

EQUIPMENT/FURNISHINGS - RH REFRESHMENT CENTER AND LH FORWARD CABINET REINFORCEMENTS INSTALLATION

In connection with the use of this document, Embraer does not provide any express or implied warranties and expressly disclaims any warranty of merchantability or fitness for a particular purpose.

This document contains trade secrets, confidential, proprietary information of Embraer and technical data subject to U.S. Export Administration Regulation ("EAR") and other countries export control laws and regulations. Diversion contrary to the EAR and other laws and regulations is strictly forbidden. The above restrictions may apply to data on all pages of this document.

1. PLANNING INFORMATION

A. SB EFFECTIVITY

Aircraft affected:

(1) GROUP 1

MODEL	SN
EMB-505 'Phenom 300'	50500027 thru 50500030, 50500032, 50500034, 50500037, 50500041, 50500047, 50500050, 50500054, 50500057, 50500059, 50500067, 50500074, 50500075, 50500077, 50500090, 50500093, 50500094, 50500097, 50500100, 50500105, 50500109, 50500111, 50500115, 50500135, 50500139, 50500145, 50500146, 50500155, 50500156, 50500166, 50500171, 50500204, 50500206, 50500208, 50500216, 50500233, 50500234, 50500236, 50500238, 50500239, 50500241 thru 50500243, 50500246, 50500269, 50500276, 50500290, 50500378, 50500380, 50500382, 50500384, 50500387, 50500388, 50500391, 50500393, 50500394, 50500447, 50500457, 50500523, 50500524, 50500536, 50500538, 50500539, 50500572, 50500576, 50500581, and 50500592.

(2) GROUP 2

MODEL	SN
EMB-505 'Phenom 300'	50500027 thru 50500030, 50500032, 50500034, 50500037, 50500047, 50500050, 50500054, 50500057, 50500059, 50500067, 50500074, 50500075, and 50500077, POST-MOD SB505-25-0007.

(3) GROUP 3

MODEL	SN
EMB-505 'Phenom 300'	50500010 thru 50500012, 50500014, 50500016, 50500018, 50500019, 50500021, 50500022, 50500024, 50500025, 50500033, 50500035, 50500036, 50500038, 50500040, 50500043 thru 50500045, 50500051, 50500052, 50500055, 50500056, 50500060 thru 50500062, 50500064, 50500065, 50500070 thru 50500072, 50500076, 50500078 thru 50500084, 50500086 thru 50500089, 50500091, 50500092, 50500095, 50500098, 50500099, 50500101, 50500103, 50500104, 50500107, 50500113, 50500114, 50500116 thru 50500119, 50500121, 50500124 thru 50500131, 50500133, 50500134, 50500140, 50500142, 50500144, 50500148 thru 50500150, 50500157, 50500159, 50500163, 50500177, 50500182, 50500185, 50500187, 50500193, 50500196, 50500211, 50500213, 50500217, 50500218, 50500220 thru 50500222, 50500232, 50500240, 50500247, 50500249, 50500251, 50500253, 50500258, 50500261, 50500267, 50500274, 50500285, 50500299, 50500305, 50500307, 50500312, 50500313, 50500315, 50500337, 50500341, 50500354, 50500366, 50500368, 50500381, 50500386, 50500404, 50500415, 50500445, 50500459, 50500499, and 50500516.

(4) GROUP 4

MODEL	SN
	50500007, POST-MOD SB505-25-0010 and SB505-25-0014.

(5) GROUP 5

MODEL	SN
	50500009, POST-MOD SB505-25-0031.

(6) GROUP 6

MODEL	SN
EMB-505 'Phenom 300'	50500004, 50500005, 50500008, 50500010 thru 50500012, 50500014, 50500016, 50500018, 50500019, 50500021, 50500022, 50500024, and 50500025.

(7) GROUP 7

MODEL	SN
EMB-505 'Phenom 300'	50500006, 50500017, 50500020, 50500023, and 50500026.

(8) GROUP 8

MODEL	SN
EMB-505 'Phenom 300'	50500282, 50500285, 50500298, 50500317, 50500326, 50500360, and 50500418.

(9) GROUP 9

MODEL	SN
EMB-505 'Phenom 300'	50500330.

(10) GROUP 10

MODEL	SN
EMB-505 'Phenom 300'	50500116, POST-MOD SB505-25-0031.

In-production effectivity:

EMB-505 "Phenom 300" aircraft SN 50500601 and on, optionally, have an equivalent modification factory-incorporated.

B. CONCURRENT REQUIREMENTS

None.

C. REASON

(1) HISTORY

Structural analysis with RH Refreshment center and LH forward cabinet indicates the need for new reinforcements installation.

(2) OBJECTIVE

To install reinforcements on the RH refreshment center and LH forward cabinet, and to replace rivets of the floor support of the RH Refreshment Center.

(3) EXPECTED BENEFITS

Additional reinforcements and rivets replacement are to be added to the affected monuments and to floor support of the RH Refreshment Center to enhance structural installation.

(4) REVISION HISTORY

None.

(a) Revision 01

- This revision is being issued to update [Figure 5](#) rivet removal part number.

D. DESCRIPTION

The modification presented in this service bulletin consists of installing reinforcement on the RH Refreshment center and LH forward cabinet, and replacing rivets of the floor support of the RH Refreshment Center.

To do this, it is necessary to gain access to the work area by removing the RH Refreshment center and the LH forward cabinet.

E. COMPLIANCE

Embraer recommends that this bulletin be accomplished during the next 60 MO maintenance package.

F. APPROVAL

The changes to the type design specified in this SB have been approved by ANAC - Agência Nacional de Aviação Civil.

This service bulletin was approved based on the airplane's original Embraer delivery configuration or as modified by other Embraer-approved documents.

G. ESTIMATED MANPOWER

This estimate is for direct labor only, performed by experienced personnel, and does not include the time to plan, prepare, or inspect the work.

It is assumed that all the tools, parts, and other means are promptly available when necessary.

This estimate does not include the sealant, paint, or adhesive curing time.

(1) APPLICABLE TO GROUPS 1 and 2 aircraft

- Access opening: 4.5 man-hours.
- Modification: 10.0 man-hours.
- Access closure: 6.0 man-hours.
- Test: 1.0 man-hours.

(2) APPLICABLE TO GROUPS 3, 4, 5 and 10 aircraft

- Access opening: 2.5 man-hours.
- Modification: 6.0 man-hours.
- Access closure: 4.0 man-hours.
- Test: 1.0 man-hours.

(3) APPLICABLE TO GROUPS 6 and 8 aircraft

- Access opening: 4.5 man-hours.
- Modification: 14.0 man-hours.
- Access closure: 6.0 man-hours.
- Test: 1.0 man-hours.

(4) APPLICABLE TO GROUP 7 aircraft

- Access opening: 4.5 man-hours.
- Modification: 8.0 man-hours.
- Access closure: 6.0 man-hours.
- Test: 1.0 man-hours.

(5) APPLICABLE TO GROUP 9 aircraft

- Access opening: 2.5 man-hours.
- Modification: 6.0 man-hours.
- Access closure: 4.0 man-hours.
- Test: 1.0 man-hours.

H. WEIGHT AND BALANCE

- (1) APPLICABLE TO GROUPS 1 and 2 aircraft
 - Change in basic weight: +0.858 lb (+0.389 kg).
 - Change in basic moment: +115.44 lb.in (+1.33 kg.m).
- (2) APPLICABLE TO GROUPS 3, 4, 5 and 10 aircraft
 - Change in basic weight: +1.248 lb (+0.566 kg).
 - Change in basic moment: +167.51 lb.in (+1.93 kg.m).
- (3) APPLICABLE TO GROUP 6 aircraft
 - Change in basic weight: +2.416 lb (+1.096 kg).
 - Change in basic moment: +324.61 lb.in (+3.74 kg.m).
- (4) APPLICABLE TO GROUP 7 aircraft
 - Change in basic weight: +1.168 lb (+0.530 kg).
 - Change in basic moment: +157.10 lb.in (+1.81 kg.m).
- (5) APPLICABLE TO GROUP 8 aircraft
 - Change in basic weight: +2.401 lb (+1.089 kg).
 - Change in basic moment: +322.88 lb.in (+3.72 kg.m).
- (6) APPLICABLE TO GROUP 9 aircraft
 - Change in basic weight: +1.153 lb (+0.523 kg).
 - Change in basic moment: +155.36 lb.in (+1.79 kg.m).

I. ELECTRICAL LOAD DATA

Not changed.

J. SOFTWARE ACCOMPLISHMENT SUMMARY

None.

K. REFERENCES

AMM 505/()	Aircraft Maintenance Manual PART II - 06-47-00 - DIMENSIONS AND AREAS.
AMM 505/()	Aircraft Maintenance Manual PART II - 20-00-00 - STANDARD PRACTICES-AIRFRAME.

AMM 505/()	Aircraft Maintenance Manual PART II - 21-61-04 - AIR CONDITIONING.
AMM 505/()	Aircraft Maintenance Manual PART II - 24-41-00 and 24-54-01 - ELECTRICAL POWER.
AMM 505/()	Aircraft Maintenance Manual PART II - 25-21-01, 25-23-01, 25-23-05, 25-25-02, 25-26-01, 25-26-04, 25-31-02, and 25-37-01 - EQUIPMENT/FURNISHINGS.
AMM 505/()	Aircraft Maintenance Manual PART II - 26-24-01 - FIRE PROTECTION.
AMM 505/()	Aircraft Maintenance Manual PART II - 31-42-01 - INDICATING/RECORDING SYSTEMS.
AMM 505/()	Aircraft Maintenance Manual PART II - 38-31-05 and 38-31-07 - WATER/WASTE.
AMM 505/()	Aircraft Maintenance Manual PART II - 44-21-17, 44-32-03, and 44-32-05 - CABIN SYSTEMS.

L. PUBLICATIONS AFFECTED

AIPC 505/() Aircraft Illustrated Parts Catalog - 25-31-01 - EQUIPMENT/FURNISHINGS.

2. MATERIAL INFORMATION**A. MATERIAL - PRICE AND AVAILABILITY****(1) MATERIAL AVAILABLE FROM EMBRAER**

The material below required for the accomplishment of this bulletin will be available from Embraer.

When ordering, specify SB 505-25-0046 and Top Kit PN presented in Table below, as applicable.

REF	TOP KIT PN	TOP KIT EFFECTIVITY
01	BS5052500460001	GROUPS 1 and 2 aircraft.
02	BS5052500460002	GROUPS 3, 4, 5, and 10 aircraft.
03	BS5052500460003	GROUP 6 aircraft.
04	BS5052500460004	GROUP 7 aircraft.
05	BS5052500460005	GROUP 8 aircraft.
06	BS5052500460006	GROUP 9 aircraft.

At the time of issuance of this SB a number of kits is available to support the first orders and a supply sequence may be established.

Please consult sjkpartsrequest@embraer.com.br for prices and lead time.

- NOTE:**
- 1) Lead Times for delivery are conservative and are estimated from the date Embraer gets the purchase order.
 - 2) The prices are for reference only, subject to confirmation upon receipt of orders.
 - 3) In addition to the kit(s), you must use the consumable materials and parts present in item [Item 2.C.\(2\)](#), to complete this service bulletin.

(2) MATERIAL AVAILABLE FROM OTHER VENDORS

None.

B. INDUSTRY SUPPORT INFORMATION**(1) WARRANTY COVERAGE****(a) Parts**

At Embraer expenses, for customers under warranty coverage, if it is performed at an Embraer-authorized service center.

(b) Labor

- 1) **APPLICABLE TO GROUPS 1 and 2 aircraft**
Embraer will compensate, for customers under warranty coverage, 21,5 man-hours for the SB incorporation if it is performed at an Embraer-authorized service center.
- 2) **APPLICABLE TO GROUPS 3, 4, 5, 9, and 10 aircraft**

Embraer will compensate, for customers under warranty coverage, 13,5 man-hours for the SB incorporation if it is performed at an Embraer-authorized service center.

- 3) **APPLICABLE TO GROUPS 6 and 8 aircraft**
Embraer will compensate, for customers under warranty coverage, 25,5 man-hours for the SB incorporation if it is performed at an Embraer-authorized service center.
- 4) **APPLICABLE TO GROUPS 7 aircraft**
Embraer will compensate, for customers under warranty coverage, 19,5 man-hours for the SB incorporation if it is performed at an Embraer-authorized service center.

(c) **Expiration**

The terms expressed in the warranty coverage will be valid for 60 months after the SB issue date.

C. MATERIAL NECESSARY FOR EACH AIRCRAFT

When applicable, the use of alternative or similar parts in place of the ones specified in the kits is allowable, provided that these alternative or similar parts are approved by Embraer as indicated in the related Embraer Technical Publications or through a formal Embraer communication channel.

The expendable or consumable parts presented in the AMM Tasks referred to in this bulletin, which are necessary for its accomplishment, should be procured from the operator's inventories or ordered as spares.

(1) **TOP KITS AND KITS**

Kit Summary: Top Kit Composition (Kit –6xx PN / Quantity)

Top Kit PN	506-20720-601	506-23680-601	506-23681-601	506-23682-601	506-23683-601	505-05477-601
BS5052500460001	1	1	-	-	-	-
BS5052500460002	-	-	1	-	-	1
BS5052500460003	-	-	1	1	-	1
BS5052500460004	-	-	-	1	-	-
BS5052500460005	-	-	1	-	1	1
BS5052500460006	-	-	-	-	1	-

(a)

Kit PN 506-20720-601 - LH WARDROBE					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-66837-001	Support	-	01	01	2

(a)

(Continued)

Kit PN 506-20720-601 - LH WARDROBE					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-66853-001	Reinforcement	-	01	01	2

(b)

Kit PN 506-23680-601 - RH REFRESHMENT CENTER					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-66849-001	Support	-	04	04	2
506-66850-001	Support	-	01	01	2
506-66851-001	Support	-	01	01	2

(c)

Kit PN 506-23681-601 - RH REFRESHMENT CENTER					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-23665-001	Reinforcement	-	01	01	2

(d)

Kit PN 506-23682-601 - LH WARDROBE					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-66806-001	Reinforcement	-	02	02	2
506-66855-001	Reinforcement	-	01	01	2
506-66856-001	Reinforcement	-	01	01	2

(e)

Kit PN 506-23683-601 - LH WARDROBE					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
506-66806-001	Reinforcement	-	02	02	2
506-66854-001	Reinforcement	-	01	01	2
506-66856-001	Reinforcement	-	01	01	2

(f)

Kit PN 505-05477-601 - RH REFRESHMENT CENTER					
NEW PN	DESCRIPTION	OLD PN	QTY SUP	QTY RQD	DISP/ Notes
MS20470E5-7	Rivet	-	01	01	2
MS20470E5-8	Rivet	-	01	01	2

(2) MATERIAL TO BE PROCURED

(a) Parts

None.

(b) Consumable Materials

The material below or equivalent, required for the accomplishment of this bulletin, should be procured from the operator's inventories or from a local supplier.

