53

FUSELAGE

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FUSELAGE

DESCRIPTION AND OPERATION

1. GENERAL

The fuselage is a metallic, aluminium alloy structure of semi-monocoque design.

It is composed of frames and fittings, cross beams and stringers, formed and riveted light alloy fairings and skins.

The fuselage consists of :

- the forward fuselage structure,
- the rear fuselage structure,
- the upper fuselage panel structure,
- the footstep,
- the access door mechanism.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Forward fuselage structure	1	210	/	53-10-00
Rear fuselage structure	1	220	/	53-20-00
Upper fuselage panel structure	1	240	/	53-40-00
Footstep	2	210	/	53-70-00
Access door mechanism	2	230	233L / 233R	53-80-00

3. DESCRIPTION

A. Forward fuselage structure

The forward fuselage structure provides attachment for the engine mount, the nose landing gear mount and the wings. It includes the cockpit and the baggage compartment, the latter being accessible through a door located on the L.H. side of the fuselage.

B. Rear fuselage structure

The rear fuselage structure provides attachment for the vertical / horizontal stabilizers assy.

C. Upper fuselage panel structure

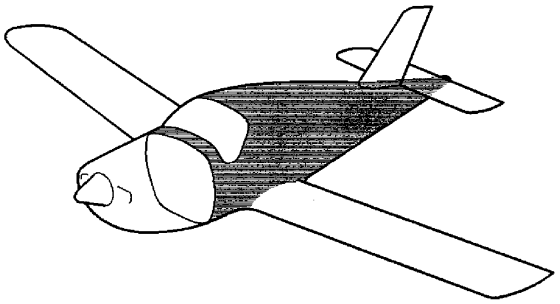
The upper fuselage panel structure provides attachment for the windshield, both access doors and both passenger windows.

D. Footstep

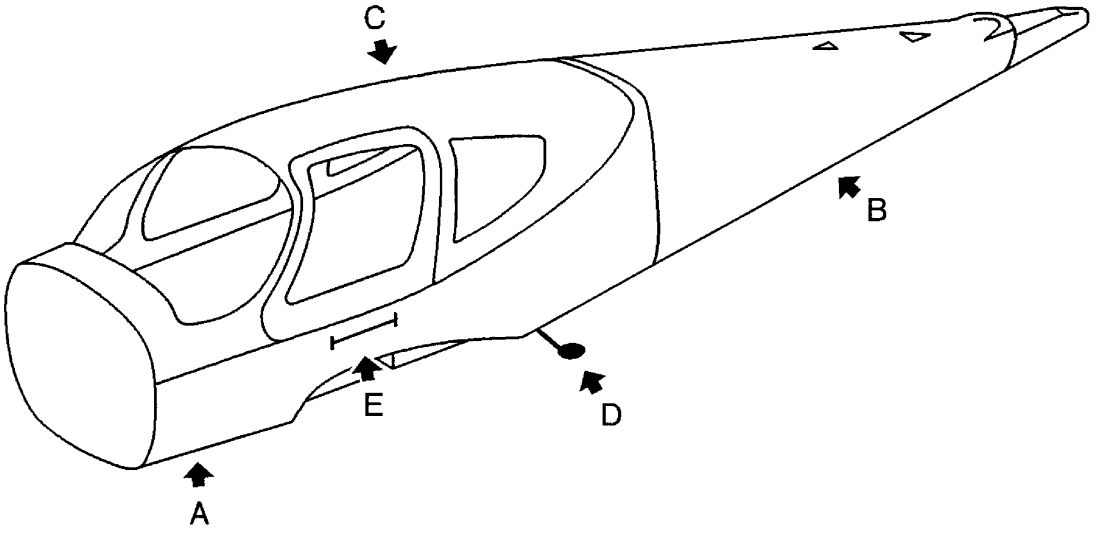
The footstep makes it possible to enter and exit the cabin easily.

E. Access door mechanism

The access door mechanism allows access door opening and closing.



A - Forward fuselage
B - Rear fuselage
C - Upper fuselage panel structure
D - Footstep
E - Access door mechanism



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Fuselage - Identification and location of components
Figure 1

FUSELAGE

INSPECTION / CHECK

1. INSPECTION / CHECK - FUSELAGE

A. Tools and consumable materials

- Portable lamp
- Swivelling mirror

B. Procedure

1) Remove the tail cone - refer to 53-20-04.
2) Thoroughly clean the fuselage - refer to 12-20-03.
3) Thoroughly inspect the fuselage skin for corrosion.
4) Visually inspect all the sections of the fuselage structure, the frames, ribs, floor stiffeners and floor panels for corrosion, cracks and loose rivets.
5) Thoroughly inspect frame C9 for cracks and loose rivets. Use a swivelling mirror to inspect the inner section of frame C9.
6) Inspect the rear flight control support for attachment.
7) Thoroughly inspect the tail cone.
8) Install the tail cone - refer to 53-20-04.

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FORWARD FUSELAGE STRUCTURE

DESCRIPTION AND OPERATION

1. GENERAL

The forward fuselage structure is a metallic, aluminium alloy structure of semi-monocoque design.

The forward fuselage structure consists of :

- the frames and fittings,
- the cross beams and stringers,
- the fairings and anti-spin edges,
- the skins.

The forward fuselage structure is reinforced with horizontal spars made of aluminium sections.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Frames and fittings	/	210	/	53-10-00
Cross beams and stringers	/	210	/	53-10-00
Fairings and anti-spin edges	/	210	/	53-10-00
Skins	/	210	/	53-10-00

3. DESCRIPTION

A. Frames and fittings

The forward fuselage structure is limited by frames C0 and C6.

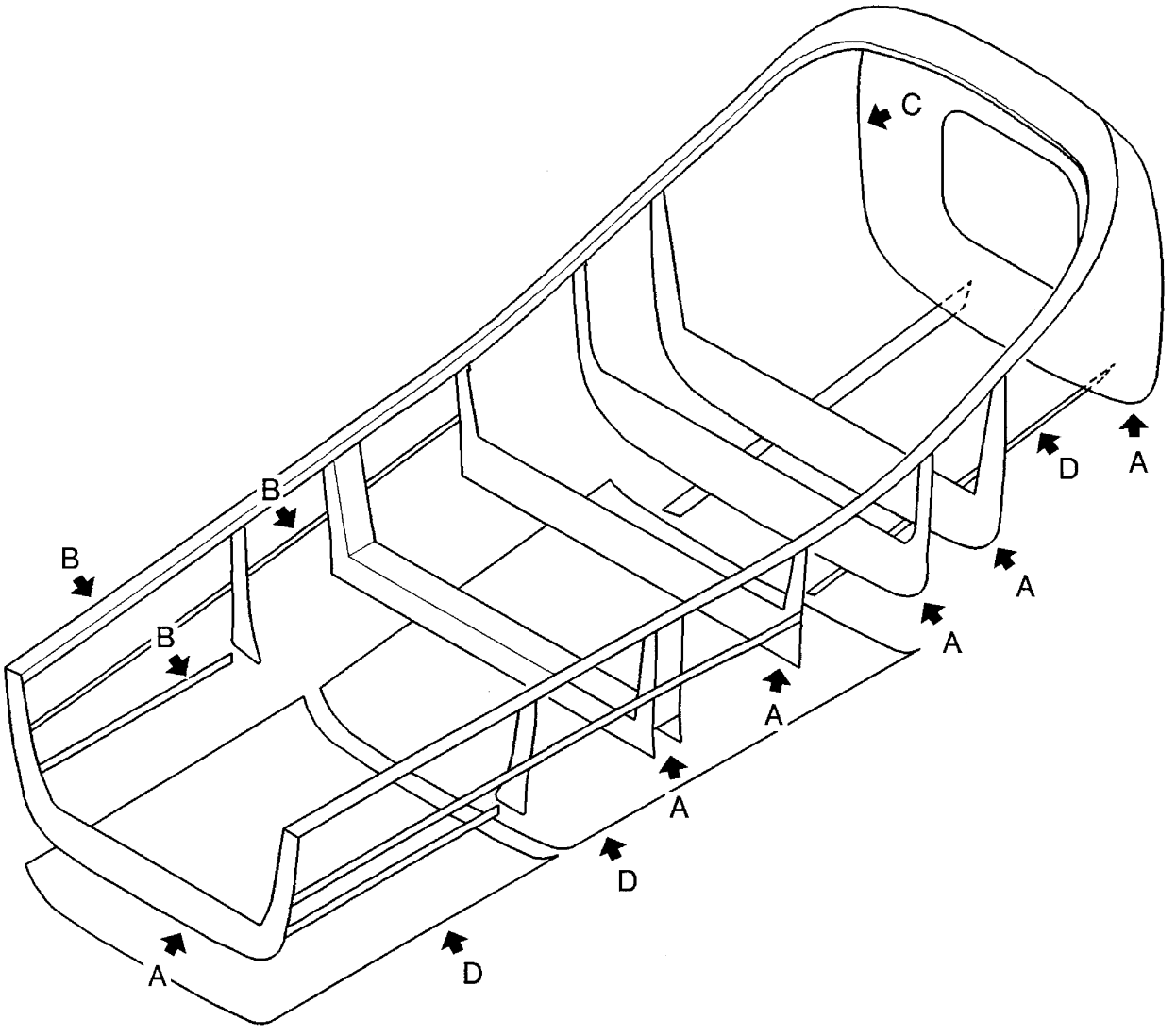
The firewall, the engine mount and the nose landing gear mount are secured to frame C0.

The wings front attachment fittings are secured to frame C1.

Frame C2 is a double frame which provides passage and attachment for the wing spar.

The L.H. and R.H. footsteps are secured to frame C4.

A - Frames
B - Cross beams and stringers
C - Skins
D - Fairings and anti-spin edges



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Forward fuselage - Identification and location of components
Figure 1

REAR FUSELAGE STRUCTURE

DESCRIPTION AND OPERATION

1. GENERAL

The rear fuselage structure is a metallic, aluminium alloy structure of semi-monocoque design.

The rear fuselage structure consists of :

- the frames,
- the cross beams and stringers,
- the fairings,
- the skins,
- the fittings.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Frame (S / N 1- 450)	3	220	/	53-20-01
Frame (S / N 451 - 9999)	3	220	/	53-20-00
Cross beams and stringers	/	220	/	53-20-00
Fairings	/	220	/	53-20-04
Skins	/	220	/	53-20-03
Fittings	2	220	222	53-20-05

3. DESCRIPTION

A. Frames

The rear fuselage structure is limited by frames C7 and C9.

The vertical stabilizer front attachment is secured to frame C7.

The vertical stabilizer rear attachment is secured to frame C8.

The elevator hinge fittings are secured to frame C9.

B. Skins

The skins are made of formed and riveted light alloys.

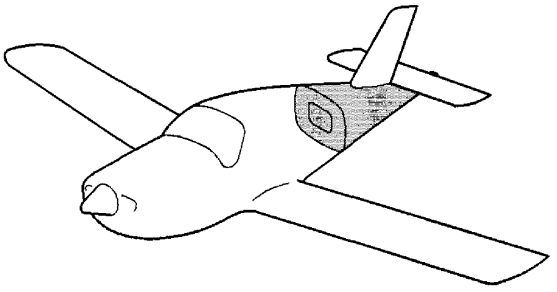
C. Fairings

The tail cone ensures the aerodynamic continuity of the fuselage.

