

COURSE - DAY IV

BOEING
737-800
STRUCTURAL REPAIR MANUAL

Repair 7 - Repair of Damage to the Edgeband and the Honeycomb Core

WARNING: MAKE SURE THAT FLIGHT CONTROL SURFACES ARE CORRECTLY BALANCED AFTER THEY ARE REPAIRED. IF YOU DO NOT OBEY, FLUTTER CAN OCCUR AND THE RESULT CAN BE A STRUCTURAL FAILURE.

CAUTION: REFER TO THE SPECIFIED COMPONENT REPAIR SUBJECT FOR THE MATERIALS AND PROCEDURES APPROVED FOR THIS REPAIR. IF YOU DO NOT OBEY, THE REPAIR CAN BE UNSATISFACTORY.

1. Applicability

- A. Repair 7 is a typical repair that is applicable to damage to the edgeband and the honeycomb panel.
- B. Repair 7 is not applicable to radomes and floor panels. Refer to SRM 53-10-72 for radomes and SRM 53-00-50 for floor panels.

2. General

- A. Repair 7 is a Category A damage tolerant repair. Refer to SRM 51-00-06 for the definitions of the different categories of repairs.
- B. Refer to Figure 201 for the layout of the repair parts.

3. References

- A. SRM 51-00-06, General - Structural Repair Definitions
- B. SRM 51-70-04, Repair General - Repair Procedures for Wet Layup Materials
- C. SRM 53-00-50, Repair General - Composite Floor Panel Repairs
- D. SRM 53-10-72, Repair General - Nose Radomes

4. Repair Instructions

- A. Find the limits of the damage. Refer to Repair General, Paragraph 4.A.
- B. Remove the damaged plies as given in Repair General, Paragraph 4.B.
- C. Remove all contamination and water from the damaged area as given in Repair General, Paragraphs 4.C and 4.3. Make sure the repair area is fully dry.
- D. Prepare the damaged area as given in Repair General, Paragraph 4.E.
- E. Cut out, clean, and install the core repair plug as given in Repair General, Paragraphs 4.F, 4.G, and 4.H.

51-70-04
REPAIR 7
Page 201
Jul 10/01

D634A210

BOEING
737-800
STRUCTURAL REPAIR MANUAL

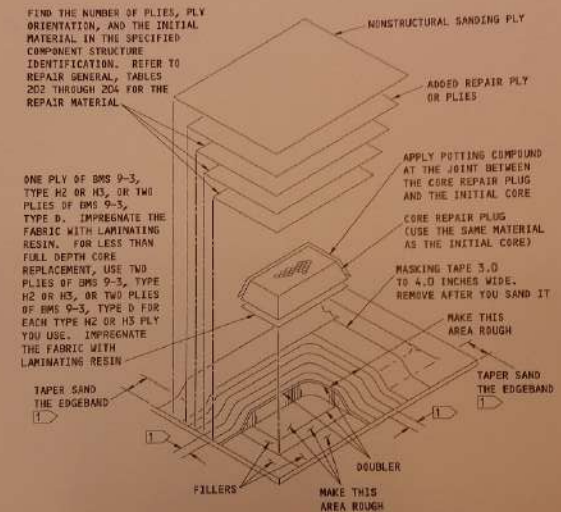
4. Repair Instructions (Continued)

- F. Cure the core repair plug as given in Repair General, Paragraphs 4.I and 4.J.
- G. Clean the repair surfaces as given in Repair General, Paragraph 4.2.
- H. Prepare the repair plies as given in Repair General, Paragraph 4.M through 4.O.
- I. Install the fabric repair plies and the vacuum bag system as given in Repair General, Paragraph 4.P.
- J. Cure the repair as given in Repair General, Paragraph 4.Q.
- K. Examine the completed repair as given in Paragraph 4.R.
- L. Apply the finish to the repair area as given in Repair General, Paragraph 4.S.
- M. After repair of a flight control surface, check to see if it must be balanced again. Refer to SRM 51-00-00 for the procedure.

