



TASK CARD

Ref : P2F-00090-TSK1052-S01-R00

CARGO CONVERSION ON ATR
Door upper sill install

Applicability

NOTE: THIS DOCUMENT IS ONLY APPLICABLE TO THE AIRCRAFT LISTED IN THE ASSOCIATED MASTER DOCUMENT LIST (MDL) REF. P2F-00090-MDL

All deviations to procedures described in this Task Card shall be notified to PMV Engineering using the Deviation Request Form (last page of this document).

According to AMC 145.A.65(b)(3), proposed as good practice and in order to prevent omissions, every maintenance task or group of tasks shall be signed-off.

Note: A “sign-off” is a statement by the competent person performing or supervising the work, that the task has been correctly performed. A sign-off relates to one step in the maintenance process and is therefore different to the release to service of the aircraft.

			Authoring (PCM)	Verification (CVEs)	Approval (HAO)
Revision	Date	Subject of revision	Name and sign.	Name and sign.	Name and sign.
R00	03FEB2020	Initial release	Amaury Masson	Eric Deniaud	Eric Sperazza



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**CARGO CONVERSION ON ATR**
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The purpose of this task card is to provide instructions for the application of a task requested in the frame of the related Service Bulletin ref P2F-00090-SB.

1.1. TASK DESCRIPTION

This task-card gives instructions to modify the upper sill structure from the frame 14 to the frame 22.

1.2. INSTALLATION DESCRIPTION

Refer to the Service Bulletin ref. P2F-00090-SB §1.4 "Description".

1.3. APPROVAL

Refer to the Service Bulletin ref. P2F-00090-SB §1.7 "Approval".

2. PUBLICATIONS**2.1. REFERENCE DOCUMENT**

These instructions are a compilation of the original Alenia instructions:

- 13S5337F220-004
- 13S5337F321-000

2.2. ENGINEERING DOCUMENT

Refer to Master Data List P2F-00090-MDL.

2.3. INSTALLATION DRAWINGS

P2F-00090-DWG1052, refer MDL for effectivity.



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3. TASK INSTRUCTIONS

3.1. PREPARATION

	Description	Perf.	Chk.
1.	Get the appropriate drawing P2F-00090-DWG1052 (refer to MDL for effectivity).		
2.	Get the parts to be installed (refer P2F-00090-PL1052-S01 , refer MDL for effectivity).		
3.	Refer to the drawing P2F-00090-DWG1052-S01 for the general notes and installation overview.		
4.	If needed, temporarily remove any cover or part to get access to impacted areas.	N/A	N/A

3.2. FITTING ACTUATOR PREPARATION


Prerequisite:

- The spider is installed (see **P2F-00090-TSK9499**),
- The Maglione is installed (see **P2F-00090-TSK1672**).

CAUTION:

- Before drilling the holes, ensure that there is no other part using same holes.
- The “Maglione” upper fittings must be installed and secured.

	Description	Perf.	Chk.
1.	Check that upper frames FR14 & FR20 are properly installed on the spider with tooling pins and identify the toolsets to be used to locate references used during this task card. NOTE: Install or swap them every time it is needed.		
2.	Perform the assembly of the dumper att assy (1155), both extruded (1170) and aux sill STR3 (1163) using the radius fillers (1118 & 1119), the shim (1116) and appropriate fasteners as per P2F-00090-DWG1052-S13 .		

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3.3. UPPER SILL INSTALLATION

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

	Description	Perf.	Chk.
1.	Install upper sill FR14 & FR20 (1133) at stringer 4L on the spider fittings and align the outer flange with the outer flanges of frames FR14 & FR20 , as per P2F-00090-DWG1052-S03 & S04 .		
2.	The task #3 cannot be performed without the shear ties and angles (at STR4L) installation on FR15 to FR19 (see task P2F-00090-TSK0930). And the task #3 has to be performed with the secondary structure installation (see task P2F-00090-TSK1853).	N/A	N/A
3.	Locate and install the five gussets (1052) on FR15 to FR19 inner flanges on the upper sill FR14 & FR20 (1133) , as per P2F-00090-DWG1052-S05 & S06 .		

3.4. INTERCOSTALS AND GUSSETS INSTALLATION STR3AL

Prerequisite:

-The new STR3AL is installed and cut out (see **P2F-00090-TSK0952**).

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

NOTE: During next instructions, it is recommended to temporarily install an aluminum plate (2.5mm thick) at lap joint location (STR3L) between the shim and the new stringer 3L to simulate the theoretical skin installation.

	Description	Perf.	Chk.
1.	Locate and temporarily install the intercostal aux sill (1145, 1146, 1147, 1148, 1149, 1150 & 1151) and the angles (1120, 1152, 1154 & 1164) as per P2F-00090-DWG1052-S05 & S06 . NOTE: -Use the spider to have a proper install. -Ensure that inner flanges of intercostal aux sills are aligned with inner flanges of FR20, FR21 and FR22 .		
2.	Locate and temporarily install the gussets (1054 & 1055) as per P2F-00090-DWG1052-S05 & S06 . NOTE: Install the gussets IAW the installation of the rail supports (see task P2F-00090-TSK0135).		
3.	Locate and install the clip (1143) to the FR15 and to the stringer 3AL using appropriate fasteners as per P2F-00090-DWG1052-S07 & S08 .		
4.	Install the parts previously temporarily install on chapter §3.4 with associated hardware as per P2F-00090-DWG1052-S05 & S06 .		



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3.5. FITTING ACTUATOR AND BACK-UP FRAME INSTALLATION

Prerequisite:

-The upper skin is installed and (see P2F-00090-TSK0952).

