

NUMBER: SB 550-53-001, Rev B  
MODEL: ECLIPSE EA550  
SUBJECT: External Stowage Compartment Door Inspection and Modification

**Recommended**

[www.ECLIPSE.aero](http://www.ECLIPSE.aero)

## 1. PLANNING INFORMATION

### A. Effectivity

Aircraft Serial Numbers: 0263-0265, 0268-0280, 0282-0284, and 1001 - UP

### B. Reason

This Service Bulletin provides the steps to enhance the security of the External Stowage Compartment door.

### C. Description

This Service Bulletin provides the steps to inspect the External Stowage Compartment and recommended modification options.

Revision B of this Modification Bulletin updates Effectivity.

### D. Relevant Publications

06-1123838, EA550 AMM, current revision

### E. Compliance

Eclipse Aerospace Inc. considers this to be a recommended inspection that should be accomplished at the next maintenance visit.

Compliance with Rev A does constitute compliance with Rev B.

### F. Approval

This Service Bulletin is based on engineering data that is FAA-approved, and the modification herein complies with the applicable regulations.

### G. Labor Requirements

The following information is for planning purposes only

Inspection: 0.5 Hour

Modification Option 2, Render INOP: 3 Hours

Modification Option 3, Replace Striker: 2 Hours

Actual labor hours may vary depending on work force experience, concurrent maintenance, discovery of other discrepancies, etc.

### H. Weight and Balance Change

N/A

### I. Electrical Load Data Change

N/A

### J. Software Accomplishment Summary

N/A

**K. References**

06-123838, EA550 AMM, current revision

**L. Publications Affected**

N/A

**M. Export Control**

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## 2. MATERIAL INFORMATION

**A. Materials**

(1) Non-kitted parts. Non-kitted parts must be ordered separately. Parts needed are determined by which modification is chosen.

**Modification Option 2**

Part Number	Description	Qty	Unit of Issue
11-125116-2001	PLACARD, INOP DOOR SEALED	1	EA.
53-125118-2001	SPACER	2	EA.
AN525-832R10	SCREW-WASHER HEAD	2	EA.
CCR244CS-3-07PR	NUT-PLATE RIVETS	8	EA.
NAS1791A08-1	NUT, SELF-LOCKING, PLATE-TWO LUG, FLOATING	2	EA.

**Modification Option 3**

Part Number	Description	Qty	Unit of Issue
53-125117-2001	STRIKER-REPLACEMENT	1	EA.
NAS1097AD3-3	RIVET, SOLID, FLUSH SHEAR HEAD	2	EA.

## B. Consumables

The following consumables are required for this Service Bulletin. Install/apply consumable items in accordance with manufacturer's instructions.

Material	Specification	Use
Abrasive	320 grit	Removal of access paint and sealant.
Sealant	PR-2001 or equivalent	For aerodynamic smoothing, fillet sealing, fastener sealing, prepack sealing, injection sealing, and sealing joints and seams.
Sealant	PRC-Desoto aerodynamic smoothing sealant (PR-2050) or PRC-Desoto epoxy sealant (PR-2001) or Class B Sealant (AC-240 B½) or Class B Sealant (AC-350 B½)	Form-in-place seal (if required)
Release Agent	McLube 1733	Form-in-place seal (if required)
Alodine	MIL-C81706, Henkel Alodine 1201 or Touch-n-Prep 1132, 5700 and Alodine 700 (conductive)	Chemical conversion coating for aluminum.
Primer	MIL-PRF-23377	Apply to components that will not require a polyurethane top coat.
Painters Tape	3M	Form-in-place seal (if required)
Alcohol	Isopropyl	Cleaning

