



sabena [®] B707	Module: GENERAL	A/C Reg :	Check :	 04G2000308
	Oper. : NRT			
	Type : MODIF	Issuer : A59513	Cert.St.: 45379	Page 1 of 8
Spec. : ELECTRICIAN	Release Date: 05.12.2007			

DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.


		MAINT	RII/INSP
Execution / Start Date:			
End Date:			

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					MAINT	RII/INSP																								
Nr.	Hardtime	Task	Spec.	Related Documents																										
1.			REI	DFW B707-23-501 rev 0																										
Check:																														
Zones:																														
Access:																														
NRC YES <input type="radio"/> NO <input type="radio"/>		IF YES, NUMBER(S):																												
REMOVAL OF THE INTERPHONE JACKS FROM THE ENGINE NACELLE:																														
A. Inspection:				ENGINE 1																										
				ENGINE 2																										
				ENGINE 3																										
				ENGINE 4																										
1. Inspect:																														
a) if any wiring or hardware is installed, remove as specified in step B.																														
b) If the modification has been accomplished fill out page 14 and 15 (see figures end of jobcard)																														
B. Removal instructions:				ENGINE 1																										
				ENGINE 2																										
				ENGINE 3																										
				ENGINE 4																										
1. Wiring removal, engine nose cowl No. # 1, # 2, # 3, # 4, on nacelle: STA N85, N87 and N136																														
a) Remove plugs RD601 (STA: N136), RD4311 and RD4321 (STA: N87)																														
b) Remove the following wires:																														
<table border="1"> <thead> <tr> <th>wire</th> <th>from</th> <th colspan="2">to</th> </tr> </thead> <tbody> <tr> <td>RZ115BB20</td> <td>RD718</td> <td>RD4321-1</td> <td>WDM 23-3-3</td> </tr> <tr> <td>RZ117AE20</td> <td>RD718</td> <td>RD4321-3</td> <td>WDM 23-3-3</td> </tr> <tr> <td>RZ118AE20</td> <td>RD718</td> <td>RD4321-5</td> <td>WDM 23-3-3</td> </tr> <tr> <td>Shielding</td> <td></td> <td>RD4321-2</td> <td>WDM 23-3-3</td> </tr> <tr> <td>Shielding</td> <td></td> <td>RD4321-4</td> <td>WDM 23-3-3</td> </tr> </tbody> </table>							wire	from	to		RZ115BB20	RD718	RD4321-1	WDM 23-3-3	RZ117AE20	RD718	RD4321-3	WDM 23-3-3	RZ118AE20	RD718	RD4321-5	WDM 23-3-3	Shielding		RD4321-2	WDM 23-3-3	Shielding		RD4321-4	WDM 23-3-3
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wire	from	to																												
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Shielding	RD601-A		WDM 23-3-3																											
Note: For LX2000 and LX20199 WDM 71-50-4 are also applicable.																														

