permit butt joint of seal ends with no gap permitted.
- (i) Apply RTV157 adhesive, A00562 to the bond surface of the door seal halves
- (j) Apply RTV157 adhesive, A00562 to the outer and inner surfaces of the blow-out door flange.
- (k) Install one half (either half) of the door seal onto the blow-out door flange.
NOTE: The door seal is molded to fit over the flange of the blow-out door flange.
- (l) Install the other half of door seal onto the blow-out door flange.
- (m) Carefully close and latch the door in the closed position to permit seal to be tightly held into position while the door seal adhesive cures.
- (n) Apply RTV157 adhesive, A00562 along the door-to-seal joint line, especially in areas where unfilled gaps between door and seal bulb are visually apparent.

———— END OF TASK ————

TASK 53-54-00-300-805

6. Broadband Radome Exterior Coating Repair

A. General

- (1) The exterior coating repair consists of the application of coating materials on the damaged area of the radome.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (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-6457	Meter - Insulation (Range: 1-1,000 VDC or equivalent, select meter per test requirements) Part #: 1863-9700 Supplier: 62015 Part #: 1864-9700 Supplier: 62015 Part #: 1865PLUS Supplier: 62015 Part #: 1865PLUSCE Supplier: 62015 Part #: 2471F Supplier: 21844 Opt Part #: 1865-00-CE Supplier: 62015

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D. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

E. Radome Exterior Coating Repair

SUBTASK 53-54-00-300-005

- (1) Use 240 grit (or finer) sandpaper to feather the coating around the damaged area for a distance of 1 to 2 inches.
- (2) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.
- (3) If bare laminate is exposed as a result of the sanding, do these steps:

(a) If the radome is still installed on the airplane, remove it. Do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

(b) Mix and apply primer, C00766 to the damaged area.

1) Apply the primer to a thickness of 0.0003" to 0.0008" per Boeing BAC5325.

(c) Mix and apply Caapcoat FP-100CM coating system. To apply the coating system, do these steps:

NOTE: If provided in the coating kit, discard the components of the Aeroglaze 9947 wash primer kit. DO NOT apply these components to the radome.

1) Add the contents of the polyurethane accelerator container to the polyurethane basecoat/curing agent mixture container and mix well.

2) Add the volume of polyurethane thinner to the polyurethane basecoat/curing agent/accelerator mixture necessary to obtain a viscosity of 22 to 28 seconds on a Number 2 Zahn viscosity measuring cup and mix thoroughly.

3) Allow the thinned mixture to set at room temperature for 30 minutes or more after mixing.

NOTE: The thinned mixture has a 4 to 6 hour pot life.

4) Spray or brush the thinned mixture on the primed area of the radome.

a) Apply as many coats as required to achieve a thickness of 0.0085" to 0.010".
b) Allow the coating to dry for 5 to 20 minutes between coats.

5) Allow polyurethane basecoat to air dry at room temperature for 15 to 30 minutes before beginning to apply tiecoat.

(d) Mix and apply the tiecoat. To apply the tiecoat, do these steps:

1) Add the contents of the curing agent container to the FE-AS fluoroelastomer tiecoat container and mix well.

NOTE: The tiecoat mixture has a 6 hour pot life.

2) Apply the tiecoat mixture onto the polyurethane coating to a depth of 0.0005" to 0.002" (1-2 coats).

3) Allow 45 to 90 minutes of air drying time prior to the application of the anti-static topcoat.

(e) Mix and apply the anti-static topcoat. To apply the anti-static topcoat, do these steps:

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- 1) Thoroughly mix the liquid container (Can A) contents.
- 2) Filter the contents of the liquid container (Can A) into the fibers container (Can B).
- 3) Add the contents of the curing agent container to the mixture now in the fibers container (Can B) and mix thoroughly.
- 4) Apply the anti-static topcoat over the previously applied tiecoat to a thickness of 0.001" to 0.002" (1 or 2 coats).
- (4) Let the coating cure for 24 hours at room temperature.
- (5) Use an insulation meter, COM-6457 to test the antistatic topcoat for surface resistance per AMS 3138-6.
 - (a) Make sure that the resistance is between 0.5 and 15 megaohms.
- (6) Test the coating in the repair area and at least one area which includes the repair topcoat bridged to the original radome topcoat.

