

CHAPTER - 52 HIGHLIGHTS
(Summary of Changes)

Revision No. TR52-2 Apr 24/19

TO: HOLDERS OF THE AIRCRAFT MAINTENANCE MANUAL (06-117751)

Pages that have been added or revised are summarized below. Remove and insert the affected pages as listed, and enter the above revision number with issue date into the Record of Revisions sheet.

This Temporary Revision incorporates and supersedes previously released temporary revisions for the chapters listed below.

Do not remove this page. Keep it in place as a record of previous changes.

CH/SE/SU Page Block No.	Description of Change
52-00-00 PgBlk 601	Added Passenger Door Lock Inspection.
52-10-21 PgBlk 401-Rem	Added Passenger Door Lock Pin – Removal task to AMM.
52-10-21 PgBlk 401-Inst	Added Passenger Door Lock Pin – Installation task to AMM.

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DOORS - INSPECTION/CHECK

AMM-52-00-00-021-801

1. General

- A. This task gives procedures to do inspection/check of aircraft doors.
- B. Aircraft doors are located as follows:
 - Passenger/crew door: left side of aircraft
 - Emergency exit door: right side of aircraft
 - Entrance stairs: lower door assembly
 - Landing gear doors: nose gear and main landing gear

2. Job Set-Up

SUBTASK AMM-52-00-00-021-921-001

(Refer to [Fig. 601.](#))

- A. Make aircraft safe for maintenance. Refer to [AMM-20-00-01-051-801 – Make Safe For Maintenance.](#)
- B. Remove the 241 AR - Upper Cabin Door interior panel. Refer to [AMM-25-21-23-001-801 – Upper Door Panel - Removal.](#)
- C. Remove the 241 HZ - Lower Cabin Door Panel Closeout from the lower door assembly (1). Refer to [AMM-06-50-00-051-801 – Aircraft Access Panels.](#)

3. Inspection/Check

SUBTASK AMM-52-00-00-021-211-001

(Refer to [Fig. 601](#), & [Fig. 602.](#))

- A. Examine upper door assembly (5) and lower door assembly (1) as follows. If necessary, refer to [AMM-52-10-10-001-801 – Passenger Door Assembly - Removal](#) for removal and [AMM-52-10-10-041-801 – Passenger Door Assembly - Installation](#) for installation.
 - (1) Examine the upper door assembly (5) for loose or missing hardware and worn or damaged parts.
 - (2) Make sure that the upper door assembly (5) metal surfaces are clean and have no corrosion.
 - (3) Examine the lower door assembly (1) for loose or missing hardware and worn or damaged parts.
 - (4) Make sure that the lower door assembly (1) metal surfaces are clean and have no corrosion.
 - (5) Close the lower door assembly (1).

- (6) Make sure that the lower door assembly (1) remains closed and is flush with the fuselage.
- (7) Close the upper door assembly (5) .
- (8) Make sure that the upper door assembly (5) is flush with the fuselage.
- (9) From outside the aircraft, open the upper door assembly (5) with the exterior handle (6) . Make sure that the upper door assembly (5) and exterior handle (6) operates smoothly.
- (10) Make sure that the upper door strut (4) extends the upper door assembly (5) to the full open position.
- (11) From outside the aircraft, open the lower door assembly (1) . Make sure that the lower door assembly (1) operates smoothly and the steps (9) extend to a horizontal position.
- (12) Check the door support cables (8) for wear or damage.
- (13) Check the terminal ends of door support cables (8) as follows:
 - (a) Make sure that no less than three threads are visible on each door support cable (8) end.
 - (b) Make sure that the locking clips are installed on each door support cable (8) .
- (14) Check the step cable (2) for wear or damage.
- (15) Check the step cable pulley (3) for wear or damage.
- (16) Make sure that the door seal (7) is correctly installed and shows no signs of wear or damage.
- (17) From inside the aircraft, close the lower door assembly (1) .
- (18) Make sure that the lower door assembly (1) operates smoothly.
- (19) From inside the aircraft, close the upper door assembly (5) with the internal handle (10) .
- (20) Make sure that the upper door assembly (5) and internal handle (10) operates smoothly.
- (21) Turn the internal handle (10) to the full aft/horizontal (closed) position.
- (22) Make sure that the internal handle (10) operates smoothly.
- (23) Make sure that the five locking flags (13) change from barber pole black/white to solid green.
- (24) Make sure that the lock knob assembly automatically retracts and the lock flag ring (14) on the lock knob (12) can not be seen.
- (25) With the lock knob (12) in the locked position, make sure that the internal handle (10) can not be opened.
- (26) Pull the lock knob (12) out and turn the internal handle (10) to a full vertical (open) position.
- (27) Make sure that the internal handle (10) operates smoothly and the five locking flags (13) change from solid green to barber pole black/white.

