52

DOORS

LIST OF EFFECTIVE PAGES

CHAPTER	PAGE	DATE	CHAPTER	PAGE	DATE
52-LEP (BA)	1	SEP 04	52-40-00 (BA)	1	JUN 01
	2	JUN 01		2	JUN 01
52-TC (BA)	1	JUN 01	52-40-00 (BA)	201	JUN 01
	2	JUN 01		202	JUN 01
	3	JUN 01		203	JUN 01
	4	JUN 01		204	JUN 01
				205	JUN 01
52-00-00 (BA)	1	JUN 01		206	JUN 01
	2	JUN 01		207	JUN 01
				208	JUN 01
52-10-00 (BA)	1	JUN 01			
	2	JUN 01	52-40-00 (CA)	201	JUN 01
				202	JUN 01
52-10-00 (CA)	1	JUN 01		203	JUN 01
	2	JUN 01		204	JUN 01
52-10-00 (BA)	201	JUN 01			
	202	JUN 01			
	203	JUN 01			
	204	JUN 01			
	205	JUN 01			
	206	JUN 01			
52-10-00 (CA)	201	SEP 04			
	202	SEP 04			
	203	JUN 01			
	204	SEP 04			
	205	SEP 04			
	206	JUN 01			
	207	JUN 01			
	208	JUN 01			
52-30-00 (BA)	1	JUN 01			
	2	JUN 01			
	3	JUN 01			
	4	JUN 01			
52-30-00 (BA)	201	JUN 01			
	202	JUN 01			
	203	JUN 01			
	204	JUN 01			

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TABLE OF CONTENTS

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DOORS

DESCRIPTION AND OPERATION

1. GENERAL

Doors are removable items provided :

- for pilot and passengers to enter or exit the aircraft and for cargo loading and unloading,
- to shut off certain sections of the fuselage or the wings structure.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Access door	2	200	/	52-10-00
Cargo compartment door	1	200	/	52-30-00
Inspection door	/	/	/	52-40-00

3. DESCRIPTION

A. Access doors - refer to 52-10-00

Access doors enable the pilot and the passengers to enter and exit the aircraft.

Access doors are of the "gull-wing" type, they are located on both sides of the fuselage.

B. Cargo compartment door - refer to 52-30-00

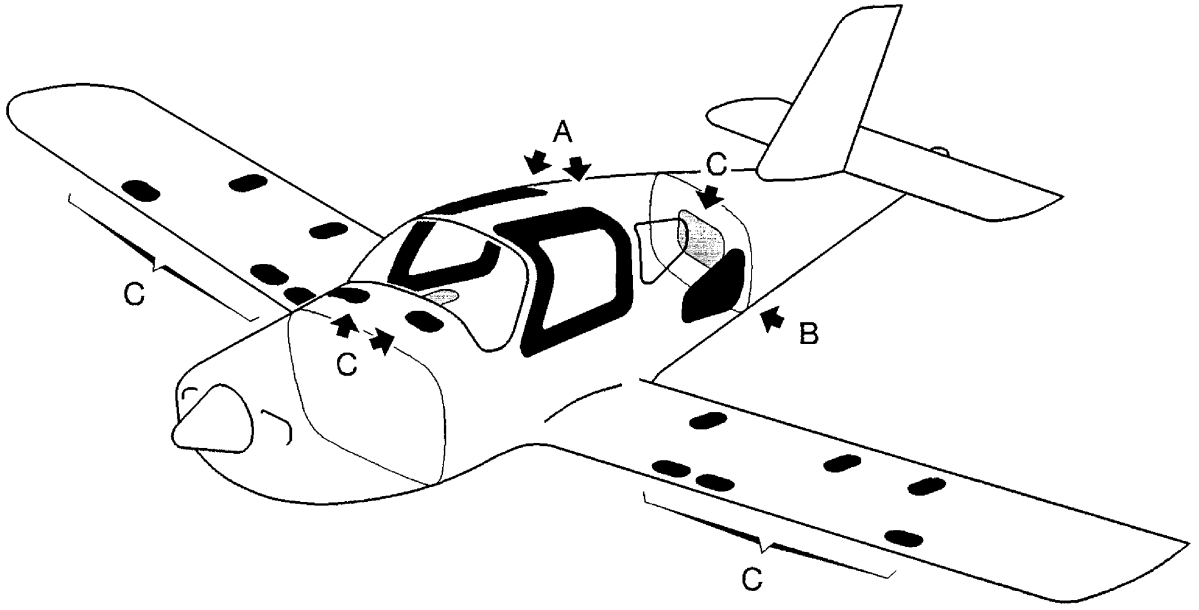
The cargo compartment door provides access to the cargo compartment from outside the aircraft.

C. Inspection doors - refer to 52-40-00

Inspection doors provide access to the aircraft systems and equipment.

There are two types of inspection doors : sealed inspection doors and non-sealed inspection doors.

A - Access doors
B - Cargo compartment door
C - Inspection doors



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Doors - Identification and location of components
Figure 1

ACCESS DOORS

DESCRIPTION AND OPERATION

1. GENERAL

Access doors allow the pilot and the passengers to enter and exit the aircraft. They also permit bulky cargo loading.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Access door	2	200	/	52-10-00

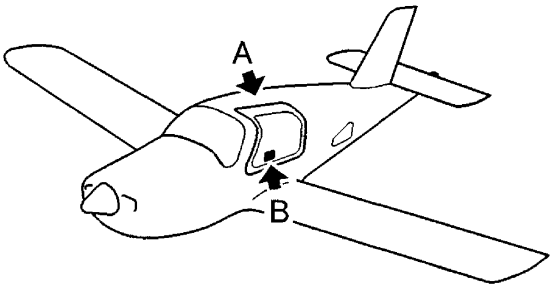
3. DESCRIPTION

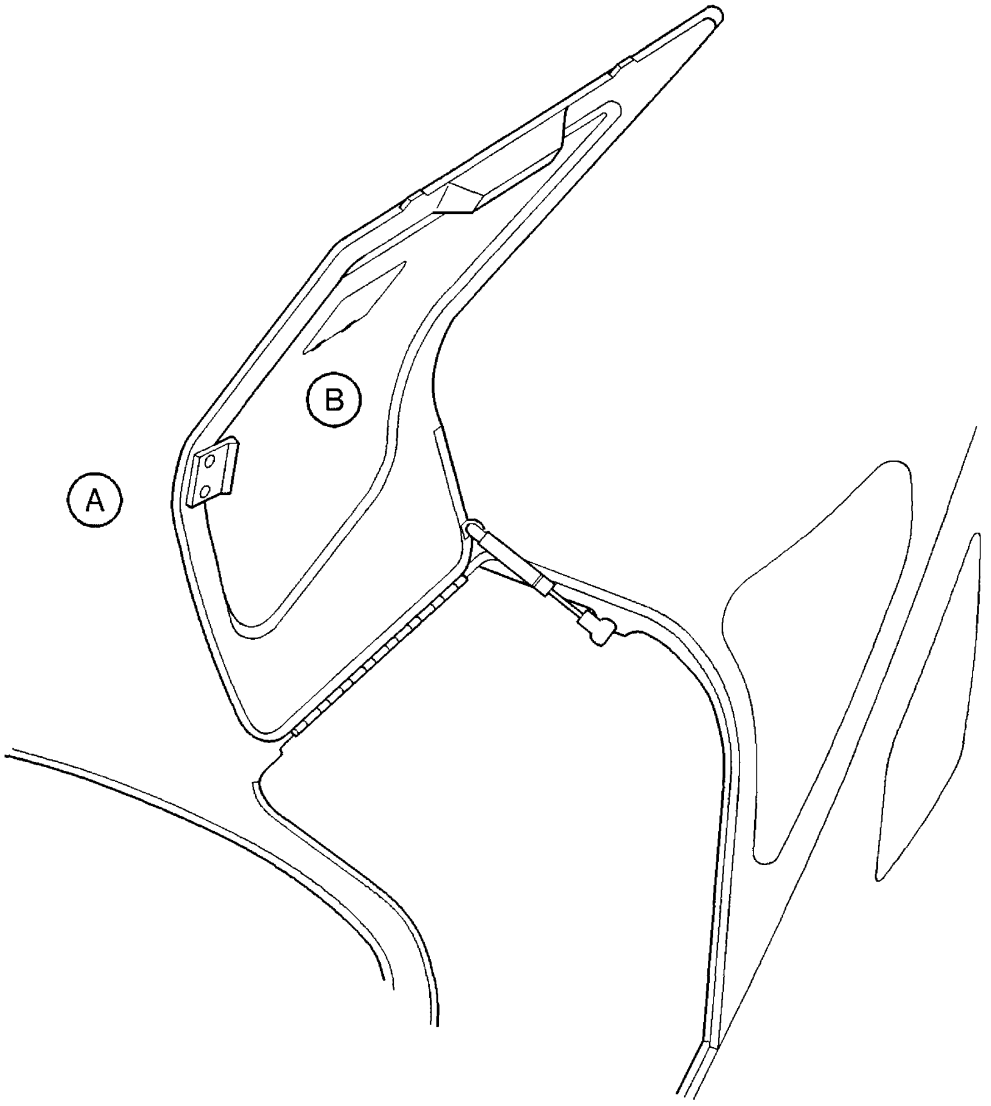
A. Access doors

The access doors are of the "gull-wing" type, they are located on both sides of the fuselage at cabin level. Entirely made of composite (S / N 1 - 274) or metallic (S / N 275 - 9999) materials, they are articulated around a hinge on the top of the fuselage. Opening and closing are slowed down by a compensating cylinder located on the rear part of the door. Closing is ensured by two hooks which lock onto two attachment rings controlled by a handle. This closing system is completed by a lock which locks the control handle when the aircraft is parked.

The access doors can be equipped with a little window.