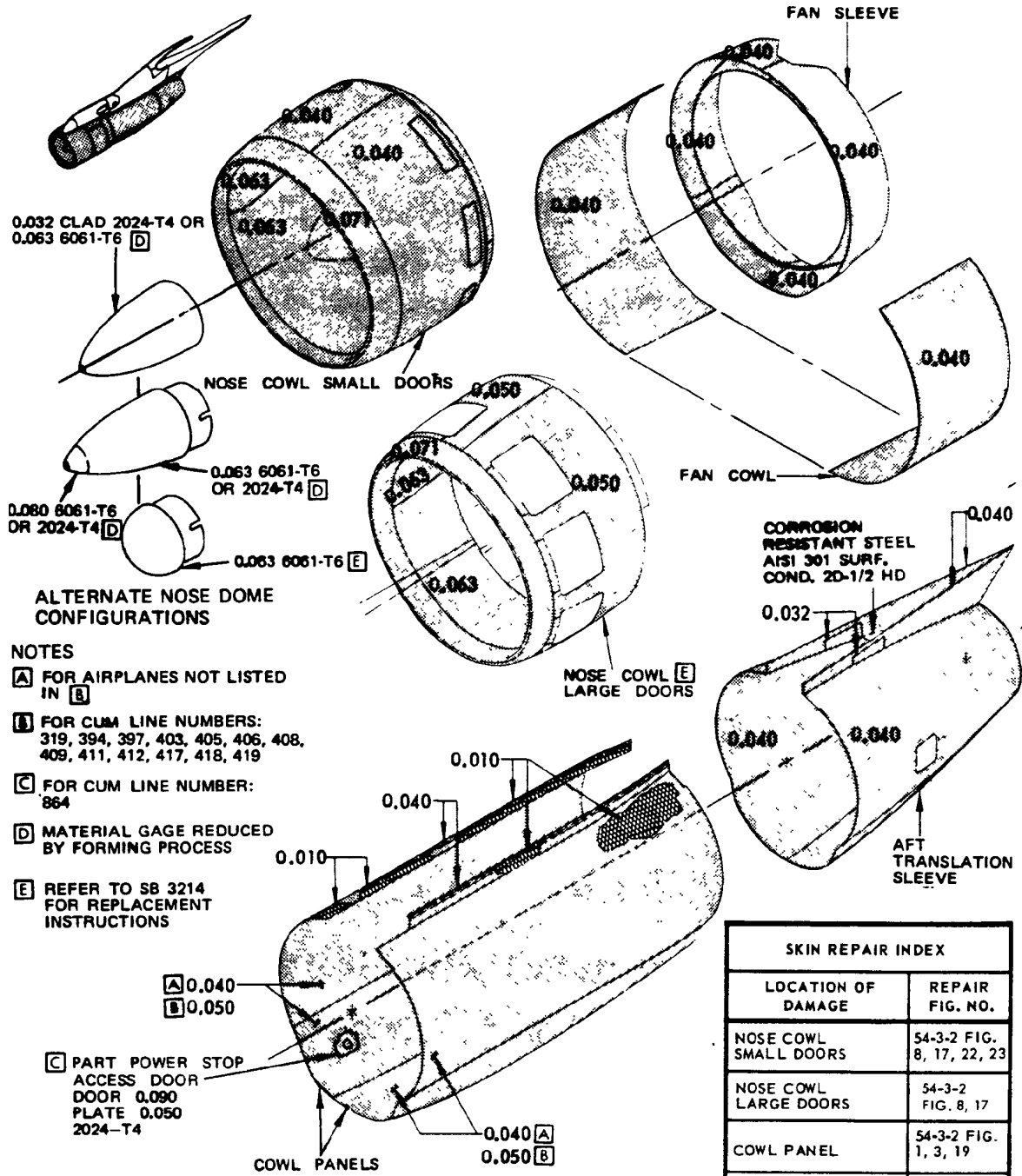
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DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.



			MAINT	RII/INSP
2. Hardware removal: a) Remove Jack 2J1511 (1) and washer MS35333-43 (1). b) Remove screw NAS603-8 (4), bracket assy 66-11294 (1) and insulator 69-10825-1 (1).	ENGINE 1			
	ENGINE 2			
	ENGINE 3			
	ENGINE 4			
C. Installation instructions: see figure 2 to plug the hole with the additional information given below. 1. Plug the interphone jack hole with round fillers made from 2024T3 Clad sheet, 0.748 in.dia., to a total thickness of 0.275" as follows: a) Attach the aluminum round fillers together with one standard aluminum flush head rivet to a nesting aluminum doubler. b) Use nesting Doubler material of 2024-T3 Clad Aluminum sheet, dimensions 4,7" x 1.18", 0.080" thick. c) Install Doubler on the internal side of the nose cowl skin with 6 ea standard aluminum flush head rivets.	ENGINE 1			
	ENGINE 2			
	ENGINE 3			
	ENGINE 4			
2. Fill out and process Accomplishment report on page. 15. (see figure end of jobcard)	ENGINE 1			
	ENGINE 2			
	ENGINE 3			
	ENGINE 4			

DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.

MAINT RII/INSP



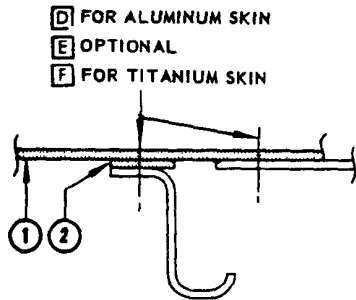
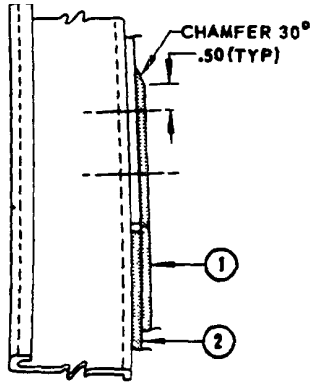
- NOTES**
- A** FOR AIRPLANES NOT LISTED IN **B**
 - B** FOR CUM LINE NUMBERS: 319, 394, 397, 403, 405, 406, 408, 409, 411, 412, 417, 418, 419
 - C** FOR CUM LINE NUMBER: 864
 - D** MATERIAL GAGE REDUCED BY FORMING PROCESS
 - E** REFER TO SB 3214 FOR REPLACEMENT INSTRUCTIONS