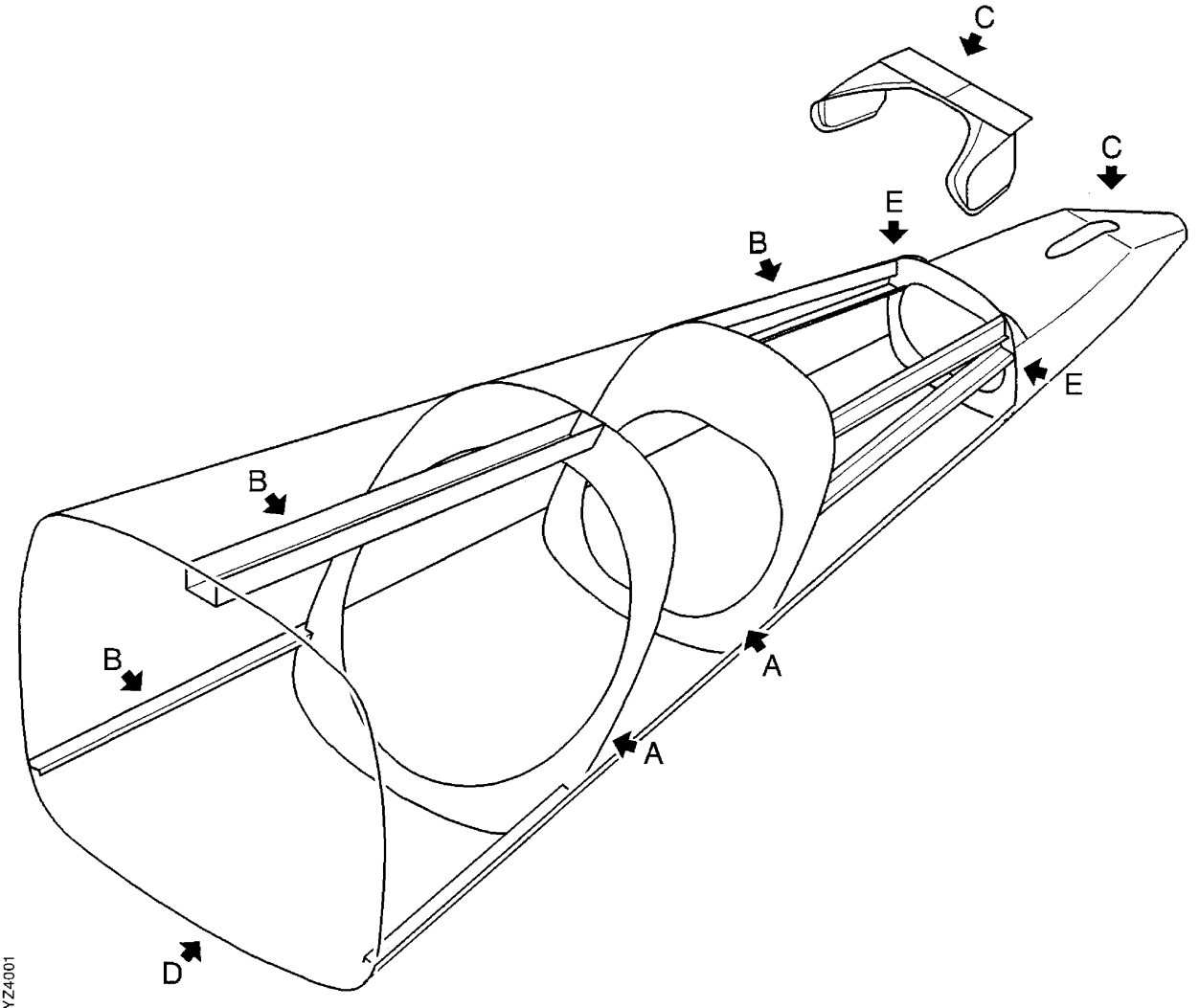
The tail cone is screwed to frame C9 of the rear fuselage.

D. Fittings

The elevator fittings are secured to frame C9.



A - Frames
B - Cross beams and stringers
C - Fairings
D - Skins
E - Fittings



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Rear fuselage - Identification and location of components
Figure 1

FRAMES

REPAIR

1. REPLACEMENT OF THE FLIGHT CONTROL REAR SUPPORT ON FRAME C9 (Figures 801 and 802)

A. Tools and consumable materials

- 1 padded support for frame C8
- Grease (TB 04-004A)
- Alodine (TB 13-002)
- Primer (TB 16-901)
- Drill dia. 1/8" (3.2 mm)
- Drill No. 20 (dia. 4.1 mm)
- Drill No. 7 (dia. 5.1 mm)
- Kit OPT10 908600, composed of :

. 1 L.H. doubler	TB10 21013103	(27)
. 1 R.H. doubler	TB10 21013104	(32)
. 1 L.H. support	TB10 27088004	(18)
. 1 R.H. support	TB10 27088005	(35)
. 1 L.H. unfolding wedge	TB10 27088118	(16)
. 1 R.H. unfolding wedge	TB10 20088117	(15)
. 1 pin	TB10 27000131	(23)
. 1 spacer dia. 0.47 in (12 mm), L 5.52 in (140.3 mm)	TB10 27000158	(21)
. 1 spacer dia. 0.63 in (16 mm), L 0.59 in (15 mm)	TB10 27000159	(34)
. 1 spacer dia. 0.63 in (16 mm), L 0.39 in (10 mm)	TB10 27000160	(19)
. 6 bolts	Z00.N5101229079	(29)
. 6 bolts	Z00.N5101229175	(25)
. 2 bolts	Z00.N5101229174	(17)
. 2 bolts	Z00.N5101229179	(12)
. 6 washers	Z00.N5701039160	(30)
. 10 washers	Z00.N5701039240	(13)
. 2 cotter pins	Z00.N5783009087	(22)
. 6 nuts	Z00.N5401458159	(31)
. 10 nuts	Z00.N5401458239	(14)

B. Procedure

CAUTION : THE SUPPORT MUST FIT TO FUSELAGE PROFILE PERFECTLY AND BEARING FACES MUST BE PADDED TO AVOID DAMAGING THE STRUCTURE.

1) Install a padded support under the rear fuselage, at frame C8.
2) Remove the tail cone - refer to 53-20-04.
3) Remove baggage compartment bottom door 242.
4) Disconnect the rods (elevator and rudder) from levers (2) and (10).
5) Remove the 8 attachments (1) of the flight control rear support on frame C9.
6) Disengage the rear support assembly towards the front of the fusealge and remove it.
7) Remove attachment (8).
8) Counterdrill the 6 rivets (7) with a drill dia. 1/8" (3.2 mm).
9) Remove and discard fitting doubler (9).
10) On a work bench, remove levers (2) and (10) from L.H. support (3) and R.H. support (11).
11) Discard L.H. support (3) and R.H. support (11), central spacer (6), pin (5) and cotter pins (4).
12) Position L.H. doubler (27) to counterdrill the 6 holes of rear fuselage and of lower fitting (28) using a drill No. 20 (dia. 4.1 mm). Deburr.
13) Vacuum-clean any chips forward of frame C9.
14) Protect bare metal with Alodine (TB 13-002).
15) Touch up with primer (TB 16-901).
16) Touch up with finish paint - refer to 20-00-03.
17) Install L.H. doubler (27) and R.H. doubler (32) and secure with bolts (29), washers (30) and nuts (31).
18) Install attachment (8). Install a new nut.
19) Lubricate spacers (19), (21), (33) and (34) with grease (TB 04-004A).
20) On a work bench, equip L.H. support (18) and R.H. support (35) with levers (2) and (10), spacers (19), (21), (33) and (34), pin (23), washer (24) and nut (20). Install a new cotter pin (22).
21) Install and temporarily secure the rear support assembly on frame C9. Counterdrill both additional lower attachments (26) using a drill No. 7 (dia. 5.1 mm). Remove the rear support assembly to deburr the holes.
22) Vacuum-clean any chips forward of frame C9.
23) Protect bare metal with Alodine (TB 13-002).
24) Touch up with primer (TB 16-901).
25) Touch up with finish paint - refer to 20-00-03.
26) Secure the rear support assembly to frame C9 with bolts (12), (17) and (25), washers (13) and nuts (14). Install R.H. unfolding wedge (15) and L.H. unfolding wedge (16) between the supports and washers (13).
27) Connect the rods (elevator and rudder) to levers (2) and (10). Install new cotter pins.

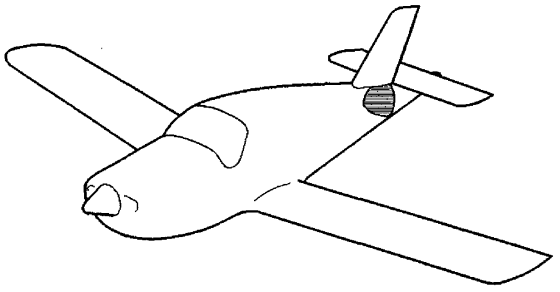
28) Make sure all the tools and materials are removed and the work area is clean and free from debris.

29) Remove padded support.

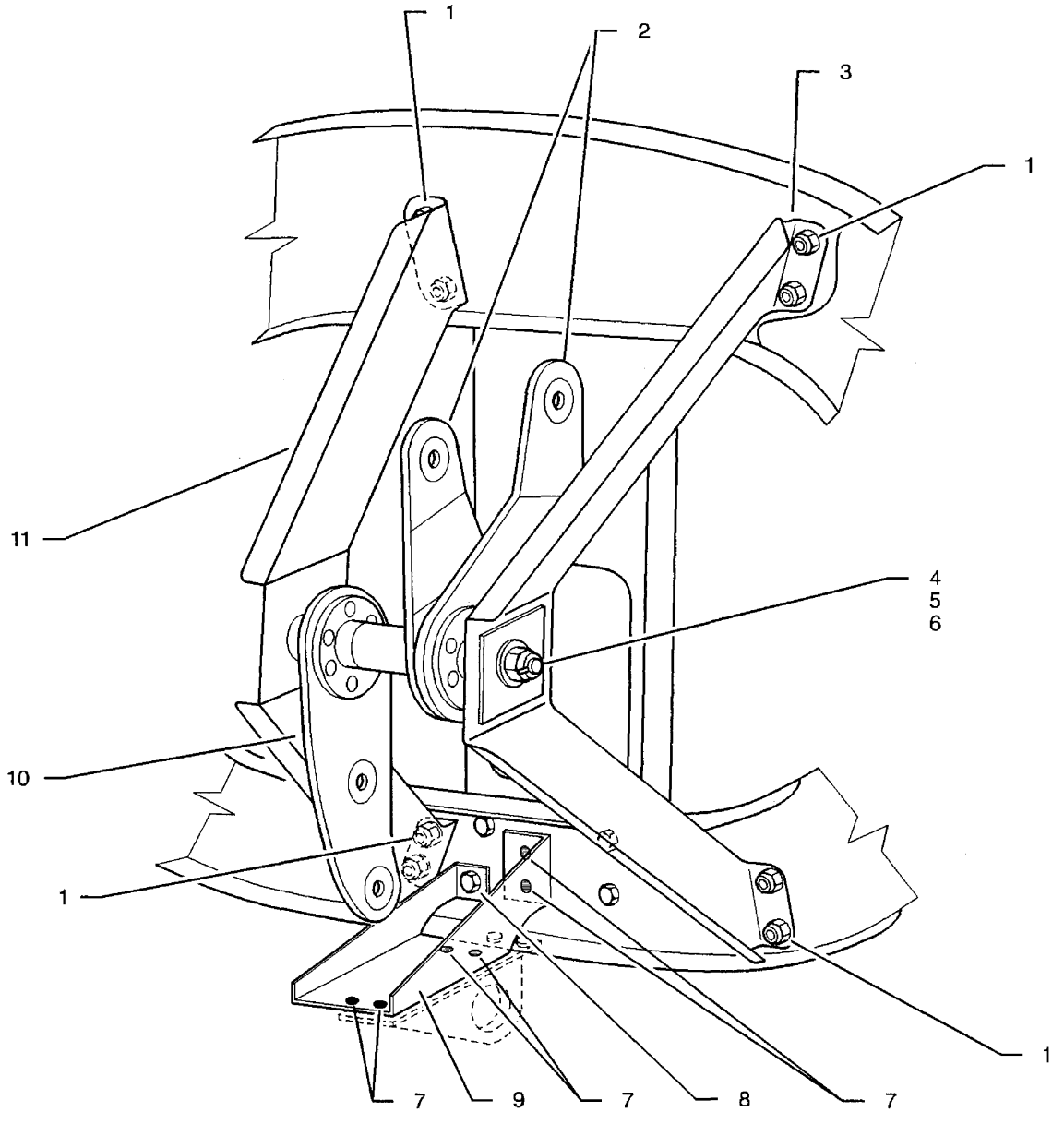
30) Check the control surfaces for correct operation.

31) Check the control surfaces for correct travel - refer to 27-30-00. Adjust if necessary.

32) Install the tail cone - refer to 53-20-04, and baggage compartment bottom door 242.