———— END OF TASK ————

TASK 53-54-00-300-806

7. Broadband Radome Hoist Point Nutplate Repair

A. General

- (1) The radome hoist point nutplate repair consists of replacing the damaged nutplate with a new nutplate.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Radome Hoist Point Nutplate Repair

SUBTASK 53-54-00-020-003

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

SUBTASK 53-54-00-300-006

- (2) To replace the radome hoist point nutplate, do these steps:
 - (a) Use a small diameter (1" to 2") disc sander to remove the rivet tail, which attaches the defective hoist point nutplate to the radome.
 - (b) Use a small hammer and a small-diameter (0.070" to 0.090") punch to remove the rivets that attach the hoist point nutplate to the radome.
 - (c) Install new rivets (NAS1200M3-7) into the hoist point nutplate rivet holes from the outer surface of the radome.
 - (d) Put the new hoist point nutplate (BACN11G3A1CD) onto the rivets protruding through radome shell.
 - (e) Position a pneumatic rivet squeezer over the hoist point nutplate rivets.
 - (f) Squeeze the rivets to attach the hoist point nutplate to the radome.
- (3) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

———— END OF TASK ————

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TASK 53-54-00-300-807

8. Broadband Radome Leading Edge Protector Repair

A. General

- (1) The radome leading edge protector repair consists of replacing the damaged leading edge protector with a new leading edge protector.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade
STD-3729	Fastener - Spring Loaded, Sheet Metal, 3/16 Cleco

D. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)

E. Radome Leading Edge Protector Repair

SUBTASK 53-54-00-020-004

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

SUBTASK 53-54-00-300-007

- (2) To replace the radome leading edge protector, do these steps:
 - (a) Mask the coated radome surface surrounding the leading edge protector.
 - (b) Use a small drill motor and #40 (0.098" diameter) drill bit to remove the countersink heads of the rivets that attach the leading edge protector to the radome.
 - (c) Use a small hammer and small (0.070" to 0.090") diameter punch to remove the rivets.
 - (d) Use a broad blade putty knife, STD-549 to carefully disbond and remove the leading edge protector.
 - (e) Use a small drill motor and a #40 (0.098" diameter) drill bit to enlarge the pilot hole nearest each end of the new leading edge protector to size #40 (0.098").
 - (f) "Dry fit" the new leading edge protector on the radome.
 - (g) Use a spring loaded fastener, STD-3729 to hold the leading edge protector in place.
 - (h) Use a small drill motor and #40 (0.098") drill bit to "back drill" through the existing rivet hole in the radome and through the remaining ("unopened") leading edge protector rivet hole.
 - (i) Repeat steps (g) and (h) on the holes on the other end of the leading edge protector.
 - (j) Use a drill motor and a small microstop with a 100-degree cutter and #40 (0.098" diameter) pilot to countersink the outer surface of the leading edge protector at the edge protector rivet hole locations to accept NAS1200M3-6.5 rivet.
 - (k) Remove the spring loaded fastener, STD-3729 and the leading edge protector from the radome.

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- (l) Apply adhesive, A01076 to the lower (radome trim) edge of the radome and to the outer surface of the radome in the leading edge protector area.
- (m) Apply adhesive, A01076 to the bond surface of the leading edge protector.
- (n) Put the new leading edge protector in place on the radome.
- (o) Secure each end of the leading edge protector with a spring loaded fastener, STD-3729 while the adhesive cures.
- (p) After the adhesive has cured, install a rivet in the open hole in each end of the leading edge protector.
- (q) Remove the spring loaded fastener, STD-3729 and install a rivet in the other open hole in each end of the leading edge protector.
- (r) Put a pneumatic rivet squeezer into position to squeeze the rivets.
- (s) Squeeze the rivets.