## C. Tooling

N/A

## D. Cost

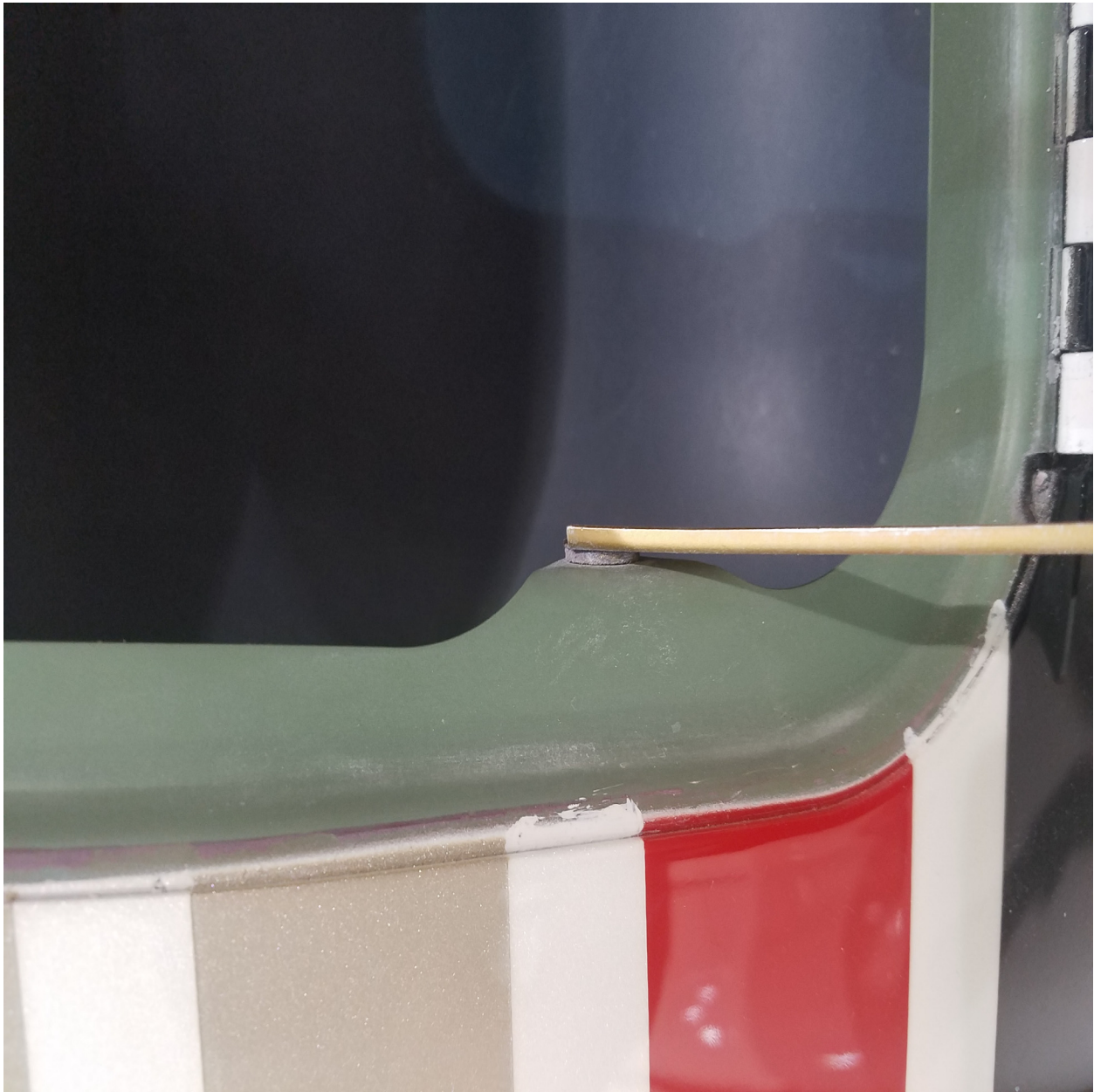
Contact Eclipse Aerospace Inc. for cost and availability.

## 3. ACCOMPLISHMENT INSTRUCTIONS

### A. Inspection

#### Paint Over-spray

- (1) Open stowage door.
- (2) Ensure engagement face of latch and opening for stowage door is free of paint over-spray, and sealant. Refer to [Figure 1, Sheet 1](#) and [Figure 1, Sheet 2](#) for acceptable and unacceptable conditions.
  - (a) If found, remove paint over-spray, and/or sealant.
  - (b) If necessary, treat bare surfaces with Alodine (Chemical Conversion Coating). Refer to AMM 20-09-00 - Aircraft Finishes.
  - (c) If necessary, apply primer MIL-PRF-23377 to reworked surfaces. Refer to AMM 20-09-00 - Aircraft Finishes.