	CLAD 2024-T3 OR 2024-T4
	CORROSION RESISTANT STEEL AISI 302 ANNEALED

SKIN REPAIR INDEX	
LOCATION OF DAMAGE	REPAIR FIG. NO.
NOSE COWL SMALL DOORS	54-3-2 FIG. 8, 17, 22, 23
NOSE COWL LARGE DOORS	54-3-2 FIG. 8, 17
COWL PANEL	54-3-2 FIG. 1, 3, 19
FAN COWL	54-3-2 FIG. 2, 3
FAN SLEEVE	54-3-2 FIG. 13, 14, 21, 24
AFT TRANSLATION SLEEVE	54-3-2 FIG. 18

DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.

MAINT RII/INSP

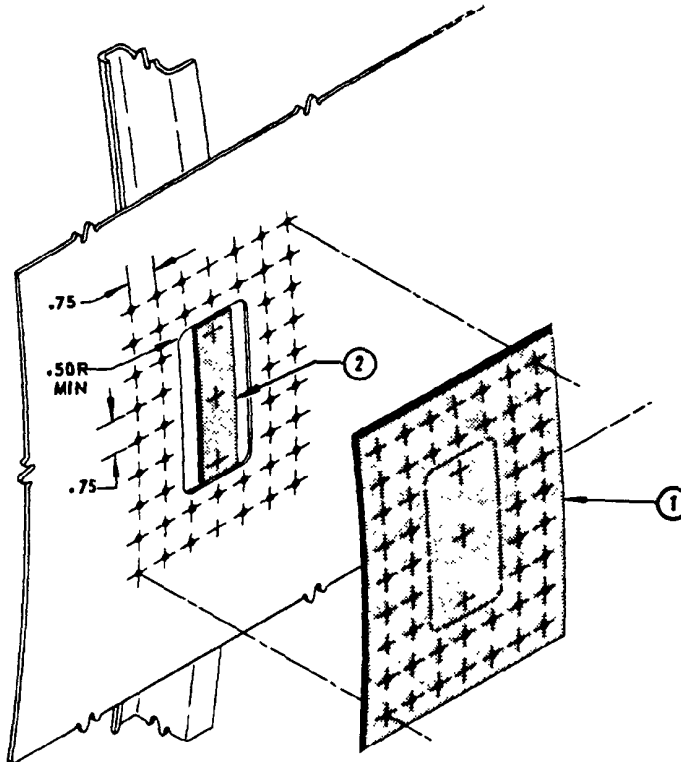


SECTION THROUGH REPAIR

NOTE
 APPLY SKYDROL RESISTANCE FINISH PER 51-2-0 OF THE MAINTENANCE MANUAL
 BREAK SHARP EDGES 0.03 ALL REPAIR PARTS AND TRIMMED ORIGINAL PARTS
 FINISH PER 51-2-0 OF THE MAINTENANCE MANUAL
 SEE 51-2-0 FOR FASTENER CODE, REMOVAL AND INSTALLATION, HOLE SIZES AND EDGE MARGINS.
 SEE 51-8-0 FOR METAL PROTECTIVE TREATMENT
 SEE 51-13-1 FOR DEFINITION OF AN EXTERNAL REPAIR
 SEE 51-4-1 FOR PERFORMANCE CONSIDERATIONS IN REGIONS OF CRITICAL SMOOTHNESS

-  ORIGINAL FASTENER LOCATIONS
-  REPAIR FASTENER LOCATIONS

- [A] SAME MATERIAL AND GAGE AS ORIGINAL SKIN OR SKIN PLUS DOUBLER, IF DAMAGE OCCURS IN ALUMINUM ALLOY PORTION OF SKIN.
- [B] USE CORROSION RESISTANT STEEL TYPE 302 ANNEALED WITH SAME GAGE AS ORIGINAL SKIN OR SKIN PLUS DOUBLER, IF DAMAGE OCCURS IN TITANIUM ALLOY PORTION OF SKIN.
- [C] SAME GAGE AND MATERIAL AS IN ORIGINAL SKIN.