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- (28) Check the internal handle (10) force to make sure that the handle over-center spring operates correctly.
 - (29) Make sure that the lock knob (12) moves freely with the door handle (10) in the open position.
 - (30) Make sure that the lock flag ring (14) on the lock knob (12) can be seen.
- B. Examine the emergency exit door (1) as follows. If necessary, refer to [AMM-52-20-10-001-801 – Emergency Hatch - Removal](#) for removal and [AMM-52-20-10-041-801 – Emergency Hatch - Installation](#) for installation.
- (1) Examine the emergency exit door (1) metal surfaces are clean and have no corrosion.
 - (2) From inside the aircraft, remove the cover (5) and ball lock pin (6) .
 - (3) Pull out the internal handle (4) to disengage the door latch from the fuselage.
 - (4) Lift the emergency exit door (1) from the fuselage.
 - (5) Make sure that the internal handle (4) and door latch operates smoothly.
 - (6) Make sure that the door seal (7) is correctly installed and shows no signs of wear or damage.
 - (7) Install the emergency exit door (1) in the fuselage as follows:
 - (a) Install the emergency exit door (1) on the aircraft.
 - (b) Hold the internal handle (4) and align the lower latch to lower receiver.
 - (c) Pull the internal handle (4) and emergency exit door (1) to latch the upper section to upper receiver. Turn the internal handle (4) down to lock the door in position.
 - (d) Install the ball lock pin (6) .
 - (e) Install the cover (5) on the internal handle (4) .
 - (8) From outside the aircraft, push in the push panel (2) and turn the external handle (3) to disengage the door latch from fuselage.
 - (9) Lift the emergency exit door (1) from the fuselage.
 - (10) Make sure that the external handle (3) and door latch operates smoothly.
 - (11) Install the emergency exit door (1) in the fuselage as follows:
 - (a) Install the emergency exit door (1) on the aircraft.
 - (b) Hold the internal handle (4) and align the lower latch to lower receiver.
 - (c) Pull the internal handle (4) and emergency exit door (1) to latch the upper section to upper receiver. Turn the emergency exit door (1) down to lock the door in position.
 - (d) Install the ball lock pin (6) .
 - (e) Install the cover (5) on the internal handle (4) .
 - (12) Make sure that the emergency exit door (1) is flush with the fuselage.

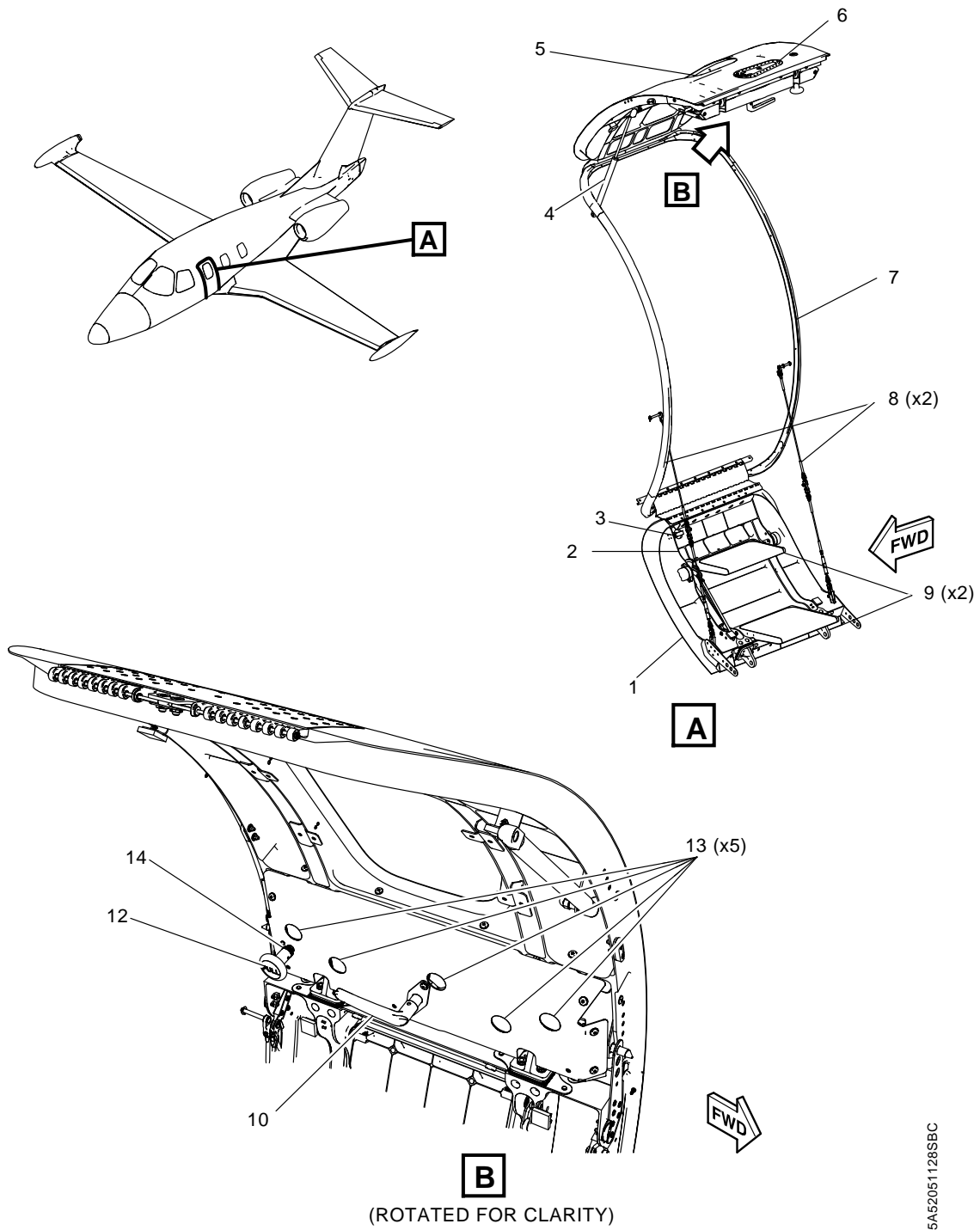
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- C. Do inspection/check of entrance stairs. Refer to [AMM-52-60-00-021-801 – Entrance Stairs - Inspection/Check](#).
 - D. Do an inspection/check of the landing gear doors. Refer to [AMM-32-10-00-021-801 – Main Gear and Doors - Inspection/Check](#) and [AMM-32-20-00-021-801 – Nose Gear and Doors - Inspection/Check](#).