———— END OF TASK ————

TASK 53-54-00-300-808

9. Broadband Radome Lightning Diverter Strip Repair

A. General

- (1) The radome lightning diverter strip repair consists of replacing the damaged lightning diverter strip with a new lightning diverter strip.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G50073	Promoter - Tape Adhesion - Adhesion Promoter 86A	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

D. Radome Lightning Diverter Strip Repair

SUBTASK 53-54-00-020-005

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

SUBTASK 53-54-00-300-008

- (2) Apply masking tape and paper along the edge of the lightning diverter strips.

NOTE: The lightning diverter strips are 0.40" wide, and the edge of the lightning diverter strips appears as a "step" in the radome exterior coating in the vicinity of the lightning diverter strips.

- (3) Use a standard putty knife to carefully pry the dimpled washers from the radome surface at the forward and aft terminations of the lightning diverter strips.
- (4) Use a utility or other narrow-blade sharp knife to very carefully cut through the radome coating at the edge of the lightning diverter strips.

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- (5) Use a standard putty knife to carefully disbond the lightning diverter strip from the radome outer surface.
- (6) If necessary due to damage, replace the masking materials (tape and paper) in the area surrounding the lightning diverter strip bond region.
- (7) Use sandpaper, G50260 to scuff sand the bond surface of the radome in the area that will receive the new lightning diverter strips.
- (8) Use a cotton wiper, G00034 moistened with solvent to wipe the abraded surface of the radome.
- (9) Use a narrow artist brush to apply Adhesion Promoter 86A, G50073 to the radome surface in the lightning diverter strip bond region.
- (10) Wait 15 to 20 minutes for the Adhesion Promoter 86A, G50073 to air dry on the surface of the radome.
- (11) Carefully peel the protective paper away from the bond side of a new lightning diverter strip.
- (12) Apply the new lightning diverter strip to the radome.
 - (a) Work may begin at either the forward termination of the lightning diverter strip, or at the aft termination of the lightning diverter strip.
 - (b) Two lightning diverter strips will be applied to the radome.
 - (c) The ends of both of these lightning diverter strips shall be positioned 0.060" to 0.100" from the edge of the dimpled washer countersink.
- (13) After one of the lightning diverter strips has been applied along its full length to the radome surface, butt-join a second section of lightning diverter strip to the first section of lightning diverter strip, with no gap between these two sections of lightning diverter.
- (14) Apply the second section of lightning diverter strip to within 1" to 3" of the dimpled washer countersink at the termination of the lightning diverter strip.
- (15) Trim the end of the second section of lightning diverter strip such that the end of the lightning diverter strip is 0.060" to 0.100" from the edge of the dimpled washer countersink.
- (16) Prepare to bond dimpled washers to termination of the lightning diverter strip sections by scuff sanding the radome surface in the region to receive the dimpled washers.
- (17) Apply Loctite / Hysol Company paste adhesive product EA-934NA to the bond surface of the dimpled washer.

NOTE: This paste adhesive shall not be applied where it will come into contact with the "buttons/segments" of the lightning diverter strip.
- (18) Apply the adhesive-coated dimpled washer to the radome surface.
- (19) Use a cotton wiper, G00034 moistened with solvent to remove excess paste adhesive.
- (20) Use only the minimum amount of solvent (acetone) required to wipe away excess adhesive.
- (21) Apply a piece of tape over dimpled washers to secure them in place during the adhesive cure period.
- (22) Let the adhesive cure for a period of 24 hours at $80 \pm 10^{\circ}\text{F}$ ($27 \pm 6^{\circ}\text{C}$).
- (23) Apply narrow masking tape to the lightning diverter strips, centering the masking tape over the buttons/segments of the lightning diverter strips.
- (24) Use 240 (or finer) sandpaper to scuff sand the diverter carrier laminate and the adjacent rain erosion coating in the area that received the new lightning diverter strips.
- (25) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.

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- (26) Apply coating to the exposed surface of the lightning diverter strips. Do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).
- (27) After the coating has cured, use a utility knife, or similar narrow-blade sharp knife, to very carefully cut the coating along the edge of the masking tape protecting the lightning diverter strip buttons/segments.
- (28) Remove the masking tape.

———— END OF TASK ————

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