1 - Attachment (bolt, washer, nut)
2 - Lever
3 - L.H. support
4 - Cotter pin
5 - Pin
6 - Central spacer
7 - Rivet
8 - Attachment (bolt, washer, nut)
9 - Fitting doubler
10 - Lever
11 - R.H. support



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Frame - Flight control rear support on frame C9
Figure 801

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2 - Lever

8 - Attachment (bolt, washer, nut)

10 - Lever

12 - Bolt

13 - Washer

14 - Nut

15 - R.H. unfolding wedge

16 - L.H. unfolding wedge

17 - Bolt

18 - L.H. support

19 - Spacer

20 - Nut

21 - Spacer

22 - Cotter pin

23 - Pin

24 - Washer

25 - Bolt

26 - Additional lower attachment

27 - L.H. doubler

28 - Lower fitting

29 - Bolt

30 - Washer

31 - Nut

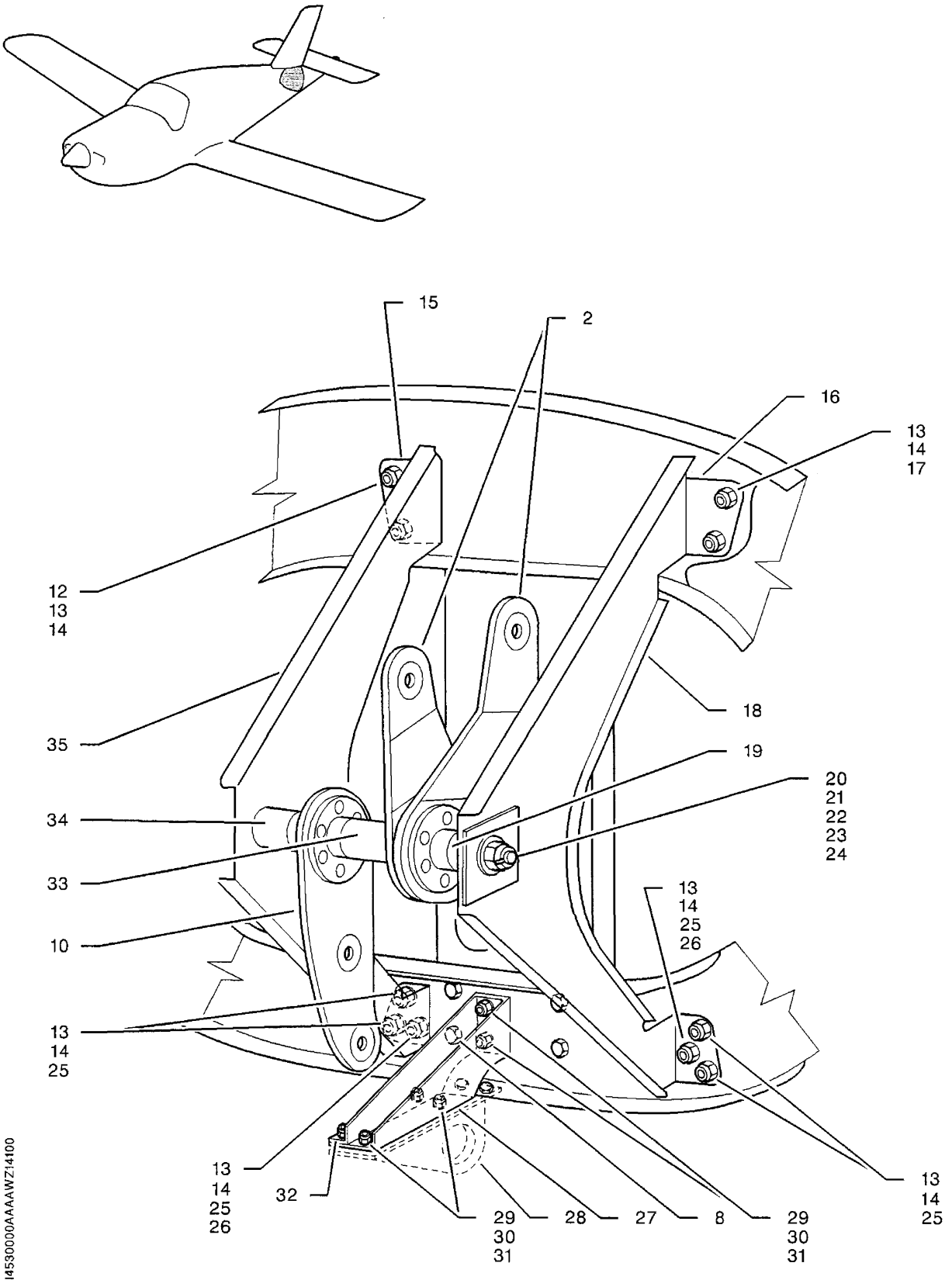
32 - R.H. doubler

33 - Spacer

34 - Spacer

35 - R.H. support

Frame - Installation of flight control rear support on frame C9
Key to Figure 802



Frame - Installation of flight control rear support on frame C9
Figure 802

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SKINS

REPAIR

1. REPAIR / REPLACEMENT - SKIN BETWEEN FRAMES C5 AND C9

A. Tools and consumable materials

- Sealant (TB 09-002A)
- Sealant (TB 09-001A)

B. Procedure

NOTE : When a skin is replaced between frames C5, C6, C7, C8 and C9, apply some sealant (TB 09-001A) to rivets and between the skin and frames - refer to 20-00-09.

NOTE : When a skin is replaced between frames C5, C6, C7, C8 and C9, apply a sealing bead with sealant (TB 09-002A) at the skin junctions - refer to 20-00-09.

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FAIRINGS

REMOVAL / INSTALLATION

1. REMOVAL OF THE TAIL CONE (Figure 401)

A. Tools and consumable materials

None

B. Procedure

Pre-MOD. 151 - refer to Detail B

1) If the rear light is installed, open navigation light and anticollision light switch-breakers.
2) Hold tail cone (3).
3) Remove screws (5) and washers (4).
4) If the rear light is installed, disconnect connectors (1).
5) Remove tail cone (3).

Post-MOD. 151 - refer to Detail A

1) Hold tail cone (3).
2) Remove screws (5) and washers (4).
3) Remove tail cone (3).

2. INSTALLATION OF THE TAIL CONE (Figure 401)

A. Tools and consumable materials

None

B. Procedure

Pre-MOD. 151 - refer to Detail B

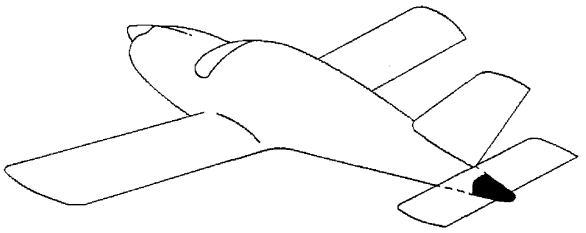
1) Prior to tail cone installation, inspect :
   - for cracks or crazing,
   - the attaching holes for elongation,

   With rear light
   - the rear light wire for routing and condition,
   - the attachment of rear light wire for condition,
   - the bulb and the glass of rear light (2) for condition and attachment,
   - connectors (1) for condition.
2) If the rear light is installed, connect connectors (1).
3) Make sure all the tools and materials are removed and the work area is clean and free from debris.
4) Install tail cone (3) on frame C9 (6), then install washers (4) and screws (5).
5) Check elevator (7) for freedom of travel.

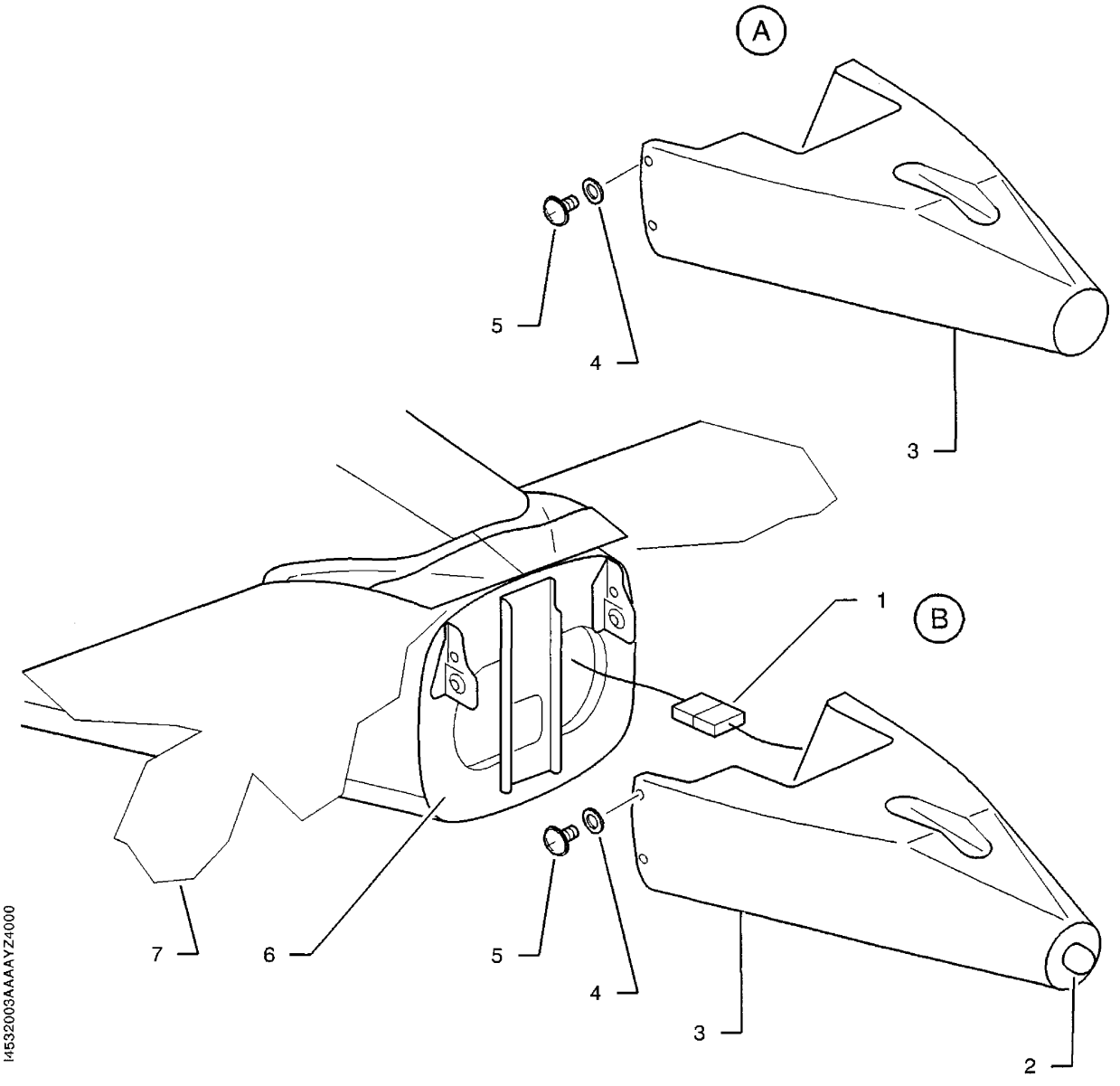
6) If the rear light is installed, close navigation light and anticollision light switch-breakers and check rear light (2) for correct operation.

Post-MOD. 151 - refer to Detail A

1) Prior to tail cone installation, inspect :
   - for cracks or crazing,
   - the attaching holes for elongation.
2) Make sure all the tools and materials are removed and the work area is clean and free from debris.
3) Install tail cone (3) on frame C9 (6), then install washers (4) and screws (5).
4) Check elevator (7) for freedom of travel.



1 - Connector
2 - Rear light
3 - Tail cone
4 - Washer
5 - Screw
6 - Frame C9
7 - Elevator



Tail cone - Removal / Installation
Figure 401

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FITTINGS

REMOVAL / INSTALLATION

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

1. REMOVAL OF BRACKET ASSEMBLY (Figure 401)

A. Tools and consumable materials

- Cleaning agent (TB 11-003)
- Spatula
- Lintfree clean cloth

B. Procedure

1) Remove the tail cone - refer to 53-20-04.

2) Remove the elevator - refer to 55-20-01.