Applicable to all Top Kit				
NEW PN	DESCRIPTION	OLD PN	QTY	DISP/ Notes
EC-460	Adhesive	-	AR	6

Applicable to Top Kit BS5052500460003 / BS5052500460004 / BS5052500460005 / BS5052500460006				
NEW PN	DESCRIPTION	OLD PN	QTY	DISP/ Notes
IP1083-ZE740	Paint	-	6	AR
20P20-3/K1G	Primer	-	6	AR

Applicable to Top Kit BS5052500460002 / BS5052500460003 / BS5052500460005				
NEW PN	DESCRIPTION	OLD PN	QTY	DISP/ Notes
NAFTOSEAL MC780 C-12	Epoxi Primer	-	6	AR

DISPOSITION: 2 = Incorporate part bearing NEW PN
6 = Apply as required

QUANTITY: AR = As Required

(c) Kit Updating

None.

D. MATERIAL NECESSARY FOR EACH SPARE

None.

E. REIDENTIFIED PARTS

Applicable to GROUP 1 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 1	50500027, 50500028, 50500029	505-30301-4001	506-20 721-60 1
	50500030, 50500032, 50500034, 50500037, 50500047, 50500050, 50500054, 50500057	505-30957-4001	506-20 723-60 1
	50500041	505-30734-4001	505-30 734-60 1
	50500059	505-30981-4001	505-30 981-60 1
	50500067	505-31559-4001	506-20 725-60 1
	50500074, 50500075, 50500077	505-30981-4001	505-30 981-60 1
	50500090, 50500093, 50500094	506-20220-4001	506-20 220-60 1
	50500097	506-20220-4101	506-20 220-61 1
	50500100, 50500105, 50500109	506-20220-4201	506-20 220-62 1
	50500111	506-20221-4001	506-20 221-60 1
	50500115, 50511135, 50500139, 50500145, 50500146, 50500155, 50500156, 50500166, 50500171, 50500204, 50500206, 50500208, 50500216, 50500236, 50500238, 50500241, 50500243	506-20222-4001	506-20 222-60 1

(Continued)

Applicable to GROUP 1 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
	50500233, 50500234, 50500269, 50500276, 50500380, 50500382, 50500388, 50500391, 50500447, 50500523, 50500538	506-20222-4003	506-20 222-60 3
	50500239, 50500242, 50500246, 50500290, 50500378, 50500384, 50500387, 50500393, 50500394, 50500457, 50500524, 50500536, 50500539	506-20222-4005	506-20 222-60 5
	50500572, 50500581	506-20223-4003	506-20 224-40 03
	50600576, 50500592	506-20223-4005	506-20 224-40 05

Applicable to GROUP 1 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 1	50500027, 50500028, 50500029	505-30271-4001	506-20 271-60 1
	50500030, 50500032, 50500034, 50500037, 50500047, 50500050, 50500054, 50500057	505-30973-4001	505-30 973-60 1
	50500041	505-30730-4001	505-30 730-60 1
	50500059, 50500074, 50500075, 50500090, 50500093, 50500094, 50500097, 50500100, 50500105	505-30986-4001	505-30 986-60 1
	50500067	505-31565-4001	505-31 565-60 1
	50500077	505-23280-4001	506-23 280-60 1
	50500109, 50500111, 50500115, 50511135, 50500139, 50500145, 50500155, 50500156, 50500166, 50500171, 50500204, 50500206, 50500208, 50500236	506-23270-4001	506-23 271-40 01
	50500146, 50500238, 50500241, 50500243	506-23310-4001	506-23 310-60 1
	50500233, 50500234, 50500269, 50500380, 50500382, 50500388, 50500391, 50500447, 50500523, 50500538, 50500572, 50500581	506-23270-4003	506-23 271-40 03
	50500239, 50500242, 50500246, 50500290, 50500378, 50500384, 50500387, 50500393, 50500394, 50500457, 50500524, 50500536, 50500539, 50600576, 50500592	506-23270-4005	506-23 271-40 05

(Continued)

Applicable to GROUP 1 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
	50500216	506-23380-4001	506-23380-601
	50500276	506-23380-4005	506-23380-605

Applicable to GROUP 2 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 2	50500027, 50500028, 50500029	505-30301-601	506-20722-601
	50500030, 50500032, 50500034, 50500037, 50500047, 50500050, 50500054, 50500057	505-30957-601	506-20724-601
	50500059, 50500074, 50500075, 50500077	506-20220-4001	506-20220-601

Applicable to GROUP 3 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 3	50500033	505-32063-4001	505-32 063-60 1
	50500035	505-30595-4001	505-30 595-60 1
	50500036	505-32061-4001	505-32 061-60 1
	50500038	505-32065-4001	505-32 065-60 1
	50500040	505-30724-4001	505-30 724-60 1
	50500043	505-30946-4001	505-30 946-60 1
	50500044	505-30946-4003	505-30 946-60 3
	50500045	505-30946-4005	505-30 946-60 5
	50500051	505-32356-4001	505-32 356-60 1
	50500052	505-30952-4003	505-30 952-60 3
	50500055	505-32448-4001	505-32 448-60 1
	50500056	505-32621-4003	505-32 621-60 3
	50500060, 50500080	506-23010-4001	506-23 010-60 1
	50500061	505-31531-4003	505-31 531-60 3

(Continued)

Applicable to GROUP 3 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
	50500062	505-31531-4005	505-31 531-60 5
	50500064	505-31531-4007	505-31 531-60 7
	50500065	505-31547-4003	505-31 547-60 3
	50500070	505-30821-4003	505-30 821-60 3
	50500071	505-30791-4005	505-30 791-60 5
	50500072	505-30607-4003	505-30 607-60 3
	50500076, 50500088	505-30791-4001	505-30 791-60 1
	50500078, 50500091	505-30791-4005	505-30 791-60 5
	50500079, 50500081	505-30821-4005	505-30 821-60 5
	50500082, 50500092	505-30791-4003	505-30 791-60 3
	50500083	505-32633-4001	505-32 633-60 1
	50500084	505-30607-4001	505-30 607-60 1
	50500086	505-30791-4007	505-30 791-60 7
	50500087	506-23010-4003	506-23 010-60 3

(Continued)

Applicable to GROUP 3 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
	50500089	505-30791-4011	505-30791-611
	50500095, 50500098	505-30607-4103	505-30607-603
	50500099	505-30791-4101	506-66871-611
	50500101	505-30607-4201	505-30607-621
	50500103	505-30607-4105	505-30607-605
	50500104	505-32621-4005	505-32621-605
	50500107	506-23011-4001	506-23011-601
	50500113	506-23200-4003	506-23200-603
	50500114, 50500133, 50500140, 50500144	506-23200-4007	506-23200-607
	50500117, 50500121	506-23200-4003	506-23200-603
	50500119	506-23210-4001	506-23210-601
	50500124, 50500129	506-23200-4005	506-23200-605
	50500148, 50500150, 50500159, 50500185	506-23201-4001	506-23201-4001
	50500149, 50500157, 50500177, 50500193, 50500196	506-23201-4003	506-23201-603

(Continued)

Applicable to GROUP 3 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
	50500187	506-23201-4005	506-23 201-60 5
	50500182	506-23201-4007	506-23 201-60 7
	50500211, 50500217, 50500218, 50500220, 50500221, 50500222, 50500232, 50500240, 50500247, 50500274	506-23202-4007	506-23 202-60 7
	50500213, 50500445	506-23202-4009	506-23 202-60 9
	50500251, 50500299, 50500305, 50500312	506-23202-4013	506-23 202-61 3
	50500261, 50500315, 50500366	506-23202-4015	506-23 202-61 5
	50500337, 50500404	506-23202-4019	506-23 202-61 9
	50500415	506-23202-4021	506-23 202-62 1
	50500459	506-23203-4001	506-23 203-60 1
	50500499, 50500516	506-23203-4003	506-23 203-60 3
	50500267, 50500313, 50500341, 50500354, 50500368, 50500386	506-23212-4001	506-23 212-60 1
	50500253	506-23212-4003	506-23 212-60 3
	50500381	506-23212-4005	506-23 212-60 5
	50500127, 50500128, 50500130, 50500131	506-23220-4001	506-23 220-60 1

(Continued)

Applicable to GROUP 3 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
	50500118, 50500142	506-23220-4003	506-23 220-60 3
	50500134	506-23220-4005	506-23 220-60 5
	50500163	506-23221-4003	506-23 221-60 3
	50500249	506-23222-4003	506-23 222-60 3
	50500258	506-23222-4007	506-23 222-60 7
	50500125	506-23230-4003	506-23 230603
	50500307	506-23232-4003	506-23 232-60 3
	50500126	506-23260-4003	506-23 260-60 3

Applicable to GROUP 4 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 4	50500007	505-30607-4103	505-30 607-61 3

Applicable to GROUP 4 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 4	50500007	505-30263-4001	505-30 263-60 1

Applicable to GROUP 5 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 5	50500007	505-29932-6003	506-66 870-60 3

Applicable to GROUP 5 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 5	50500007	505-30083-4005	505-30 083-60 5

Applicable to GROUP 6 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 6	50500004, 50500019	505-30124-4003	505-30 124-60 3
	50500005	505-29364-4001	505-29 364-60 1
	50500008	505-29932-4003	506-23 685-60 3
	50500010, 50500011	505-29927-4001	505-29 927-60 1
	50500012	505-29364-4003	505-29 364-60 3
	50500014	505-29932-4005	505-29 932-60 5
	50500016	505-30124-4007	505-30 124-60 7
	50500018	505-30126-4007	505-30 126-60 7
	50500021	505-30461-4003	505-30 461-60 3
	50500022, 50500024	505-30461-4001	505-30 461-60 1
	50500025	505-32063-4003	505-32 063-60 3

Applicable to GROUP 6 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 6	50500004	505-30414-4005	505-30 414-60 5
	50500005	505-30077-4001	505-30 077-60 1
	50500008	505-30083-4005	505-30 083-60 5
	50500010, 50500011, 50500012	505-30083-4007	505-30 083-60 7
	50500014	505-30083-4009	505-30 083-60 9
	50500016	505-30414-4009	505-30 414-60 9
	50500018, 50500022, 50500024	505-30414-4007	505-30 414-60 7
	50500019	505-30414-4005	505-30 414-60 5
	50500021	505-30414-4013	505-30 414-61 3
	50500025	505-31481-4001	505-31 481-60 1

Applicable to GROUP 7- LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 7	50500006	505-30081-4001	505-30081-601
	50500017, 50500023	505-30414-4009	505-30414-609
	50500020	505-30414-4011	505-30414-611
	50500026	505-30465-4001	505-30465-601

Applicable to GROUP 8 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 8	50500282, 50500298	506-23202-4017	506-23202-617
	50500285, 50500317	506-23202-4007	506-23202-607
	50500326, 50500360	506-23202-4013	506-23202-613
	50500418	506-23202-4019	506-23202-619

Applicable to GROUP 8 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 8	50500282, 50500298	506-20420-4003	506-20420-603
	50500285, 50500317	506-20370-4005	506-20370-605
	50500326, 50500360	506-20370-4007	506-20370-607
	50500418	506-20370-4009	506-20370-609

Applicable to GROUP 9 - LH WARDROBE			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 9	50500330	506-20370-4009	506-20370-609

Applicable to GROUP 10 - RH REFRESHMENT CENTER			
DESCRIPTION	SN	OLD PN	NEW PN
GROUP 10	50500116	506-24731-601	506-24825-601

F. TOOLING - PRICE AND AVAILABILITY

None.

3. ACCOMPLISHMENT INSTRUCTIONS

- NOTE:**
- 1) Obey all of the WARNINGS and CAUTIONS included in the referenced manuals and procedures.
 - 2) The expendable or consumable materials presented in the AMM Tasks referred to in this bulletin can be necessary for its accomplishment. Examine the operator's inventories to make sure that all materials are available.
 - 3) The required tests included in the tasks below should be accomplished after all instruments are installed.
 - 4) The Manuals and other documents are referred to by means of acronyms or using a simplified form. Refer to section "1. I. REFERENCES" for a more complete definition.
 - 5) This Service Bulletin effectivity is divided GROUPS.

REFERENCE APPLICATION TABLE

Aircraft GROUP	APPLICABLE FIGURES
01	1, 2, 3
02	1, 2, 3
03	4, 5
04	4, 5
05	4, 5
06	4, 5, 6
07	6
08	4, 5, 7
09	7
10	4, 5

The steps below outline the general accomplishment instructions.

The detailed sequence is included in the respective figure, when necessary.

- A. Make sure that the aircraft is safe for maintenance. Refer to [AMM TASK 20-00-00-910-801-A/200](#) - Aircraft Maintenance Safety Procedures.
- B. De-energize the aircraft. Refer to [AMM TASK 24-41-00-860-802-A/200](#) - Aircraft De-energization - Aircraft/System Configuration.
- C. GROUPS 1 and 2 –LH FORWARD CABINET
 - (1) Make sure that the LH forward cabinet is empty.
 - (2) Remove access panel 223CLW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
 - (3) Remove the main-door shroud. Refer to [AMM TASK 25-23-05-000-801-A/400](#) - Main Door Shroud - Removal.
 - (4) Remove the maintenance panel. Refer to [AMM TASK 31-42-01-000-801-A/400](#) - Maintenance Panel - Removal.

- (5) Remove the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-000-801-A/400](#) - Cockpit AC Electrical Outlet - Removal.
- (6) Remove the IFE drawer. Refer to [AMM TASK 25-26-04-000-801-A/400](#) - IFE Drawer - Removal.
- (7) Remove the remote-control sensor. Refer to [AMM TASK 44-21-17-000-801-A/400](#) - Remote Control Sensor - Removal.
- (8) Remove the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-000-801-A/400](#) - Aircell Configuration Module (ACM) - Removal.
- (9) Remove the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-000-801-A/400](#) - Cabin Telecommunications Router (CTR) - Removal.
- (10) Remove the LH forward cabinet. Refer to [AMM TASK 25-26-01-000-801-A/400](#) - LH Forward Cabinet - Removal.
- (11) Rework the LH forward cabinet according to instructions given in [Figure 1](#).
- (12) Reinstall the LH forward cabinet. Refer to [AMM TASK 25-26-01-400-801-A/400](#) - LH Forward Cabinet - Installation.
- (13) Reinstall the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-400-801-A/400](#) - Cabin Telecommunications Router (CTR) - Installation.
- (14) Reinstall the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-400-801-A/400](#) - Aircell Configuration Module (ACM) - Installation.
- (15) Reinstall the remote-control sensor. Refer to [AMM TASK 44-21-17-400-801-A/400](#) - Remote Control Sensor - Installation.
- (16) Reinstall the IFE drawer. Refer to [AMM TASK 25-26-04-400-801-A/400](#) - IFE Drawer - Installation.
- (17) Reinstall the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-400-801-A/400](#) - Cockpit AC Electrical Outlet - Installation
- (18) Reinstall the maintenance panel. Refer to [AMM TASK 31-42-01-400-801-A/400](#) - Maintenance Panel - Installation.

D. GROUPS 1 and 2 – RH REFRESHMENT CENTER

- (1) Make sure that the RH refreshment center is empty.
- (2) Remove the portable fire extinguisher. Refer to [AMM TASK 26-24-01-000-801-A/400](#) - Portable Fire Extinguisher - Removal.
- (3) Remove the heated drain line. Refer to [AMM TASK 38-31-07-000-801-A/400](#) - Heated Drain Line - Removal.
- (4) Remove the ice-box drain line. Refer to [AMM TASK 38-31-05-000-801-A/400](#) - Drain Line - Removal.
- (5) Remove access panel 224BRW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (6) Remove the cockpit temperature sensor. Refer to [AMM TASK 21-61-04-000-801-A/400](#) - Cockpit Temperature Sensor - Removal.
- (7) Remove the passenger seat. Refer to [AMM TASK 25-21-01-000-801-A/400](#) - Passenger Seats - Removal.