4. **Job Close-up**

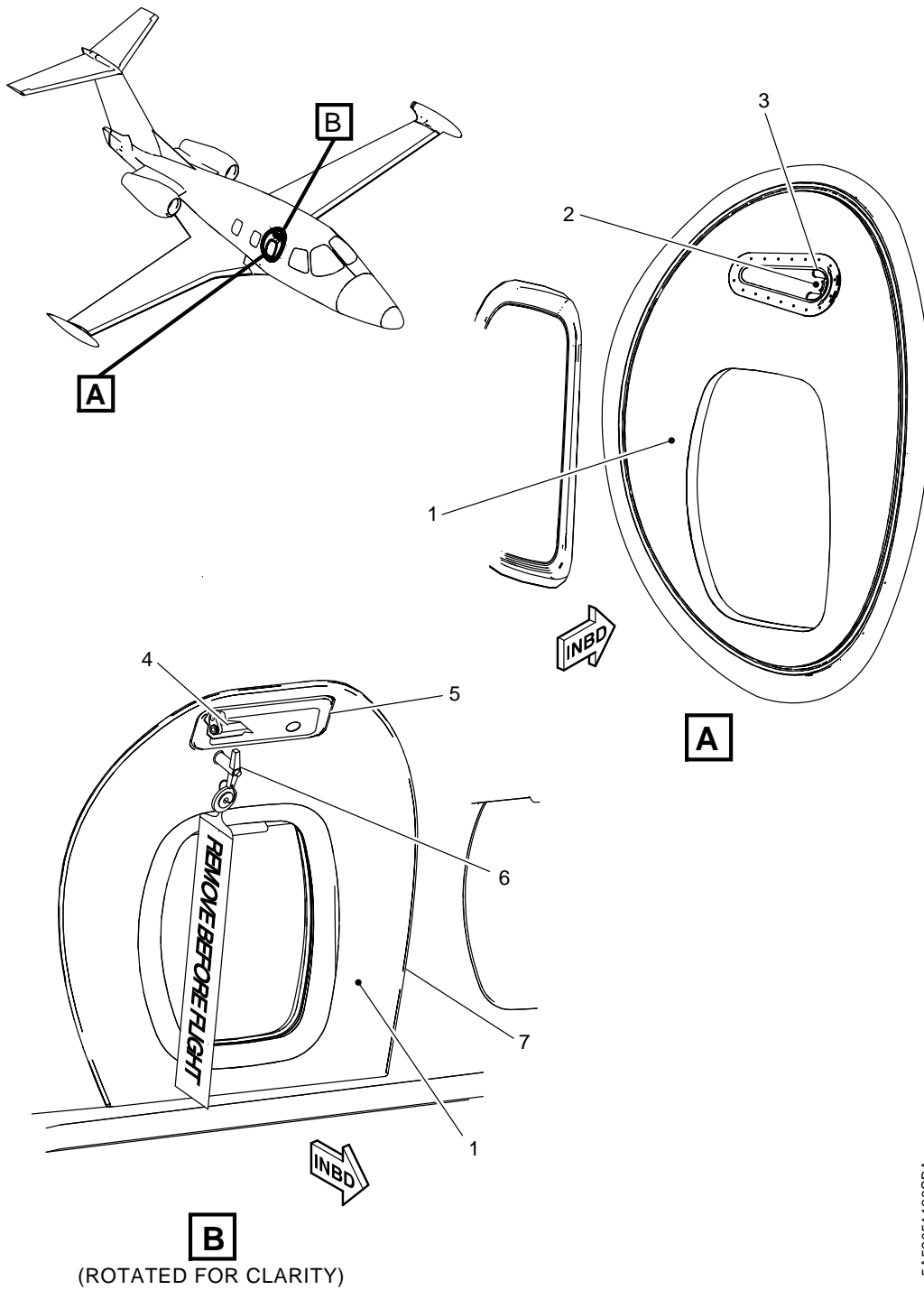
SUBTASK AMM-52-00-00-021-921-002

(Refer to [Fig. 601](#).)

- A. Install the 241 AR - Upper Cabin Door interior panel. Refer to [AMM-25-21-23-041-801 – Upper Door Panel - Installation](#).
- B. Install the 241 HZ - Lower Cabin Door Panel Closeout on the lower door assembly (1) . Refer to [AMM-06-50-00-051-801 – Aircraft Access Panels](#) for location and removal instructions.
- C. Remove all tools, equipment and unwanted material from work area.
- D. If all other maintenance is complete, return aircraft to service. Refer to [AMM-20-00-02-051-801 – Return To Service \(After Maintenance\)](#).