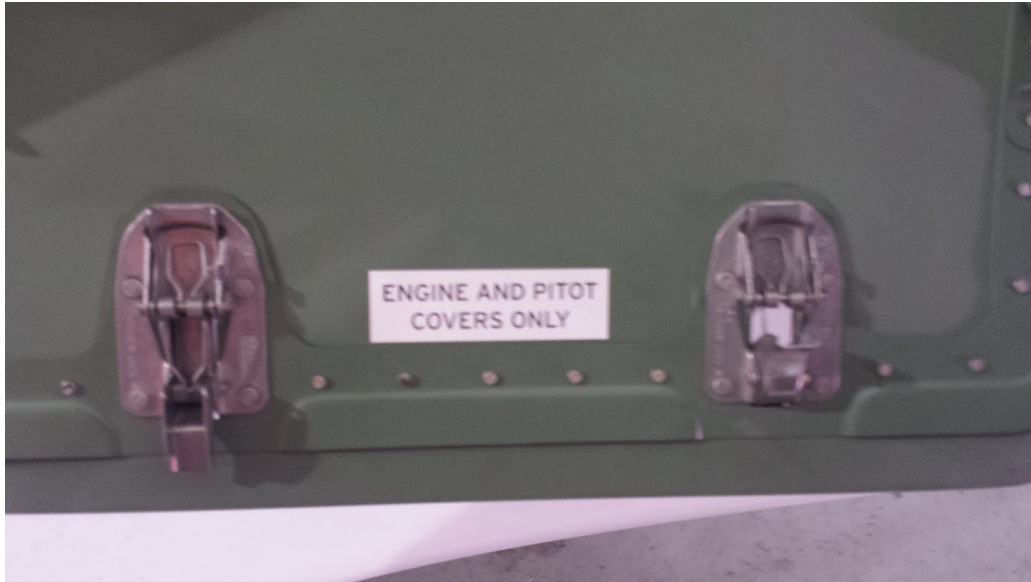
**Figure 1, Sheet 1. Unacceptable Paint Over-spray**



**Figure 1, Sheet 2. Acceptable, No Over-spray**

## Latch Inspection

- (1) Open door and inspect for distortion and abnormal wear.
- (2) Close left latch, leaving right latch open. Refer to Figure 2.



**Figure 2. Right Latch Test - Close Left Latch**

- (3) Close door and right latch. Refer to Figure 3.



**Figure 3. Right Latch Test - Door Closed with Right Latch Only**

- (4) Pull out one inch on the upper left side of the door. Refer to Figure 4.
  - (a) Door remains closed.



**Figure 4. Right Latch Test**

- (5) Open door and left latch.
- (6) Close right latch, leaving left latch open. Refer to Figure 5.



**Figure 5. Left Latch Test - Close Right Latch**

- (7) Close door and left latch. Refer to Figure 6.



**Figure 6. Left Latch Test - Door Closed with Left Latch Only**

- (8) Pull out one inch on the upper right side of the door. Refer to Figure 7.  
(a) Door remains closed.



**Figure 7. Left Latch Test**

- (9) Open door and right latch.  
(10) Close door and both latches.  
(11) If engagement test passed, proceed to B., Modification Option 1, No action required.

- (12) If engagement test does not pass, recommendation is to render the Stowage door INOP. Proceed to Step C., Modification Option 2 - Render Inop.

**OR**

- (13) If engagement test does not pass, recommendation is to replace original strikers with new striker. Proceed to Step D., Modification Option 3 - Replace Striker.

## **B. Modification Option 1 - No action required**

If the engagement test passed, no action needs to be taken. Modification Option 2 or Option 3 (on condition) may be accomplished if requested.