51-70-04
REPAIR 7
Page 202
Jul 10/01

D634A210

BOEING
737-800
STRUCTURAL REPAIR MANUAL



NOTES

1. REFER TO REPAIR GENERAL, FIGURE 207 FOR THE NECESSARY TAPER AND OVERLAP.

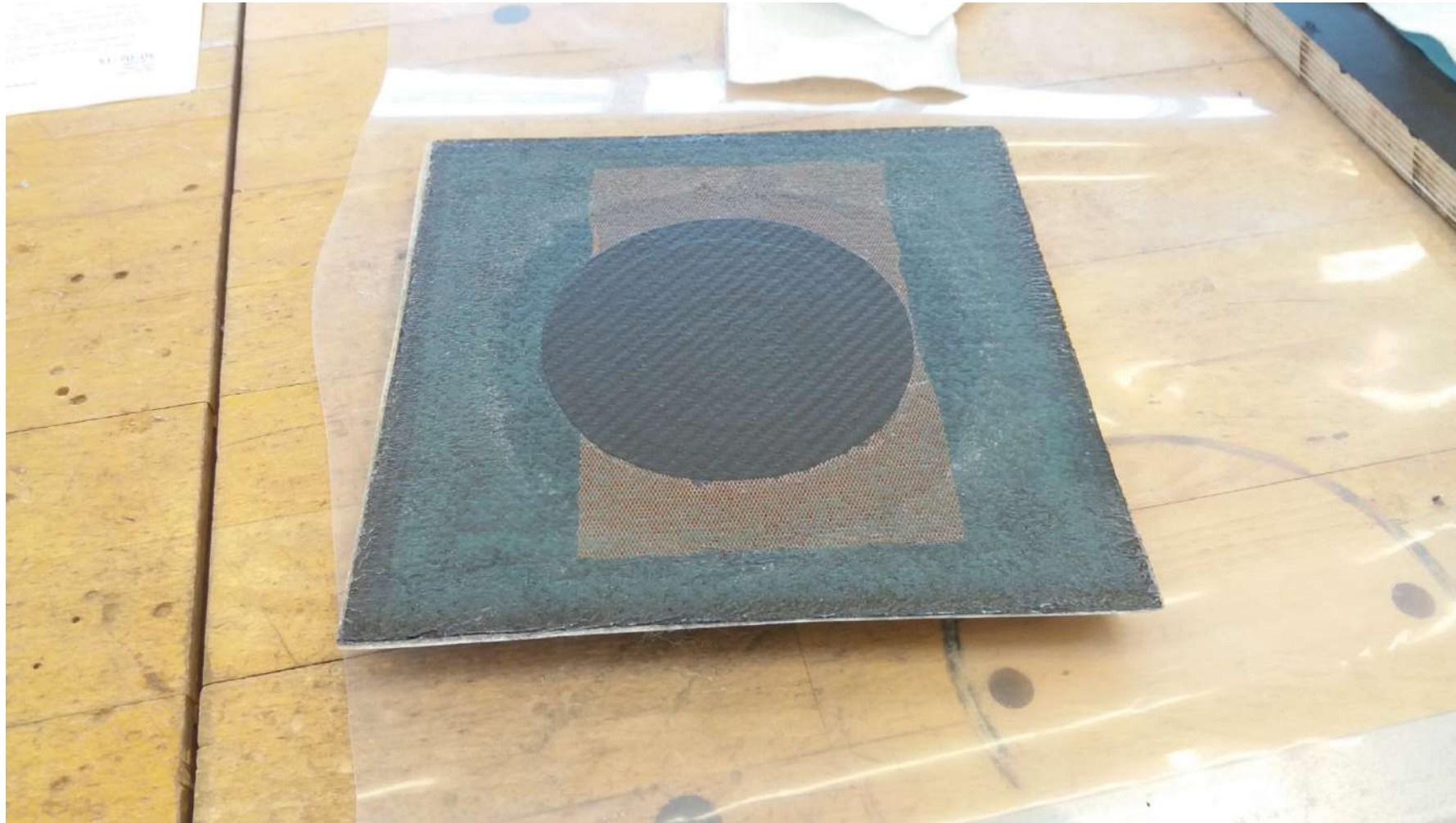
Repair 7 - Layout of the Repair Parts
Figure 201