- (8) Remove the hot jug. Refer to [AMM TASK 25-37-01-000-801-A/400](#) - Hot Jugs - Removal.
- (9) Remove the hot-jug drain line. Refer to [AMM TASK 38-31-05-000-801-A/400](#) - Drain Line - Removal.
- (10) Remove the RH sidewall panels. Refer to [AMM TASK 25-23-01-000-801-A/400](#) - Sidewall Panels - Removal.
- (11) Remove the RH sideledge. Refer to [AMM TASK 25-25-02-000-801-A/400](#) - RH Sideledge - Removal.
- (12) Remove the RH Refreshment Center. Refer to [AMM TASK 25-31-02-000-801-A/400](#) - RH Refreshment Center - Removal.
- (13) Rework the RH Refreshment Center according to instructions given in [Figure 2](#) and [Figure 3](#).
- (14) Reinstall the RH Refreshment Center. Refer to [AMM TASK 25-31-02-400-801-A/400](#) - RH Refreshment Center - Installation.
- (15) Reinstall the RH sideledge. Refer to [AMM TASK 25-25-02-400-801-A/400](#) - RH Sideledge - Installation.
- (16) Reinstall the RH sidewall panels. Refer to [AMM TASK 25-23-01-400-801-A/400](#) - Sidewall Panels - Installation.
- (17) Reinstall the hot-jug drain line. Refer to [AMM TASK 38-31-05-400-801-A/400](#) - Drain Line - Installation.
- (18) Reinstall the hot jug. Refer to [AMM TASK 25-37-01-400-801-A/400](#) - Hot Jugs - Installation.
- (19) Reinstall the passenger seat. Refer to [AMM TASK 25-21-01-400-801-A/400](#) - Passenger Seats - Installation.
- (20) Reinstall the cockpit temperature sensor. Refer to [AMM TASK 21-61-04-400-801-A/400](#) - Cockpit Temperature Sensor - Installation.
- (21) Reinstall access panel 224BRW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (22) Reinstall the ice-box drain line. Refer to [AMM TASK 38-31-07-400-801-A/400](#) - Heated Drain Line - Installation.
- (23) Remove the heated drain line. Refer to [AMM TASK 38-31-07-400-801-A/400](#) - Heated Drain Line - Installation.
- (24) Remove the portable fire extinguisher. Refer to [AMM TASK 26-24-01-400-801-A/400](#) - Portable Fire Extinguisher - Installation.

E. GROUPS 3, 4, 5, 6, 8, and 10 – RH REFRESHMENT CENTER

- (1) Make sure that the RH refreshment center is empty.
- (2) Remove the portable fire extinguisher. Refer to [AMM TASK 26-24-01-000-801-A/400](#) - Portable Fire Extinguisher - Removal.
- (3) Remove the heated drain line. Refer to [AMM TASK 38-31-07-000-801-A/400](#) - Heated Drain Line - Removal.
- (4) Remove the ice-box drain line. Refer to [AMM TASK 38-31-05-000-801-A/400](#) - Drain Line - Removal.

- (5) Remove access panel 224BRW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (6) Remove the cockpit temperature sensor. Refer to [AMM TASK 21-61-04-000-801-A/400](#) - Cockpit Temperature Sensor - Removal.
- (7) Remove the passenger seat. Refer to [AMM TASK 25-21-01-000-801-A/400](#) - Passenger Seats - Removal.
- (8) Remove the hot jug. Refer to [AMM TASK 25-37-01-000-801-A/400](#) - Hot Jugs - Removal.
- (9) Remove the hot-jug drain line. Refer to [AMM TASK 38-31-05-000-801-A/400](#) - Drain Line - Removal.
- (10) Remove the RH sidewall panels. Refer to [AMM TASK 25-23-01-000-801-A/400](#) - Sidewall Panels - Removal.
- (11) Remove the RH sideledge. Refer to [AMM TASK 25-25-02-000-801-A/400](#) - RH Sideledge - Removal.
- (12) Remove the RH Refreshment Center. Refer to [AMM TASK 25-31-02-000-801-A/400](#) - RH Refreshment Center - Removal.
- (13) Rework the RH Refreshment Center according to instructions given in [Figure 4](#).
- (14) Replace rivets at frame 8A according to instructions given in [Figure 5](#).
- (15) Reinstall the RH Refreshment Center. Refer to [AMM TASK 25-31-02-400-801-A/400](#) - RH Refreshment Center - Installation.
- (16) Reinstall the RH sideledge. Refer to [AMM TASK 25-25-02-400-801-A/400](#) - RH Sideledge - Installation.
- (17) Reinstall the RH sidewall panels. Refer to [AMM TASK 25-23-01-400-801-A/400](#) - Sidewall Panels - Installation.
- (18) Reinstall the hot-jug drain line. Refer to [AMM TASK 38-31-05-400-801-A/400](#) - Drain Line - Installation.
- (19) Reinstall the hot jug. Refer to [AMM TASK 25-37-01-400-801-A/400](#) - Hot Jugs - Installation.
- (20) Reinstall the passenger seat. Refer to [AMM TASK 25-21-01-400-801-A/400](#) - Passenger Seats - Installation.
- (21) Reinstall the cockpit temperature sensor. Refer to [AMM TASK 21-61-04-400-801-A/400](#) - Cockpit Temperature Sensor - Installation.
- (22) Reinstall access panel 224BRW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (23) Reinstall the ice-box drain line. Refer to [AMM TASK 38-31-07-400-801-A/400](#) - Heated Drain Line - Installation.
- (24) Remove the heated drain line. Refer to [AMM TASK 38-31-07-400-801-A/400](#) - Heated Drain Line - Installation.
- (25) Remove the portable fire extinguisher. Refer to [AMM TASK 26-24-01-400-801-A/400](#) - Portable Fire Extinguisher - Installation.

F. GROUPS 6 and 7– LH WARDROBE

- (1) Make sure that the LH forward cabinet center is empty.
- (2) Remove access panel 223CLW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (3) Remove the main-door shroud. Refer to [AMM TASK 25-23-05-000-801-A/400](#) - Main Door Shroud - Removal.
- (4) Remove the maintenance panel. Refer to [AMM TASK 31-42-01-000-801-A/400](#) - Maintenance Panel - Removal.
- (5) Remove the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-000-801-A/400](#) - Cockpit AC Electrical Outlet - Removal.
- (6) Remove the IFE drawer. Refer to [AMM TASK 25-26-04-000-801-A/400](#) - IFE Drawer - Removal.
- (7) Remove the remote-control sensor. Refer to [AMM TASK 44-21-17-000-801-A/400](#) - Remote Control Sensor - Removal.
- (8) Remove the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-000-801-A/400](#) - Aircell Configuration Module (ACM) - Removal.
- (9) Remove the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-000-801-A/400](#) - Cabin Telecommunications Router (CTR) - Removal.
- (10) Remove the LH forward cabinet. Refer to [AMM TASK 25-26-01-000-801-A/400](#) - LH Forward Cabinet - Removal.
- (11) Rework the LH forward cabinet according to instructions given in [Figure 6](#).
- (12) Reinstall the LH forward cabinet. Refer to [AMM TASK 25-26-01-400-801-A/400](#) - LH Forward Cabinet - Installation.
- (13) Reinstall the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-400-801-A/400](#) - Cabin Telecommunications Router (CTR) - Installation.
- (14) Reinstall the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-400-801-A/400](#) - Aircell Configuration Module (ACM) - Installation.
- (15) Reinstall the remote-control sensor. Refer to [AMM TASK 44-21-17-400-801-A/400](#) - Remote Control Sensor - Installation.
- (16) Reinstall the IFE drawer. Refer to [AMM TASK 25-26-04-400-801-A/400](#) - IFE Drawer - Installation.
- (17) Reinstall the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-400-801-A/400](#) - Cockpit AC Electrical Outlet - Installation
- (18) Reinstall the maintenance panel. Refer to [AMM TASK 31-42-01-400-801-A/400](#) - Maintenance Panel - Installation.

G. GROUPS 8 and 9 – LH WARDROBE

- (1) Make sure that the LH forward cabinet center is empty.
- (2) Remove access panel 223CLW. Refer to [AMM TASK 06-47-00-800-801-A/100](#) - Cockpit Access Panels.
- (3) Remove the main-door shroud. Refer to [AMM TASK 25-23-05-000-801-A/400](#) - Main Door Shroud - Removal.

- (4) Remove the maintenance panel. Refer to [AMM TASK 31-42-01-000-801-A/400](#) - Maintenance Panel - Removal.
- (5) Remove the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-000-801-A/400](#) - Cockpit AC Electrical Outlet - Removal.
- (6) Remove the IFE drawer. Refer to [AMM TASK 25-26-04-000-801-A/400](#) - IFE Drawer - Removal.
- (7) Remove the remote-control sensor. Refer to [AMM TASK 44-21-17-000-801-A/400](#) - Remote Control Sensor - Removal.
- (8) Remove the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-000-801-A/400](#) - Aircell Configuration Module (ACM) - Removal.
- (9) Remove the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-000-801-A/400](#) - Cabin Telecommunications Router (CTR) - Removal.
- (10) Remove the LH forward cabinet. Refer to [AMM TASK 25-26-01-000-801-A/400](#) - LH Forward Cabinet - Removal.
- (11) Rework the LH forward cabinet according to instructions given in [Figure 7](#).
- (12) Reinstall the LH forward cabinet. Refer to [AMM TASK 25-26-01-400-801-A/400](#) - LH Forward Cabinet - Installation.
- (13) Reinstall the Cabin Telecommunications Router (CTR). Refer to [AMM TASK 44-32-05-400-801-A/400](#) - Cabin Telecommunications Router (CTR) - Installation.
- (14) Reinstall the Aircell Configuration Module (ACM). Refer to [AMM TASK 44-32-03-400-801-A/400](#) - Aircell Configuration Module (ACM) - Installation.
- (15) Reinstall the remote-control sensor. Refer to [AMM TASK 44-21-17-400-801-A/400](#) - Remote Control Sensor - Installation.
- (16) Reinstall the IFE drawer. Refer to [AMM TASK 25-26-04-400-801-A/400](#) - IFE Drawer - Installation.
- (17) Reinstall the AC outlet from the wardrobe. Refer to [AMM TASK 24-54-01-400-801-A/400](#) - Cockpit AC Electrical Outlet - Installation
- (18) Reinstall the maintenance panel. Refer to [AMM TASK 31-42-01-400-801-A/400](#) - Maintenance Panel - Installation.

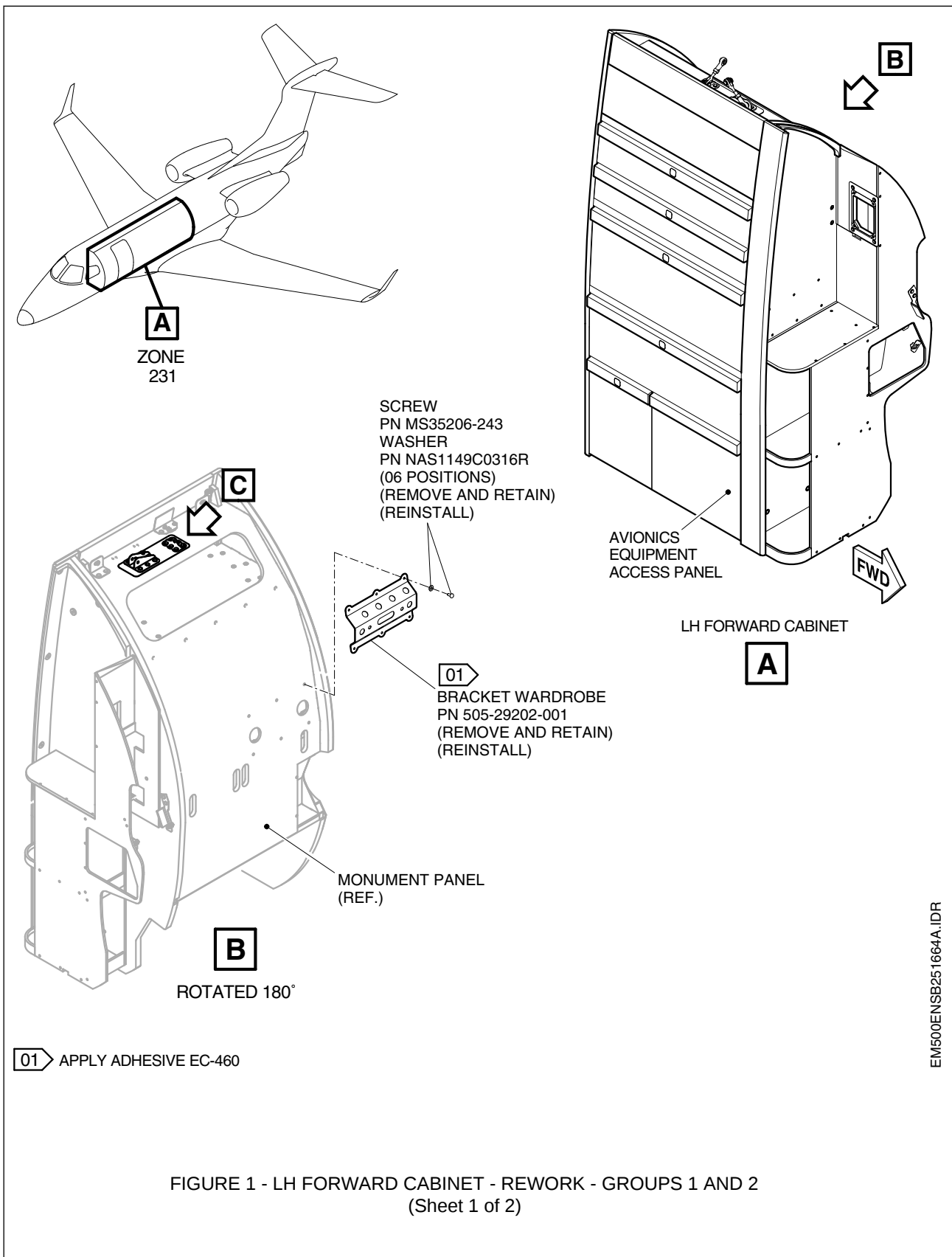
H. Restore the aircraft to normal.

I. Enter the accomplishment of PART I of this bulletin in the applicable documents.

J. Please use the online SB evaluation form available on the MyTechcare portal (<http://www.techcare.embraer.com>). Go to "Maintenance > eTechPubs > Utilities > SB Evaluation Form" to inform us about the SBs that you have incorporated in your fleet, as well as the difficulties found during the SB incorporation.

This will allow Embraer to consider your aircraft configuration when providing future modifications.

Your feedback will be much appreciated to improve the quality of Embraer modifications.