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

	Description	Perf.	Chk.
1.	Locate and temporarily install the dumper att. assy (1155) previously assembled, using appropriate spider fitting and aux sill STR3 (1163) as per P2F-00090-DWG1052-S03 & S07. NOTE: make sure outer surface of dumper att. assy is aligned with outer surface of FR14.		
2.	Locate and temporarily install the back-up frame (1167) and the shims (1101 & 1103) with the dumper att. assy (1155), the aux sill STR3 (1163) and the upper skin as per P2F-00090-DWG1052-S02, S07 & S08.		
3.	Locate and temporarily install the intercostal aux sill (1144) with the angles (1153 & 1164) at STR3L between the FR15 and the back-up frame (1167) as per P2F-00090-DWG1052-S05. NOTE: Use the spider to have a proper install.		
4.	FR12-FR14: Locate and temporarily install the upper sill (1131 & 1132) with the clips (1136, 1138 & 1140), the shim (1104) and the gussets (1052 & 1141) as per P2F-00090-DWG1052-S03, S05 & S07.		
5.	Locate and temporarily install the fail safe angle (1168) with the stringer clip (1166) as per P2F-00090-DWG1052-S02.		
6.	Install the parts previously temporarily install on chapter §3.5 with associated hardware as per P2F-00090-DWG1052-S02, S03, S05, S07 & S08. CAUTION: -Do not fasten yet the inner surface of the dumper att. assy (1155) with the backup frame (1167) inner flange until the inner skin is installed. -Do not fasten yet the dumper att. assy at areas where the gutter (1172) and the hinge fitting (1121) will be installed.		



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3.6. INTERCOSTALS AND GUSSETS INSTALLATION STR4L

Prerequisite:

-The new STR4L is installed (see **P2F-00090-TSK0952**).

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

NOTE: During next instructions, it is recommended to temporarily install an aluminum plate (2.5mm thick) at lap joint location (STR3L) between the shim and the new stringer 3L to simulate the theoretical skin installation.

	Description	Perf.	Chk.
1.	Locate and temporarily install the upper sill (1134 & 1135) with the clips (1137, 1138 & 1140) and the gussets (1055 & 1141) as per P2F-00090-DWG1052-S04 & S06 . NOTE: Ensure that outer flange of upper sills are aligned with outer flanges of FR20, FR21 and FR22 .		
2.	Install the upper sills, the clips and the gussets as per P2F-00090-DWG1052-S05 & S06 .		



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3.7. SEAL DEPRESSOR AND INNER SKIN INSTALLATION

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

NOTE: It is recommended to use the same parts previously removed and use them as template for the positioning.

	Description	Perf.	Chk.
1.	Locate and install the seal depressor (1160) as per P2F-00090-DWG1052-S05 & S06.		
2.	The tasks #3 & #4 have to be performed in the same time and these tasks have to be performed with the secondary structure installation (see task P2F-00090-TSK1853).	N/A	N/A
3.	Locate and temporarily install the inner skin (1169 & 1171) with the clip (1142) as per P2F-00090-DWG1052-S08 & S09.		
4.	FR14: Locate and temporarily install the filler seal depressor (1056), the seal depressor support upper (1061 & 1065), the corner angle (1058), the support (1067), the shim (1100) and the seal depressor (1064) as per P2F-00090-DWG1052-S03, S05 & S09. NOTE: This part has to be installed with the LCD upper secondary structure (see task P2F-00090-TSK1853).		
5.	FR20: Locate and temporarily install the filler seal depressor (1057), the seal depressor support upper (1060, 1062 & 1066), the corner angle (1059), the shim (1100), the gusset (1053) and the seal depressor (1063) as per P2F-00090-DWG1052-S04, S06 & S09. NOTE: -This part has to be installed with the LCD upper secondary structure (see task P2F-00090-TSK1853). -These parts have to be installed after the installation of the crash net fittings (see task P2F-00090-TSK0297).		
6.	Do not install the parts until the hinges installation (the install later in this task card).		



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3.8. HINGE FITTINGS INSTALLATION

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

NOTE: Ensure that the inner surface of hinge fittings is parallel to upper sill FR14/20s' one.

	Description	Perf.	Chk.
1.	Locate and install the hinge fittings (1121, 1122, 1123, 1124, 1125 & 1126), the shear fitting (1127) and the shims (1106, 1107, 1108, 1109, 1110, 1111, 1112, 1113, 1114 & 1115) as per P2F-00090-DWG1052-S10, S11 & S12 . NOTE: Use the spider to have a proper install.		
2.	Locate and install the plate assy (1128) with the fairing hinge (1161) as per P2F-00090-DWG1052-S10, S11 & S12 .		
3.	Locate and install the three nut plates (1071) and the shim (1117) with the fairing hinge (1162) as per P2F-00090-DWG1052-S10, S11 & S12 .		

3.9. ATC ANTENNA FASTENERS INSTALLATION LHS

NOTE: The use of the antenna can be helpful to have a proper install and avoid the interference with the shear ties of the FR16.

	Description	Perf.	Chk.
1.	The tasks #2 & #3 have to be performed in the same time.	N/A	N/A
2.	Cut-out the antenna hole as per P2F-00090-DWG1052-S03 & S09 .		
3.	Locate and install the four nut plates (1070) as per P2F-00090-DWG1052-S03 & S09 .		

3.10. GUTTER INSTALLATION

CAUTION:

-Before drilling the holes, ensure that there is no other part using same holes.

	Description	Perf.	Chk.
1.	Locate and install the gutter (1172) as per P2F-00090-DWG1052-S10 & S12 .		



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