A - Access door
B - Little window (if installed)





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Access door - Identification and location of components
Figure 1

ACCESS DOORS

DESCRIPTION AND OPERATION

1. GENERAL

Access doors allow the pilot and the passengers to enter and exit the aircraft. They also permit bulky cargo loading.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Access door	2	200	/	52-10-00

3. DESCRIPTION

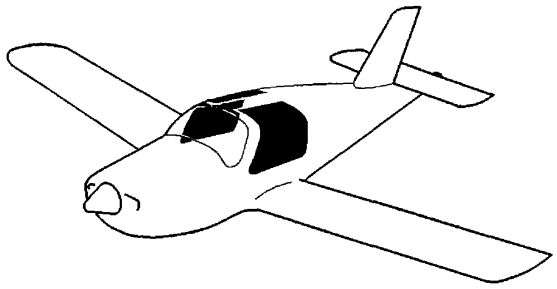
A. Access doors

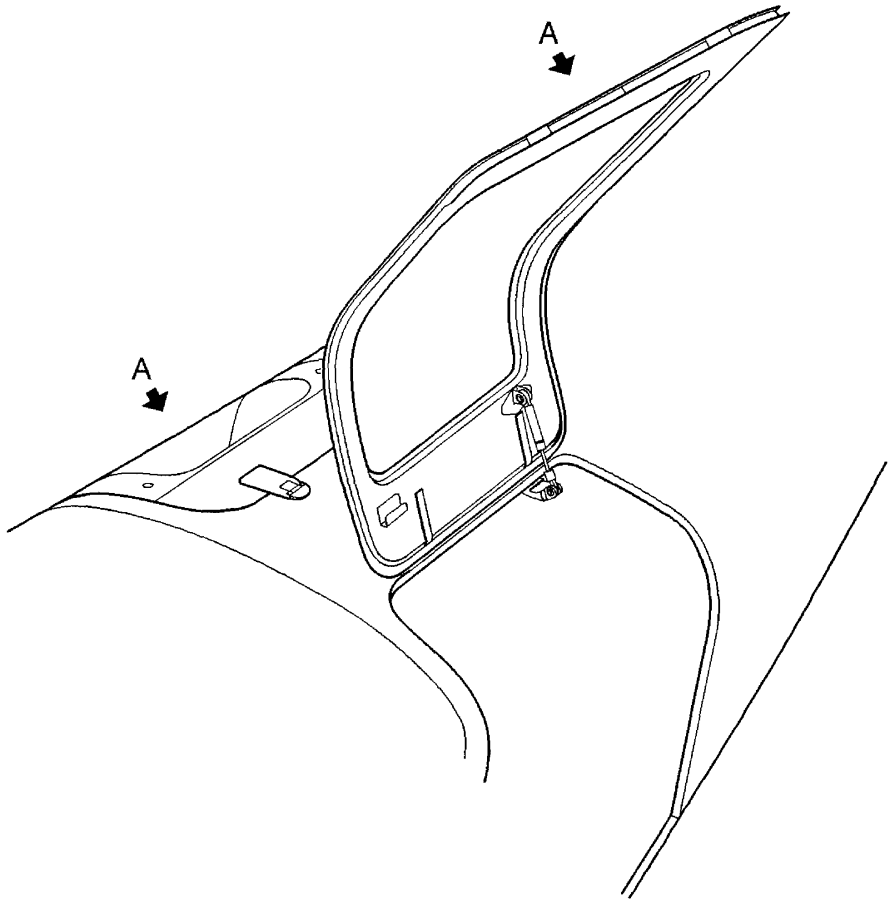
The access doors are of the "gull-wing" type, they are located on both sides of the fuselage at cabin level and are made of composite material. They are articulated around two hinges on top of the fuselage. Opening and closing are slowed down by a compensating cylinder secured at the rear of the door.

Closing is ensured by two hooks secured on the access door which lock onto the attachment rings of the door mechanism.

A safety system prevents the access door from folding down when the handle is in "Closed" position. A lock ensures the control handle locking when the aircraft is parked.

A - Access door





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Access doors - Identification and location of components
Figure 1

ACCESS DOORS

MAINTENANCE PRACTICES

1. SERVICING

None

2. REMOVAL / INSTALLATION - ACCESS DOOR (Figure 201)

A. Tools and consumable materials

- Sealant (TB 09-900) and (TB 09-909)
- Loctite (TB 08-013C)

B. Removal of the access door

1) Keep the door open, remove and discard retaining washer (3), remove pin (4).
2) Disconnect balancing rod (1) from the door.
3) Close the door to remove door hinge pin (2)
   a) Hinge pin safetied with a pin, remove the pin.
   b) Hinge pin with a knurled end. This end is identified by its center point - see Detail.
4) Using a pin drift or a pin of a diameter less than 0.197 in (5 mm), remove hinge pin (2) by pushing on the plain end while holding the door.
5) Clear the door.

C. Installation of the access door

1) Position the door locking handles to "CLOSED".
2) Tighten adjustment screw (11) until the screw head is flush with hook (5).
3) Position the door in the hinge secured to the upper fuselage panel.

   CAUTION : EXERCISE CARE TO AVOID DAMAGING THE HOOKS LOCATED AT THE BOTTOM OF THE DOOR

4) Engage hinge pin (2), plain end first, proceeding from the front, until it is flush with the hinge.

   NOTE : The knurled end of the hinge pin must be directed towards aircraft nose.

5) Lift the door and hold it in position.
6) Install balancing rod (1).
7) Insert pin (4) and a new retaining washer (3).
8) Fold down the door to check the gap required all around the door : no less than 0.08 in (2 mm). Adjust if necessary.
9) Touch up paint as required.
10) Bond the door seal.

    NOTE : If the door has been replaced, a new upper fuselage panel seal must be installed.

11) After touching up paint, coat the external periphery of the window with a bead of sealant (TB 09-900) or (TB 09-909).

12) Adjust hook (5) - refer to Paragraph 3.

3. ADJUSTMENT / TEST - ACCESS DOOR (Figure 201)

A. Tools and consumable materials

None

B. Adjustment of access door

1) Tension adjustment of doors is achieved at screws (6) by adding or removing washers (7).

2) Adjustment of hook (5) is performed by means of adjustment screw (11).

NOTE : The hook centerline must be at equal distances from stop (10) and ring (8).

a) An adjustment of the hook must be systematically performed after an adjustment of the door tension.

b) If adjustment screw (11) is not self-locked (polyamide plastic deposit), safety it with Loctite (TB 08-013C) after each adjustment.

4. INSPECTION / CHECK - ACCESS DOOR (Figure 202)

A. Tools and consumable materials

None

B. Inspection / check of stop adjustment

1) If the door bottom, when the door is locked, is not misaligned with the cabin spar, adjustment is correct. Do not modify.

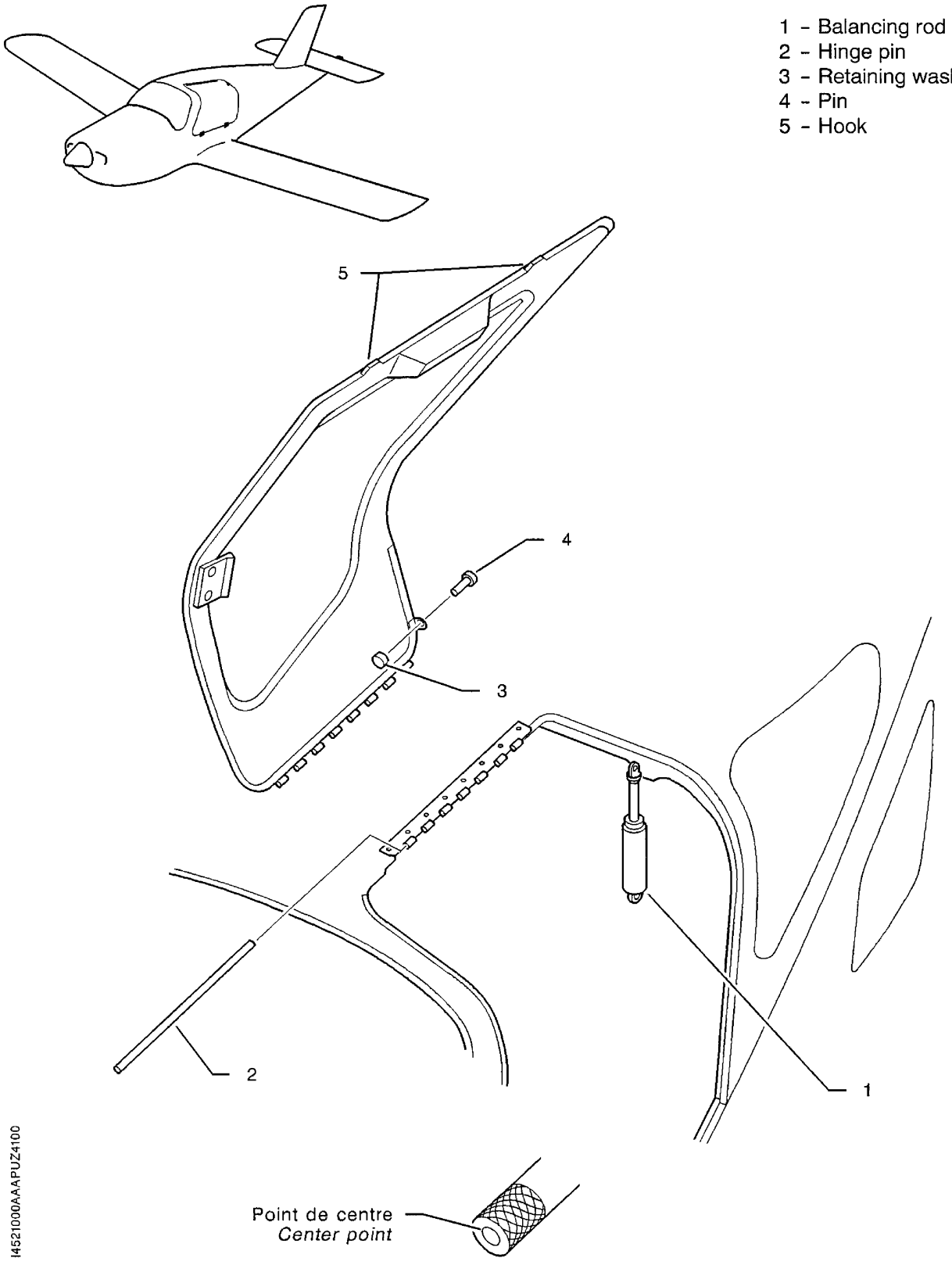
2) If a deviation greater than 0.06 in (1.5 mm) (external deviation) or greater than 0.02 in (0.5 mm) (internal deviation) is found, proceed as follows :

a) Loosen the screws securing the stop.

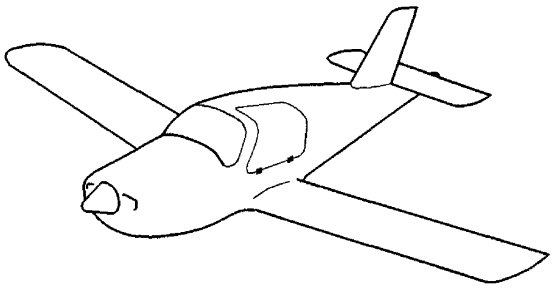
b) Move the stop towards the aircraft centerline until full alignment is obtained.

c) Tighten the screws.