## **C. Modification Option 2 - Render INOP**

- (1) Locate spacer, P/N 53-125118-2001, (2, [Figure 8, Sheet 1](#)) on to frame and using spacer (2, [Figure 8, Sheet 1](#)) as a template, drill four holes to accommodate rivets, P/N CCR244CS-3-07PR, (4, [Figure 8, Sheet 1](#)). Refer to AMM 20-07-00.
- (2) Treat bare surfaces with Alodine (Chemical Conversion Coating). Refer to AMM 20-09-00 - Aircraft Finishes.
- (3) Fasten spacer, P/N 53-125118-2001 (2, [Figure 8, Sheet 1](#)) and nut plate P/N NAS1791A08-1, (5, [Figure 8, Sheet 1](#)) to frame using four rivets, P/N CCR244CS-3-07PR, (4, [Figure 8, Sheet 1](#)). Refer to AMM 20-07-00 - Attaching Hardware.
- (4) Repeat steps 3.C.1, 3.C.2, and 3.C.3 on opposite side.
- (5) Mark with indelible ink "Modified by SB 550-53-001" on inner door. Reference Flag Note 1, [Figure 8, Sheet 1](#) for location.
- (6) Close door and apply Placard, Door Inop, P/N 11-125116-2001, (1, [Figure 8, Sheet 2](#)) in location shown. Refer to View D.
- (7) Secure door with two screws, P/N AN525-832R10, (3, [Figure 8, Sheet 2](#)). Check for flushness between the door and surrounding aircraft skin is within  $-.030/+0.030$  inch.

NOTE: If interference exists between the radius of the door doubler, P/N 52-119794 and the spacer, P/N 53-125118-2001, it is permissible to trim the spacer, P/N 52-125118-2001 to adjust the thickness of the spacer to meet flushness criteria between the surrounding aircraft skin and the door of  $-.030/+0.030$  inch.

- (8) Remove (2) screws, P/N AN525-832R10, (3, [Figure 8, Sheet 1](#)) and open door.
- (9) Fill the entire periphery between doubler, P/N 52-119794 and door with sealant PRC-2001 or equivalent. Ensure adequate squeeze out upon door closure. Remove excess sealant and ensure door, when closed is flush with the surrounding aircraft skin within  $-.030/+0.030$  inch. Refer to AMM 20-08-00 - Sealants and Adhesives, and Flag Note 2, [Figure 8, Sheet 1](#).
- (10) Install (2) screws, P/N AN525-832R10, (3, [Figure 8, Sheet 2](#)) to secure door. Refer to AMM 20-07-00 - Attaching Hardware.