**Passenger/Crew Door Assembly - Inspection/Check
Figure 601 (Sheet 1 of 1)**



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**Emergency Exit Door - Inspection/Check
Figure 602 (Sheet 1 of 1)**

PASSENGER DOOR LOCK PIN - REMOVAL

AMM-52-10-21-001-801

1. General

- A. This task gives procedures to remove the passenger door lock pin assembly.
- B. The passenger door lock pin assembly are on the upper door assembly.

2. Job Set-Up

SUBTASK AMM-52-10-21-001-921-001

- A. Make aircraft safe for maintenance. Refer to [AMM-20-00-01-051-801 – Make Safe For Maintenance](#).
- B. Remove Upper Door Panel. Refer to [AMM-25-21-23-001-801 – Upper Door Panel - Removal](#).

3. Procedure

SUBTASK AMM-52-10-21-001-011-001

(Refer to [Fig. 401](#).)

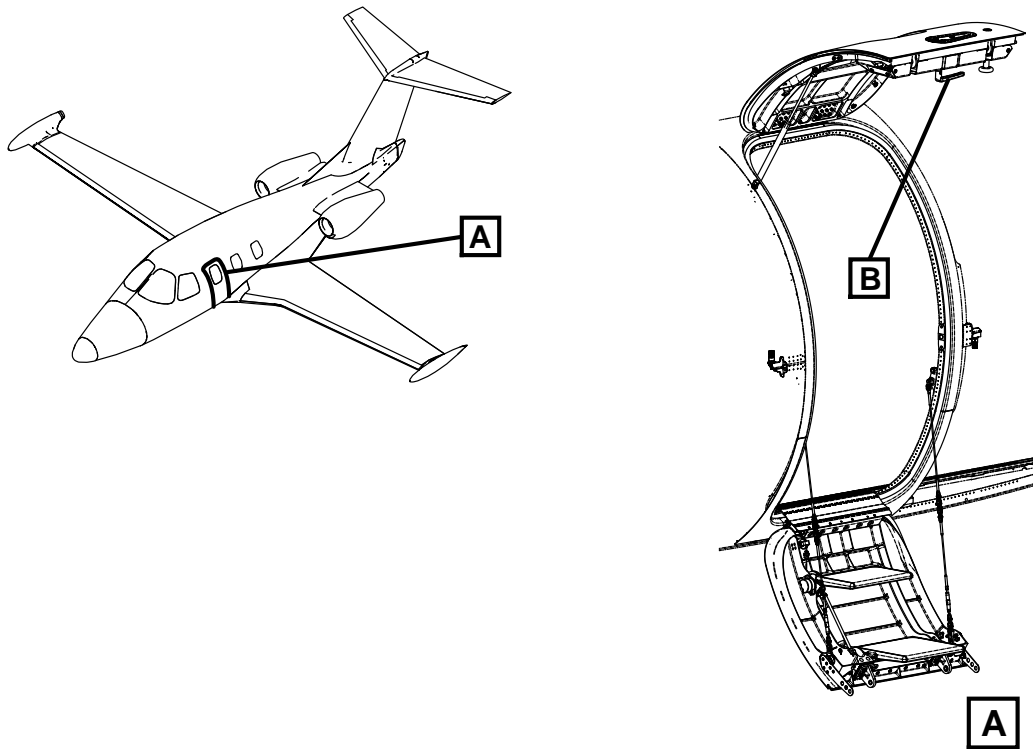
- A. Remove cover assembly (6) as follows:
 - (1) From inside aircraft, lower, but do not close or latch the upper door assembly (1).
 - (2) Remove set screw (9) that attaches lock knob (10) to lock pin (3).
 - (3) Remove lock knob (10) from lock pin (3).
 - (4) Remove set screw (7) that attaches door handle (8) to door handle actuator (19).
 - (5) Remove door handle (8) from door handle actuator (19).
 - (6) Remove screws (4) and washers (5) that attach cover assembly (6) to upper door assembly (1).
 - (7) Remove cover assembly (6) from upper door assembly (1).

SUBTASK AMM-52-10-21-001-011-002

(Refer to [Fig. 401](#).)