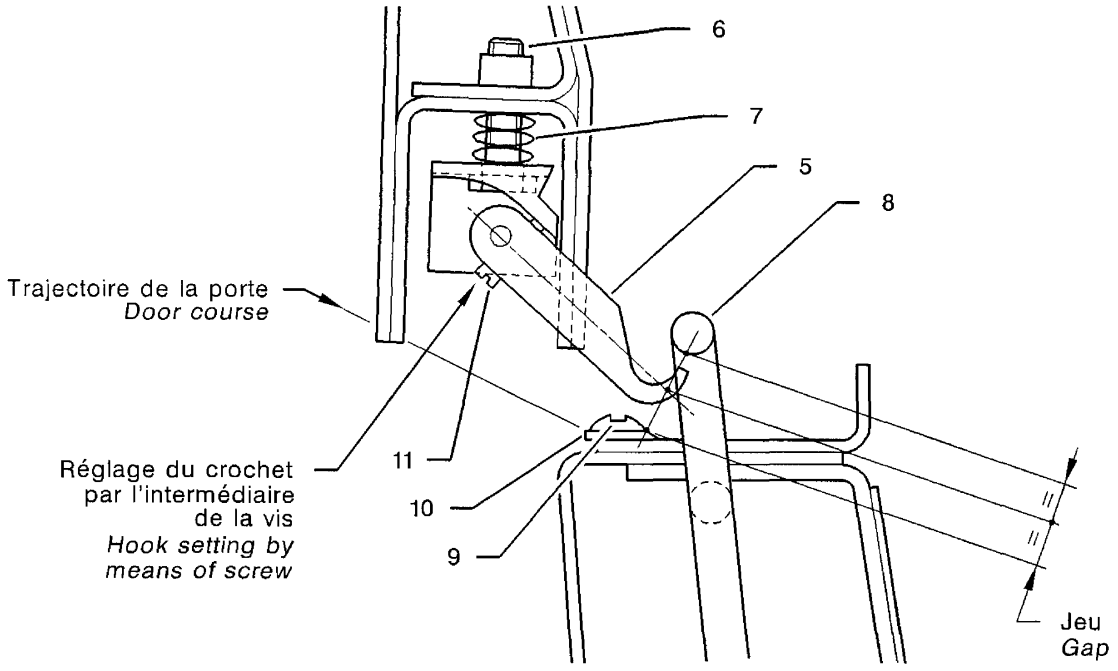
NOTE : The deviation value must be measured at points A, B, ...I.

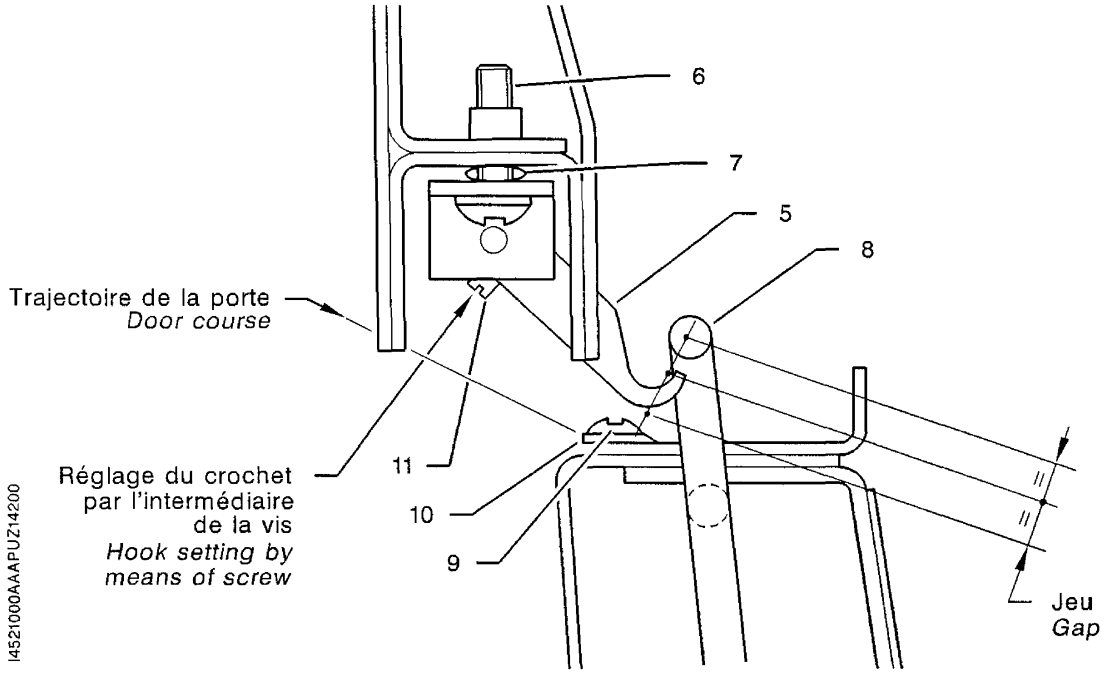


Access doors - Removal / Installation
Figure 201 (1/2)



5 - Hook
6 - Screw
7 - Washer
8 - Ring
9 - Screw
10 - Stop
11 - Adjustment screw





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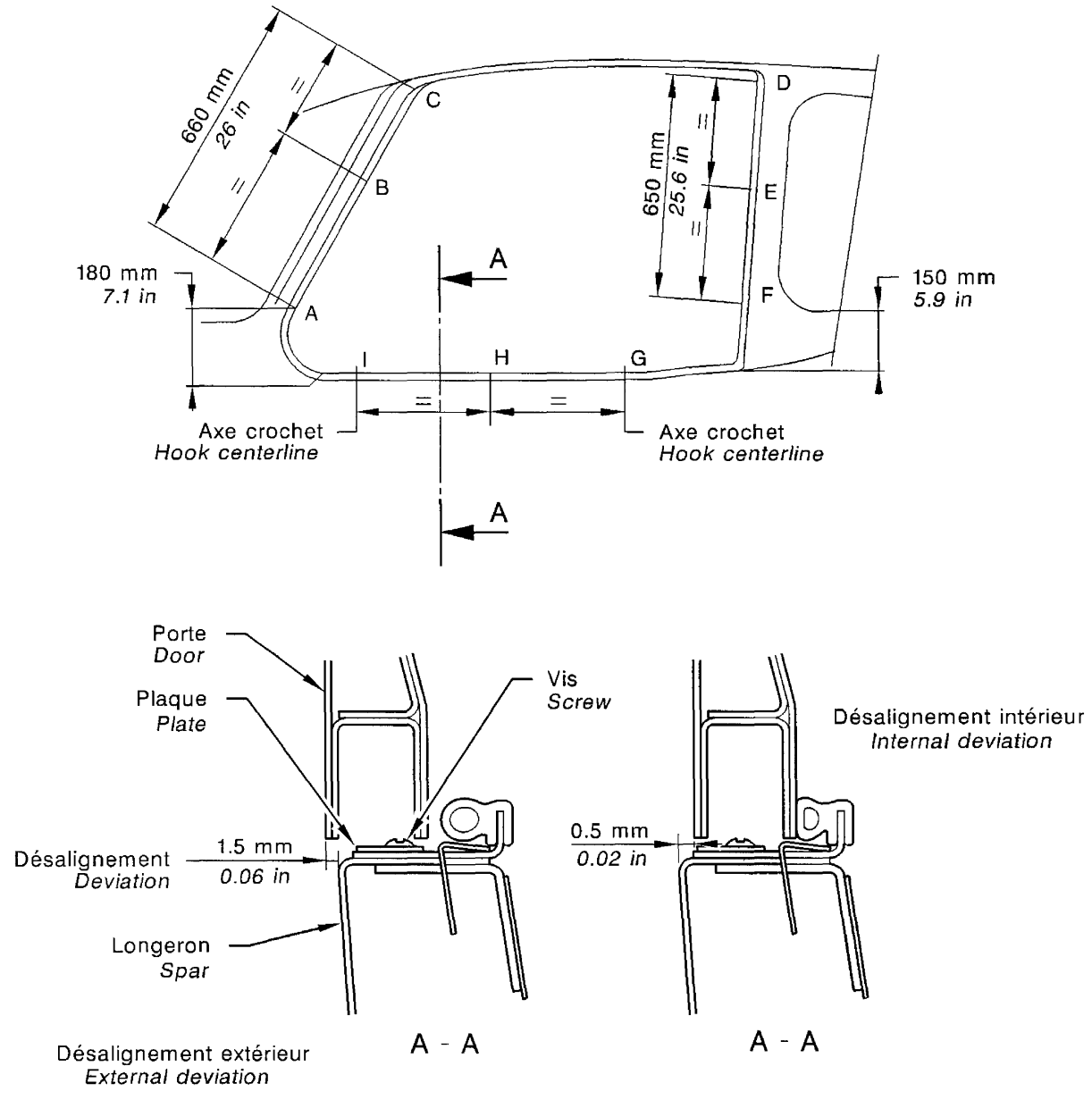
Access doors - Removal / installation
Figure 201 (2/2)



Access doors - Check
Figure 202

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ACCESS DOORS

MAINTENANCE PRACTICES

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. SERVICING

None

2. REMOVAL / INSTALLATION - ACCESS DOOR (Figure 201)

A. Tools and consumable materials

- Grease (TB 04-004A)
- Cleaning agent (TB 11-003)
- Clean, lintfree cloths

B. Removal of the access door

1) Hold access door (22) [23] open, remove and discard washer (9), remove pin (10).
2) Disconnect gas strut (8).
3) Close access door (22) [23]. Remove protective caps (11), remove and discard nuts (12), retain the fitting and, if installed, shim (30).
4) Remove screws (21) and washers (20).
5) Remove door (22) [23] and remove adjustment shims (18).
6) If necessary, remove gas strut (8)
   a) Remove the upholstery panel of access door (22) [23].
   b) Remove and discard washer (7) and remove pin (6).
   c) Remove gas strut (8).
7) If necessary, remove and disassemble the hinge fittings
   a) Remove screws (16) and (15). Remove the hinge fittings.
   b) Remove hinge pin (17) and remove door fitting (14) and upper fuselage panel fitting (19).
8) If necessary, remove hook (4) assy
   a) Remove screws (3) and washers (2).
   b) Remove hook (4) assy and retain washers (1).

C. Installation of the access door

1) Inspect parts for condition, replace as required.
2) Clean the parts with clean, lintfree cloths moistened with cleaning agent (TB 11-003).
3) If removed, install hook (4) assy
   a) Assemble screws (3), washers (2), hook (4) and washers (1).

b) Secure hook assy onto access door (22) [23]. Tighten - refer to 20-00-01.

4) If removed, assemble and secure the hinge fittings

a) Lubricate hinge pin (17) with grease (TB 04-004A).

b) Assemble door fitting (14) and upper fuselage panel fitting (19) using hinge pin (17). For front hinge fitting, the knurled section of the hinge pin must be located at the front. For rear hinge fitting, the knurled section of the hinge pin must be located at the rear.

c) Secure the hinge fittings onto access door (22) [23] with screws (16) and (15). Tighten - refer to 20-00-01.

5) If removed, secure gas strut (8) onto access door (22) [23] with pin (6) and washer (7). Install the upholstery panel of access door (22) [23].

6) Position door handles to "CLOSED".

7) Screw adjustment screw (5) until screw head is flush with hook (4).

CAUTION : EXERCISE CARE TO AVOID DAMAGING THE HOOKS LOCATED AT THE BOTTOM OF THE DOOR.

8) Install access door (22) [23] and install adjustment shims (18).

9) Install washers (20) and screws (21).

NOTE : Washers (20) have three different shapes to achieve door adjustment.

10) Install shim (30) if installed, the fitting and nuts (12). Tighten - refer to 20-00-01. Install protective caps (11).

11) Make sure access door (22) [23] is flush with upper fuselage and check that the clearance between the upper fuselage and the door is at least 0.12 in (3 mm). Adjust if necessary - refer to Paragraph 3.