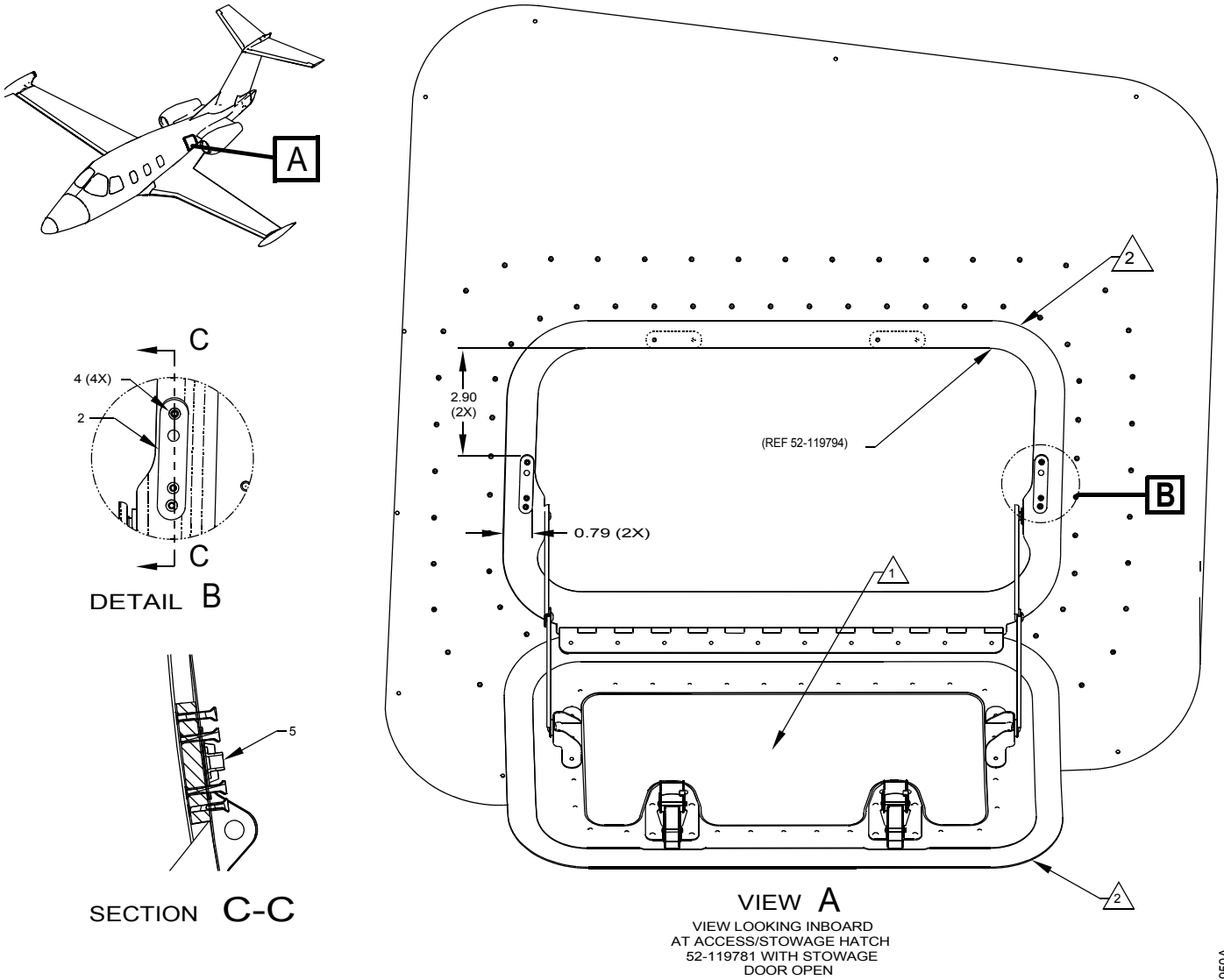
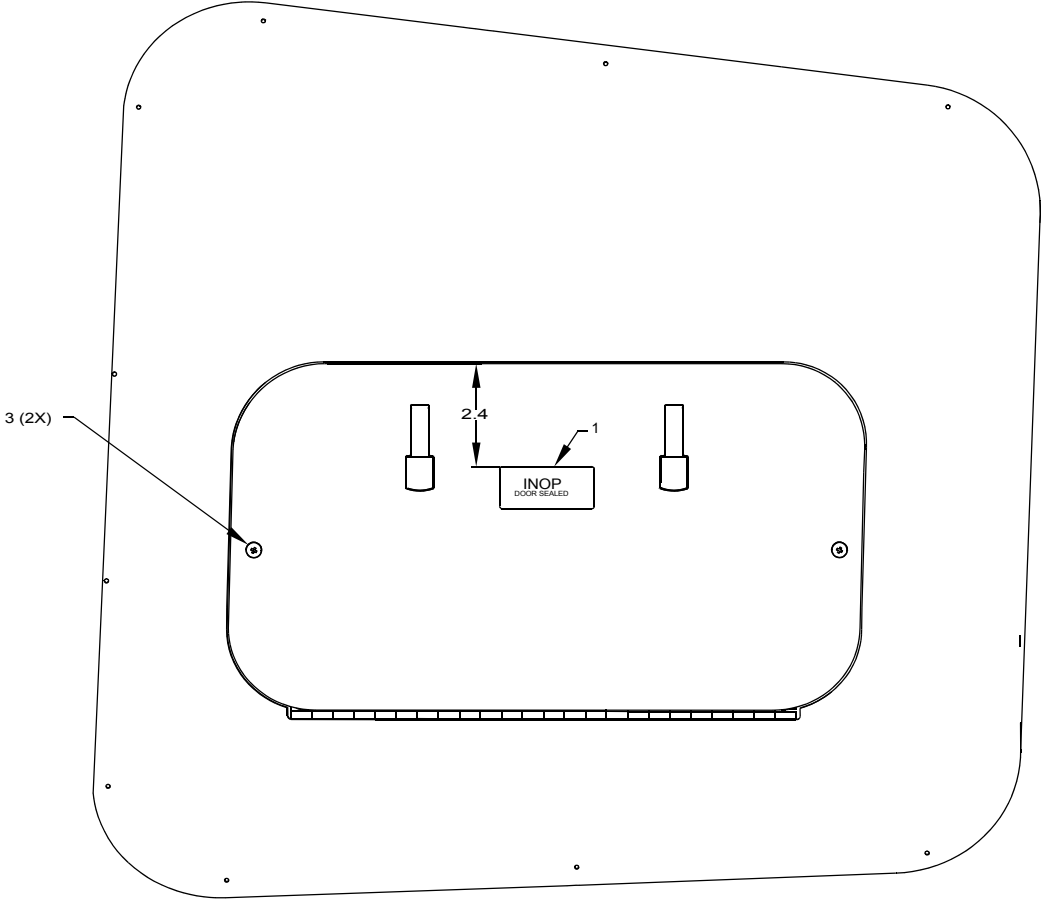