REPAIR MATERIAL			
	PART	QTY.	MATERIAL
(1)	PLATE	1	[A] [B]
(2)	FILLER	1	[C]

REPAIR INSTRUCTIONS:

1. Trim the damaged skin to form a rectangular shape
NOTE: Do not cut the frame member.
 Remove all burrs, nicks, scratches or sharp edges from damage area.
2. Alodize aluminum parts.
3. Apply Skydrol resistant faying surface finish.
4. Install repair parts.
5. Apply Skydrol resistant finish to the repaired area.

FASTENER EFFECTIVITY		
FASTENER	JT3C	JT3D
[D]	BAC R15CE-4D	BAC R15CE-5D
[E]	AN 426AD-4	AN 426AD-5
[F]	AN 427M-4	AN 427M-5

Nacelle Panel Skin at Frame - External Repair
 Figure 2

54-3-2

Jan 5/70

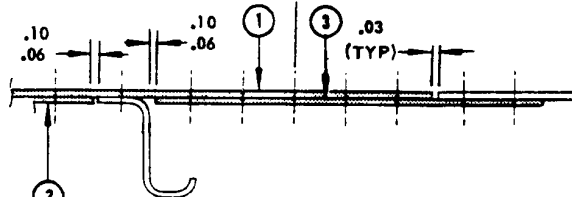
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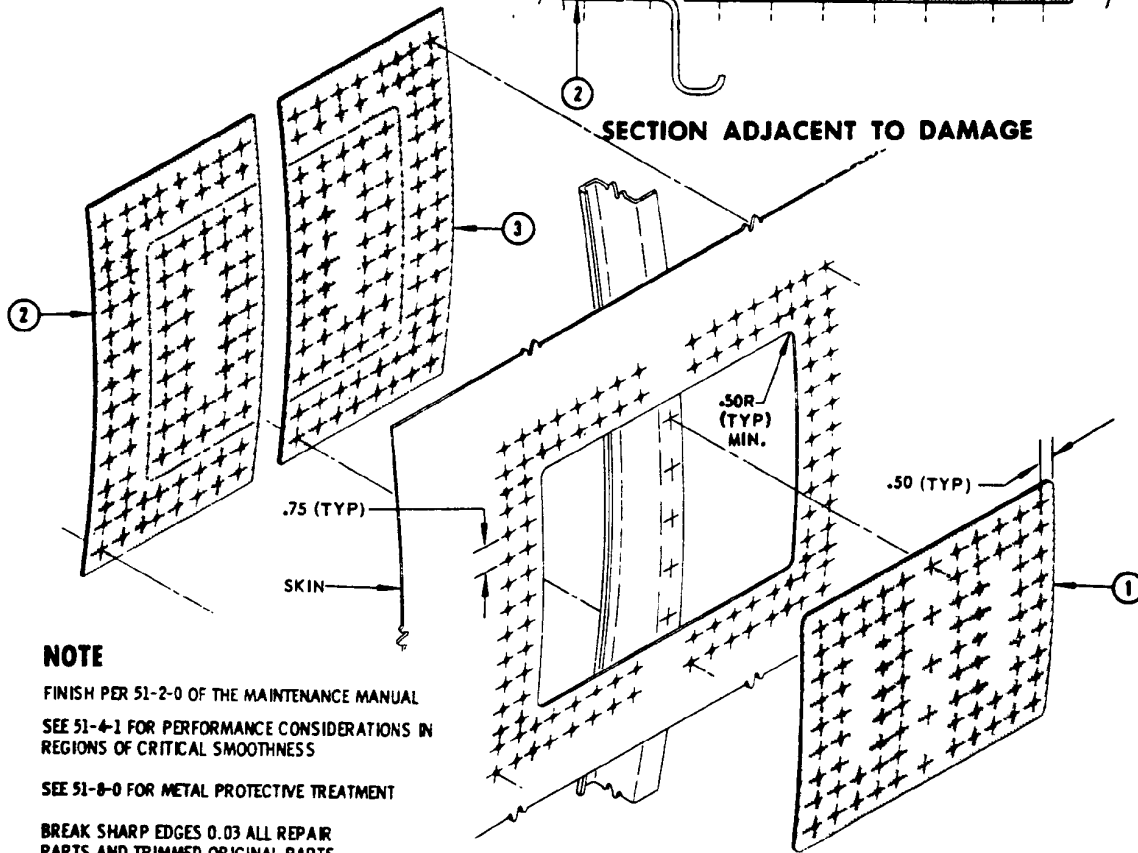
STRUCTURAL REPAIR