12) Open access door (22) [23], secure gas strut (8) with pin (10) and washer (9). Install the upholstery panel of access door (22) [23].

13) Make sure all the tools and materials are removed and the work area is clean and free from debris.

14) Adjust the closing hooks - refer to Paragraph 3.

15) Touch up paint as required - refer to 20-00-03.

16) If the door has been replaced, a new upper fuselage panel seal must be installed.

17) Lubricate access door (22) [23] - refer to 12-20-01.

3. ADJUSTMENT / TEST - ACCESS DOOR (Figure 201)

A. Tools and consumable materials

- Loctite (TB 08-013C)

B. Adjustment of access door

1) The adjustment of access door (22) [23] height is achieved by removing or adding adjustment shims (18).

2) The adjustment of access door (22) [23] clearance must be carried out by replacing washers (20).

3) The adjustment of access door (22) [23] tension must be carried out by means of screws (3) by adding or removing washers (1).

4) The adjustment of hook (4) is achieved via adjustment screw (5).

NOTE : The hook centerline must be at equal distances from stop (26) and ring (24).

a) The hook must be systematically re-adjusted each time the tension of access door (22) [23] is adjusted.

b) If adjustment screw (5) is not self-locked (polyamide plastic deposit), safety it with Loctite (TB 08-013C) after each adjustment.

4. INSPECTION / CHECK - ACCESS DOOR (Figure 202)

A. Tools and consumable materials

None

B. Inspection / check of stop adjustment

1) If the door bottom, when the door is locked, is not misaligned with the cabin spar, adjustment is correct. Do not modify.

2) If a deviation greater than 0.06 in (1.5 mm) (external deviation) or greater than 0.02 in (0.5 mm) (internal deviation) is found, proceed as follows :

a) Loosen the screws securing the stop.

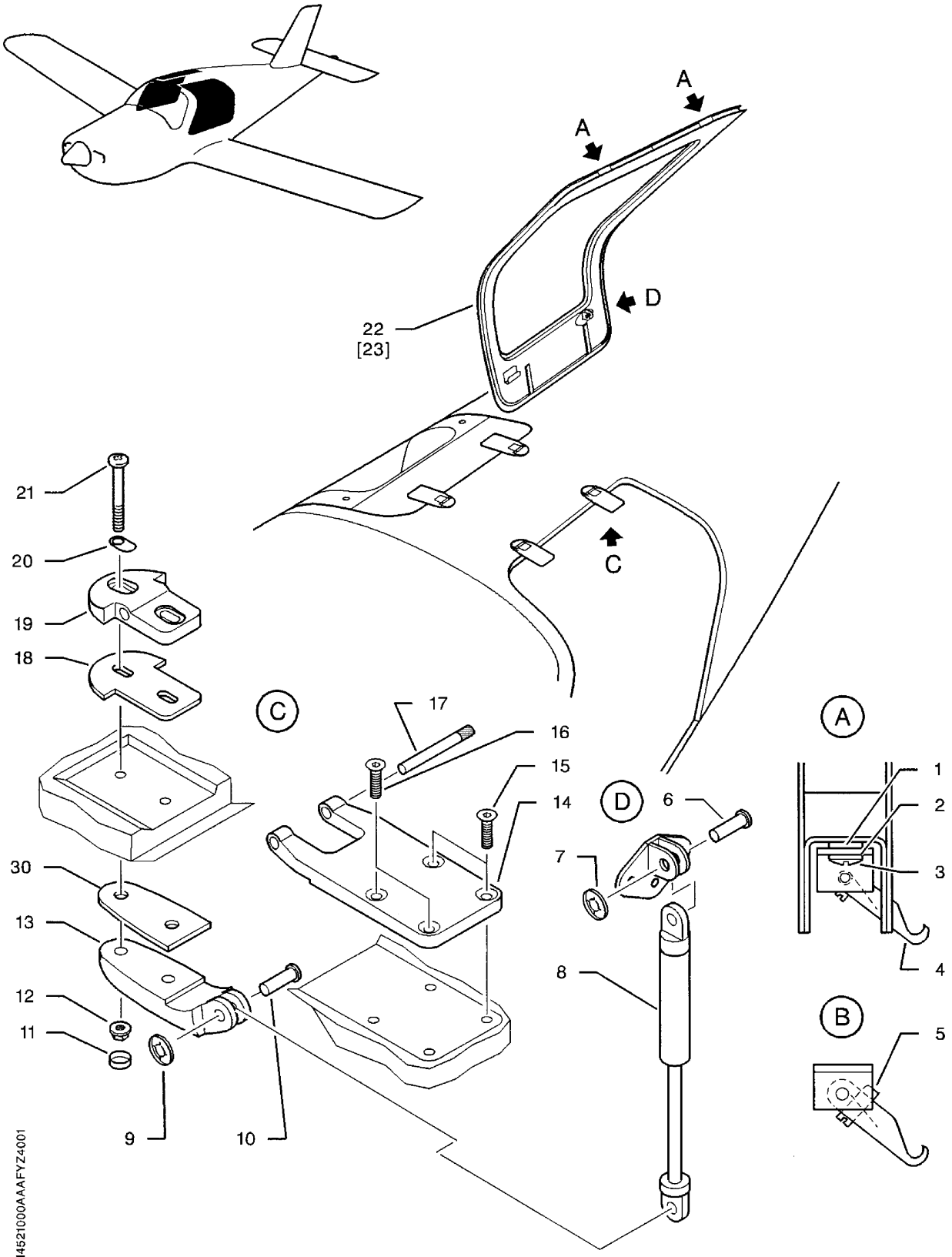
b) Move the stop towards the aircraft centerline until full alignment is obtained.

c) Tighten the screws.

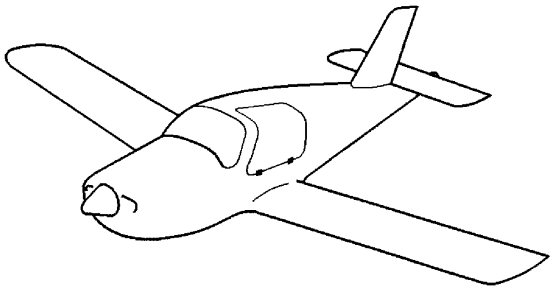
NOTE : The deviation value must be measured at points A, B, ...I.

1 - Washer
2 - Washer
3 - Screw
4 - Hook
5 - Adjustment screw
6 - Pin
7 - Washer
8 - Gas strut
9 - Washer
10 - Pin
11 - Protective cap
12 - Nut
13 - Fitting
14 - Door fitting
15 - Screw
16 - Screw
17 - Hinge pin
18 - Adjustment shim
19 - Upper fuselage panel fitting
20 - Washer
21 - Screw
22 - L.H. access door
23 - R.H. access door
30 - Shim

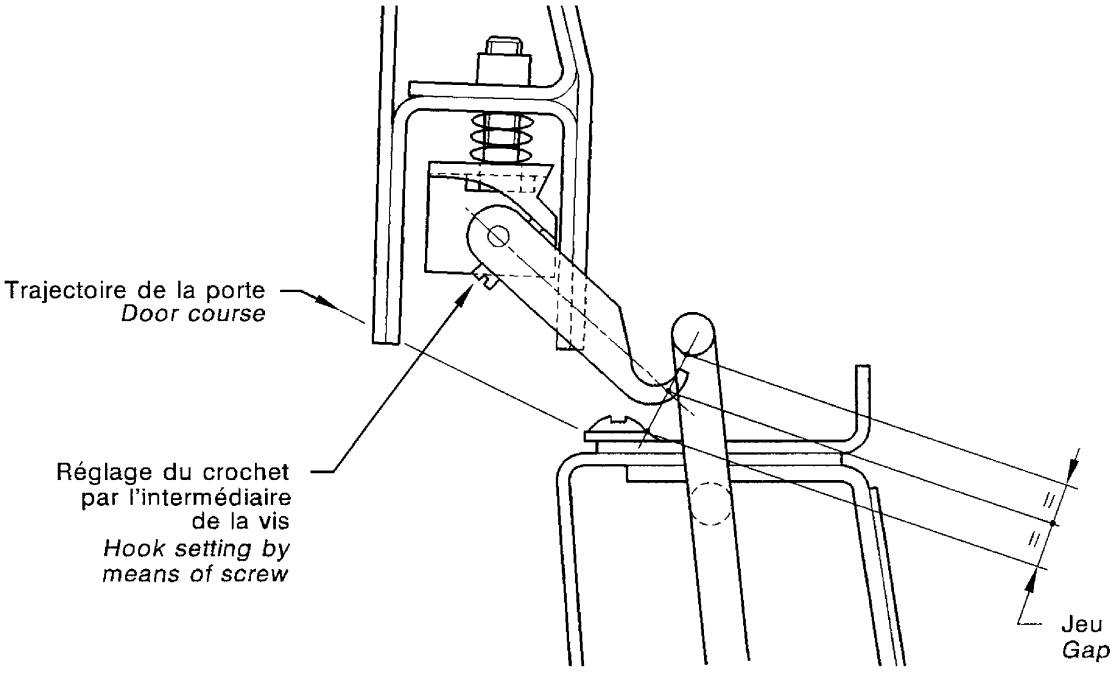
Access doors - Removal / Installation
Key to Figure 201

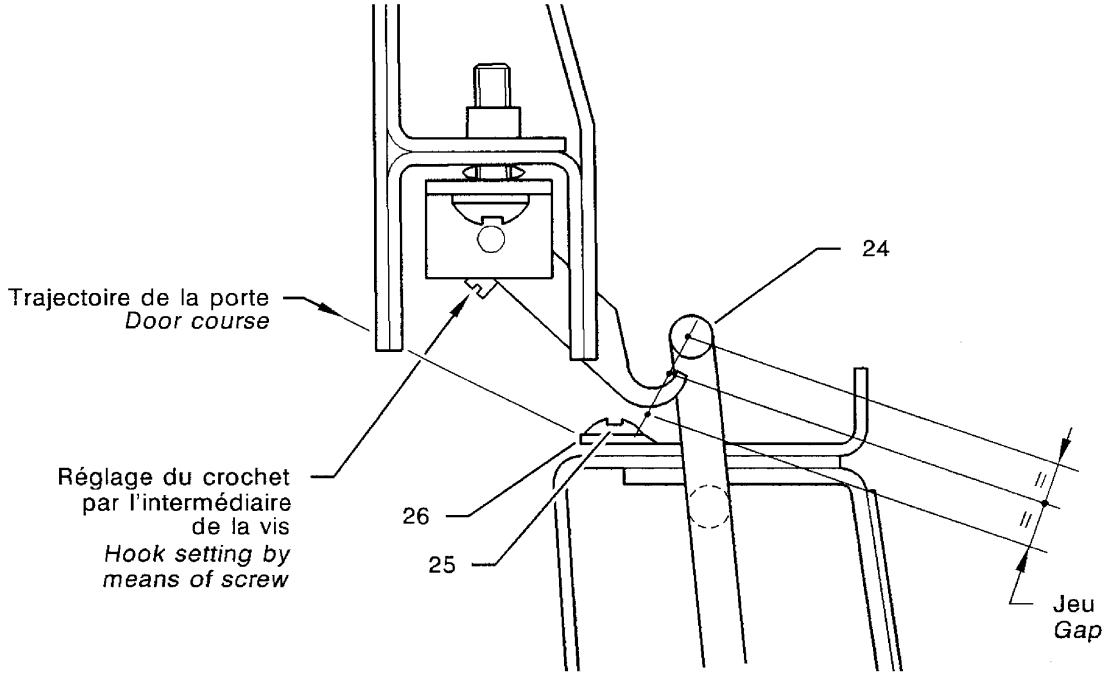


Access doors - Removal / Installation
Figure 201 (1/2)