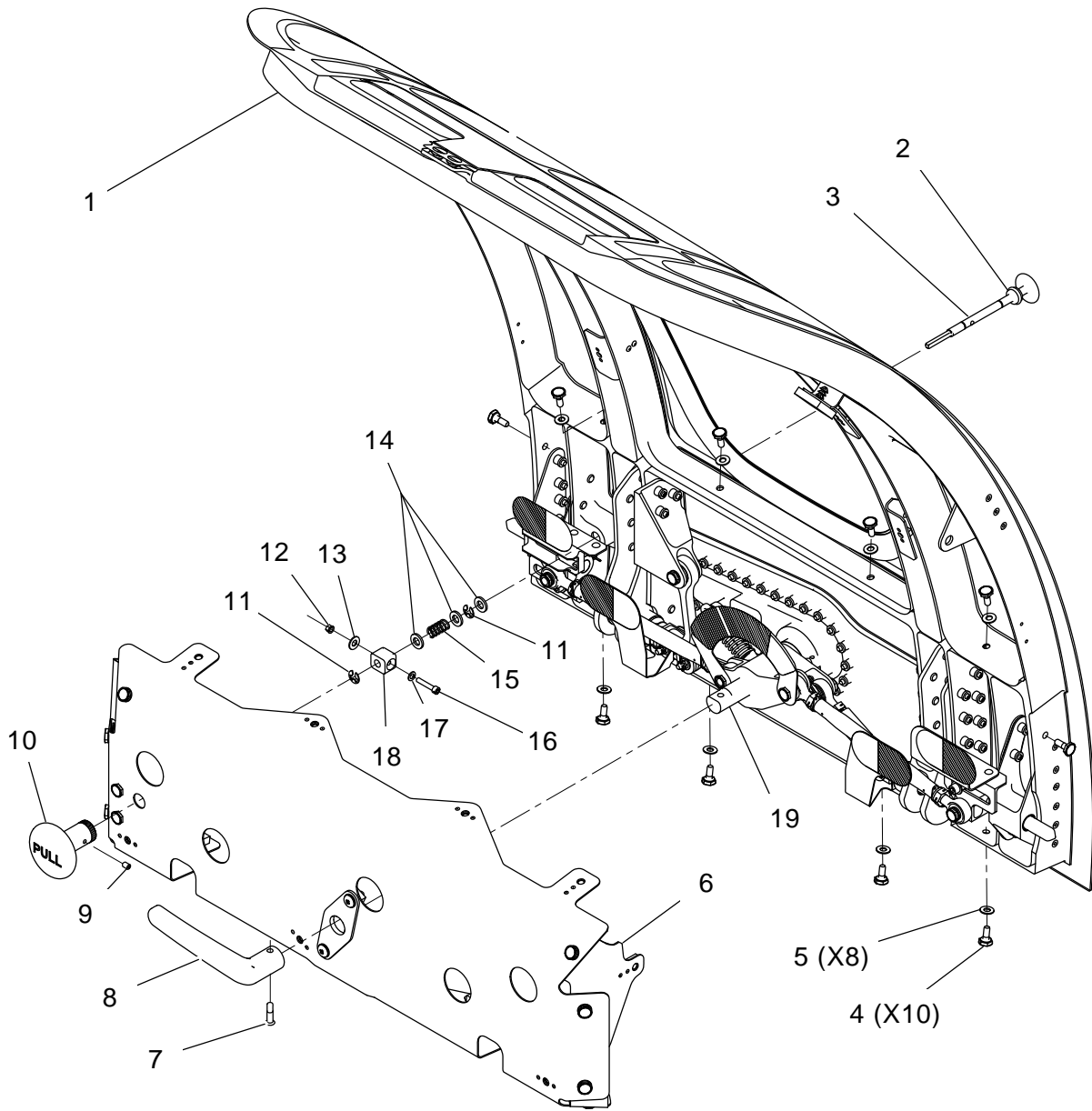
- A. Remove passenger door lock pin (3) as follows:
 - (1) Remove two retaining e-rings (11) from lock pin (3).
 - (2) Remove nut (12), bolt (16), washers (13) and (17), from bushing assembly (18).
 - (3) Push lock pin (3) out from inside the door using care to catch spring (15), washers (14), bushing assembly (18).
 - (4) Remove and discard o-ring (2).
 - (5) Clean passenger door lock pin (3) and bore in which it is installed.

- | (6) Examine for damaged or worn parts. Replace defective parts.



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Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 1 of 3)