3) Remove nuts (5) and washers (4). Discard nuts (5).

S / N 1 - 795 Pre-Kit OPT10 914500 - refer to Detail B

CAUTION : MARK THE LOCATION OF BOLTS (1) AND (7) AS THEIR LENGTH IS DIFFERENT.

4) Remove bolts (1) and (7) and washers (2).

S / N 796 - 9999 and S / N 1 - 795 Post-Kit OPT10 914500 - refer to Detail A

4) Remove bolts (1) and washers (2).

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5) Remove bracket assembly (6) [3].

6) Remove the sealant with a spatula and clean the surfaces with a lintfree clean cloth moistened with cleaning agent (TB 11-003).

2. INSTALLATION OF BRACKET ASSEMBLY (Figure 401)

A. Tools and consumable materials

- Red paint
- Torque wrench 0 - 177 lbf.in (0 - 20 N.m)
- Sealant (TB 09-916)
- Petrolatum (TB 04-012)
- Cleaning agent (TB 11-003)
- Lintfree clean cloth

B. Procedure

1) Apply a very thin layer of petrolatum (TB 04-012) to the bearing face of bracket assembly (6) [3].

S / N 1 - 795 Pre-Kit OPT10 914500 - refer to Detail B

2) Apply some sealant (TB 09-916) to the bearing face of bracket assembly (6) [3] and bolts (1) and (7) - refer to 20-00-09.

3) Position bracket assembly (6) [3] on frame C9 and secure with bolts (1) and (7), washers (2) and (4) and new nuts (5).

4) Torque according to "Specific cases" tightening procedure - refer to 20-00-01.

S / N 796 - 9999 and S / N 1 - 795 Post-Kit OPT10 914500 - refer to Detail A

2) Apply some sealant (TB 09-916) to the bearing face of bracket assembly (6) [3] and bolts (1) - refer to 20-00-09.

3) Position the bracket assembly (6) [3] on frame C9 and secure with bolts (1), washers (2) and (4) and new nuts (5).

4) Torque according to "Specific cases" tightening procedure - refer to 20-00-01.

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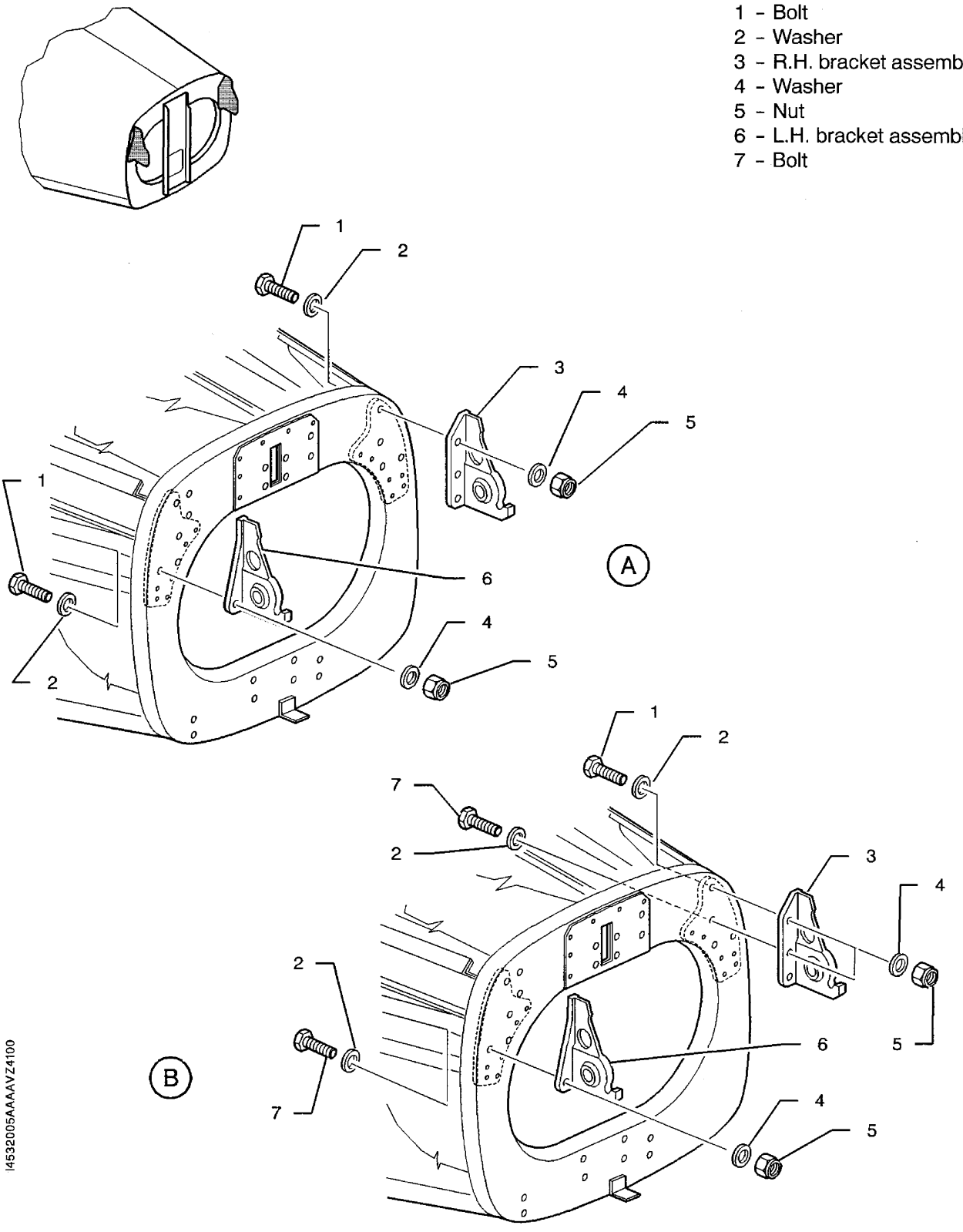
5) Wipe off excess sealant with a lintfree clean cloth moistened with cleaning agent (TB 11-003).

6) Mark nuts (5) with a red paint line.

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

8) Install the elevator - refer to 55-20-01.

9) Install the tail cone - refer to 53-20-04.



Fittings - Removal / Installation
Figure 401

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UPPER FUSELAGE PANEL STRUCTURE

DESCRIPTION AND OPERATION

1. GENERAL

Aerodynamic fairing is ensured by an upper fuselage panel.

The upper fuselage panel structure consists of :

- the front part,
- the central part,
- the rear part.

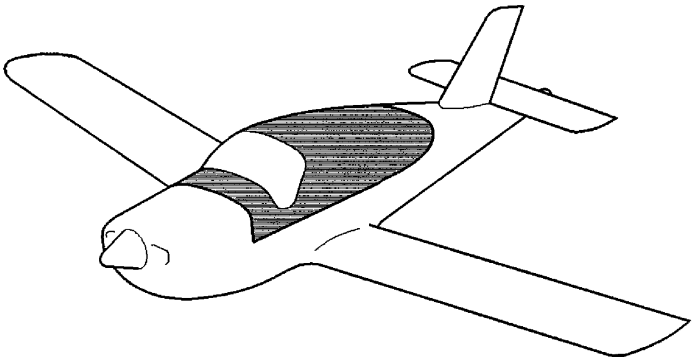
2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Front part	/	240	/	53-40-00
Central part	/	240	/	53-40-02
Rear part	/	240	/	53-40-00

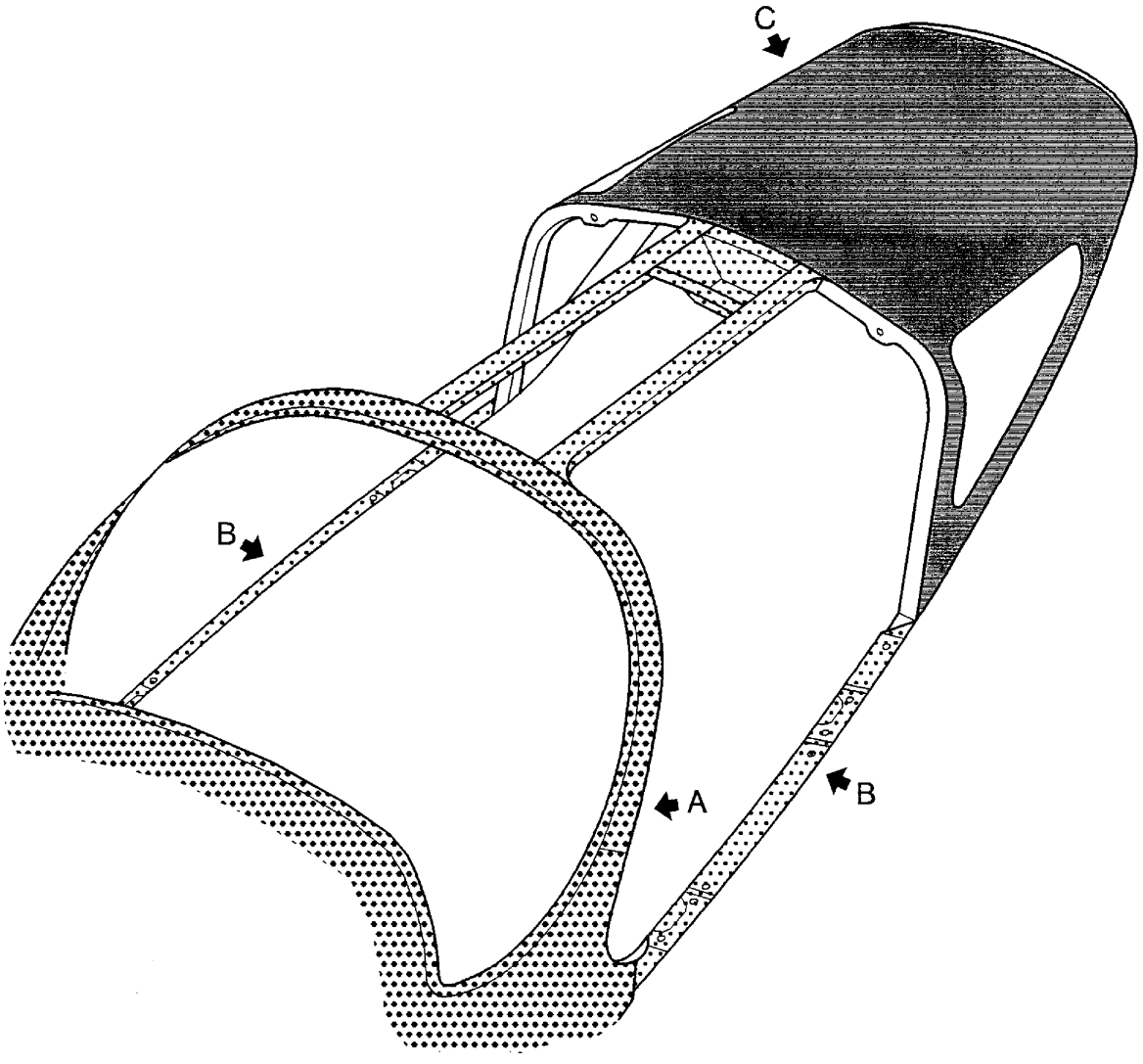
3. DESCRIPTION

A. Central part

The "gull wing" type access doors are secured to the upper fuselage panel central part.