24 - Ring
25 - Screw
26 - Stop





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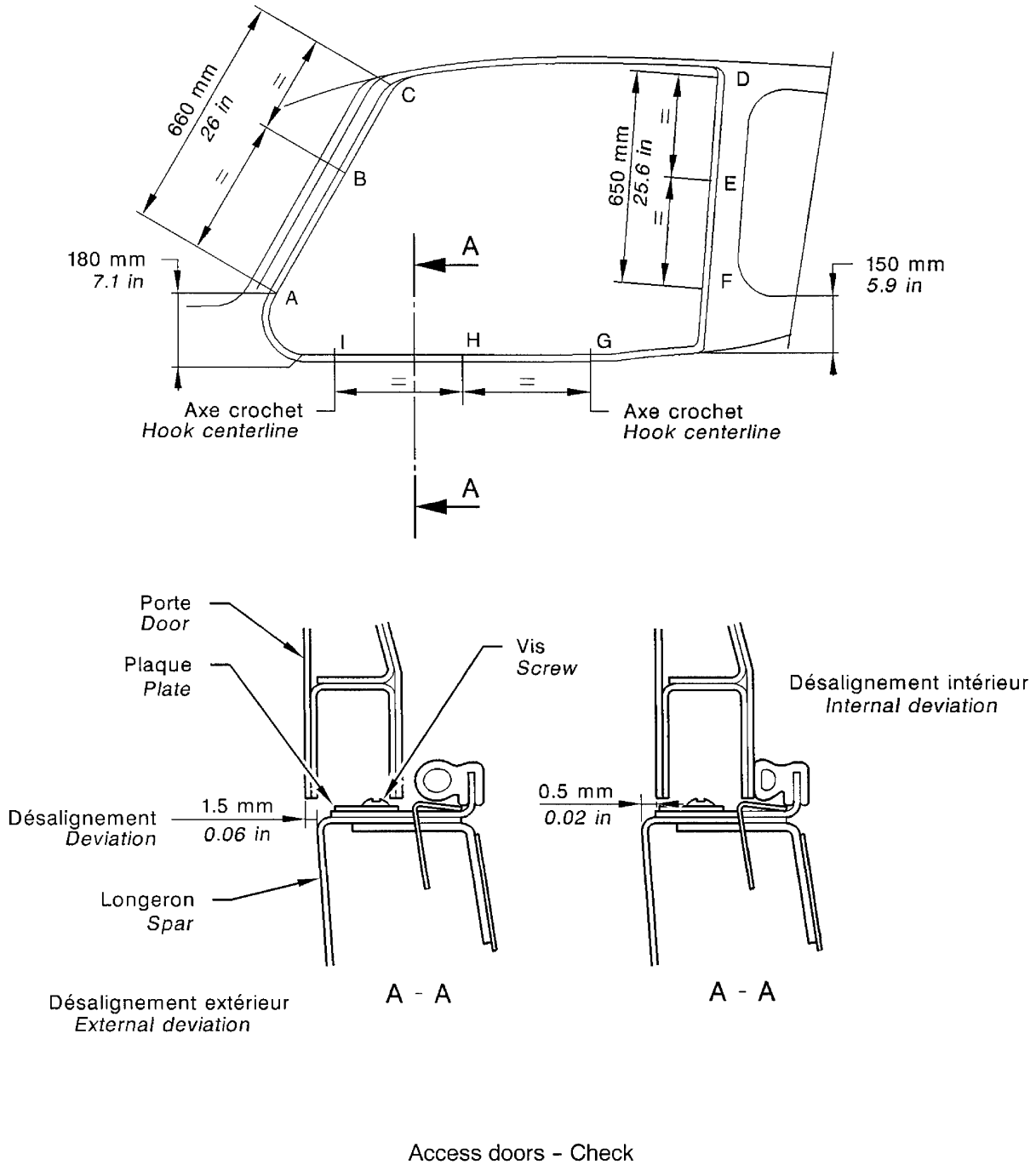
Access doors - Removal / Installation
Figure 201 (2/2)



Access doors - Check
Figure 202

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CARGO COMPARTMENT DOOR

DESCRIPTION AND OPERATION

1. GENERAL

The cargo compartment door enables the pilot and the passengers to access the cargo compartment from outside the aircraft.

During aircraft maintenance operations, it also provides access to the inside of the rear fuselage.

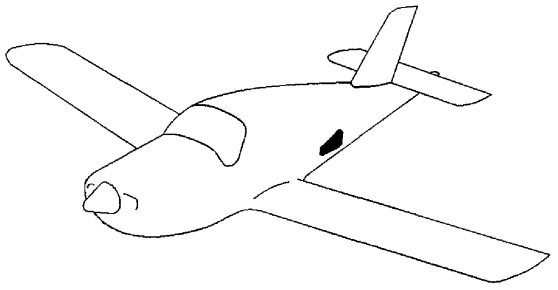
2. LOCATION (Figures 1 and 1A)

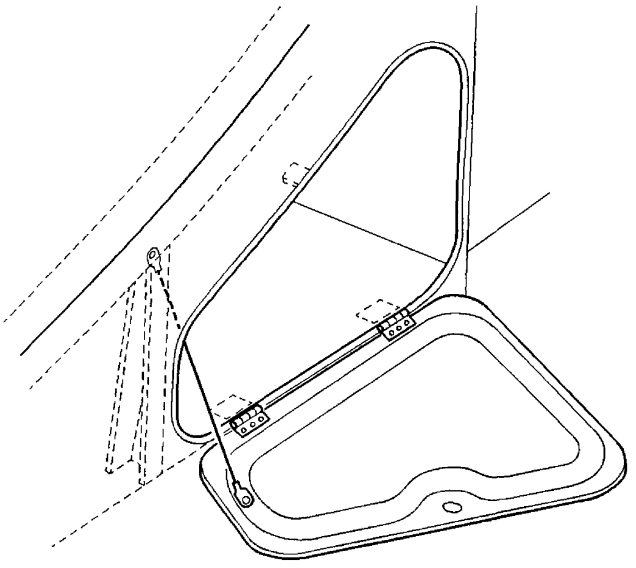
COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Cargo compartment door	1	200	/	52-30-00

3. DESCRIPTION

A. Cargo compartment door

The cargo compartment door is located at the rear of the cabin on the L.H. side of the fuselage. Entirely metallic, it is articulated on two hinges located at the bottom of the door. Closing is ensured by a locking pin actuated by a lock.





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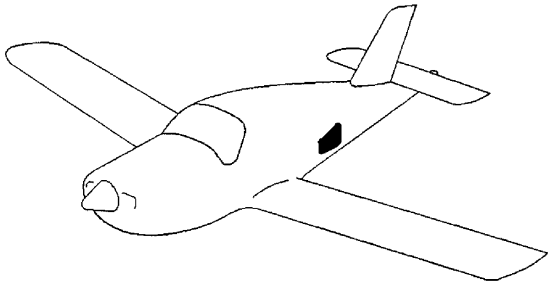
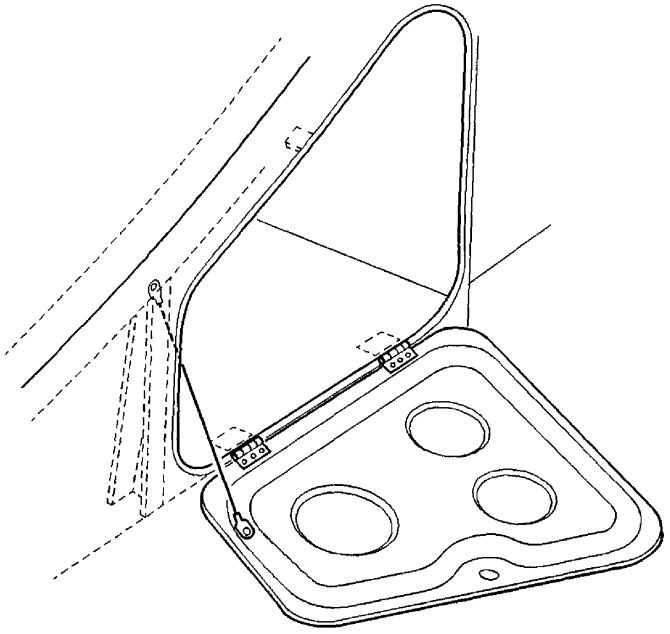
Cargo compartment door - Identification and location of components
Figure 1 - Pre-MOD. 151





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Cargo compartment door - Identification and location of components
Figure 1A - Post-MOD. 151

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CARGO COMPARTMENT DOOR

MAINTENANCE PRACTICES

1. SERVICING

None

2. REMOVAL / INSTALLATION - CARGO COMPARTMENT DOOR (Figure 201)

A. Tools and consumable materials

- Loctite (TB 08-013C)
- Cleaning agent (TB 11-003)
- Clean, lintfree cloths

B. Removal of the cargo compartment door

1) Remove the rear bench - refer to 25-12-00.
2) Remove L.H. side upholstery panel.
3) Remove seal (1) of the cargo compartment door.
4) Remove and discard nut (6), remove washer (5), bolt (4) and door retaining strap (3).
5) Push inwards front hinge pin stop (12) of rear and front hinges.
6) Hold cargo compartment door (2) and remove hinge pins (13) of front and rear hinges.
7) Remove cargo compartment door (2).
8) If necessary, remove lock (11)
   a) Remove nut (7), washer (8) and locking pin (9).
   b) Remove nut (10) and remove lock (11).

C. Installation of the cargo compartment door

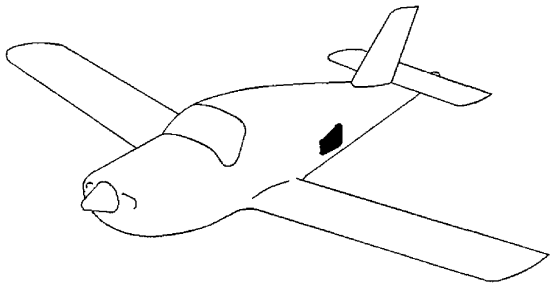
1) Inspect parts for condition, replace as required.
2) Clean parts with clean, lintfree cloths moistened with cleaning agent (TB 11-003).
3) If removed, install lock (11)
   a) Install lock (11), install and lock nut (10) with Loctite (TB 08-013C).
   b) Install locking pin (9) and washer (8).
   c) Install and lock nut (7) with Loctite (TB 08-013C).
4) Install cargo compartment door (2), install hinge pins (13) of front and rear hinges.
5) Position front hinge pin stop (12) of front and rear hinges.
6) Secure door retaining strap (3) with bolt (4), washer (5) and nut (6).
7) Touch up paint as required - refer to 20-00-03.
8) Install seal (1) of cargo compartment door.
9) Lubricate the door mechanism - refer to 12-21-02.