Figure 8, Sheet 1. Option 2 - Render Door Inoperative



VIEW D

VIEW LOOKING INBOARD  
AT ACCESS/STOWAGE HATCH  
52-119781 WITH STOWAGE  
DOOR OPEN

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Figure 8, Sheet 2. Option 2 - Render Door Inoperative

## D. Modification Option 3 - Replace Striker

NOTE: The following measurement condition must be met to accomplish Modification Option 3.

- (1) Place both latches in closed position.
- (2) For the forwards hinge and from the hinge centerline. Obtain two measurements: Refer to [Figure 9](#)
  - (a) Measurement A: Between the hinge centerline and extreme edge of closed latch.
  - (b) Measurement B: Between the hinge centerline and the nearest edge of the door opening or the striker plate.
  - (c) Engagement (C) is defined as (A) minus (B).
  - (d) Record (A), (B), and (C) measurements.
- (3) Repeat Step 3.A.(4) for the aft hinge.
- (4) If engagement is equal to or greater than 0.34 inch on either hinge, striker replacement can not be done.
- (5) If engagement is (C) is less than 0.34 inch on both hinges, proceed to replace original strikers with new striker.

Measurement A: \_\_\_\_\_

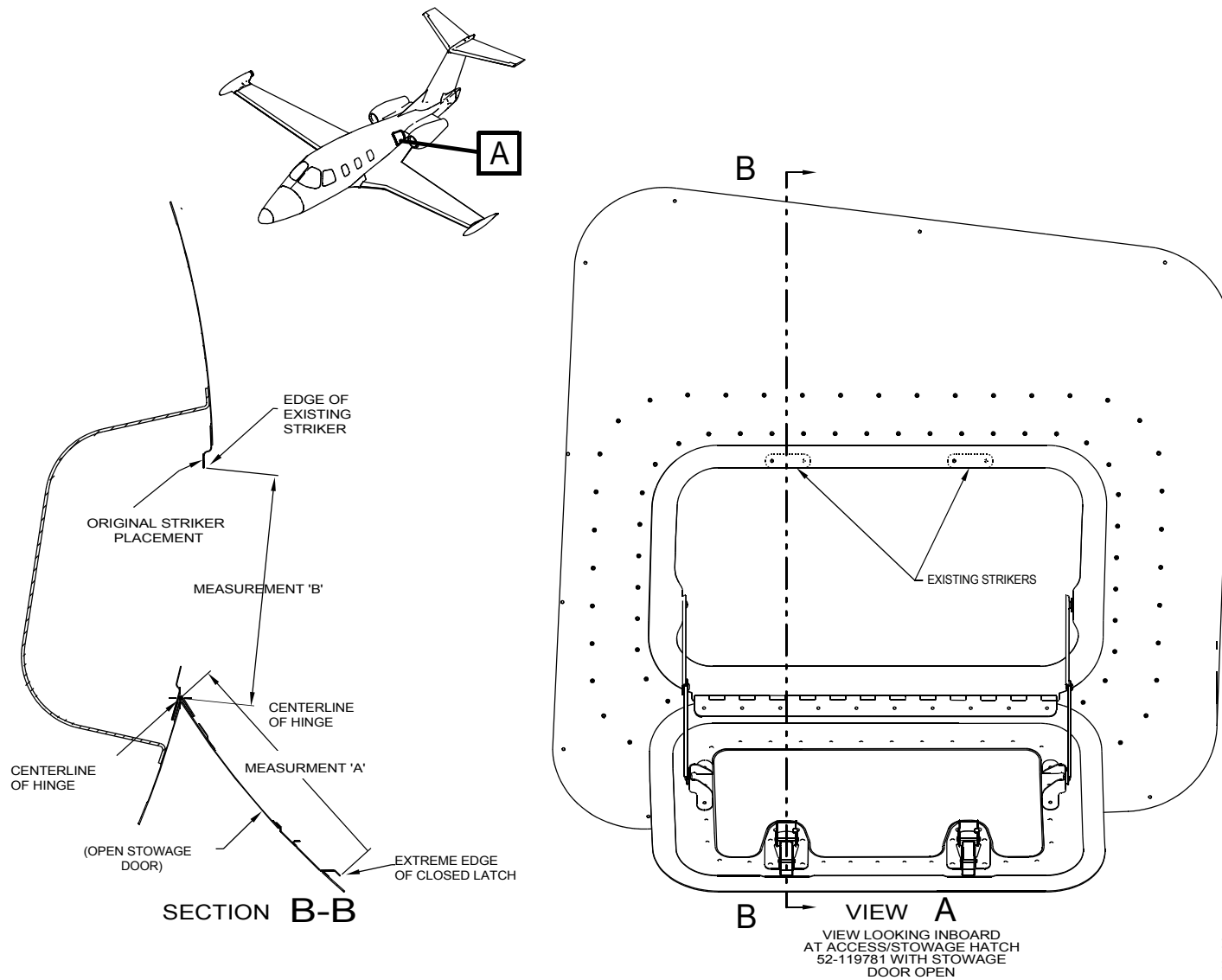
- Measurement B: \_\_\_\_\_

\_\_\_\_\_

Measurement C: \_\_\_\_\_

Measurement C must be less than 0.34 inch

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**Figure 9. Overlap Assessment**

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- (6) Remove and scrap the following:
    - (a) Rivets, P/N NAS1097AD3-3, Qty 4.
    - (b) Plate, Strike, External Stowage Compartment, P/N 52-119796-2001, Qty 2.
  - (7) Mark "Modified by SB 550-53-001" with indelible ink in location shown by Flag Note 1, [Figure 10](#).