A - Front part
B - Central part
C - Rear part



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Upper fuselage panel structure - Identification and location of components
Figure 1

CENTRAL PART

REPAIR

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

1. REINFORCEMENT OF UPPER FUSELAGE PANEL FOR ATTACHMENT OF GAS STRUT (Figure 801)

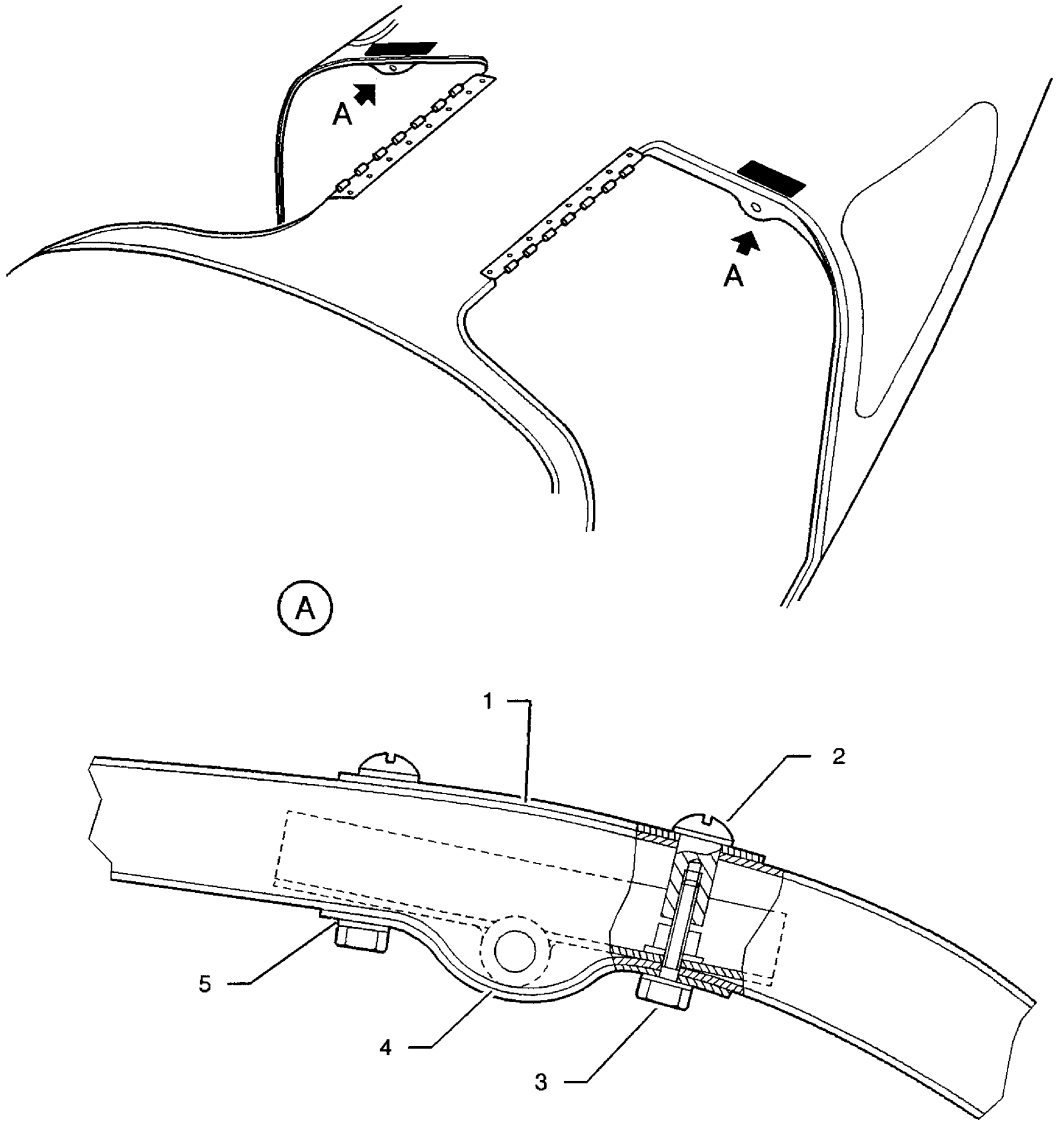
A. Tools and consumable materials

- Drill No. 19 (dia. 4.2 mm)
- Alodine (TB 13-002)
- Primer (TB 16-901)
- Cleaning agent (TB 11-003)
- Drill # N (dia. 7.7 mm)
- Sealant (TB 09-002A)
- Retrofit KIT OPT10 907200, composed of :
  - . 1 bridge (4)
  - . 1 counterplate (1)
  - . 2 nuts (2)
  - . 2 bolts (3)
  - . 2 washers (5)

B. Procedure

1) Remove the upholstery panel from the door stay to be reinforced.
2) Using a drill No. 19 (dia. 4.2 mm), drill 2 holes from inside as per arrow F (Figure 801) through the nuts crimped inside the door stay. These holes must open outside the skin.
3) On the outer face of the skin, enlarge both holes with a drill # N (dia. 7.7 mm).
4) If necessary, vacuum-clean all chips inside the cabin.
5) Protect bare metal with Alodine (TB 13-002).
6) Touch up with primer (TB 16-901).
7) Apply sealant (TB 09-002A) on the inner face of counterplate (1) and under the head of nuts (2).
8) Install bridge (4) and counterplate (1). Secure with bolts (3), washers (5) and nuts (2).
9) Wipe off excess sealant with a lintfree clean cloth moistened with cleaning agent (TB 11-003).
10) If necessary, touch up with finish paint - refer to 20-00-03.
11) Make sure all the tools and materials are removed and the work area is clean and free from debris.
12) Install the door stay upholstery panel.

1 - Counterplate
2 - Nut
3 - Bolt
4 - Bridge
5 - Washer



I4521000AAAPUZ4000

Reinforcement of the upper fuselage panel for attachment of the gas strut
Figure 801

FOOTSTEP

DESCRIPTION AND OPERATION

1. GENERAL

The footstep, composed of a tube, a mounting plate and a step, is secured to frame C4 by four screws.

The step is covered with an anti-skid coating.

Each aircraft is equipped with a L.H. footstep and a R.H. footstep.

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ACCESS DOOR MECHANISM

DESCRIPTION AND OPERATION

1. GENERAL

The access door mechanism allows access door closing and opening from inside and outside the aircraft.

Each aircraft is equipped with a L.H. and a R.H. access door mechanism.

2. LOCATION (Figure 1)

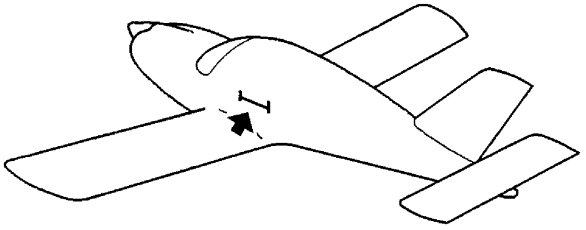
COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Latching ring	2	230	233R / 233L	53-80-00
Handle	2	230	233R / 233L	53-80-00
Lock	1	230	233R / 233L	53-80-00

3. DESCRIPTION

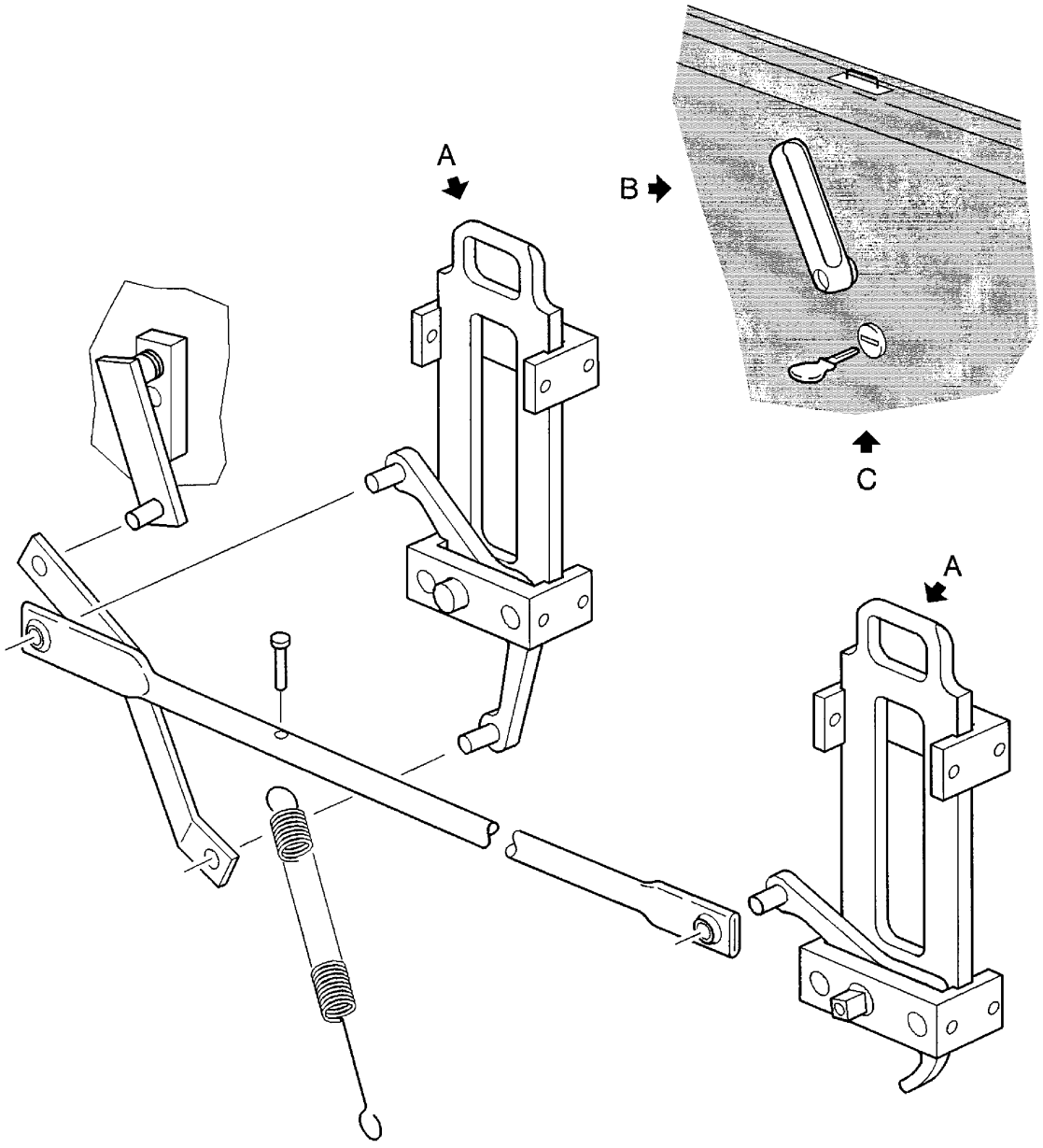
Closing is ensured by two hooks secured to the access door which lock on both latching rings of the access door mechanism.

Control is ensured by two handles, one inside the cabin and the second outside the aircraft.

A lock enables locking the external handle when the aircraft is parked.



A - Latching rings
B - Handle
C - Lock



Access door mechanism - Identification and location of components
Figure 1

ACCESS DOOR MECHANISM

DESCRIPTION AND OPERATION

1. GENERAL

The access door mechanism allows access door closing and opening from inside and outside the aircraft.

Each aircraft is equipped with a L.H. and a R.H. access door mechanism.

2. LOCATION (Figure 1)

COMPONENT	QTY	AREA	ACCESS DOOR	REFERENCE
Latching ring	2	230	233L / 233R	53-80-00
Handle	2	230	233L / 233R	53-80-00
Lock	1	230	233L / 233R	53-80-00
Door stop lever	1	230	233L / 233R	53-80-00

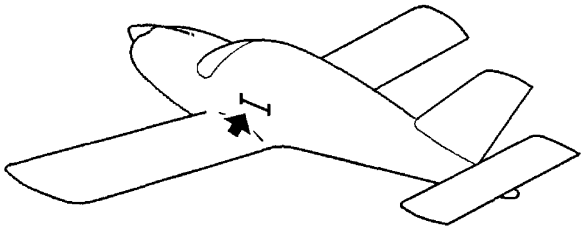
3. DESCRIPTION

Closing is ensured by two hooks secured to the access door which lock on both latching rings of the access door mechanism.