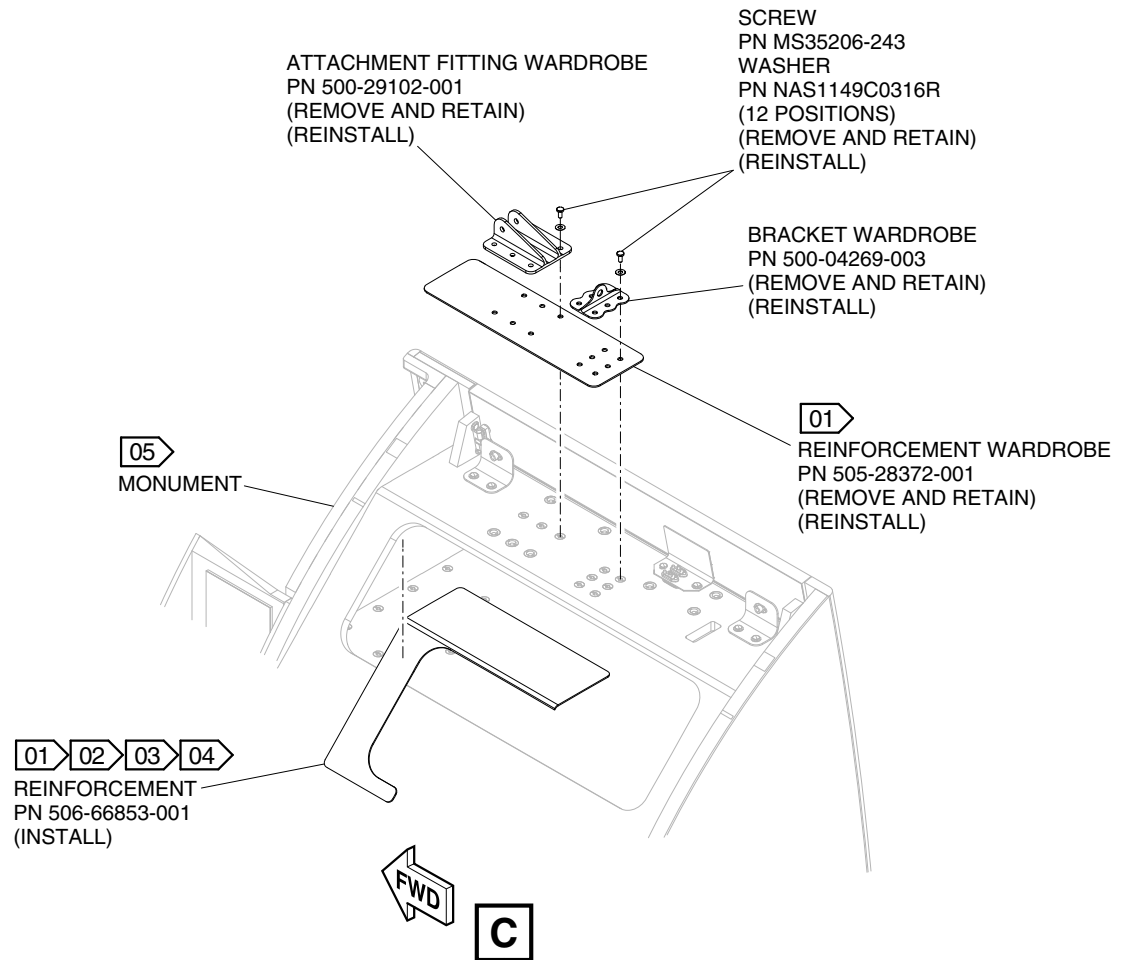
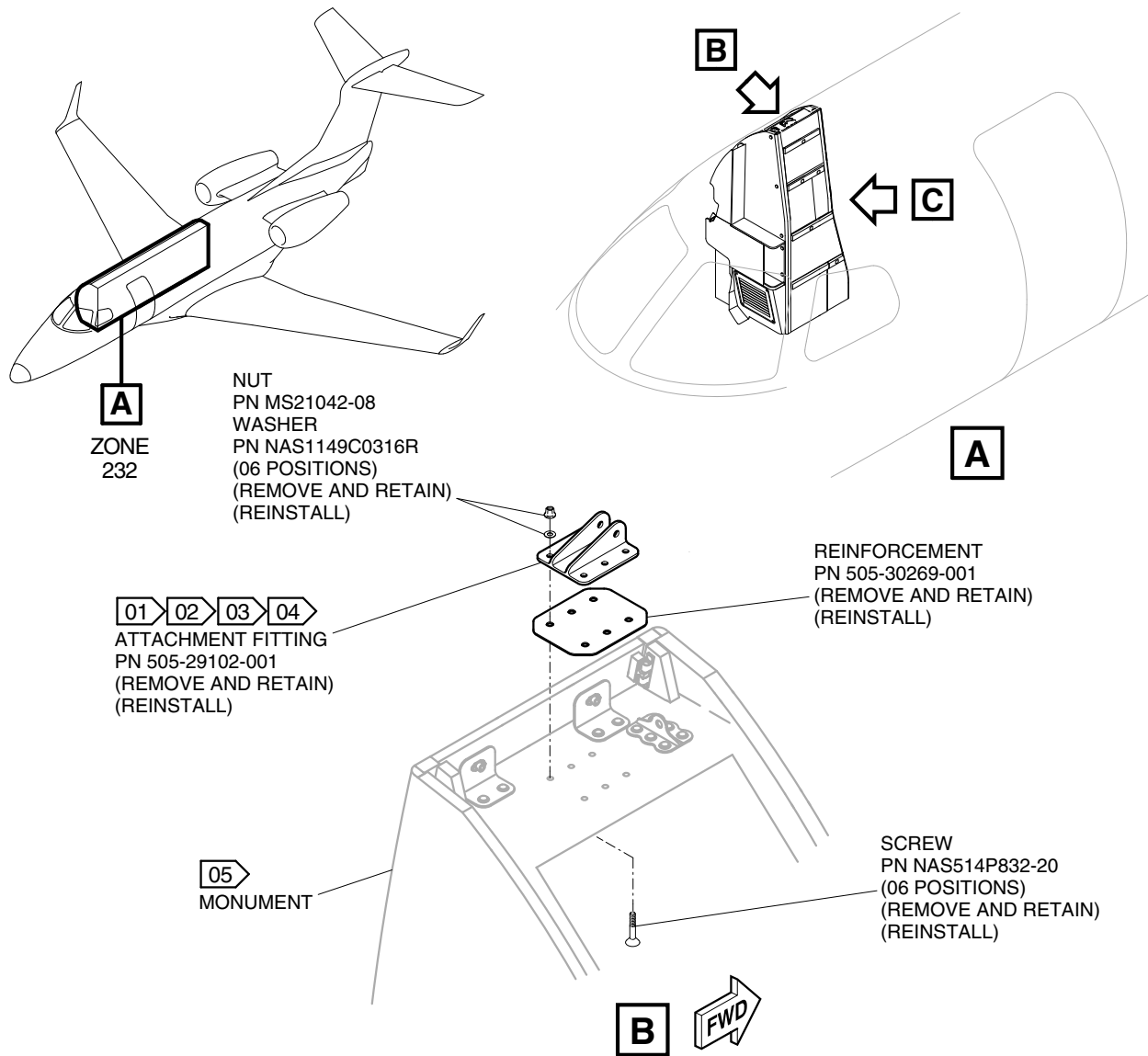


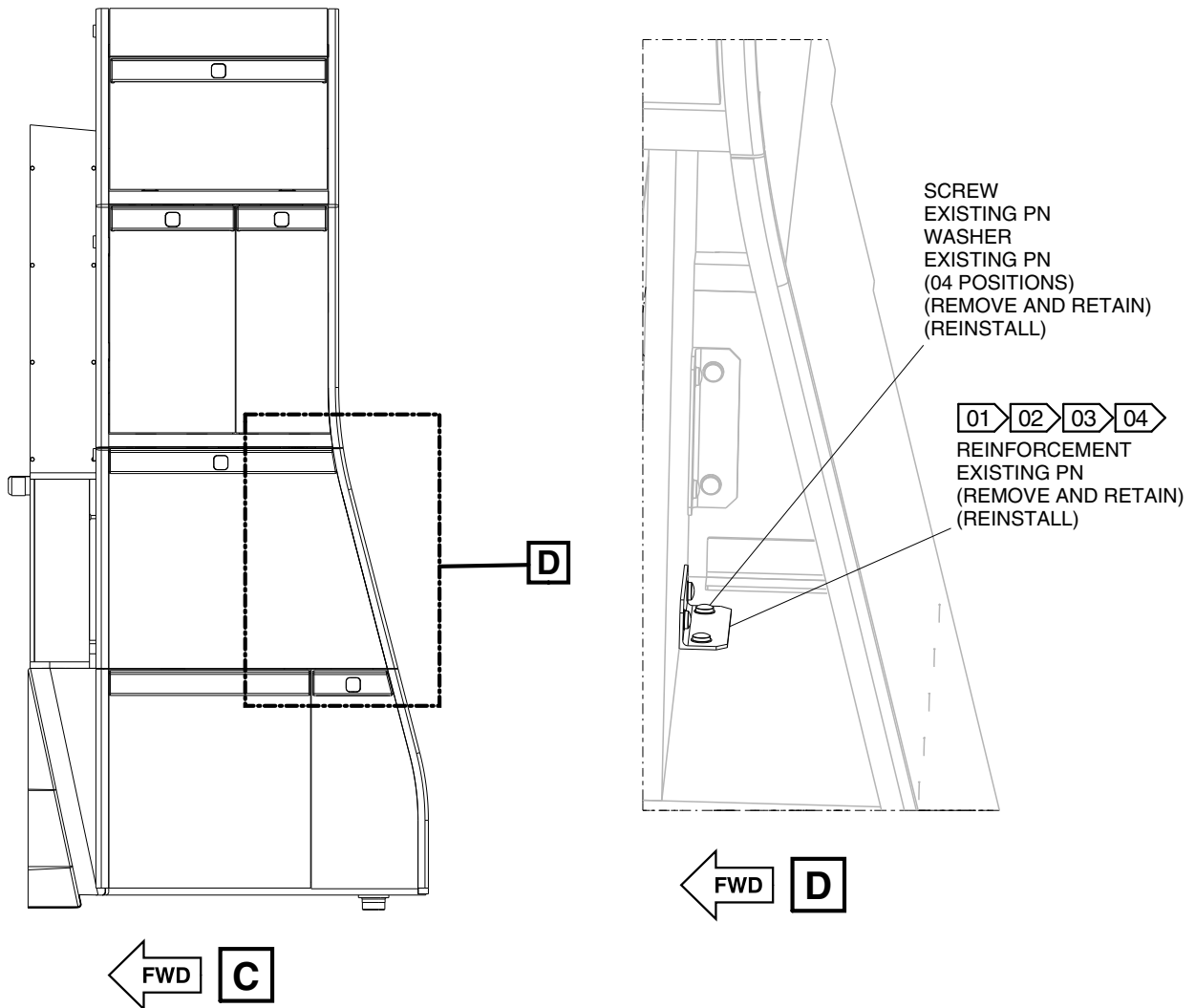
FIGURE 1 - LH FORWARD CABINET - REWORK - GROUPS 1 AND 2
(Sheet 2 of 2)



- 01 APPLY ADHESIVE EC-460
- 02 MANUALLY SAND PANEL AREA WHERE ADHESIVE IS TO BE APPLIED USING SANDPAPER GRIT 80 IN TWO PERPENDICULAR DIRECTIONS TO BREAK THE GLOSS AND SCRATCH THE SURFACE. CLEAN PANEL BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 03 MANUALLY SAND SURFACE OF METAL DOUBLERS AND BRACKETS TO BE BONDED TO PANELS USING ADHESIVE. SAND IN TWO PERPENDICULAR DIRECTIONS TO AID BONDING. CLEAN METAL SURFACE BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 04 USE TAPE TO HOLD BONDED ITEMS IN PLACE DURING TIME TAKEN FOR ADHESIVE TO CURE
- 05 USE PERMANENT INK MARKER TO REIDENTIFY MONUMENT

FIGURE 2 - RH REFRESHMENT CENTER - REINFORCEMENT INSTALLATION - GROUPS 1 AND 2
(Sheet 1 of 2)

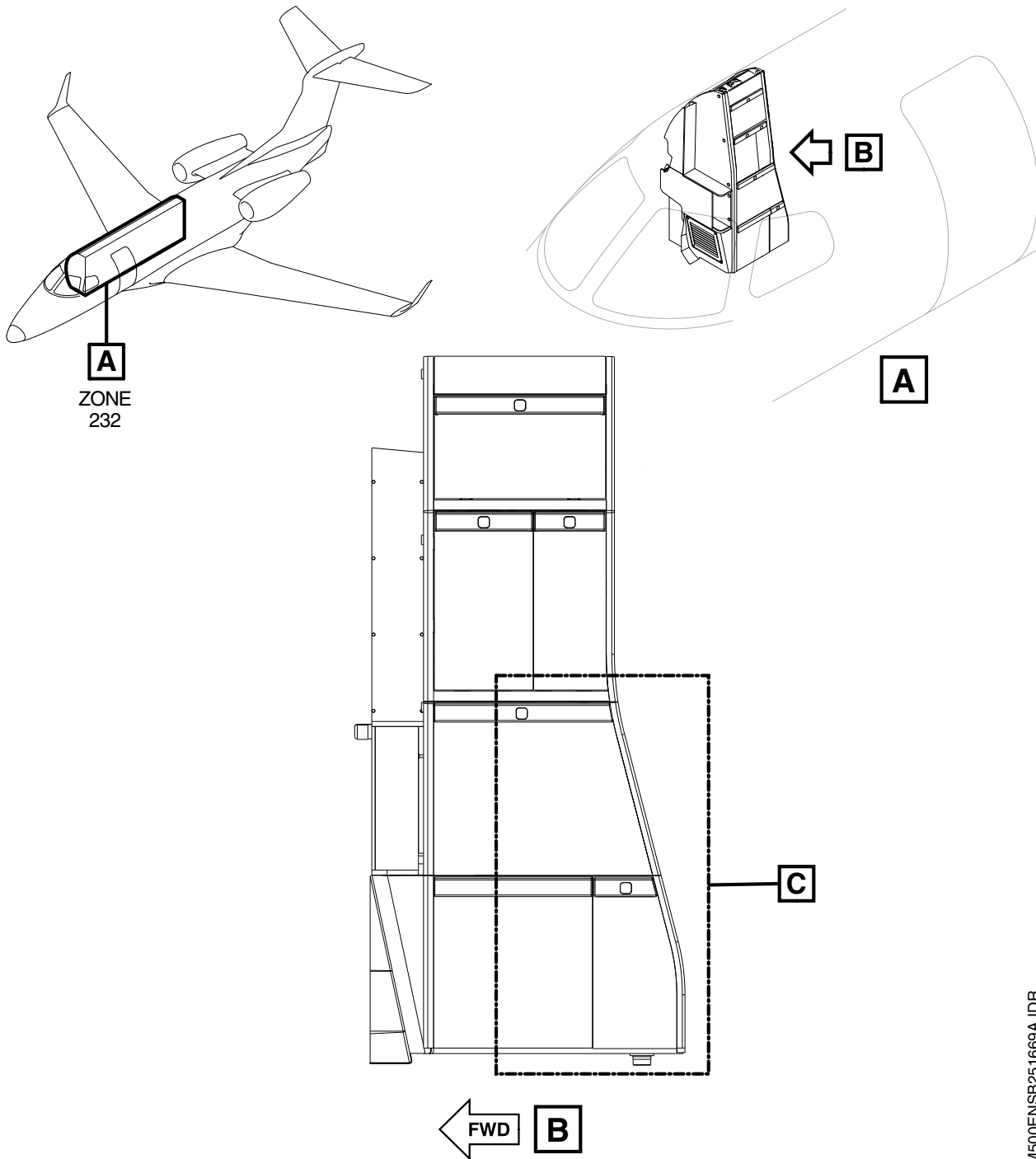
EM500ENSB251667A.IDR



- 01 APPLY ADHESIVE EC-460
- 02 MANUALLY SAND PANEL AREA WHERE ADHESIVE IS TO BE APPLIED USING SANDPAPER GRIT 80 IN TWO PERPENDICULAR DIRECTIONS TO BREAK THE GLOSS AND SCRATCH THE SURFACE. CLEAN PANEL BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 03 MANUALLY SAND SURFACE OF METAL DOUBLERS AND BRACKETS TO BE BONDED TO PANELS USING ADHESIVE. SAND IN TWO PERPENDICULAR DIRECTIONS TO AID BONDING. CLEAN METAL SURFACE BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 04 USE TAPE TO HOLD BONDED ITEMS IN PLACE DURING TIME TAKEN FOR ADHESIVE TO CURE