10) Make sure the cargo compartment door closes correctly.

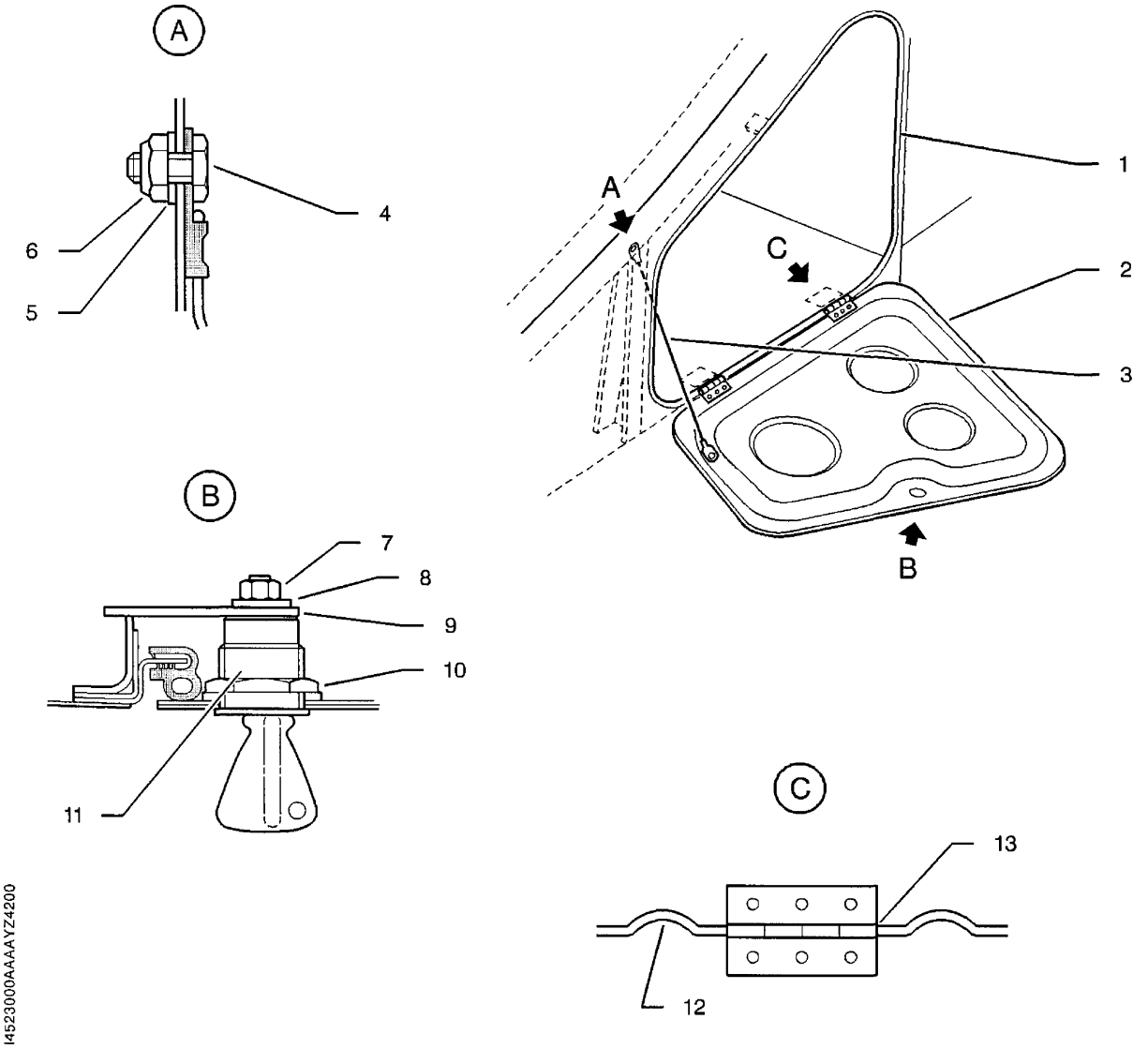
11) Make sure all the tools and materials are removed and the work area is clean and free from debris.

12) Install L.H. side upholstery panel.

13) Install the rear bench - refer to 25-12-00.



1 - Seal
2 - Cargo compartment door
3 - Door retaining strap
4 - Bolt
5 - Washer
6 - Nut
7 - Nut
8 - Washer
9 - Locking pin
10 - Nut
11 - Lock
12 - Front hinge pin stop
13 - Hinge pin



Cargo compartment door - Removal / Installation
Figure 201

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INSPECTION DOORS

DESCRIPTION AND OPERATION

1. GENERAL (Figure 1)

Inspection doors are mainly used to gain access to the aircraft systems and equipment and to ease access for maintenance.

NOTE : The location of the inspection doors is described in Chapter 06-30-00.

The main divisions of this section are :

- Sealed inspection doors,
- Non-sealed inspection doors.

2. DESCRIPTION

A. Sealed inspection door

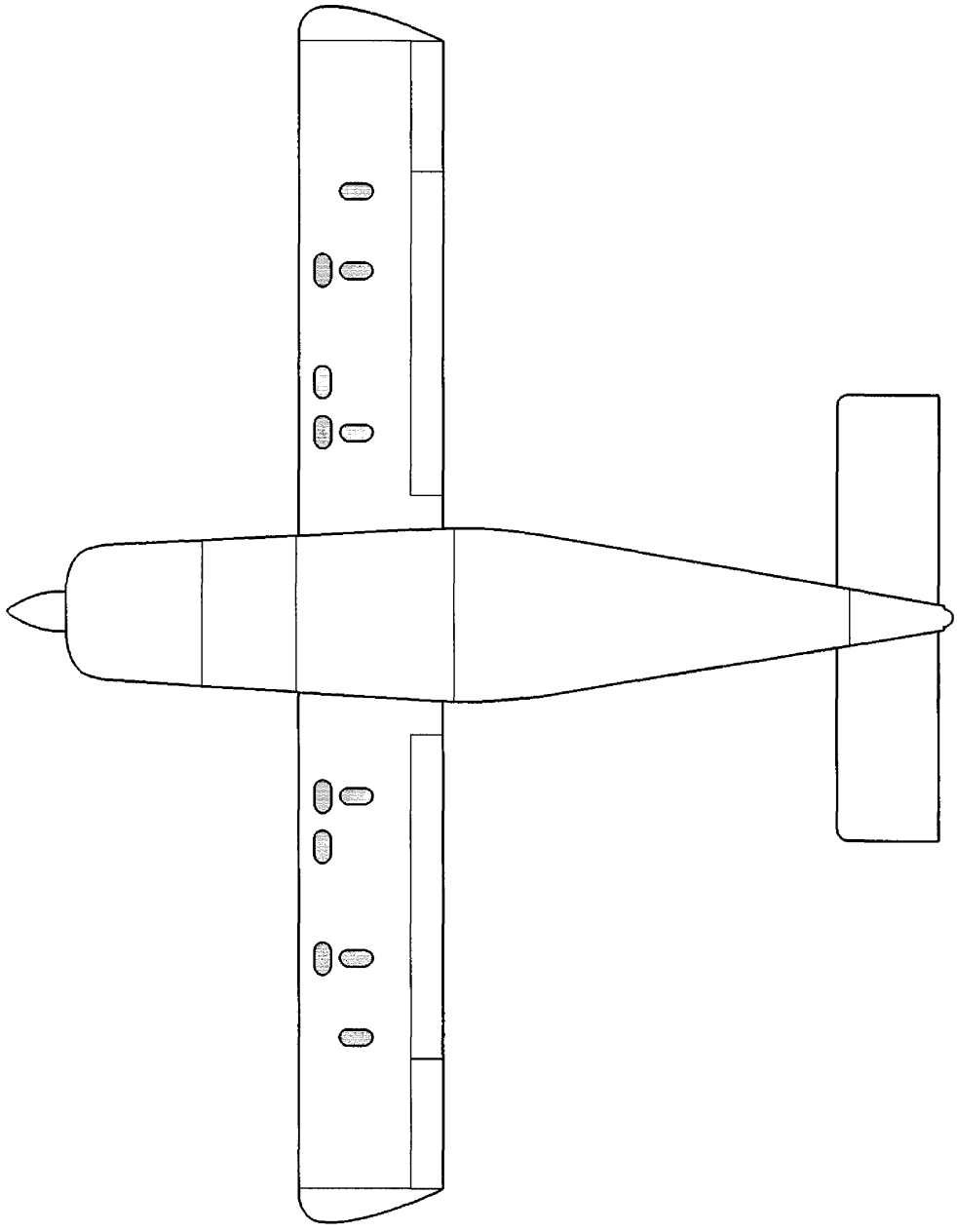
Sealed inspection doors are used to shut off access to sealed compartments of the fuel tanks. Located on wing lower surface, they are entirely metallic and are secured by means of sealed nuts.

There are two types of sealed inspection doors :

- sealed inspection doors with built-in seals,
- sealed inspection doors (sealing is ensured by means of sealant).

B. Non-sealed inspection door

Non-sealed inspection doors are used to shut off access to non-sealed compartments of the structure. They can be either metallic or of composite materials, depending on their location.



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Inspection doors
Figure 1

INSPECTION DOORS

MAINTENANCE PRACTICES

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. SERVICING

None

2. REMOVAL / INSTALLATION - INSPECTION DOORS

A. Tools and consumable materials

- Clean, lintfree cloths
- Cleaning agent (TB 11-003)
- Cleaning agent (TB 11-914)
- Sealant (TB 09-019A)
- Loctite (TB 08-013C)

B. Removal of a fuel tank sealed inspection door (Figures 201 and 201A)

WARNING : OBEY THE SAFETY PRECAUTIONS DESCRIBED IN 28-00-00.

WARNING : APPLY THE FUEL TANKS MAINTENANCE PROCEDURE - REFER TO 28-00-00 PAGE 200.

1) Drain the fuel tanks - refer to 12-11-02.

2) Identify and mark the sealed inspection door (3) to be removed.

NOTE : Aircraft S / N 823 - 849 and 888 : the portion of the fuel tank sealed inspection door coated with sealant is directed towards the wing root.

3) Remove screws (4) securing sealed inspection door (3) to wing lower surface.

4) Using a thin blade, separate sealed inspection door (3) from skin (5).

CAUTION : EXERCISE CARE TO AVOID DAMAGING THE FUEL LEVEL GAGE DURING INSPECTION DOOR REMOVAL.

5) Tilt sealed inspection door (3) to remove it from the tank.

C. Installation of a fuel tank sealed inspection door (Figures 201, 201A and 202)

WARNING : OBEY THE SAFETY PRECAUTIONS DESCRIBED IN 28-00-00.