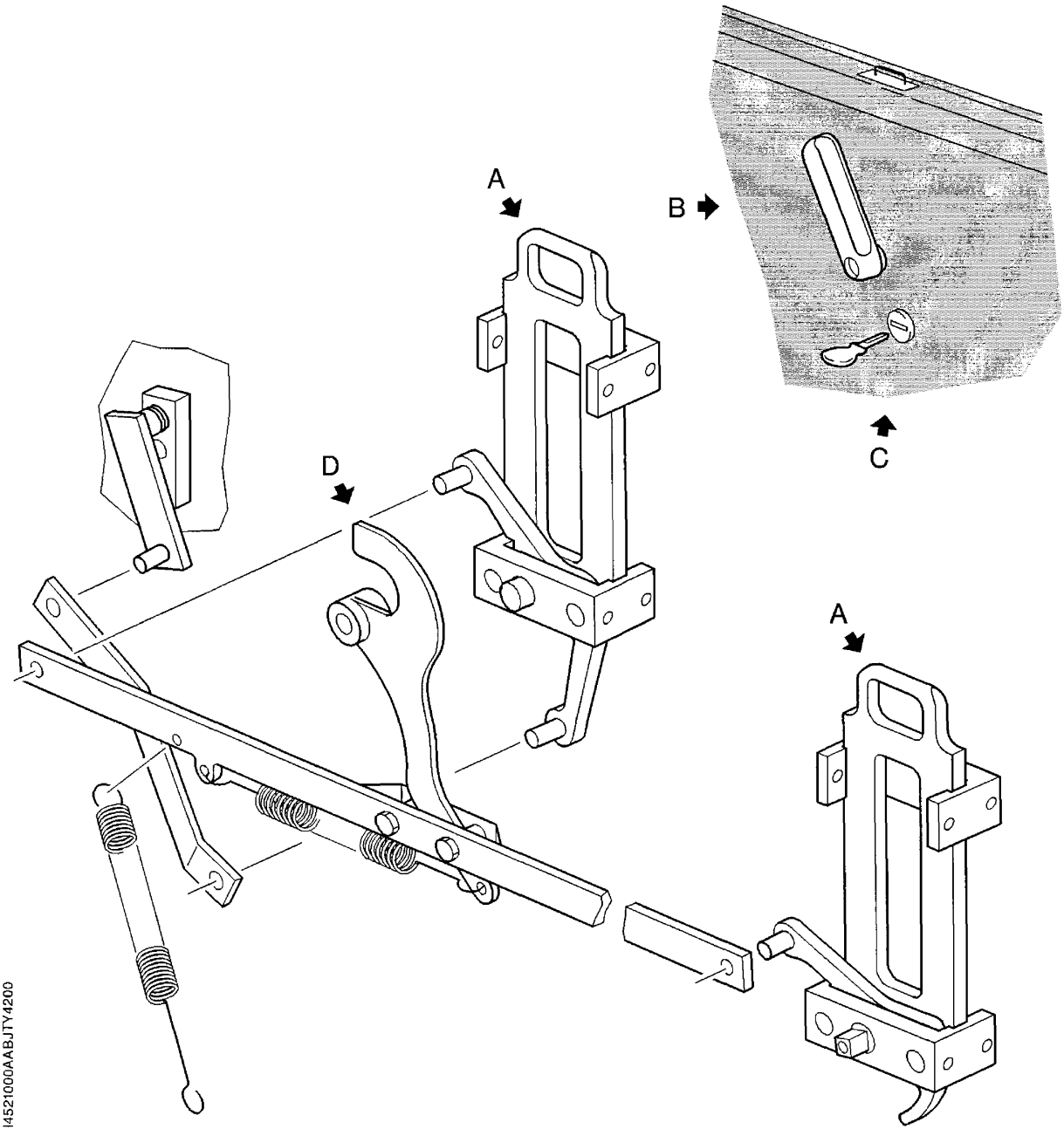
Control is ensured by two handles, one inside the cabin and the second outside the aircraft.

A door stop system prevents the access door from being folded down when the handle is in "CLOSED" position.

A lock enables locking the external handle when the aircraft is parked.



A - Latching rings
B - Handle
C - Lock
D - Door stop lever



Access door mechanism - Identification and location of components
Figure 1

ACCESS DOOR MECHANISM

REMOVAL / INSTALLATION

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

1. REMOVAL OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

None

B. Procedure

1) Open the access door.

2) Remove the front seat - refer to 25-11-00.

3) Remove the internal and external access door handles.

S / N 1 - 145

a) Remove and discard pin (30). Remove handle (23) and washer (20).

S / N 146 - 9999

a) Remove screw (22), washer (21), handle (23) and washer (20).

4) Remove the side upholstery panels.

5) Sufficiently debond the sealing cloth to gain access to the access door mechanism.

6) Remove spring (24) from interconnection rod (25) [26]. Retain clevis pin (27).

7) Remove and discard cotter pins (18). Retain washers (17).

8) Remove and discard nuts (6). Remove washers (5), bolts (3) and washers (4).

9) Remove and discard nuts (16). Remove washers (15) and bolts (9).

10) Remove and discard nuts (14). Remove washers (13) and bolts (10).

11) Disconnect interconnection rod (25) [26] and link rod (28) [29].

12) Remove FWD box assembly (1) [2] and rear box assembly (7) [8]. Retain washer (19), adjusting shims (11) and shims (12) (if installed).

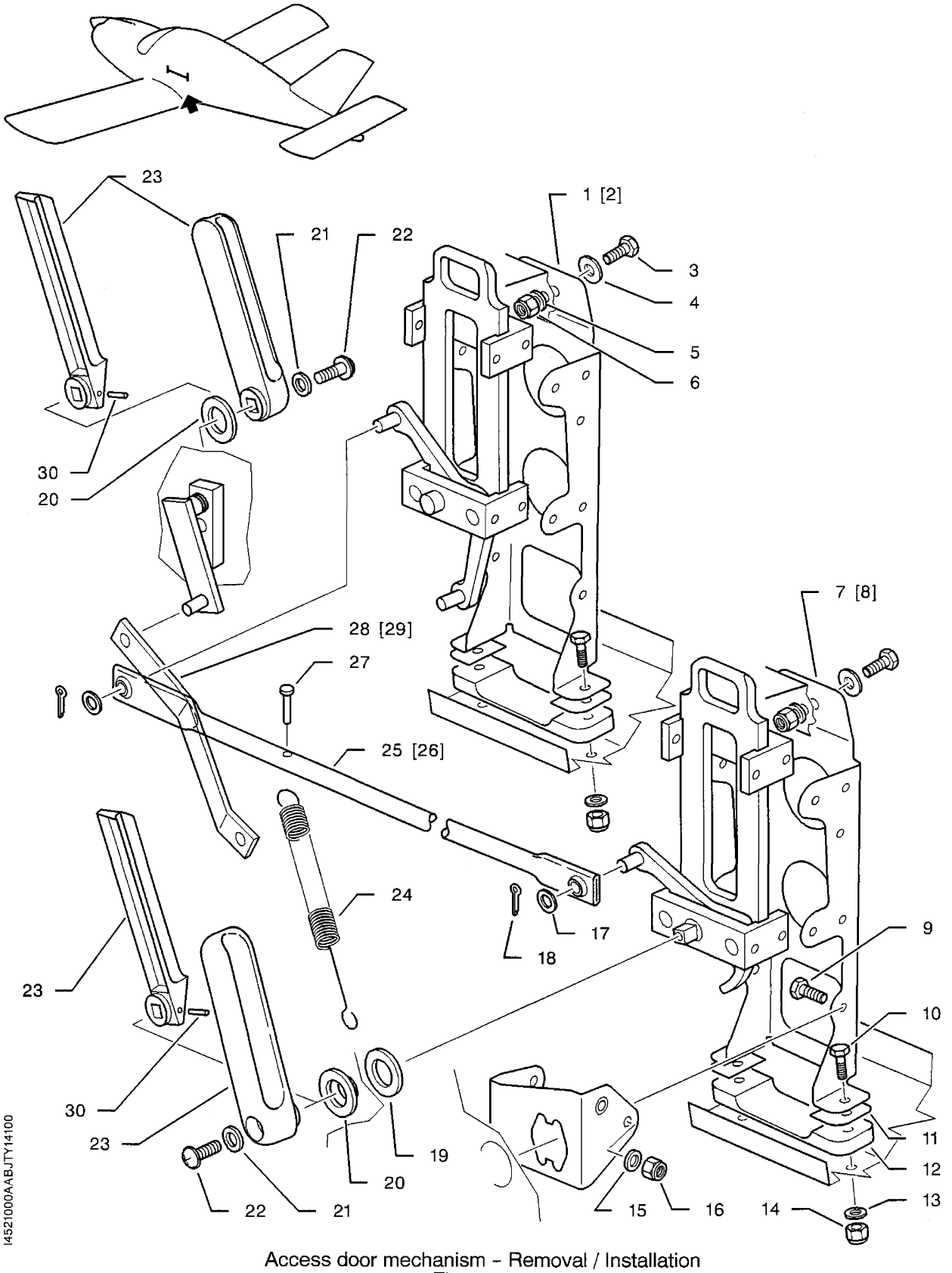
2. INSTALLATION OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

- Cleaning agent (TB 11-003)
- Lintfree clean cloths
- Grease (TB 04-004A)
- Loctite (TB 08-013C)

1 - L.H. FWD box assembly
2 - R.H. FWD box assembly
3 - Bolt
4 - Washer
5 - Washer
6 - Nut
7 - L.H. rear box assembly
8 - R.H. rear box assembly
9 - Bolt
10 - Bolt
11 - Adjusting shim
12 - Shim
13 - Washer
14 - Nut
15 - Washer
16 - Nut
17 - Washer
18 - Cotter pin
19 - Washer
20 - Washer
21 - Washer
22 - Screw
23 - Handle
24 - Spring
25 - L.H. interconnection rod
26 - R.H. interconnection rod
27 - Clevis pin
28 - L.H. link rod
29 - R.H. link rod
30 - Pin

Access door mechanism - Removal / Installation
Key to Figure 401



Access door mechanism - Removal / Installation
Figure 401

B. Procedure

1) Inspect the parts for correct condition, replace if necessary.
2) Clean the parts with lintfree clean cloths and cleaning agent (TB 11-003).
3) Install FWD box assembly (1) [2] and rear box assembly (7) [8]. Install washer (19).
4) Install interconnection rod (25) [26] and link rod (28) [29]. Secure with washers (17) and new cotter pins (18).
5) Install bolts (3), washers (4), washers (5) and new nuts (6).
6) Install bolts (9), washers (15) and new nuts (16).
7) Install shims (12) (if installed) and adjusting shims (11).

   NOTE : Install 3 adjusting shims (11) maximum under the rear box only.

8) Install bolts (10), washers (13) and new nuts (14).
9) Install clevis pin (27) and secure spring (24) to interconnection rod (25) [26].
10) Install the external access door handle.

    S / N 1 - 145

    a) Install washer (20) and handle (23). Install a new pin (30).

    S / N 146 - 9999

    a) Apply some loctite (TB 08-013C) to thread of screw (22) - refer to 20-00-08.
    b) Install washer (20), handle (23), washer (21) and screw (22).

11) Lubricate the access door mechanism - refer to 12-21-02.
12) Check the access door mechanism for correct operation.
13) Check the access door for correct locking, adjust if necessary - refer to 52-10-00.
14) Make sure all the tools and materials are removed and the work area is clean and free from debris.
15) Bond the sealing cloth.
16) Install the side upholstery panels.
17) Install the internal access door handle.

    S / N 1 - 145

    a) Install washer (20) and handle (23). Install a new pin (30).

    S / N 146 - 9999

    a) Install washer (20), handle (23), washer (21) and screw (22).

18) Install the front seat - refer to 25-11-00.
19) If installed, operate the L.H. access door mechanism and check the rear overhead light for correct operation. Adjust if necessary - refer to 33-10-00.

ACCESS DOOR MECHANISM

REMOVAL / INSTALLATION

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

1. REMOVAL OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

None

B. Procedure

1) Open the access door.

2) Remove the front seat - refer to 25-11-00.

3) Remove the internal and external access door handles (21). Retain screws (20), washers (19) and washers (18).

4) Remove the side upholstery panels.

5) Sufficiently debond the sealing cloth to gain access to the access door mechanism.

6) Remove spring (24) from interconnection rod (26) [27] and spring (25) from lever (30) [31].

7) Remove bolts (39) and washers (38).

8) Remove screws (42) and washers (41).

9) Remove support assembly (32) [33].

10) Remove and discard cotter pins (23). Retain washers (22).

11) Remove and discard nuts (6). Remove washers (5), bolts (3) and washers (4).

12) Remove and discard nuts (16). Remove washers (15) and bolts (9).

13) Remove and discard nuts (14). Remove washers (13) and bolts (10).

14) Disconnect interconnection rod (26) [27] and link rod (28) [29].