FIGURE 2 - RH REFRESHMENT CENTER - REINFORCEMENT INSTALLATION - GROUPS
1 AND 2
(Sheet 2 of 2)

EM500ENSB251668A.IDR



EM500ENSB251669A IDR

FIGURE 3 - RH REFRESHMENT CENTER - SUPPORT INSTALLATION - GROUPS 1 AND 2
(Sheet 1 of 3)

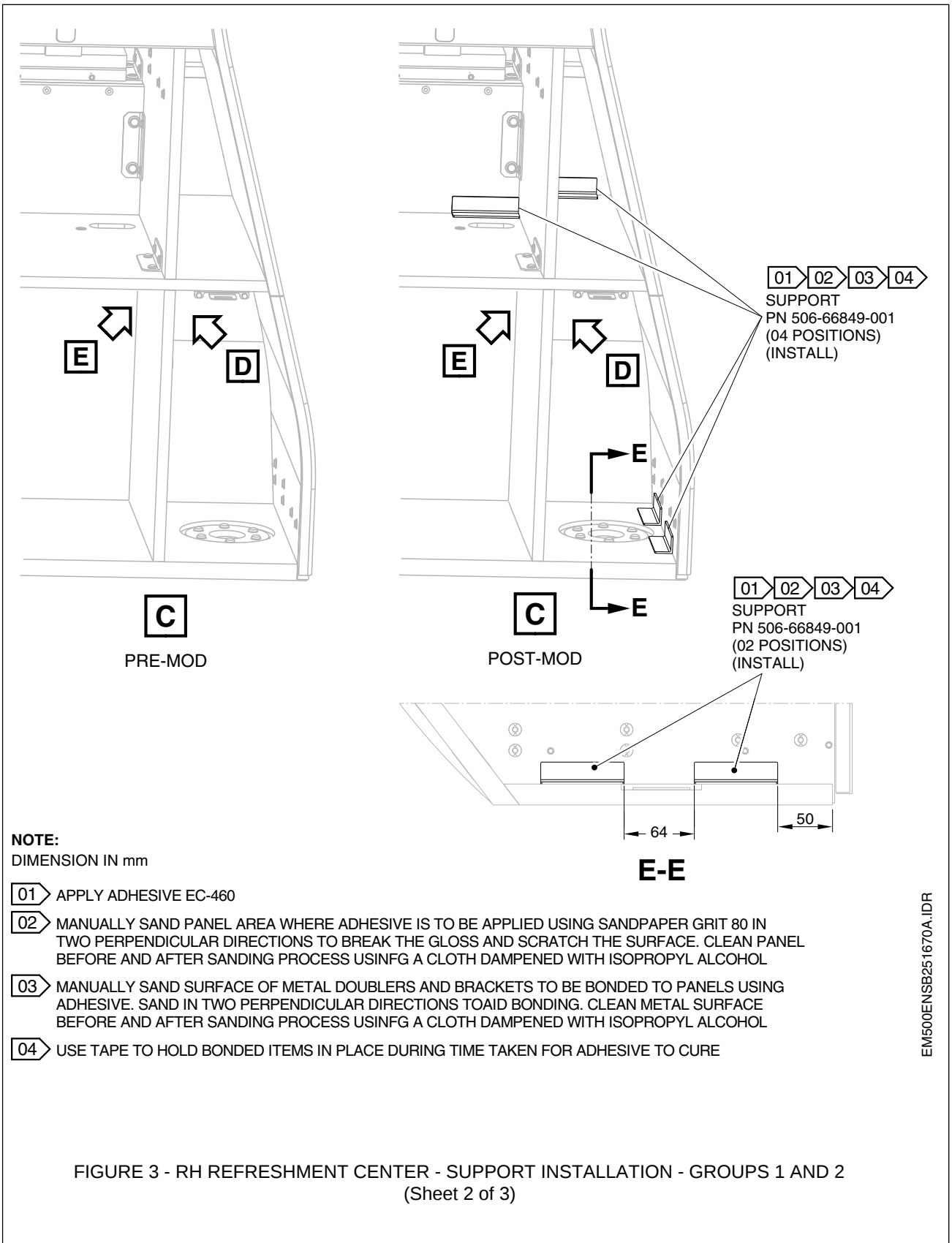
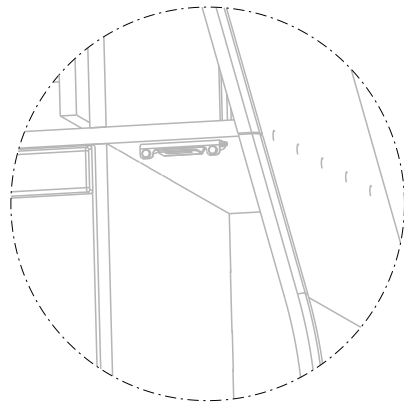
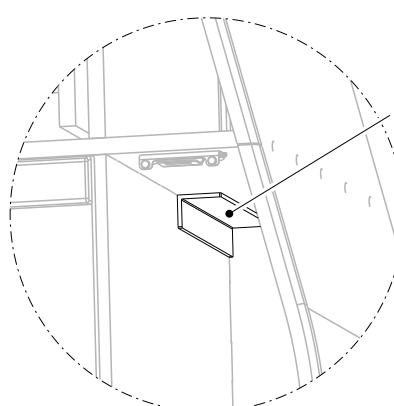


FIGURE 3 - RH REFRESHMENT CENTER - SUPPORT INSTALLATION - GROUPS 1 AND 2
(Sheet 2 of 3)



D

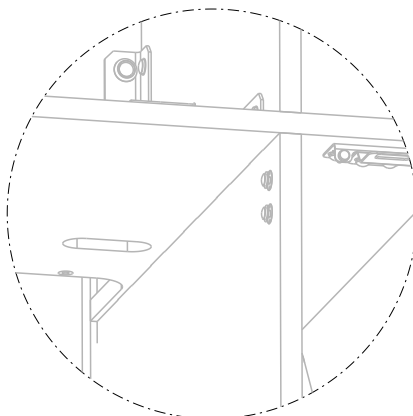
PRE-MOD



D

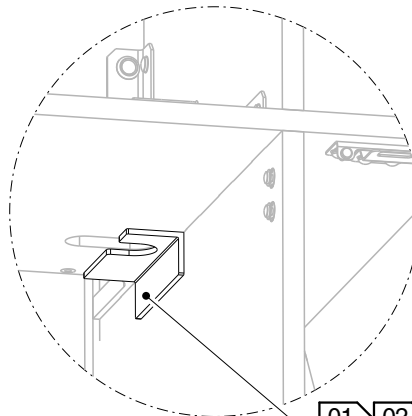
POST-MOD

01 02 03 04 05
SUPPORT
PN 506-66851-001
(INSTALL)



E

PRE-MOD



E

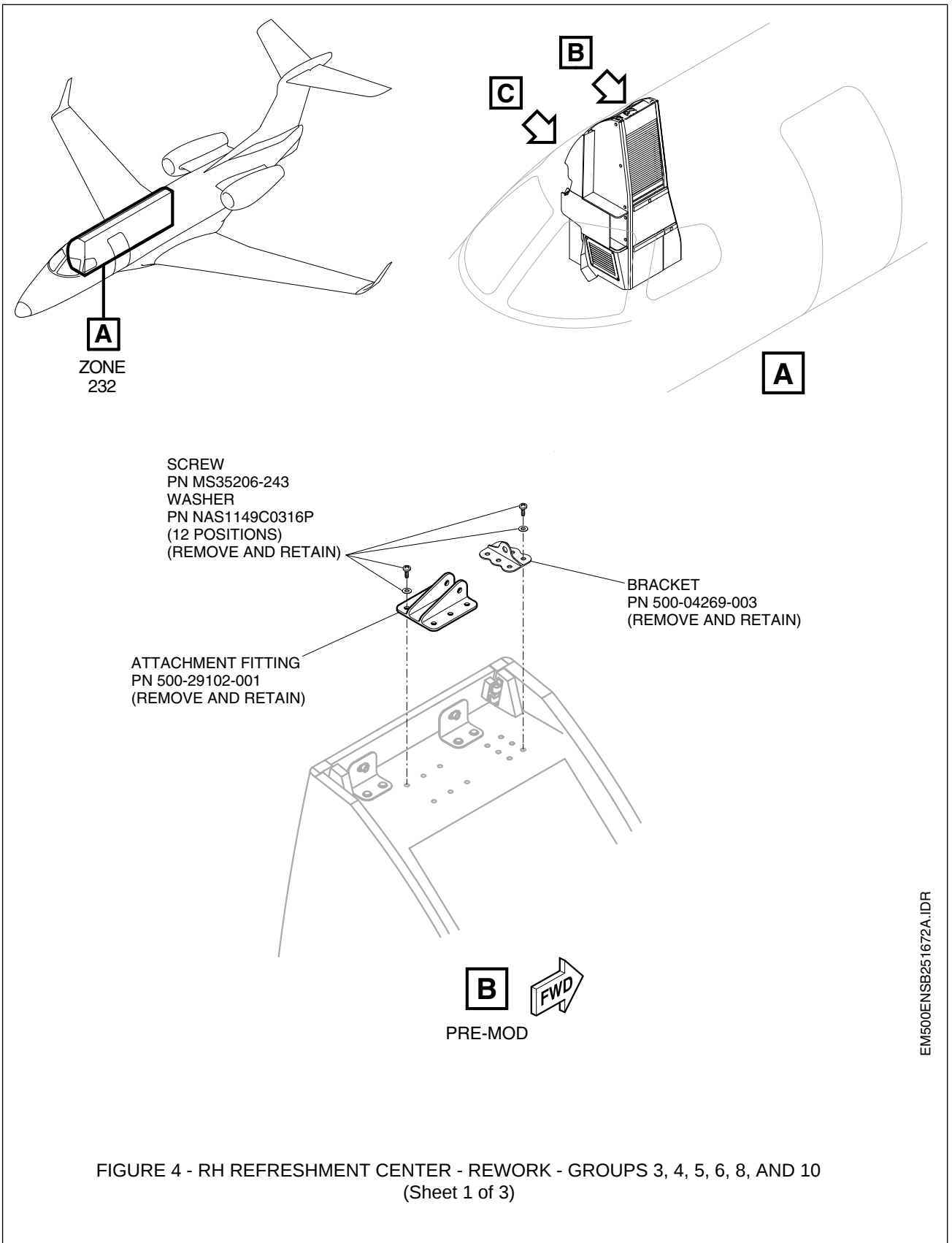
POST-MOD

01 02 03 04 05
SUPPORT
PN 506-66851-001
(INSTALL)

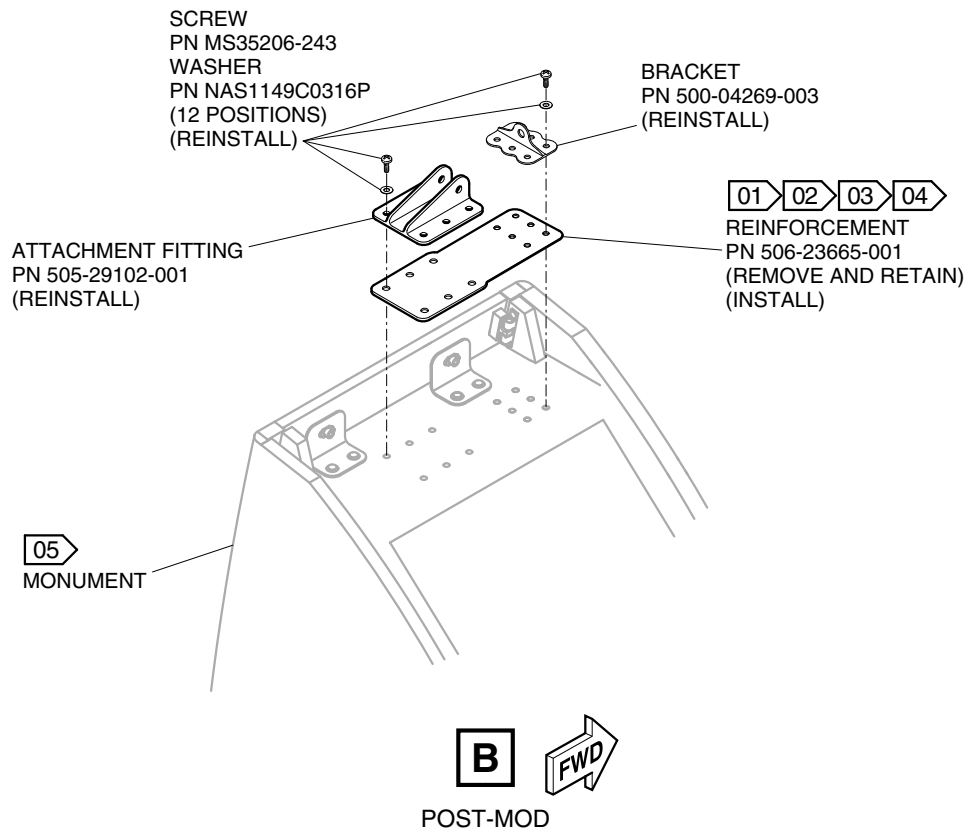
- 01 APPLY ADHESIVE EC-460
- 02 MANUALLY SAND PANEL AREA WHERE ADHESIVE IS TO BE APPLIED USING SANDPAPER GRIT 80 IN TWO PERPENDICULAR DIRECTIONS TO BREAK THE GLOSS AND SCRATCH THE SURFACE. CLEAN PANEL BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 03 MANUALLY SAND SURFACE OF METAL DOUBLERS AND BRACKETS TO BE BONDED TO PANELS USING ADHESIVE. SAND IN TWO PERPENDICULAR DIRECTIONS TO AID BONDING. CLEAN METAL SURFACE BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 04 USE TAPE TO HOLD BONDED ITEMS IN PLACE DURING TIME TAKEN FOR ADHESIVE TO CURE
- 05 ALIGN SUPPORT CUT OUT WITH MONUMENT CUT OUT