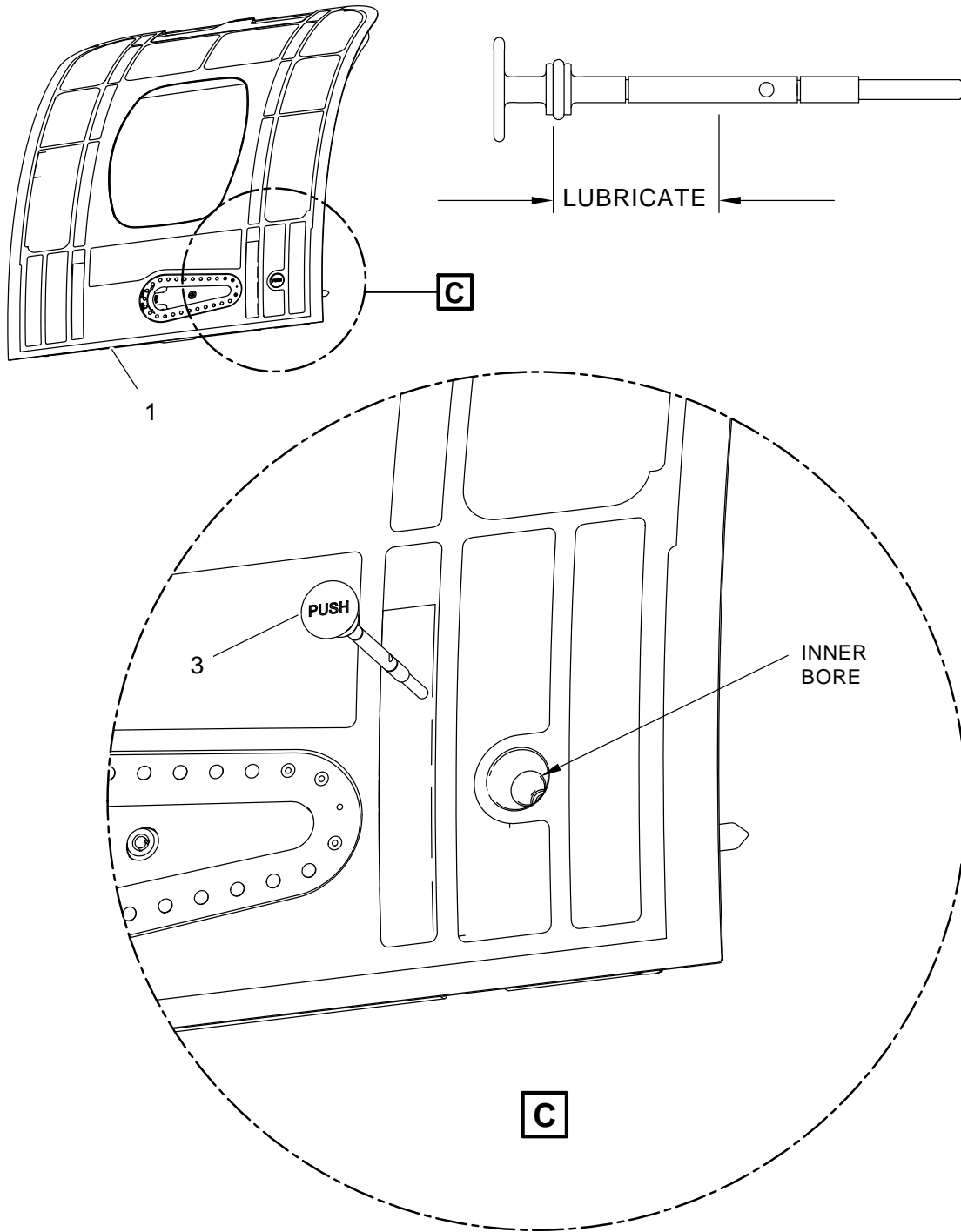


B

(ROTATED FOR CLARITY)

Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 2 of 3)

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Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 3 of 3)

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PASSENGER DOOR LOCK PIN - INSTALLATION

AMM-52-10-21-041-801

1. Job Set-Up

SUBTASK AMM-52-10-21-041-921-001

- A. Make sure aircraft is in same configuration as it was when removal task was completed.
Refer to [AMM-52-10-21-001-801 – Passenger Door Lock Pin - Removal](#).

2. Procedure

SUBTASK AMM-52-10-21-041-411-001

(Refer to .)

- A. Install passenger door lock pin (3) on to upper passenger door (1) as follows:
- (1) Install o-ring (2) on to passenger door lock pin (3) .
 - (2) Lightly lubricate passenger door lock pin (3) and o-ring (2) with Aeroshell 7/Aeroshell 33 grease (MIL-PRF-23827C).
 - (3) Lightly lubricate passenger door lock pin bore with Aeroshell 7/Aeroshell 33 grease (MIL-PRF-23827C).
 - (4) Slide passenger door lock pin (3) with installed o-ring (2) into upper passenger door lock pin bore.
 - (5) Assemble spring (15) , washers (14) , bushing assembly (18) , and retaining e-rings (11) on to passenger door lock pin (3) .
 - (6) Install nut (12) , bolt (16) , washers (13) and (17) , onto bushing assembly (18) .

SUBTASK AMM-52-10-21-041-411-002

(Refer to [Fig. 401](#).)

- A. Install cover assembly (6) as follows:
- (1) From inside aircraft, lower, but do not close and latch upper door assembly (1) .
 - (2) Put cover assembly (6) on upper door assembly (1) and align holes.
 - (3) Attach cover assembly (6) to upper door assembly (1) with screws (4) and washers (5) . Tighten screws (4) until cover assembly (6) and upper door assembly (1) do not move.
 - (4) Put door handle (8) on door handle actuator (19) .
 - (5) Attach door handle (8) to door handle actuator (19) with set screw (7) . Tighten set screw (7) until door handle (8) and door handle actuator (19) do not move.
 - (6) Put lock knob (10) on lock pin (3) .
 - (7) Attach lock knob (10) to lock pin (3) with set screw (9) . Tighten set screw (9) until lock knob (10) and lock pin (3) do not move.