15) Remove FWD box assembly (1) [2] and rear box assembly (7) [8]. Retain washer (17), adjusting shims (11) and shims (12) if installed.

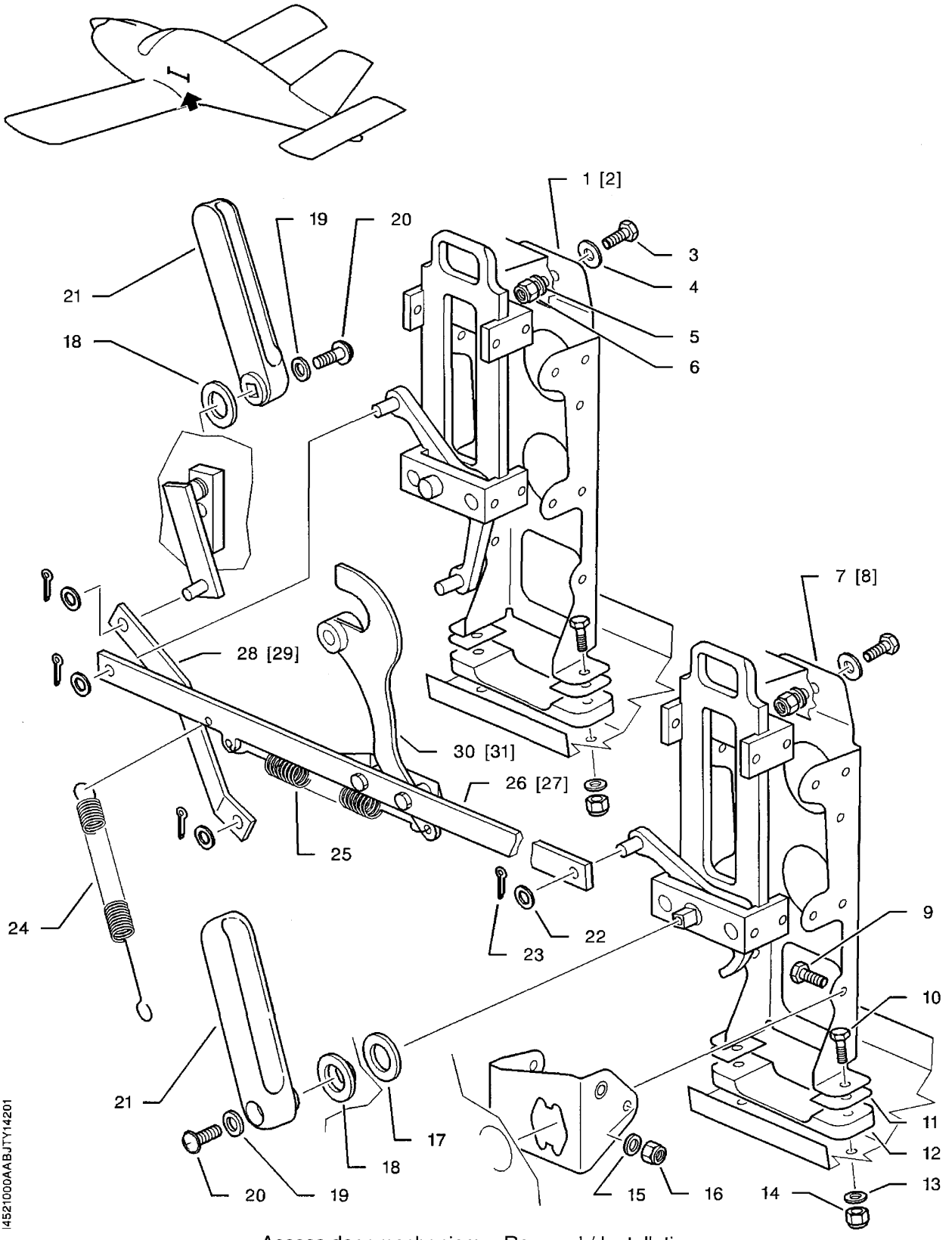
16) If necessary, disassemble support assembly (32) [33].

a) Remove and discard nut (37). Retain washer (36).

b) Remove bolt (34) and lever (30) [31]. Retain spacer (35) and washer (40).

1 - L.H. FWD box assembly
2 - R.H. FWD box assembly
3 - Bolt
4 - Washer
5 - Washer
6 - Nut
7 - L.H. rear box assembly
8 - R.H. rear box assembly
9 - Bolt
10 - Bolt
11 - Adjusting shim
12 - Shim
13 - Washer
14 - Nut
15 - Washer
16 - Nut
17 - Washer
18 - Washer
19 - Washer
20 - Screw
21 - Access door handle
22 - Washer
23 - Cotter pin
24 - Spring
25 - Spring
26 - L.H. interconnection rod
27 - R.H. interconnection rod
28 - L.H. link rod
29 - R.H. link rod
30 - L.H. lever
31 - R.H. lever

Access door mechanism - Removal / Installation
Key to Figure 401 (1/2)



Access door mechanism - Removal / Installation
Figure 401 (1/2)

ABAB
Validity : S / N 1 - 9999 Pre-MOD. 151
With door stop system

2. INSTALLATION OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

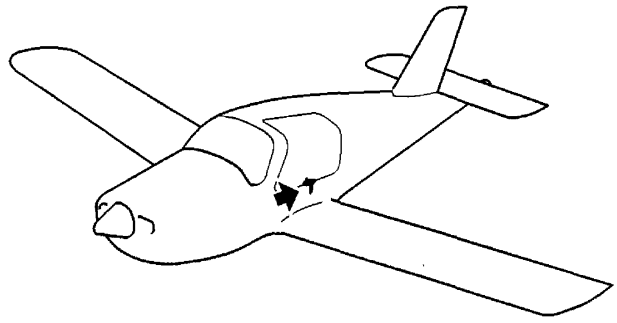
- Cleaning agent (TB 11-003)
- Lintfree clean cloths
- Grease (TB 04-004A)
- Loctite (TB 08-013C)

B. Procedure

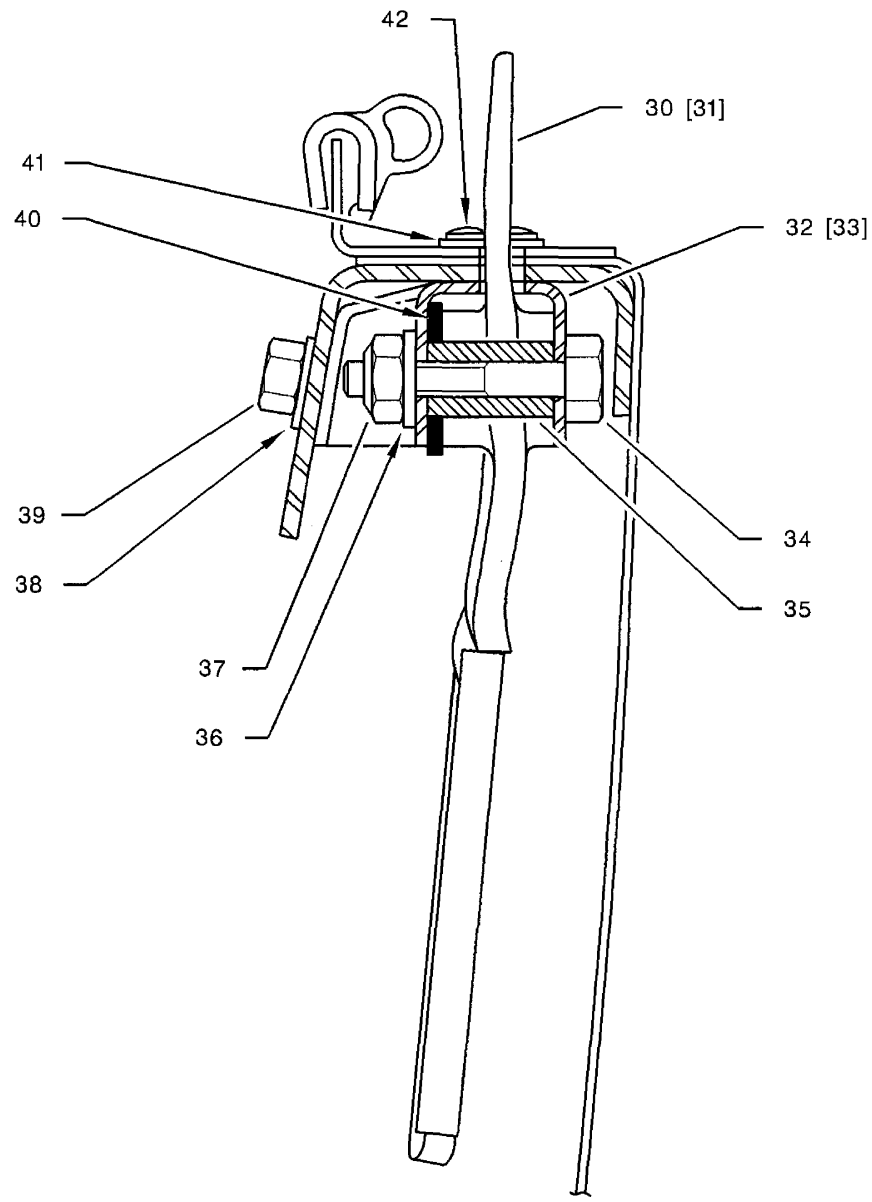
1) Inspect the parts for correct condition, replace if necessary.
2) Clean the parts with lintfree clean cloths and cleaning agent (TB 11-003).
3) If disassembled, assemble support assembly (32) [33].
   a) Lubricate bolt (34) with grease (TB 04-004A).
   b) Install washer (40) and spacer (35) in lever (30) [31].
   c) Install lever (30) [31] in support assembly (32) [33] then install bolt (34).
   d) Install washer (36) and a new nut (37).
4) Install FWD box assembly (1) [2] and rear box assembly (7) [8]. Install washer (17).
5) Install interconnection rod (26) [27] and link rod (28) [29]. Secure with washers (22) and new cotter pins (23).
6) Install bolts (3), washers (4), washers (5) and new nuts (6).
7) Install bolts (9), washers (15) and new nuts (16).
8) Install shims (12) (if installed) and adjusting shims (11).

   NOTE : Install 3 adjusting shims (11) maximum under the rear box only.

9) Install bolts (10), washers (13) and new nuts (14).
10) Install and secure support assembly (32) [33] with screws (42), washers (41), bolts (39) and washers (38).
11) Secure spring (24) to interconnection rod (26) [27] and spring (25) to lever (30) [31].
12) Apply some loctite (TB 08-013C) to thread of screw (20) - refer to 20-00-08.
13) Install the external access door handle (21) with washer (18), washer (19) and screw (20).
14) Lubricate the access door mechanism - refer to 12-21-02.
15) Check the access door mechanism for correct operation.
16) Check the access door for correct locking, adjust if necessary - refer to 52-10-00.
17) Make sure all the tools and materials are removed and the work area is clean and free from debris.
18) Bond the sealing cloth.
19) Install the side upholstery panels.
20) Install the internal access door handle (21) with washer (18), washer (19) and screw (20).
21) Install the front seat - refer to 25-11-00.



30 - L.H. lever
31 - R.H. lever
32 - L.H. support assembly
33 - R.H. support assembly
34 - Bolt
35 - Spacer
36 - Washer
37 - Nut
38 - Washer
39 - Bolt
40 - Washer
41 - Washer
42 - Screw



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Access door mechanism - Removal / Installation
Figure 401 (2/2)

ABAB
Validity : S / N 1 - 9999 Pre-MOD. 151
With door stop system

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ACCESS DOOR MECHANISM

REMOVAL / INSTALLATION

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

1. REMOVAL OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

None

B. Procedure

1) Open the access door.

2) Remove the front seat - refer to 25-11-00.

3) Remove the internal and external access door handles (29). Retain screws (28), washers (27) and washers (26).

4) Remove the side upholstery panels.

5) Sufficiently debond the sealing cloth to gain access to the access door mechanism.

6) Remove spring (30) from interconnection rod (32) [33] and spring (31) from lever (36) [37].

7) Remove bolts (45) and washers (44).

8) Remove screws (47) and washers (46).

9) Remove support assembly (38) [39].