EM500ENSB251671A.IDR

FIGURE 3 - RH REFRESHMENT CENTER - SUPPORT INSTALLATION - GROUPS 1 AND 2
(Sheet 3 of 3)



EM500ENSB251672A IDR



- 01 APPLY ADHESIVE EC-460
- 02 MANUALLY SAND PANEL AREA WHERE ADHESIVE IS TO BE APPLIED USING SANDPAPER GRIT 80 IN TWO PERPENDICULAR DIRECTIONS TO BREAK THE GLOSS AND SCRATCH THE SURFACE. CLEAN PANEL BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 03 MANUALLY SAND SURFACE OF METAL DOUBLERS AND BRACKETS TO BE BONDED TO PANELS USING ADHESIVE. SAND IN TWO PERPENDICULAR DIRECTIONS TO AID BONDING. CLEAN METAL SURFACE BEFORE AND AFTER SANDING PROCESS USING A CLOTH DAMPENED WITH ISOPROPYL ALCOHOL
- 04 USE TAPE TO HOLD BONDED ITEMS IN PLACE DURING TIME TAKEN FOR ADHESIVE TO CURE
- 05 USE PERMANENT INK MARKER TO REIDENTIFY MONUMENT

EM500ENSB251684A IDR

FIGURE 4 - RH REFRESHMENT CENTER - REWORK - GROUPS 3, 4, 5, 6, 8, AND 10
(Sheet 2 of 3)

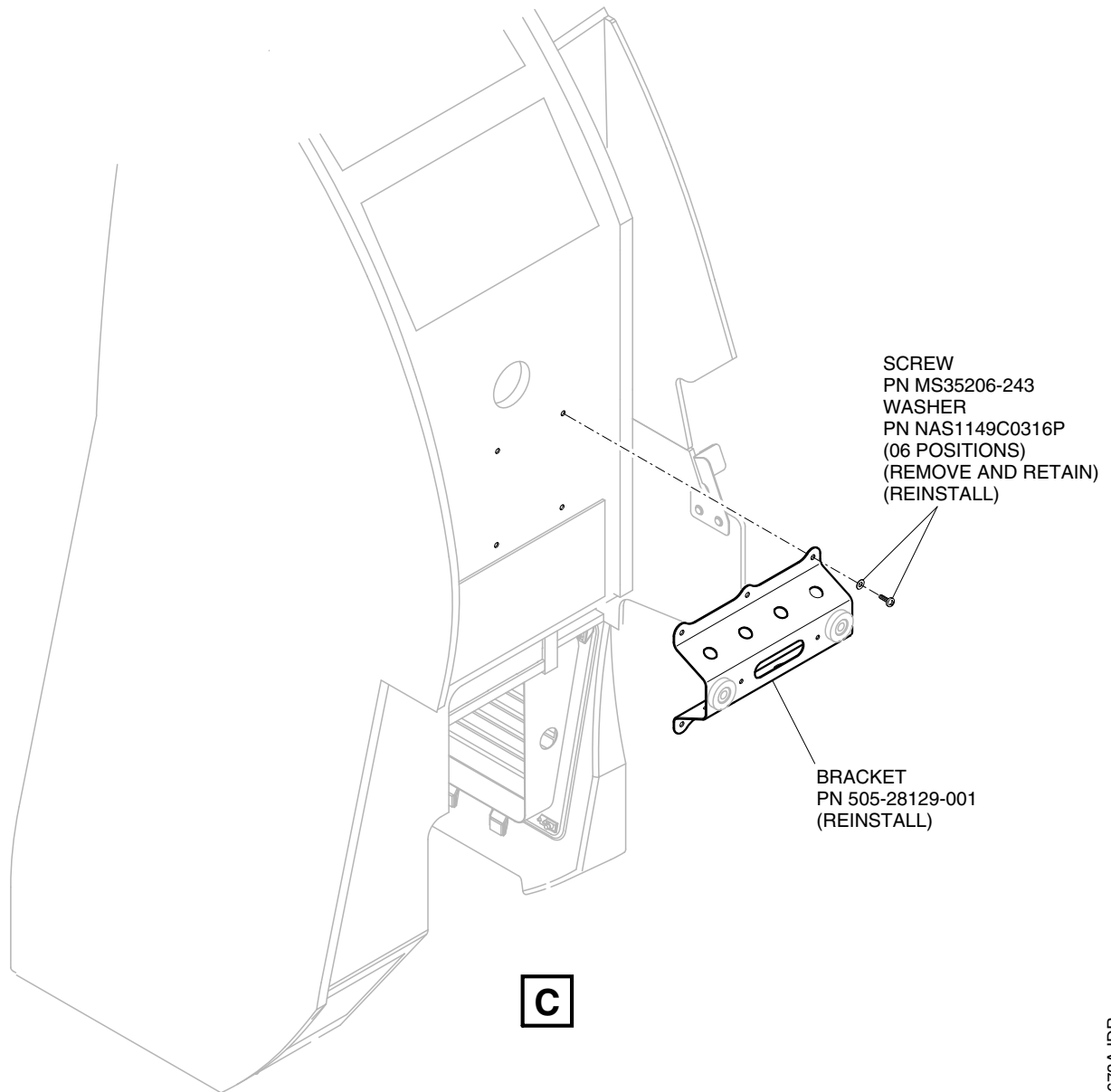
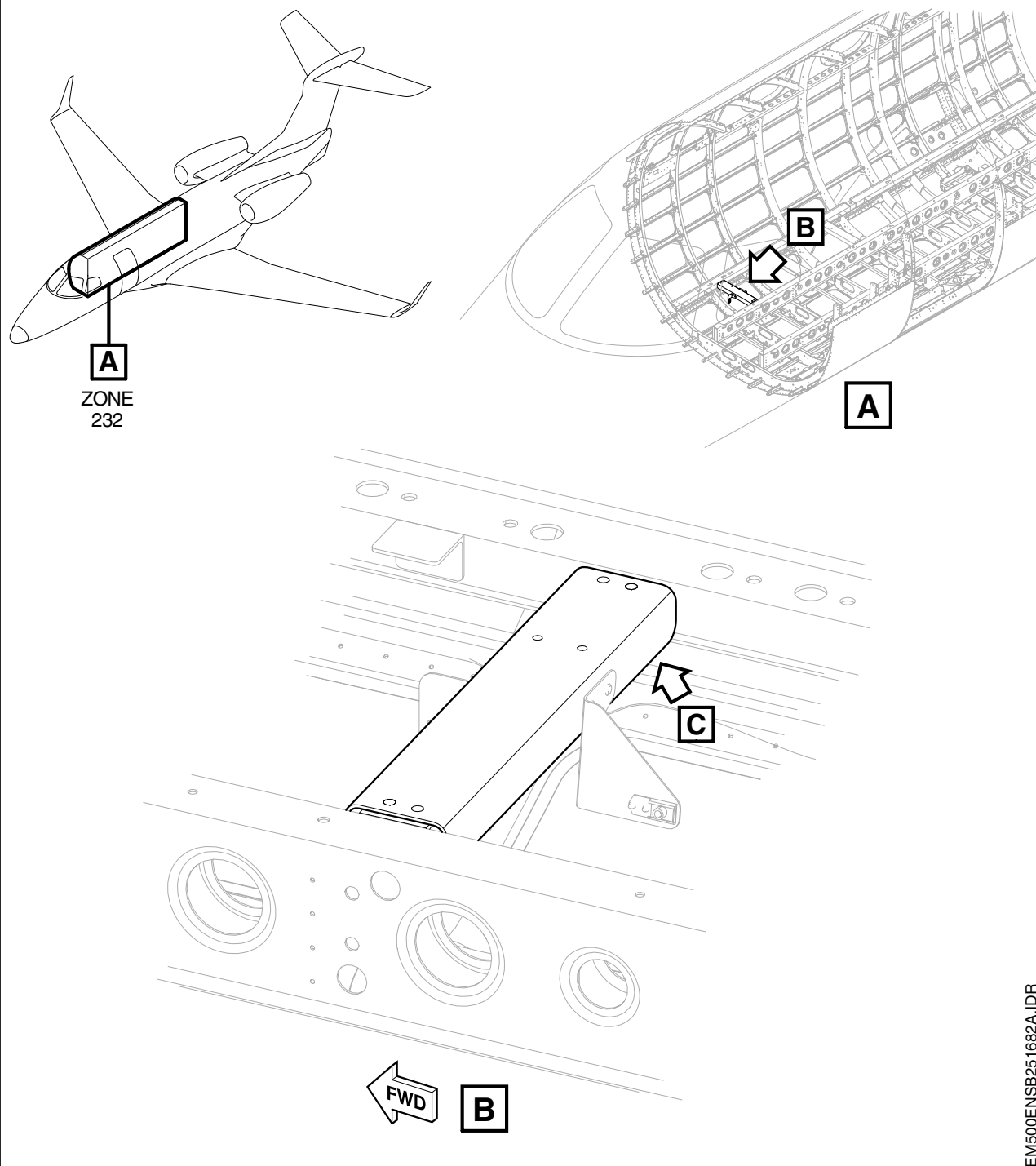


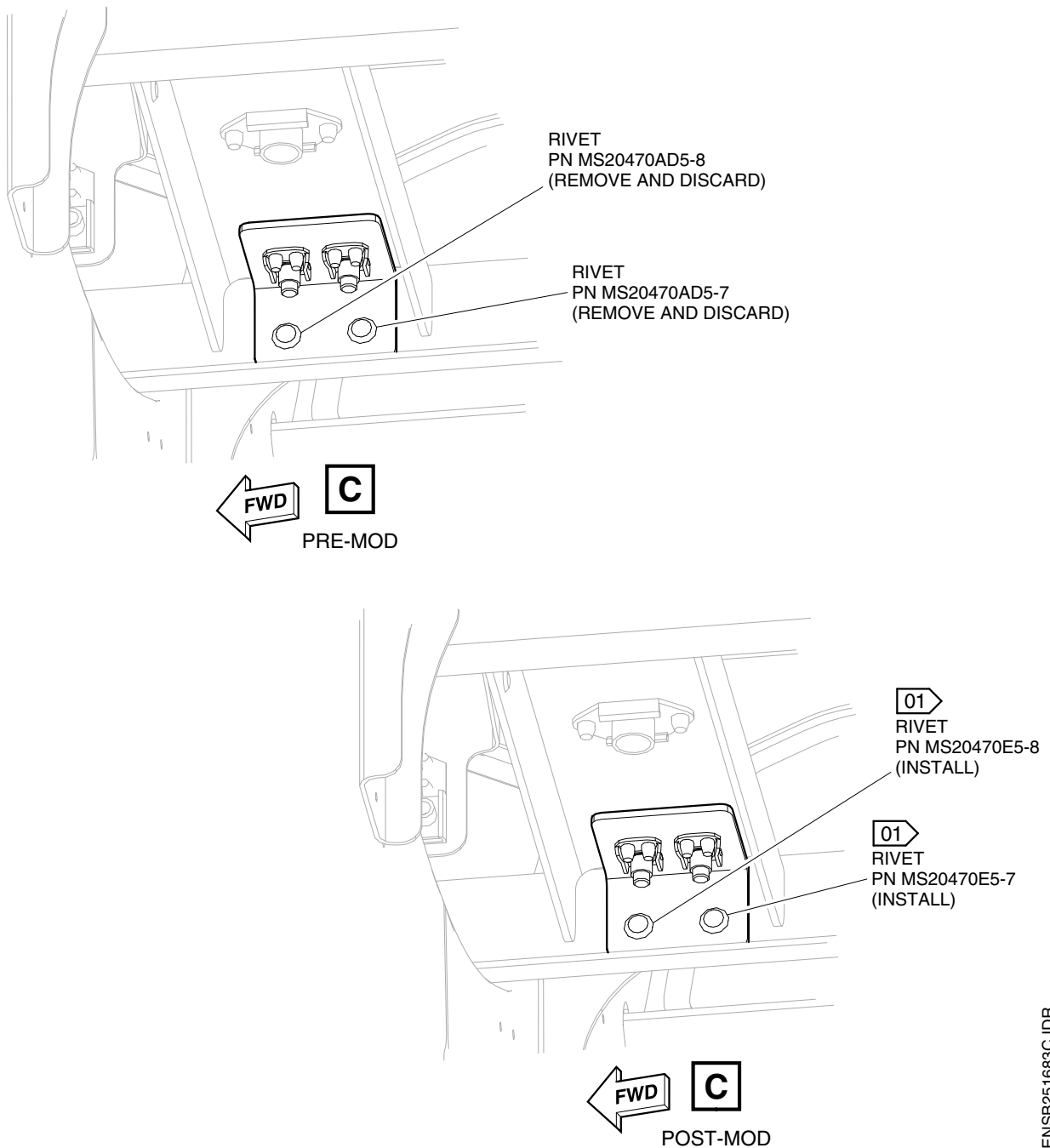
FIGURE 4 - RH REFRESHMENT CENTER - REWORK - GROUPS 3, 4, 5, 6, 8, AND 10
(Sheet 3 of 3)

EM500ENSB251673A IDR



EM500ENSB251682A IDR

FIGURE 5 - RIVETS REPLACEMENT - FRAME 8A - GROUPS 3, 4, 5, 6, 8, AND 10
(Sheet 1 of 2)



01 APPLY PN NAFTOSEAL MC780 C-12. SEE SRM 51-21-05.

FIGURE 5 - RIVETS REPLACEMENT - FRAME 8A - GROUPS 3, 4, 5, 6, 8, AND 10
(Sheet 2 of 2)