WARNING : APPLY THE FUEL TANKS MAINTENANCE PROCEDURE - REFER TO 28-00-00 PAGE 200.

1) Remove the sealant from the seating surface of sealed inspection door (3) in the tank. Remove any sealant particles from inside the tank.

2) Remove sealant from sealed inspection door (3) and clean the seating surface of sealed inspection door (3) with cleaning agent (TB 11-914).

3) Make sure the threads of nuts (1) are free from sealant. Check nuts (1) for correct crimping, replace if necessary - refer to Paragraph 6.

NOTE : Check the bead of sealant (TB 09-001A) for condition at door nuts, apply a new bead if necessary.

4) Make sure all the tools and materials are removed and the work area is clean and free from debris.

5) Apply a coat of sealant (TB 09-019A) on the seating surface all around sealed inspection door (3).

6) Coat the threading of screws (4) with Loctite (TB 08-013C) - refer to 20-00-08.

7) Install sealed inspection door (3) and secure with screws (4).

8) Torque screws (4) according to the sequence specified on Figure 202.

NOTE : Tightening the screws linearly, one after the other, could lead to sealed inspection door warping. This could result in a fuel leak.

9) Allow to dry.

NOTE : In order to obtain the drying time of sealants, refer to technical notices.

10) Fill up the fuel tanks - refer to 12-11-01.

11) Check sealed inspection door (3) for tightness.

D. Removal of a non-sealed inspection door

1) Identify and mark the door to be removed.

2) Remove the screws securing the non-sealed inspection door to wing lower surface.

3) Tilt the non-sealed inspection door to remove it.

E. Installation of a non-sealed inspection door (Figure 203)

1) Check parts for condition, replace as required.

2) Clean the parts with clean, lintfree cloths moistened with cleaning agent (TB 11-003).

3) Make sure all the tools and materials are removed and the work area is clean and free from debris.

4) Coat the threading of attachment screws with Loctite (TB 08-013C) - refer to 20-00-08.

5) Install the non-sealed inspection door and secure with attachment screws.

6) Torque the attachment screws according to the sequence specified on Figure 203.

3. ADJUSTMENT / TEST

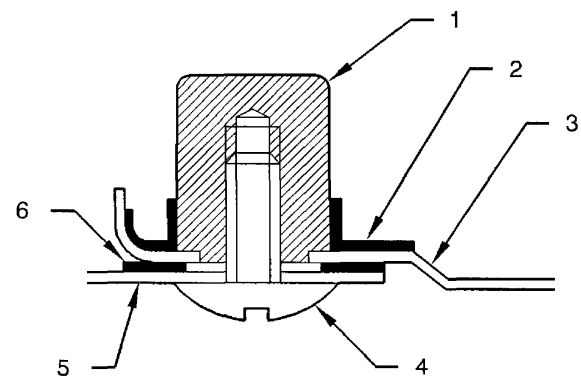
None

4. INSPECTION / CHECK

None

5. CLEANING / PAINTING

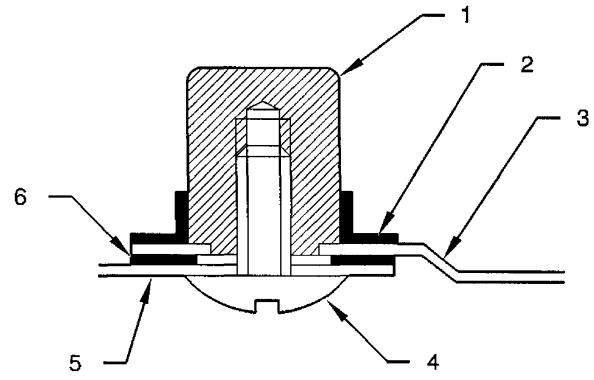
None



I4524000AAAKVZ4002

1 - Nut
2 - Sealant (TB 09-001A)
3 - Sealed inspection door
4 - Screw
5 - Skin
6 - Sealant (TB 09-019A)

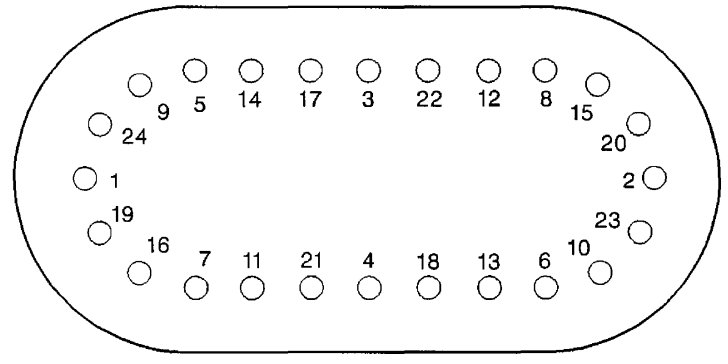
Installation of a fuel tank sealed inspection door
Figure 201 - S / N 1 - 1646, 1648 - 1664



I4524000AAAKVZ4002

1 - Nut
2 - Sealant (TB 09-001A)
3 - Sealed inspection door
4 - Screw
5 - Skin
6 - Sealant (TB 09-019A)

Installation of a fuel tank sealed inspection door
Figure 201A - S / N 1647, 1665 - 9999



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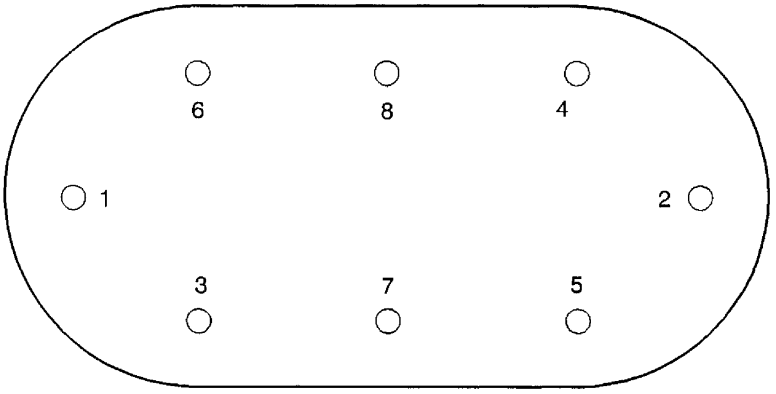
Tightening sequence of a fuel tank sealed inspection door
Figure 202



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Tightening sequence of a wing non-sealed inspection door
Figure 203

6. REPAIR / REPLACEMENT - SEALED INSPECTION DOOR NUT (Figures 204 and 204A)

A. Tools and consumable materials

- Cleaning agent (TB 11-914)
- Anchor nut Z00.N5427218050 (Qty 1)
- Rivet Z00.N5548371069 (Qty 2)
- Screw Z00.N5169911168 (Qty 1)
- Sealant (TB 09-001A)

B. Repair - Removal

1) Remove the inspection door - refer to Paragraph 2.
2) Remove sealant (TB 09-001A) from the defective nut.

CAUTION : EXERCISE EXTREME CARE DURING THE UNCRIMPING OPERATION TO AVOID DAMAGING THE SEALED INSPECTION DOOR.

3) Using a drill dia. 0.28 in (7 mm), remove nut crimping.
4) Remove the sealed nut.
5) Clean any sealant particles from the seating surface of the sealed nut. If necessary, clean the surface with cleaning agent (TB 11-914).

C. Repair - Installation

CAUTION : SINCE THE DIAMETER OF THE REPLACEMENT SEALED NUT IS 0.197 IN (5 MM) GREATER THAN THAT OF THE PREVIOUS NUT, DO NOT FORGET TO MARK THE NUT LOCATION ON THE DOOR EXTERNAL SIDE WITH A RED PAINT LINE TO PREVENT ERRORS DURING DOOR REINSTALLATION.

1) Position nut (1) on sealed inspection door (4). Temporarily secure the nut with a pair of pliers.
2) Using a drill dia. 0.10 in (2.5 mm), counterdrill sealed inspection door (4).
3) Countersink at 100° on the door external side the rivets passage holes to make the heads flush [Drill dia. 0.18 in (4.5 mm)].

4) Coat the sealed nut seating surface with sealant (TB 09-001A).

5) Position the nut on its location, exercise care to prevent sealant (TB 09-001A) from penetrating in nut threads and secure the nut with 2 rivets (3) P/N Z00.N5548371069.

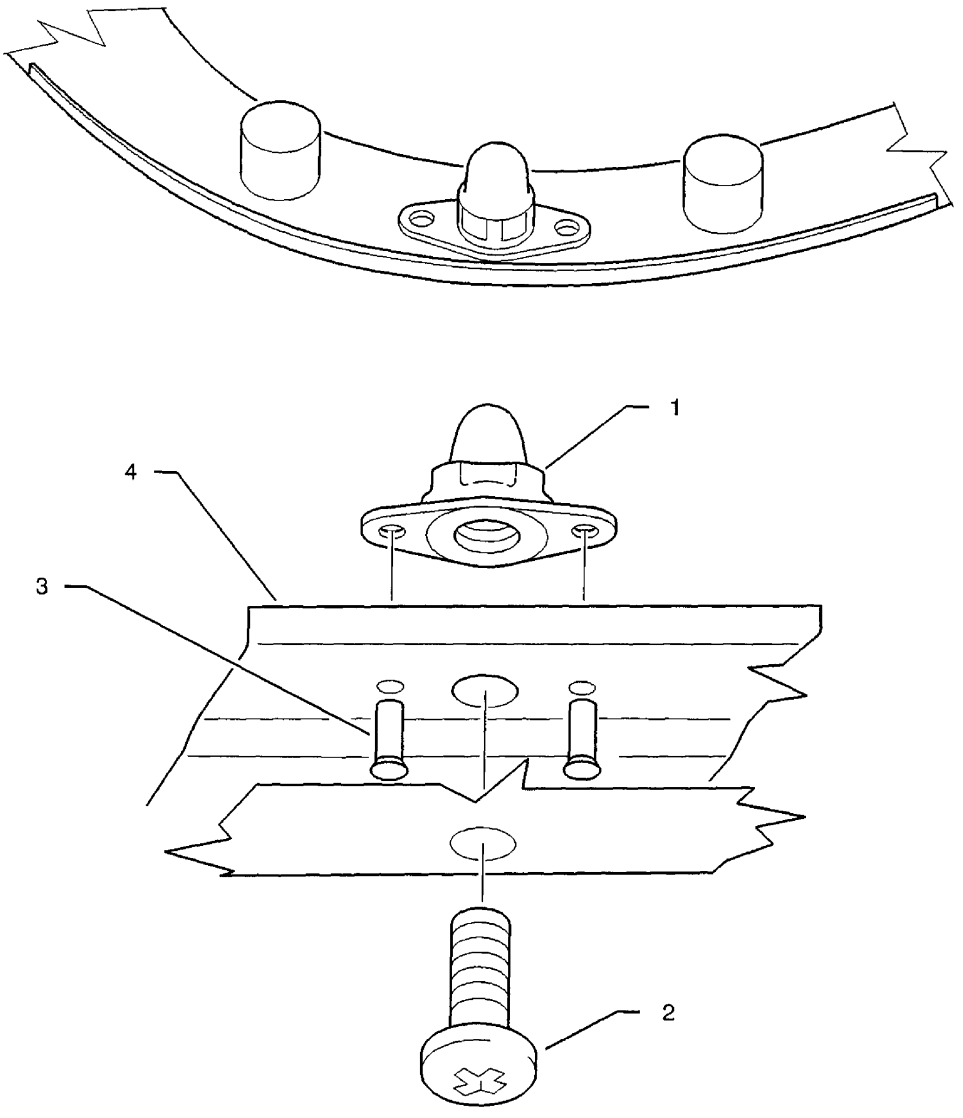
6) Ensure tightness by applying a bead of sealant (TB 09-001A) around the sealed nut base and on the rivets. Observe the sealant curing time before reinstalling the door.