  - (8) Locate new striker P/N 53-125117-2001 (1, [Figure 10](#)) so that engagement (C) after installation will be 0.30 - 0.40 inches using existing (4) holes from removal of original striker plates and drill (4) holes to accept rivets P/N NAS1097AD3-3. (2, [Figure 10](#)).
  - (9) Fasten new striker P/N 53-125117-2001 (1, [Figure 10](#)) to frame with (8) rivets, P/N NAS1097AD3-3. (2, [Figure 10](#)).
  - (10) If necessary, replace the form-in-place seal around door opening.
    - (a) Remove old seal.
    - (b) Clean surfaces with a clean cloth moistened with alcohol.
    - (c) Check surfaces for bare metal, treat with Alodine (Chemical Conversion Coating) and touch up with primer MIL-PRF-23377. Allow primer to dry. Refer to AMM 20-09-00 - Aircraft Finishes.
    - (d) Mask surrounding area with painters tape where contact with sealant is unwanted and to ease smoothing and clean-up.
    - (e) Apply Release Agent McLube 1733 to outer perimeter of the door, P/N 52-119782.
    - (f) Apply a bead of PRC-Desoto aerodynamic smoothing sealant (PR-2050) or PRC-Desoto epoxy sealant (PR-2001) or Class B Sealant (AC-240 B½) or Class B Sealant (AC-350 B½) to the perimeter of the door opening.

NOTE: The form-in-place seal must to allow the door, when closed, and the 311-AL Maintenance Bay Panel skin to be flush with in -.030/+ .030 inch to prevent abnormal airflow.
    - (g) Close door and allow sealant to cure.
    - (h) After sealant has cured, open door.
    - (i) Inspect the form-in-place seal for cracking, tears and flushness.
- CAUTION: Use care when cutting the sealant as not to scratch the metal.
- (j) Trim off excess sealant along the edges of the painters tape on the door.
  - (k) Remove Painters tape from all surfaces.
  - (l) Touch-up any scratched or bare aluminum with Alodine, primer and topcoat if necessary. Refer to AMM 20-09-00 - Aircraft Finishes.
- (11) Close and latch External Stowage Compartment door.