REPAIR MATERIAL			
PART	QTY.	MATERIAL	
①	1	A	B
②	1	A	B
③	1	A	B

BEAM AN427M-4 FOR TITANIUM SKIN
 XFMN BAC-R15CE-4D FOR ALUMINUM SKIN
 BEAM AN426D-4 OPTIONAL



SECTION ADJACENT TO DAMAGE



NOTE

FINISH PER 51-2-0 OF THE MAINTENANCE MANUAL
 SEE 51-4-1 FOR PERFORMANCE CONSIDERATIONS IN REGIONS OF CRITICAL SMOOTHNESS

SEE 51-8-0 FOR METAL PROTECTIVE TREATMENT

BREAK SHARP EDGES 0.03 ALL REPAIR PARTS AND TRIMMED ORIGINAL PARTS

SEE 51-2-0 FOR FASTENER CODE, REMOVAL AND INSTALLATION, HOLE SIZES AND EDGE MARGINS.

APPLY SKYDROL RESISTANCE FINISH PER 51-2-0 OF THE MAINTENANCE MANUAL

- ✦ ORIGINAL FASTENER LOCATIONS
- ◆ REPAIR FASTENER LOCATIONS

A SAME MATERIAL AND GAGE AS ORIGINAL SKIN OR SKIN PLUS DOUBLER IF DAMAGE OCCURS IN ALUMINUM ALLOY PORTION OF SKIN.

B USE CORROSION RESISTANT STEEL TYPE 302 ANNEALED WITH SAME GAGE AS ORIGINAL SKIN OR SKIN PLUS DOUBLER IF DAMAGE OCCURS IN TITANIUM ALLOY PORTION OF SKIN


REPAIR INSTRUCTIONS:

1. Trim the damaged skin to form a rectangular shape.
 NOTE: Do not cut the frame member.
 Remove all burrs, nicks, scratches or sharp edges from damage area.
2. Alodize aluminum parts.
3. Apply Skydrol resistant faying surface finish
4. Install repair parts.
5. Apply a Skydrol resistant finish to the repaired area

Nacelle Side Panel Skin at Frame - Flush Repair
 Figure 3

Jan 5/70

54-3-2

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	Spec. : ELECTRICIAN	Release Date: 05.12.2007	Page 7 of 8	

DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.

MAINT **RII/INSP**

Modification/Inspection Order

From ESEC To: Sabena LM Cc: LIBRARY	File: DFW B707-23-501
	Aircraft/Component: all TCA
	Subject: Nacelle interphone jack removal
Accepted:	Ref.:
Schedule:	Annex:


Return this form to ESEC if the work described has been completed.
Fax: +49 (0) 8459 - 8165853

Aircraft	Performed
LX19999	yes / no
LX20000	yes / no
LX20199	yes / no

Spare Engine nose cowl P/N 65-41416-1	Performed
RR166	yes / no
TCA1	yes / no
TCA11	yes / no
TCA15	yes / no

Responsible System Engineer:

Remarks from Performing Dept:	Remarks from Q.A. Dept:		
	Inspection	Yes <input type="checkbox"/>	No <input type="checkbox"/>
	Modification	Yes <input type="checkbox"/>	No <input type="checkbox"/>
	Repair	Yes <input type="checkbox"/>	No <input type="checkbox"/>
	Revision of SB C/W:		
Date:	Signature:	Date:	Signature:

sabena B707	Module: GENERAL	A/C Reg :	Check :	
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DFW B707-23-501 rev 0 ENGINE NACELLE INTERPHONE JACKS Removal.

MAINT RII/INSP

Accomplishment Report

Subject: Inspection/ Removal of the Engine nose cowl nacelle P/N 65-41416-1 Interphone jack installation

Model: B707

Accomplished at (Tailnumber):

Date of Accomplishment:

Description of Deviations:

Findings:

Carry Overs:

SOR Statements:

Executed/performed by: Name: Signature: Date: SOR:	SOR Engineering Representative: Name: Signature: Date:	SOR Quality Assurance: Name: Signature: Date:
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