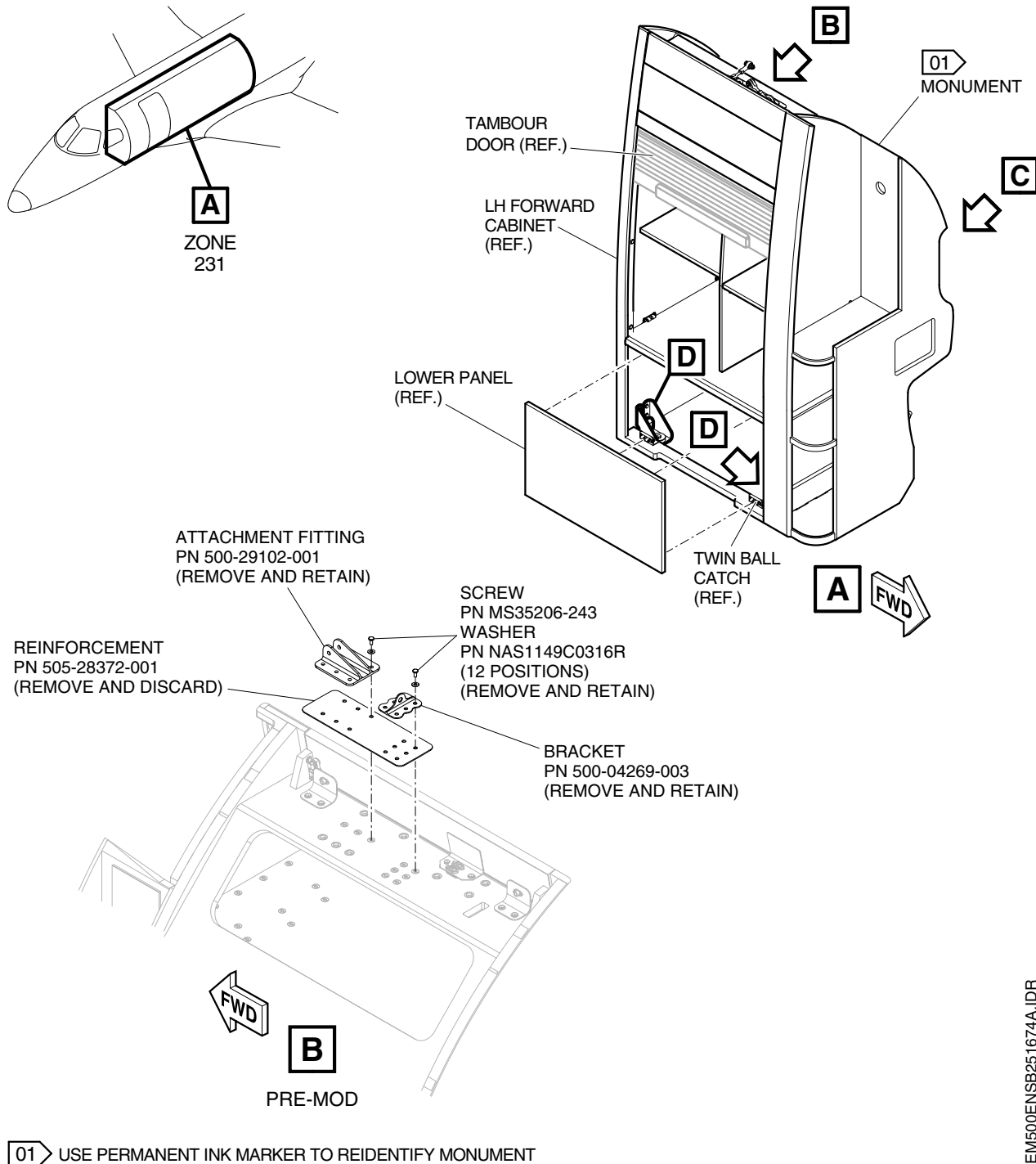


FIGURE 6 - LH FORWARD CABINET - REWORK - GROUPS 6 AND 7
(Sheet 1 of 4)

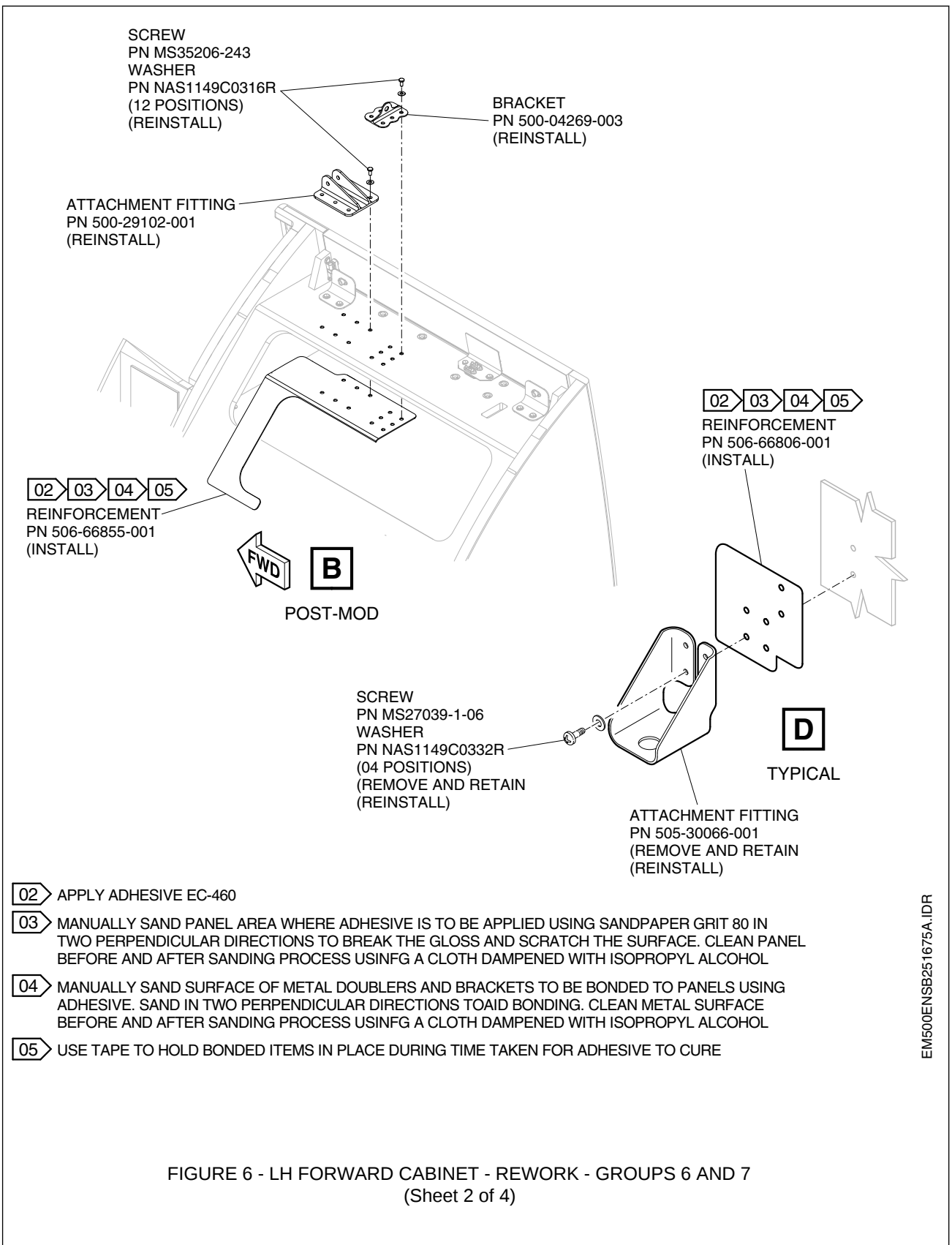
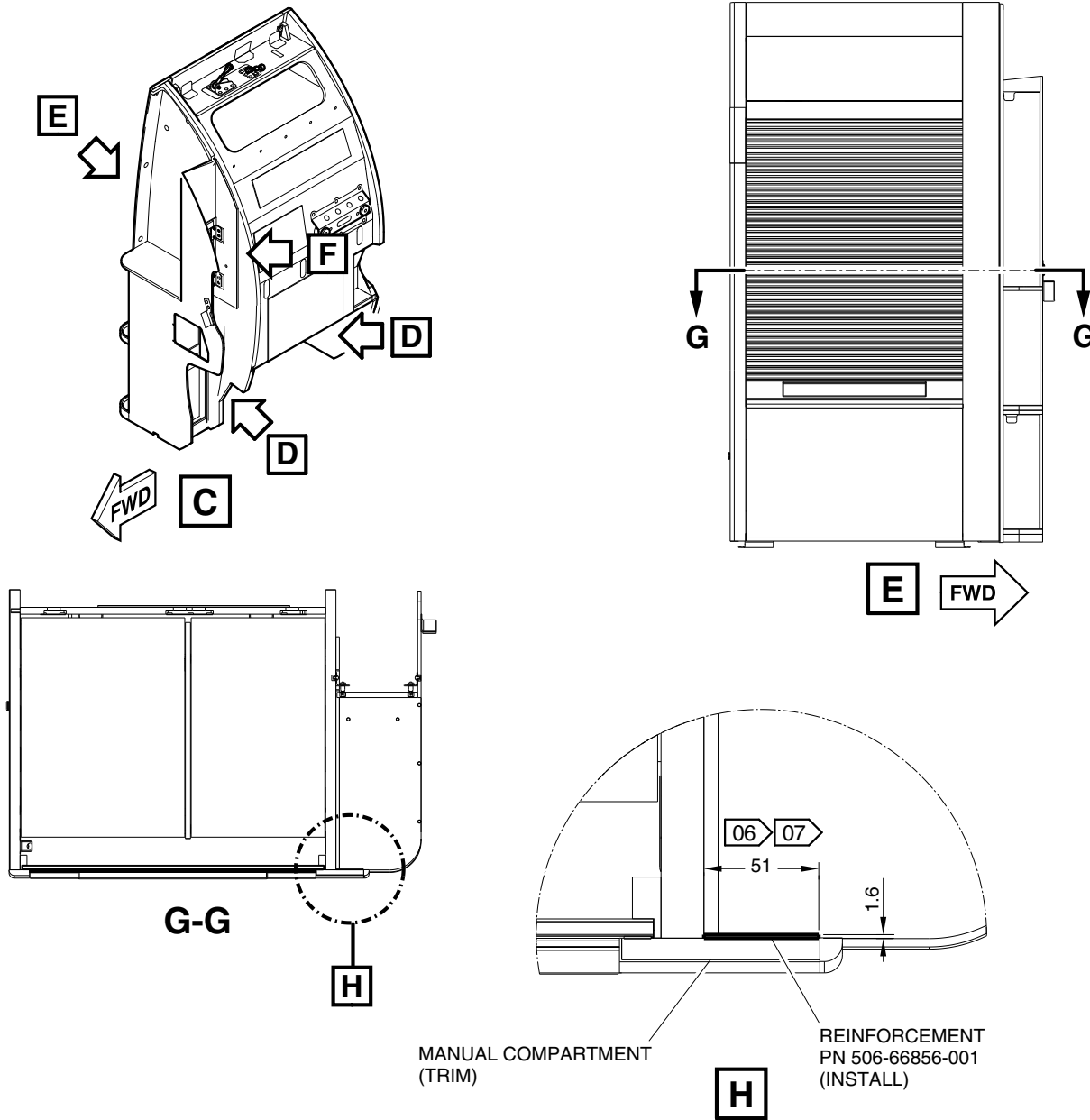


FIGURE 6 - LH FORWARD CABINET - REWORK - GROUPS 6 AND 7
(Sheet 2 of 4)



NOTE:

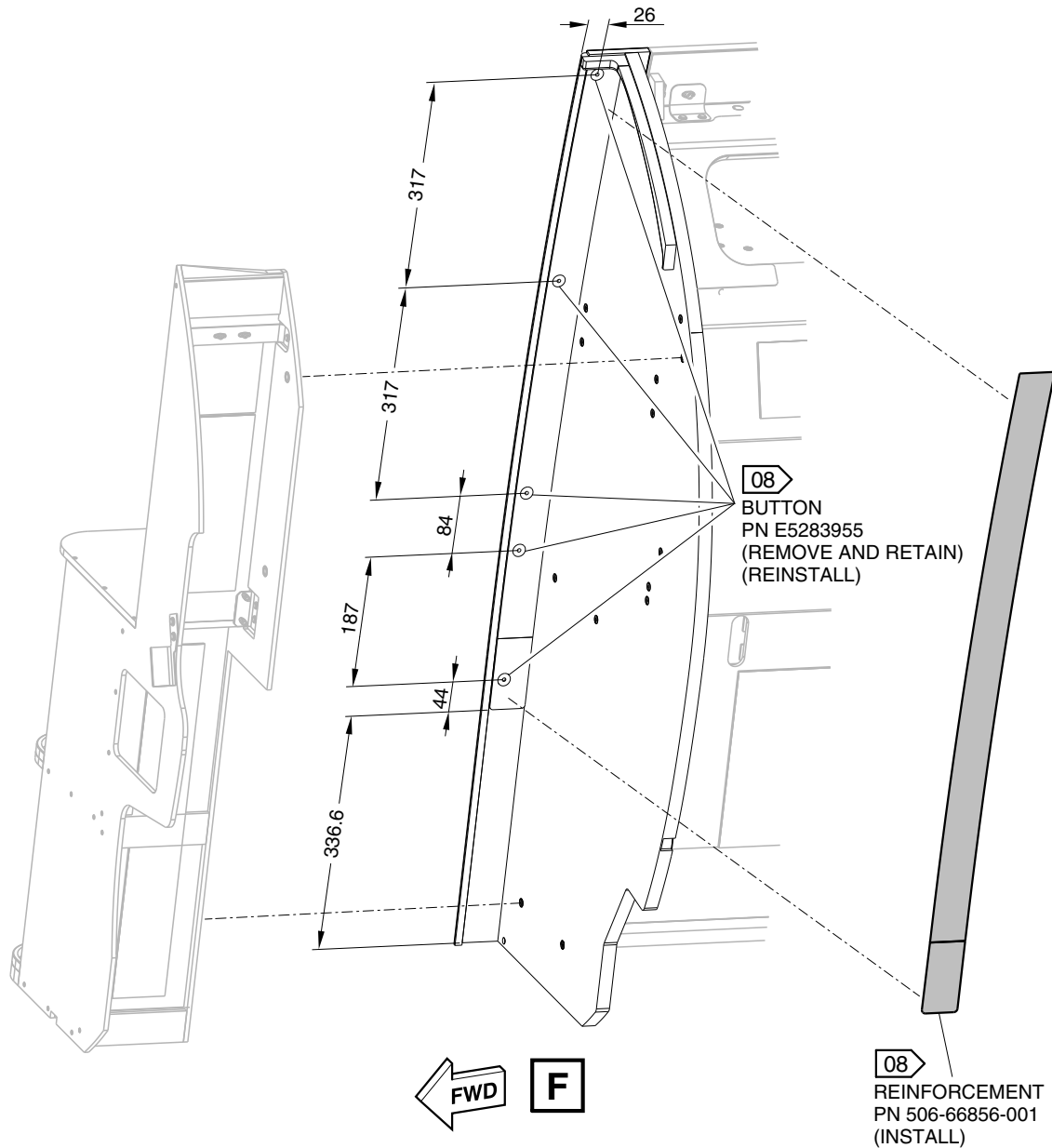
DIMENSION IN mm

06 TRIM MANUAL COMPARTMENT

07 APPLY PAINT IP1083-740 WITH PRIMER 20P20-3/K1G

FIGURE 6 - LH FORWARD CABINET - REWORK - GROUPS 6 AND 7
(Sheet 3 of 4)

EM500ENSB251676A.IDR



NOTE:

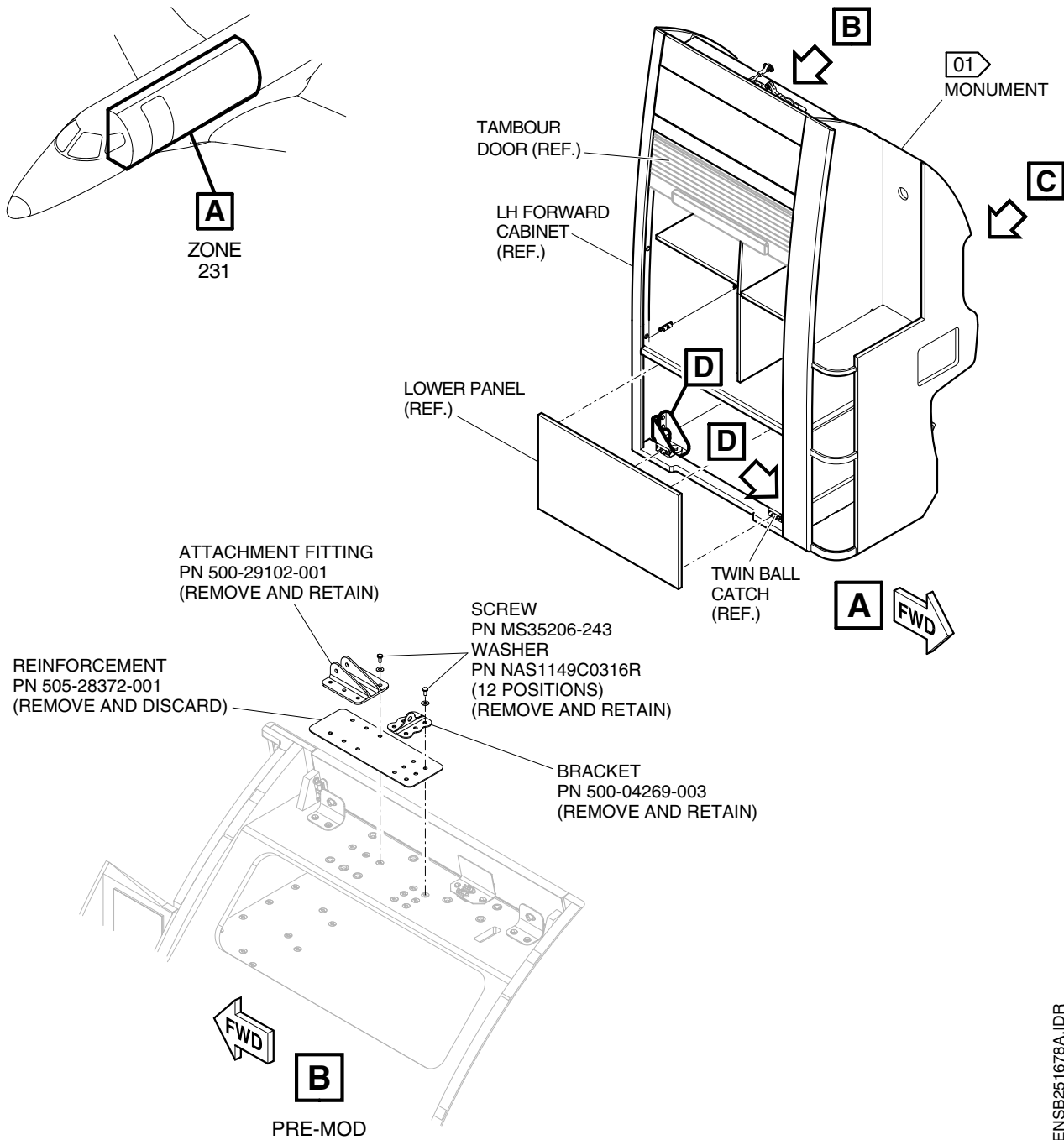
DIMENSION IN mm

02 APPLY ADHESIVE EC-460

08 POSITION, TRANSFER AND DRILL THE HOLES AS DIMENSION INDICATED

FIGURE 6 - LH FORWARD CABINET - REWORK - GROUPS 6 AND 7
(Sheet 4 of 4)

EM500ENSB251677A IDR



01 USE PERMANENT INK MARKER TO REIDENTIFY MONUMENT

FIGURE 7 - LH FORWARD CABINET - REWORK - GROUPS 8 AND 9
(Sheet 1 of 4)

EM500ENSB251678A.IDR

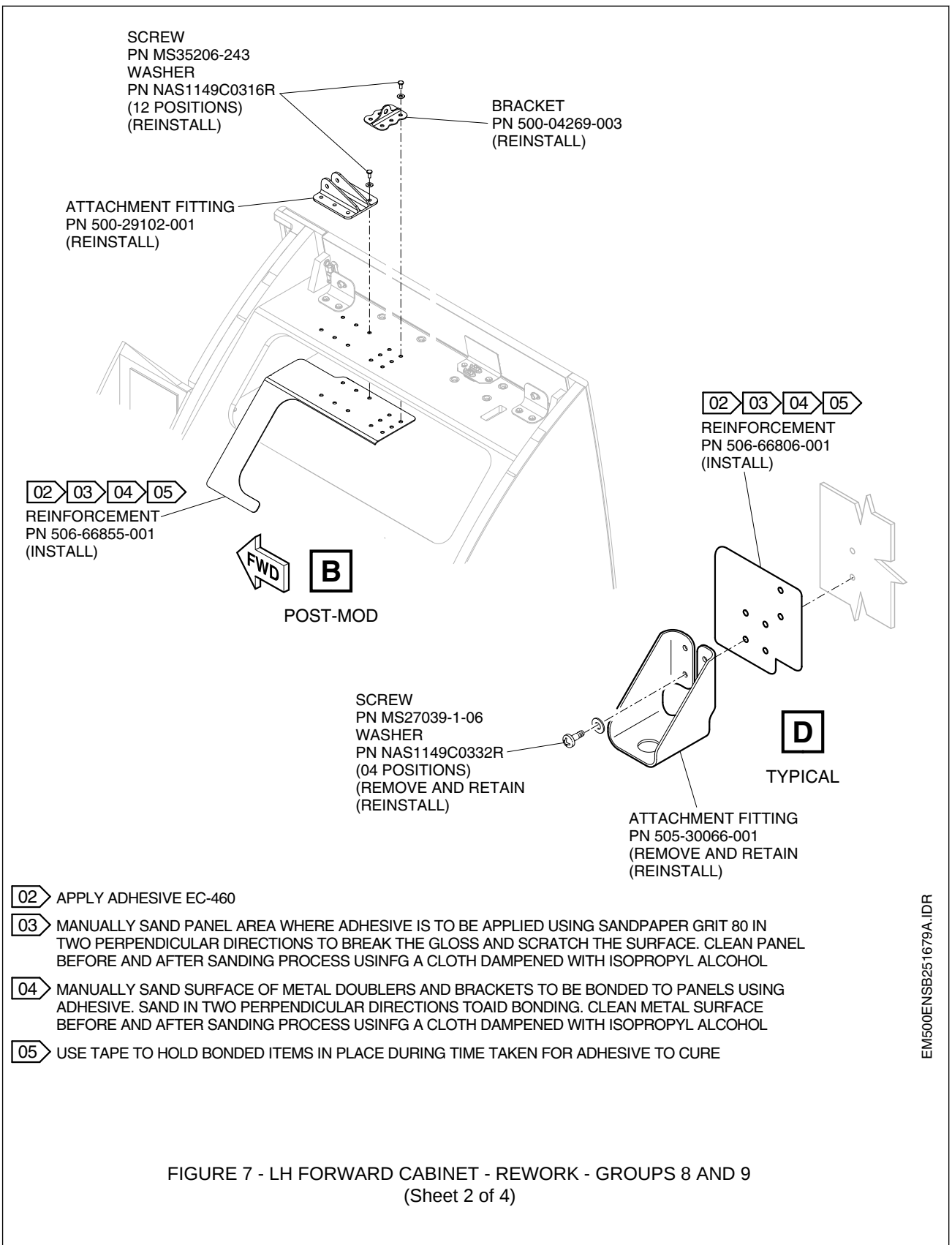
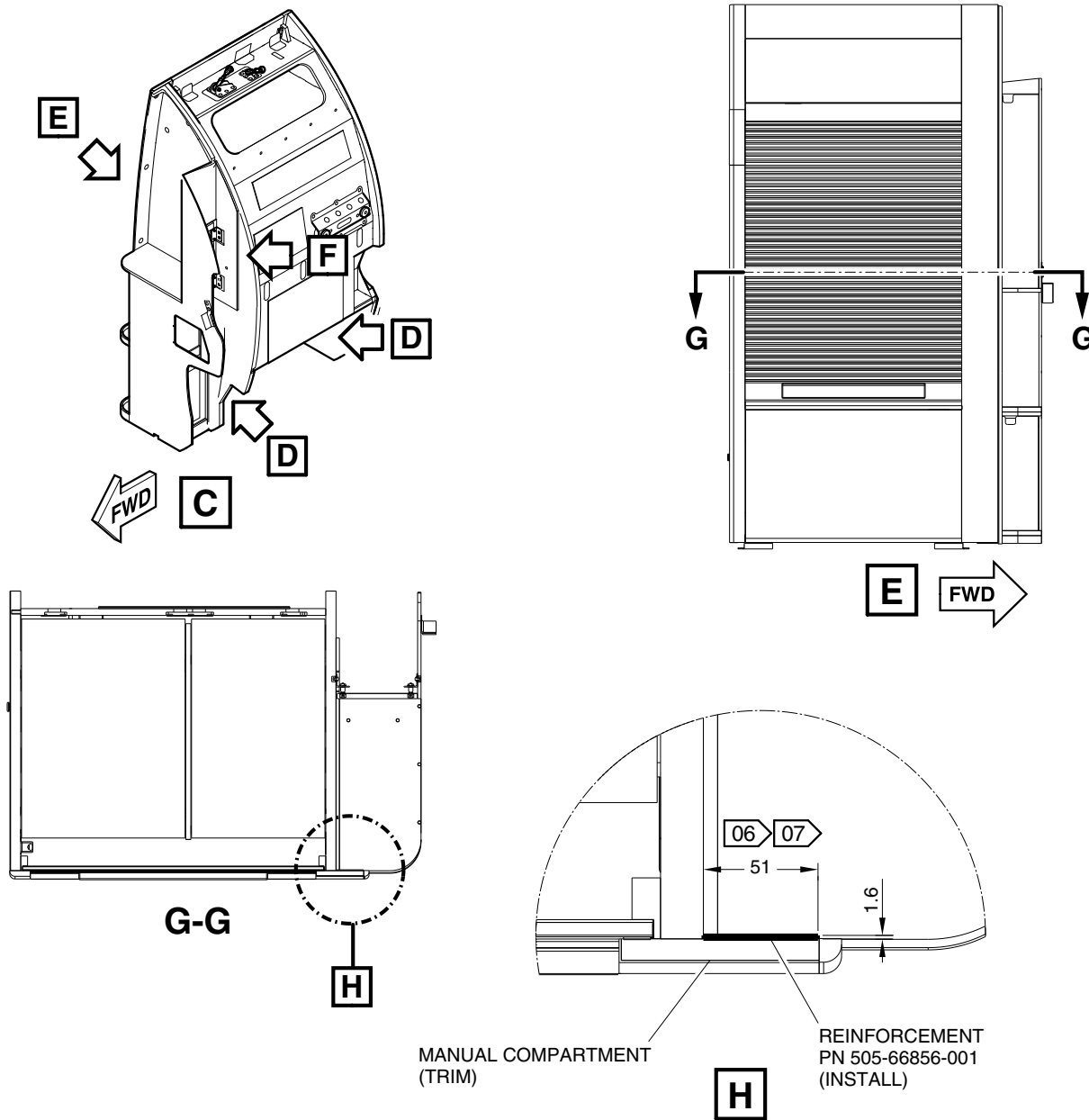


FIGURE 7 - LH FORWARD CABINET - REWORK - GROUPS 8 AND 9
(Sheet 2 of 4)



NOTE:

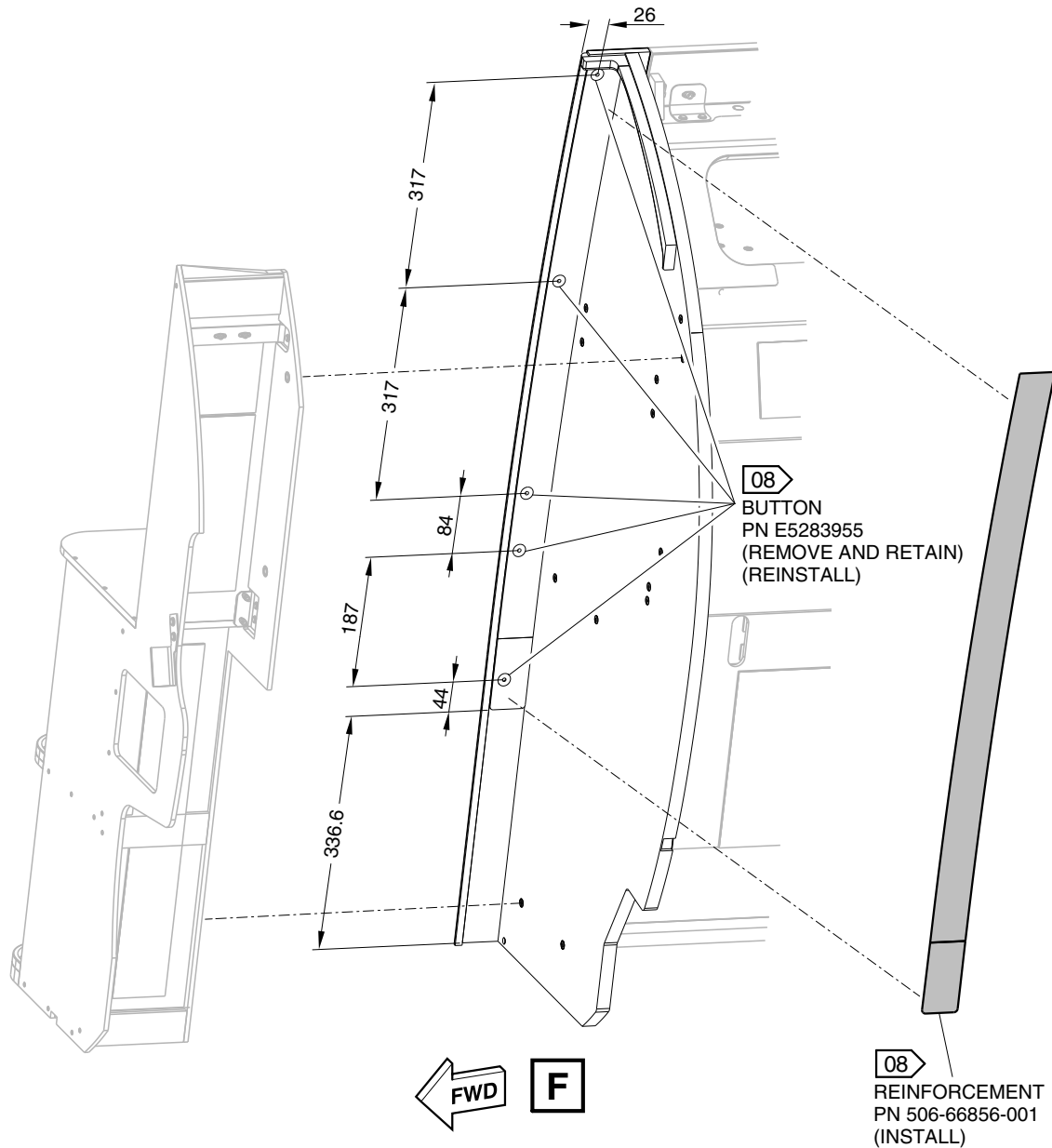
DIMENSION IN mm

06 TRIM MANUAL COMPARTMENT

07 APPLY PAINT IP1083-740 WITH PRIMER 20P20-3/K1G

FIGURE 7 - LH FORWARD CABINET - REWORK - GROUPS 8 AND 9
(Sheet 3 of 4)

EM500ENSB251680A.IDR



NOTE:

DIMENSION IN mm

02 APPLY ADHESIVE EC-460

08 POSITION, TRANSFER AND DRILL THE HOLES AS DIMENSION INDICATED

FIGURE 7 - LH FORWARD CABINET - REWORK - GROUPS 8 AND 9
(Sheet 4 of 4)

EM500ENSB251681A.IDR