7) On wings, counterdrill the new screw (2) passage hole to dia. 0.20 in (5.1 mm) facing the new sealed nut.

8) Thoroughly clean all drilling chips from inside the wings.

9) Install the inspection door - refer to Paragraph 2.

1 - Nut
2 - Screw
3 - Rivet
4 - Sealed inspection door



I4524000AAAKVZ14202

Sealed nuts installation detail
Figure 204 - N / S 1 - 1646, 1648 - 1664

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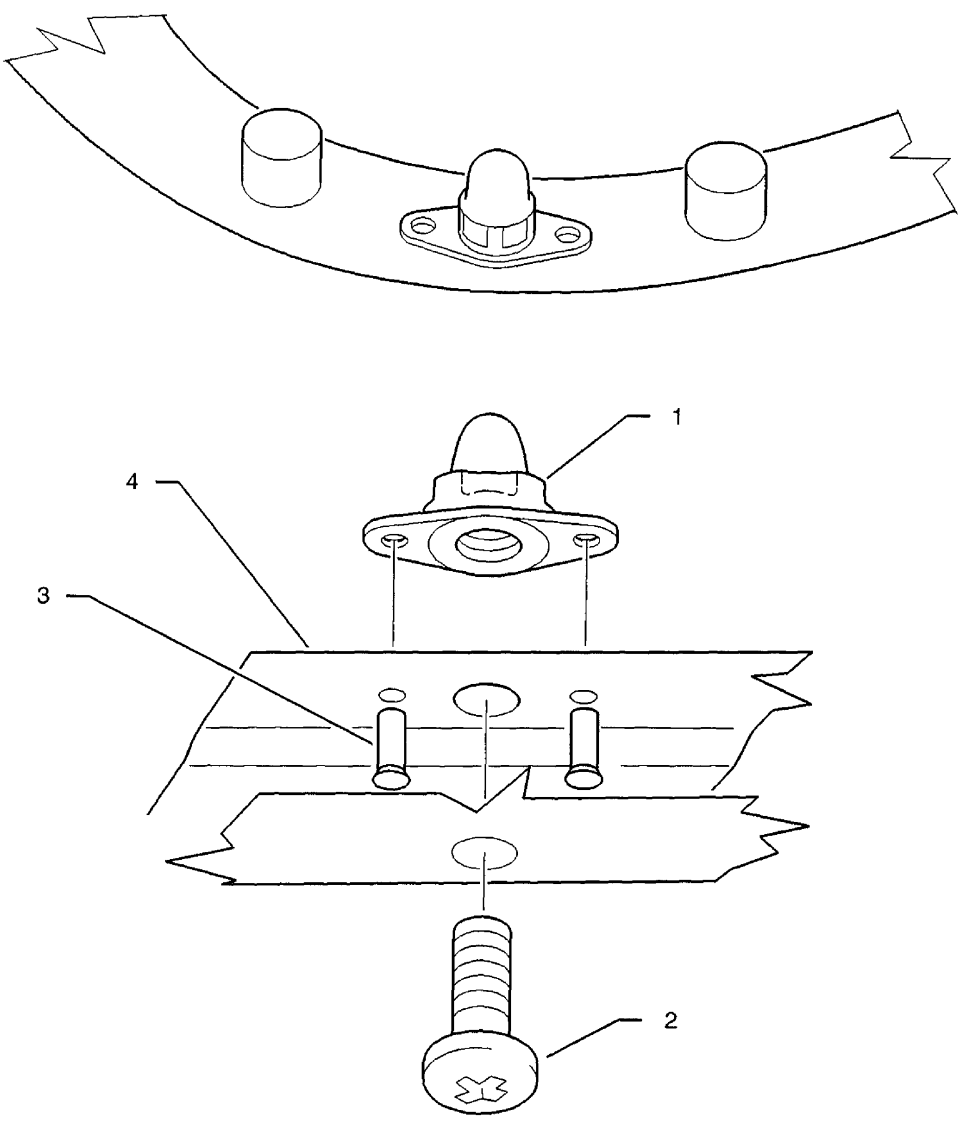
Validity : S / N 1 - 9999 Pre-MOD. 162

1 - Nut
2 - Screw
3 - Rivet
4 - Sealed inspection door



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Sealed nuts installation detail
Figure 204A - N / S 1647, 1665 - 9999

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Validity : S / N 1 - 9999 Pre-MOD. 162

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INSPECTION DOORS

MAINTENANCE PRACTICES

NOTE : This procedure is applicable to L.H. and R.H. installations. Information specific to R.H. installation are given in square brackets.

1. SERVICING

None

2. REMOVAL / INSTALLATION - INSPECTION DOORS

A. Tools and consumable materials

- Clean, lintfree cloths
- Cleaning agent (TB 11-003)
- Loctite (TB 08-013C)

B. Removal of a fuel tank sealed inspection door with built-in seal (Figures 201 and 202)

WARNING : OBEY THE SAFETY PRECAUTIONS DESCRIBED IN 28-00-00.

WARNING : APPLY THE FUEL TANKS MAINTENANCE PROCEDURE - REFER TO 28-00-00 PAGE 200.

1) Drain the fuel tanks - refer to 12-11-02.

2) Identify and mark the sealed inspection door (2) to be removed.

3) Remove screws (4) securing sealed inspection door (2) to wing lower surface.

CAUTION : EXERCISE CARE TO AVOID DAMAGING THE FUEL LEVEL GAGE DURING INSPECTION DOOR REMOVAL.

4) Tilt sealed inspection door (2) to remove it from the tank.

C. Installation of a fuel tank sealed inspection door with built-in seal (Figures 201 and 202)

WARNING : OBEY THE SAFETY PRECAUTIONS DESCRIBED IN 28-00-00.

WARNING : APPLY THE FUEL TANKS MAINTENANCE PROCEDURE - REFER TO 28-00-00 PAGE 200.

1) Inspect seal (5), sealed inspection door (2) and crimping nuts (1) for condition. If the seal is damaged or if a crimping nut is defective, replace sealed inspection door (2).

2) Using clean, lintfree cloths and cleaning agent (TB 11-003), clean the seating surface of seal (5) of sealed inspection door (2) on the skin.

3) Make sure all the tools and materials are removed and the work area is clean and free from debris.

4) Coat the threading of screws (4) with Loctite (TB 08-013C) - refer to 20-00-08.

5) Install sealed inspection door (2) and secure with screws (4).

6) Torque screws (4) according to the sequence specified on Figure 202.

NOTE : Tightening the screws linearly, one after the other, could lead to sealed inspection door warping. This could result in a fuel leak.

7) Fill up the fuel tanks. - refer to 12-11-01.

8) Check sealed inspection door (2) for tightness.

D. Removal of a non-sealed inspection door

1) Identify and mark the door to be removed.

2) Remove the screws securing the non-sealed door to wing lower surface.

3) Tilt the non-sealed inspection door to remove it.

E. Installation of a non-sealed inspection door (Figure 203)

1) Check parts for condition, replace as required.

2) Clean the parts with clean, lintfree cloths moistened with cleaning agent (TB 11-003).

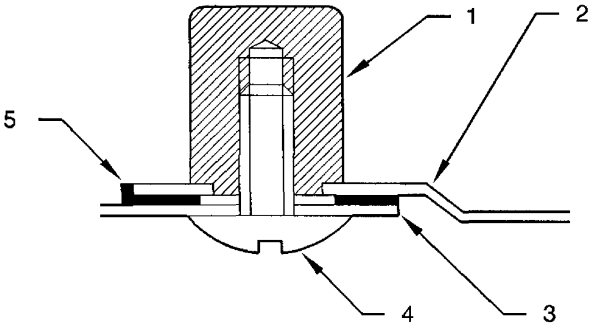
3) Make sure all the tools and materials are removed and the work area is clean and free from debris.

4) Coat the threading of attachment screws with Loctite (TB 08-013C) - refer to 20-00-08.

5) Install the non-sealed inspection door and secure with attachment screws.

6) Torque the attachment screws according to the sequence specified on Figure 203.

1 - Crimping nut
2 - Sealed inspection door
3 - Skin
4 - Screw
5 - Seal



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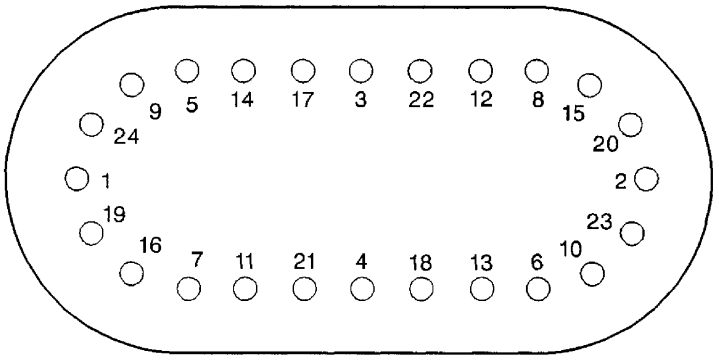
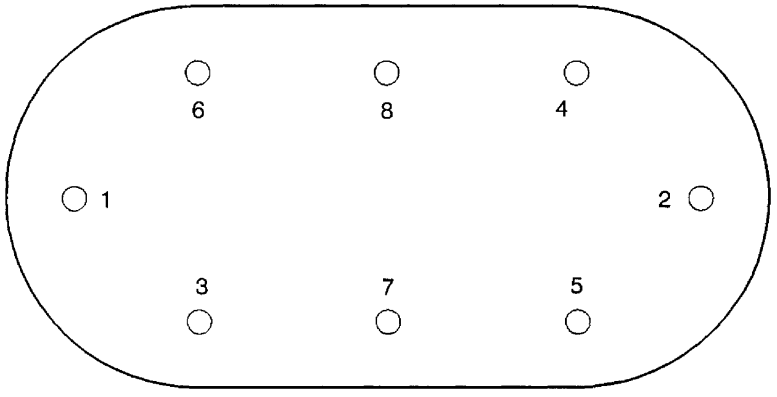
Installation of a fuel tank sealed inspection door
Figure 201

I4524000AAAKVZ4102



Tightening sequence of a fuel tank sealed inspection door
Figure 202

I4524000AAAKVZI4002



Tightening sequence of a wing non-sealed inspection door
Figure 203

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