10) Remove and discard cotter pins (21). Retain washers (20).

11) Remove and discard nuts (6). Remove washers (5), bolts (3) and washers (4).

12) Remove and discard nuts (23). Remove washers (22) and bolts (9).

13) Remove and discard nuts (14). Remove washers (13) and bolts (10).

14) Disconnect interconnection rod (32) [33] and link rod (34) [35].

15) Remove FWD box assembly (1) [2] and rear box assembly (7) [8]. Retain washer (25), adjusting shims (11) and shims (12).

16) If necessary, disassemble support assembly (38) [39].

   a) Remove and discard nut (43). Retain washer (42).

   b) Remove bolt (40), remove lever (36) [37]. Retain spacer (41).

17) If necessary, remove lock (24).

   a) Remove nut (15), washer (16) and locking pin (17) [18].

   b) Remove nut (19) and remove lock (24).

2. INSTALLATION OF THE ACCESS DOOR MECHANISM (Figure 401)

A. Tools and consumable materials

- Cleaning agent (TB 11-003)
- Lintfree clean cloths
- Grease (TB 04-004A)
- Loctite (TB 08-013C)

B. Procedure

1) Inspect the parts for correct condition, replace if necessary.
2) Clean the parts with lintfree clean cloths and cleaning agent (TB 11-003).
3) If removed, install lock (24).
   a) Install lock (24), install and lock nut (19) with Loctite (TB 08-013C).
   b) Install locking pin (17) [18] and washer (16).
   c) Install and lock nut (15) with Loctite (TB 08-013C).
4) If disassembled, assemble support assembly (38) [39].
   a) Lubricate bolt (40) with grease (TB 04-004A).
   b) Install spacer (41) in lever (36) [37].
   c) Install lever (36) [37] in support assembly (38) [39] then install bolt (40).
   d) Install washer (42) and a new nut (43).
5) Install FWD box assembly (1) [2] and rear box assembly (7) [8]. Install washer (25).
6) Install interconnection rod (32) [33] and link rod (34) [35]. Secure with washers (20) and new cotter pins (21).
7) Install bolts (3), washers (4), washers (5) and new nuts (6).
8) Install bolts (9), washers (22) and new nuts (23).
9) Install shims (12) and adjusting shims (11).

   NOTE : Install 3 adjusting shims (11) maximum under the rear box only.

10) Install bolts (10), washers (13) and new nuts (14).
11) Install and secure support assembly (38) [39] with screws (47), washers (46), bolts (45) and washers (44).
12) Secure spring (30) to interconnection rod (32) [33] and spring (31) to lever (36) [37].
13) Apply some loctite (TB 08-013C) to thread of screw (28) - refer to 20-00-08.
14) Install the external access door handle (29) with washer (26), washer (27) and screw (28).
15) Lubricate the access door mechanism - refer to 12-21-02.
16) Check the access door mechanism for correct operation.
17) Check the access door for correct locking, adjust if necessary - refer to 52-10-00.

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

19) Bond the sealing cloth.

20) Install the side upholstery panels.

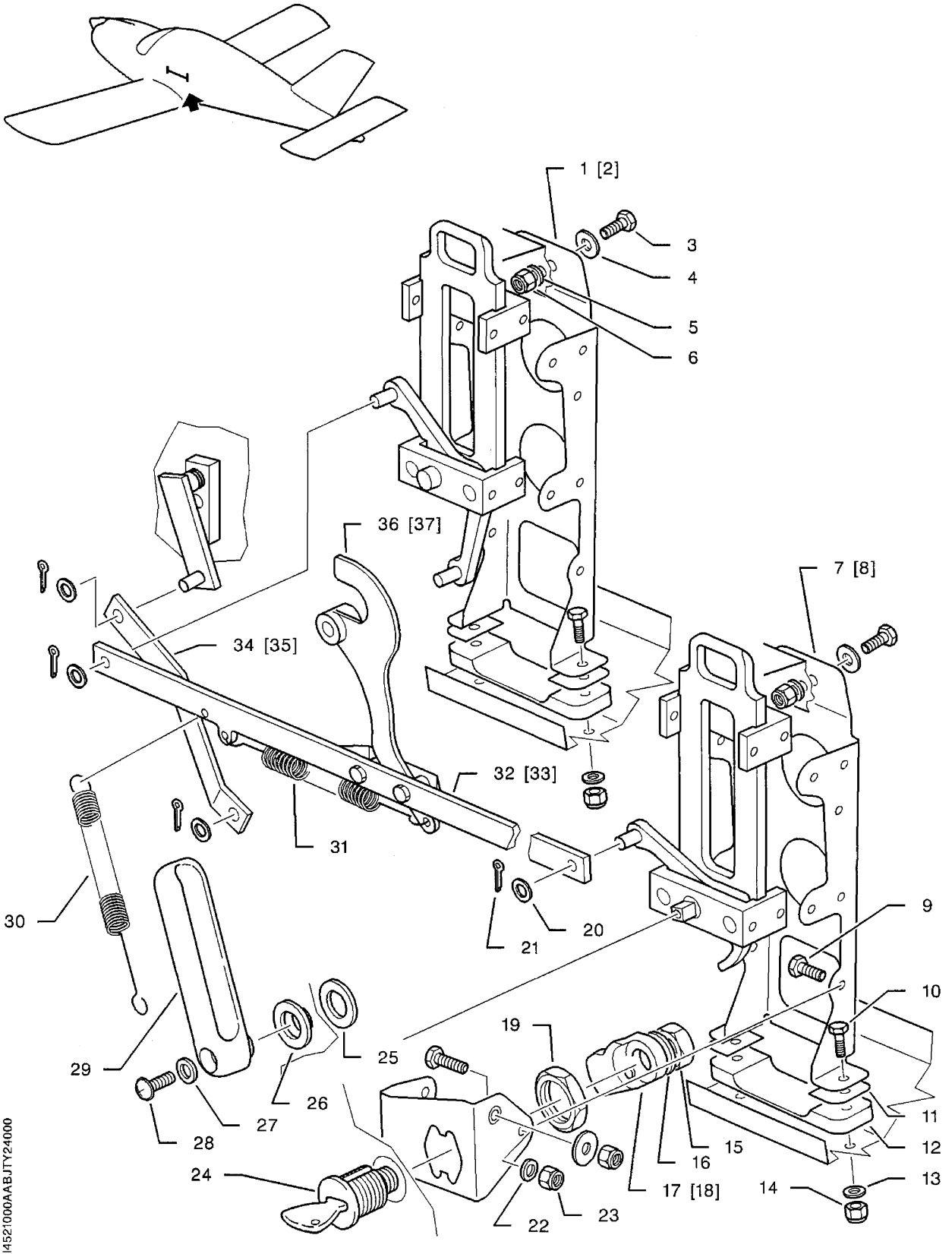
21) Install the internal access door handle (29) with washer (26), washer (27) and screw (28).

22) Install the front seat - refer to 25-11-00.

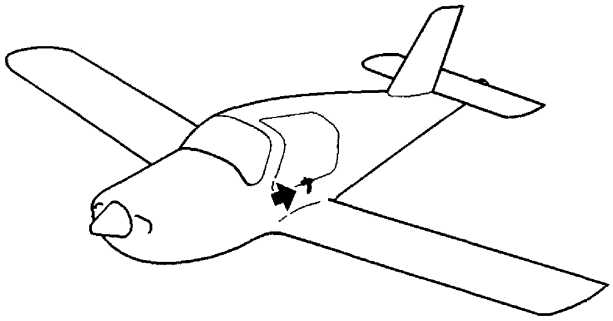
23) If installed, operate the L.H. access door mechanism and check the rear overhead light for correct operation. Adjust if necessary - refer to 33-10-00.

1 - L.H. FWD box assembly
2 - R.H. FWD box assembly
3 - Bolt
4 - Washer
5 - Washer
6 - Nut
7 - L.H. rear box assembly
8 - R.H. rear box assembly
9 - Bolt
10 - Bolt
11 - Adjusting shim
12 - Shim
13 - Washer
14 - Nut
15 - Nut
16 - Washer
17 - L.H. locking pin
18 - R.H. locking pin
19 - Nut
20 - Washer
21 - Cotter pin
22 - Washer
23 - Nut
24 - Lock
25 - Washer
26 - Washer
27 - Washer
28 - Screw
29 - Handle
30 - Spring
31 - Spring
32 - L.H. interconnection rod
33 - R.H. interconnection rod
34 - L.H. link rod
35 - R.H. link rod
36 - L.H. lever
37 - R.H. lever

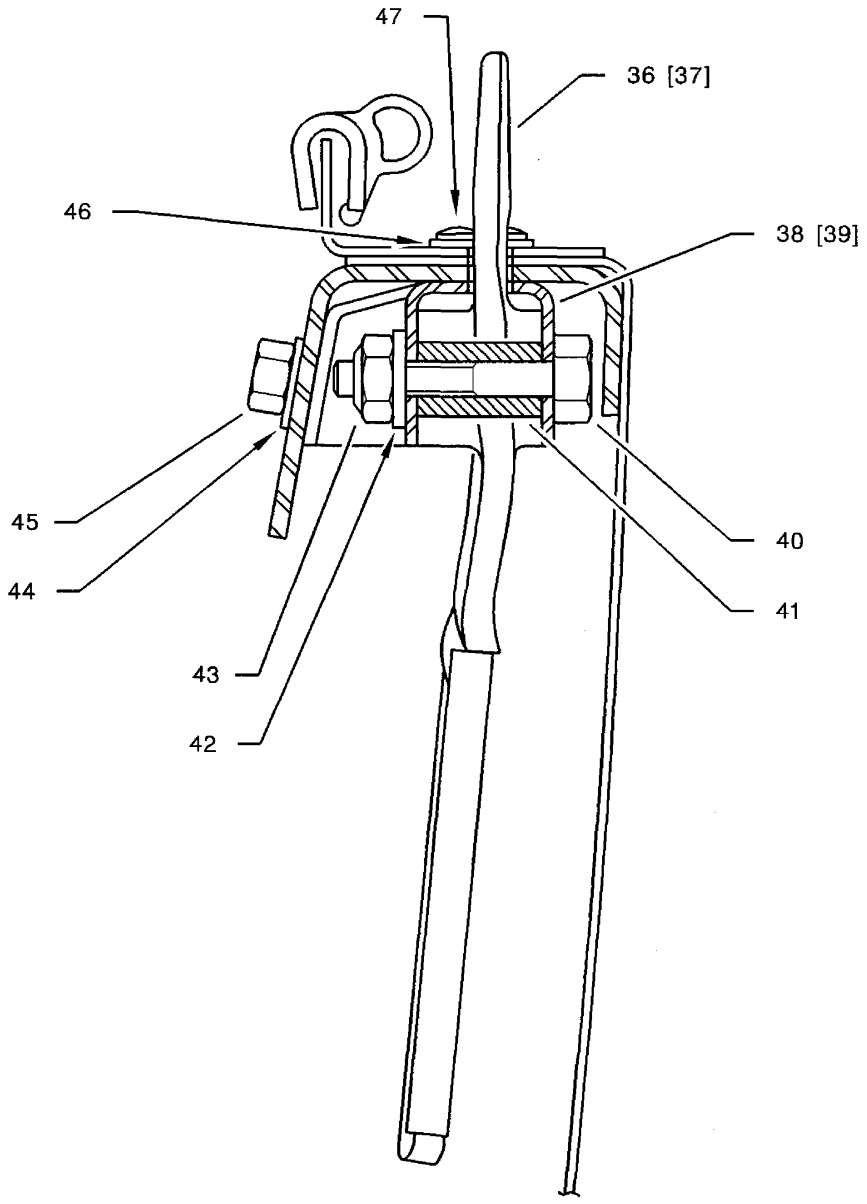
Access door mechanism - Removal / Installation
Key to Figure 401 (1/2)



Access door mechanism - Removal / Installation
Figure 401 (1/2)



36 - L.H. lever
37 - R.H. lever
38 - L.H. support assembly
39 - R.H. support assembly
40 - Bolt
41 - Spacer
42 - Washer
43 - Nut
44 - Washer
45 - Bolt
46 - Washer
47 - Screw



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Access door mechanism - Removal / Installation
Figure 401 (2/2)