EFFECTIVITY: ALL

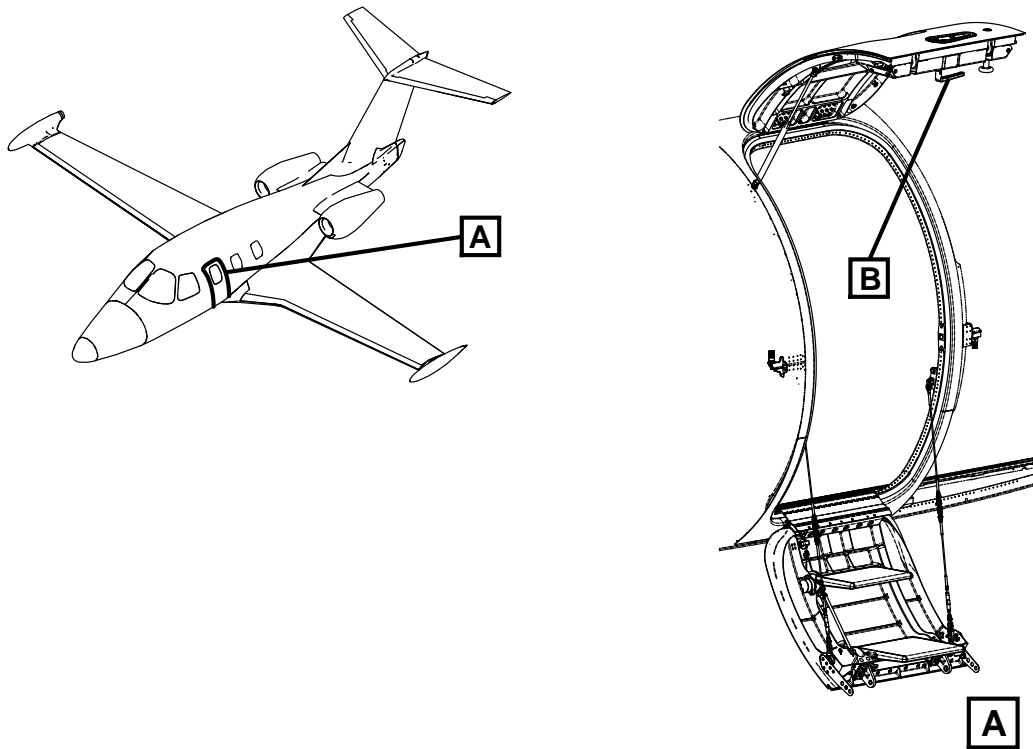
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3. Job Close-Up