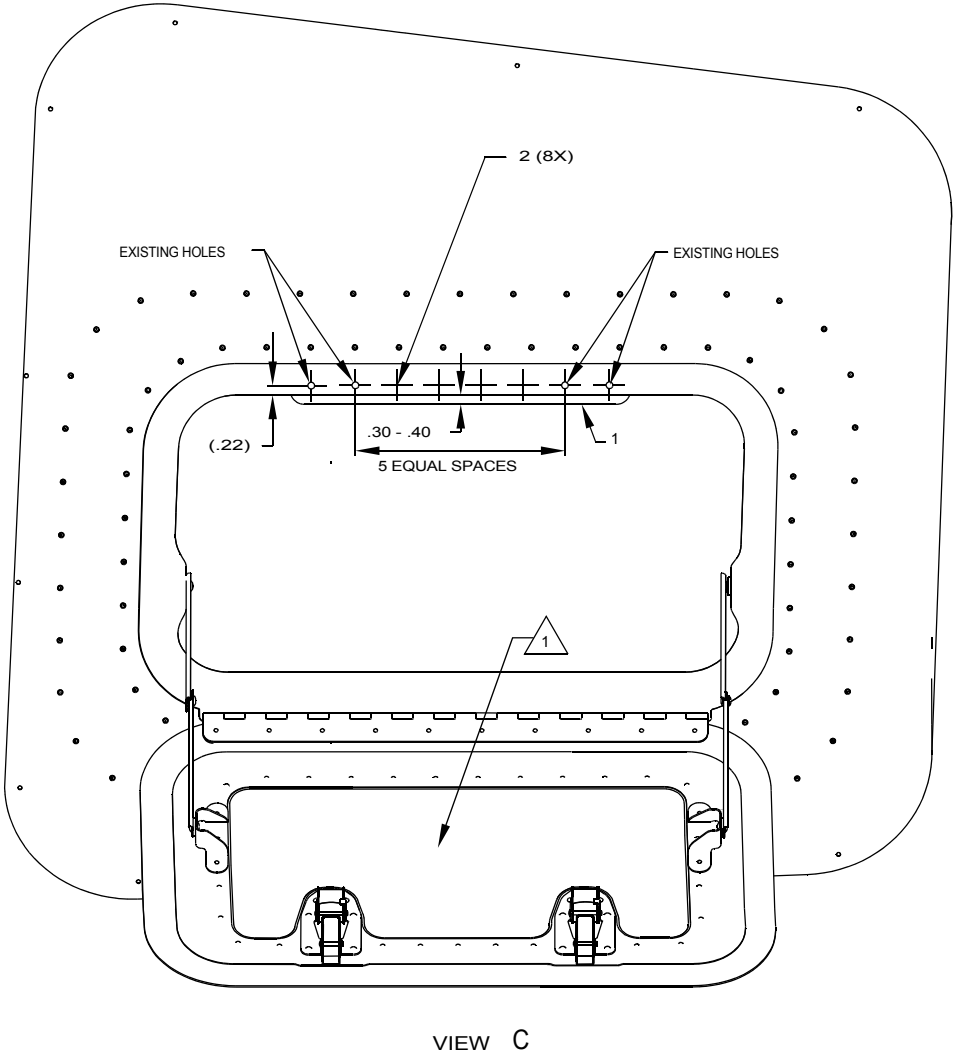


Figure 10. Option 3 - Replace Strikers

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## E. Final Inspection

- (1) Remove all tools and unused materials for work area.
- (2) If all other maintenance is complete, return the aircraft to service. Refer to the AMM 20-00-02 RETURN TO SERVICE (AFTER MAINTENANCE).

## F. Limitations and Procedures

N/A

## G. Parts Disposition

Dependent upon action taken.

## 4. RECORD OF COMPLIANCE

Upon completion of this Service Bulletin, make an appropriate maintenance-record entry specifying the Service Bulletin number.

## 5. NOTIFYING ECLIPSE AEROSPACE

On completing this Service Bulletin, the operator/maintainer shall complete the attached Compliance Record and send it to Eclipse Aerospace via regular mail, fax, or e-mail.

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