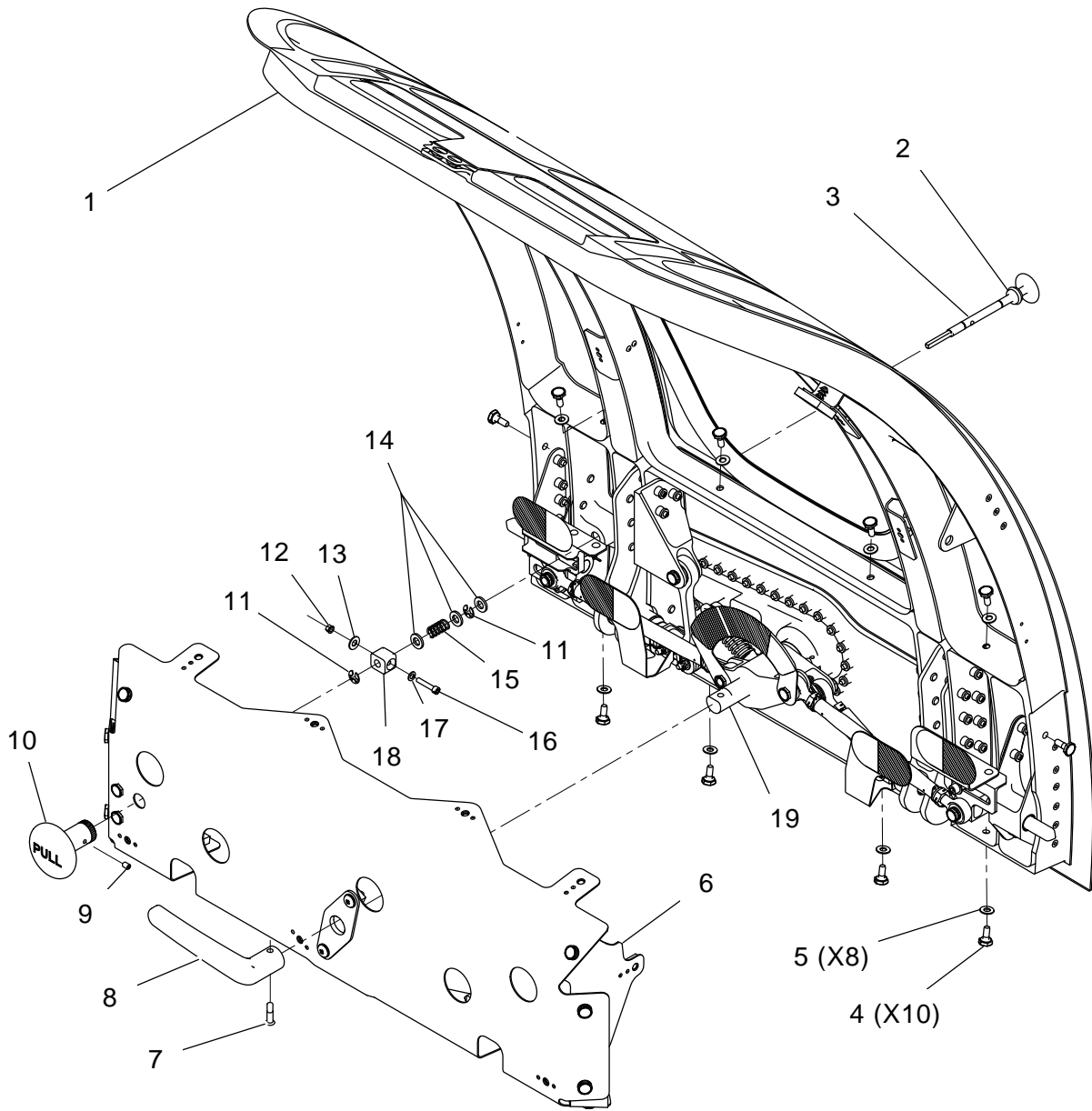
SUBTASK AMM-52-10-21-041-921-002

- A. Install Upper Door Panel. Refer to [AMM-25-21-23-041-801 – Upper Door Panel - Installation](#) .
- B. Remove all tools, equipment and unwanted material from work area.
- C. Do adjustment/testing of door. Refer to [AMM-52-00-00-071-801 – Doors - Adjustment/ Test](#).
- D. If all other maintenance is complete, return aircraft to service. Refer to [AMM-20-00-02-051-801 – Return To Service \(After Maintenance\)](#).



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Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 1 of 3)

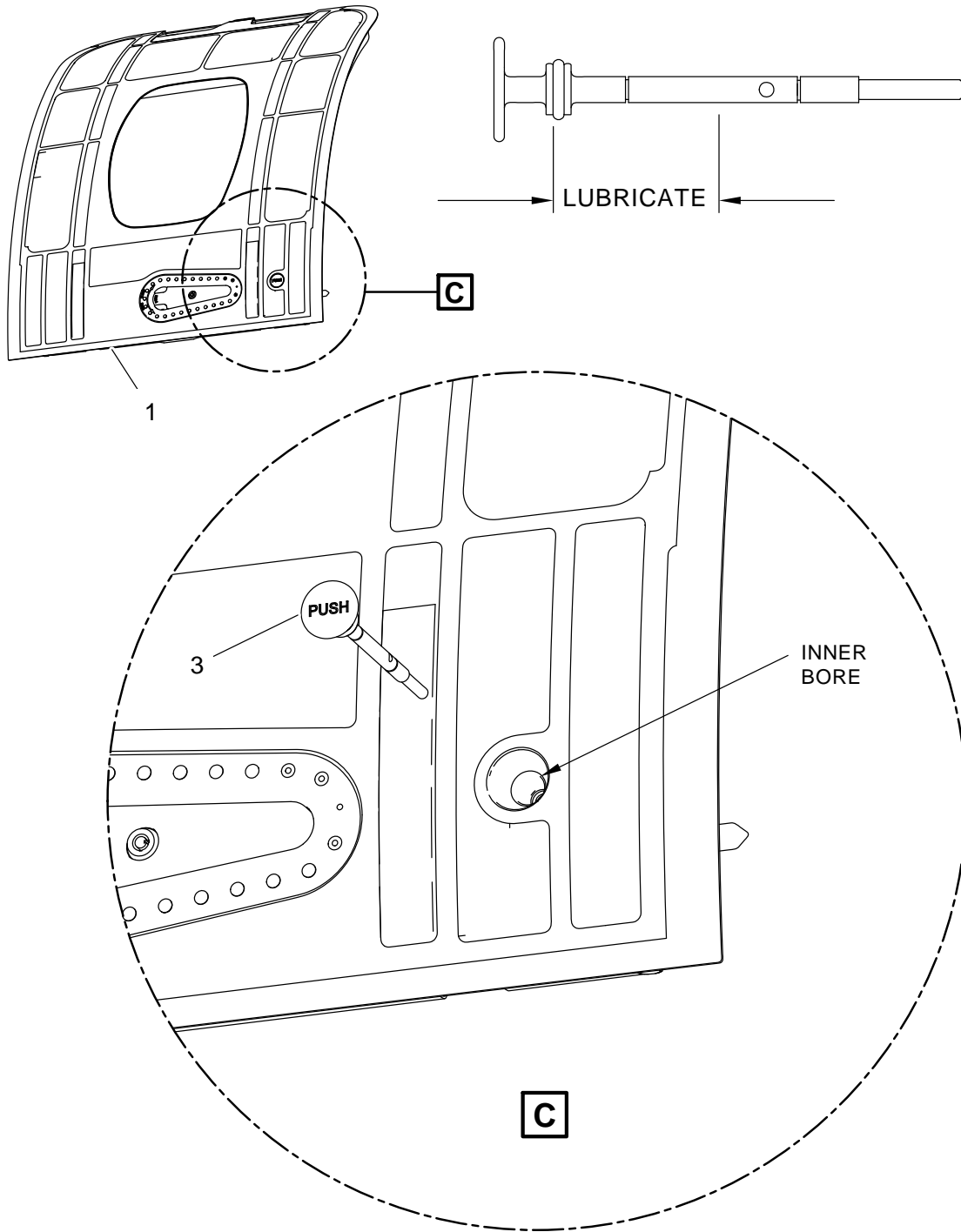


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(ROTATED FOR CLARITY)

Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 2 of 3)

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Passenger Door Lock Pin Assembly - Removal/Installation
Figure 401 (Sheet 3 of 3)

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