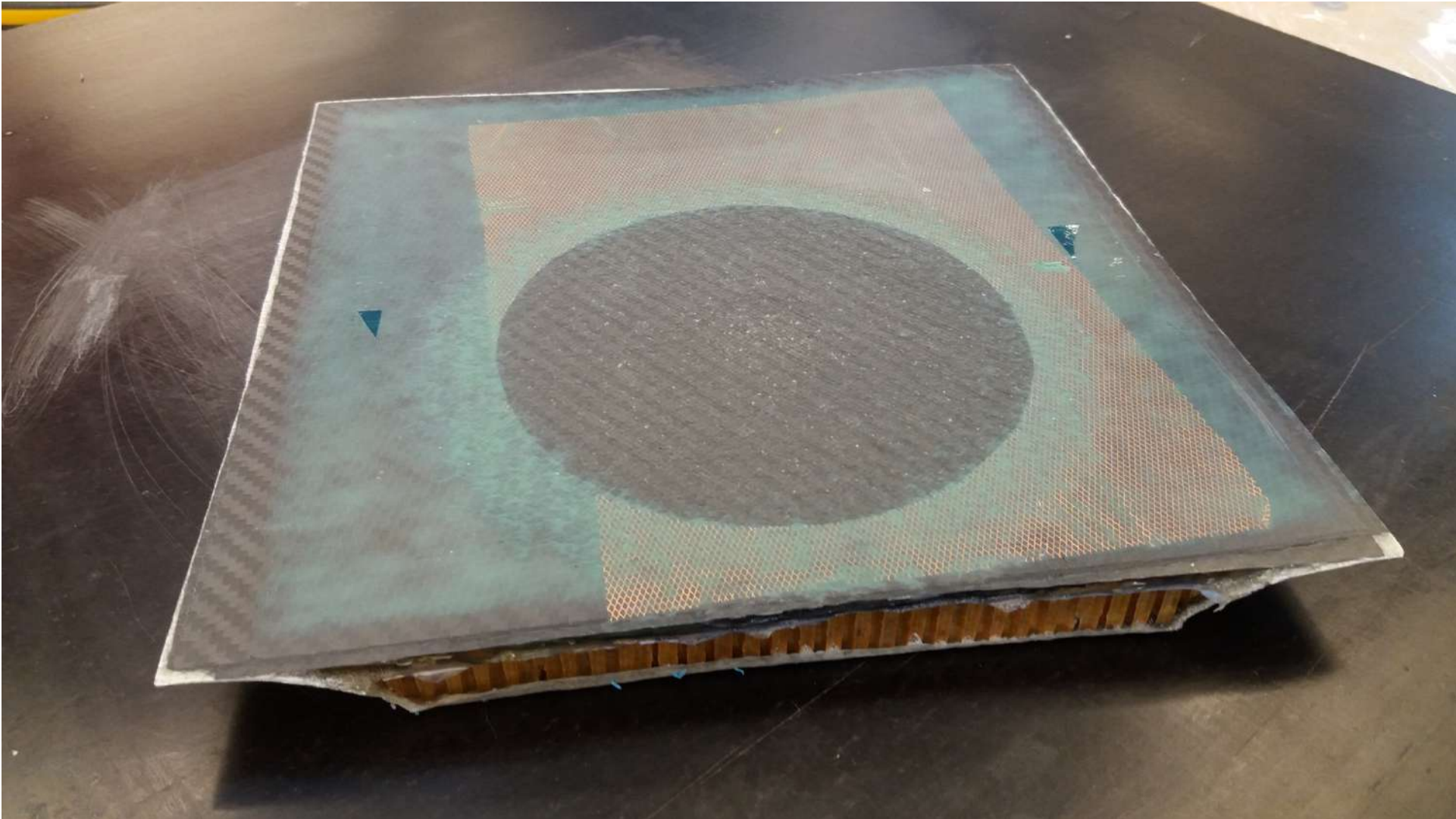
51-70-04
REPAIR 7
Page 203
Jul 10/01

D634A210





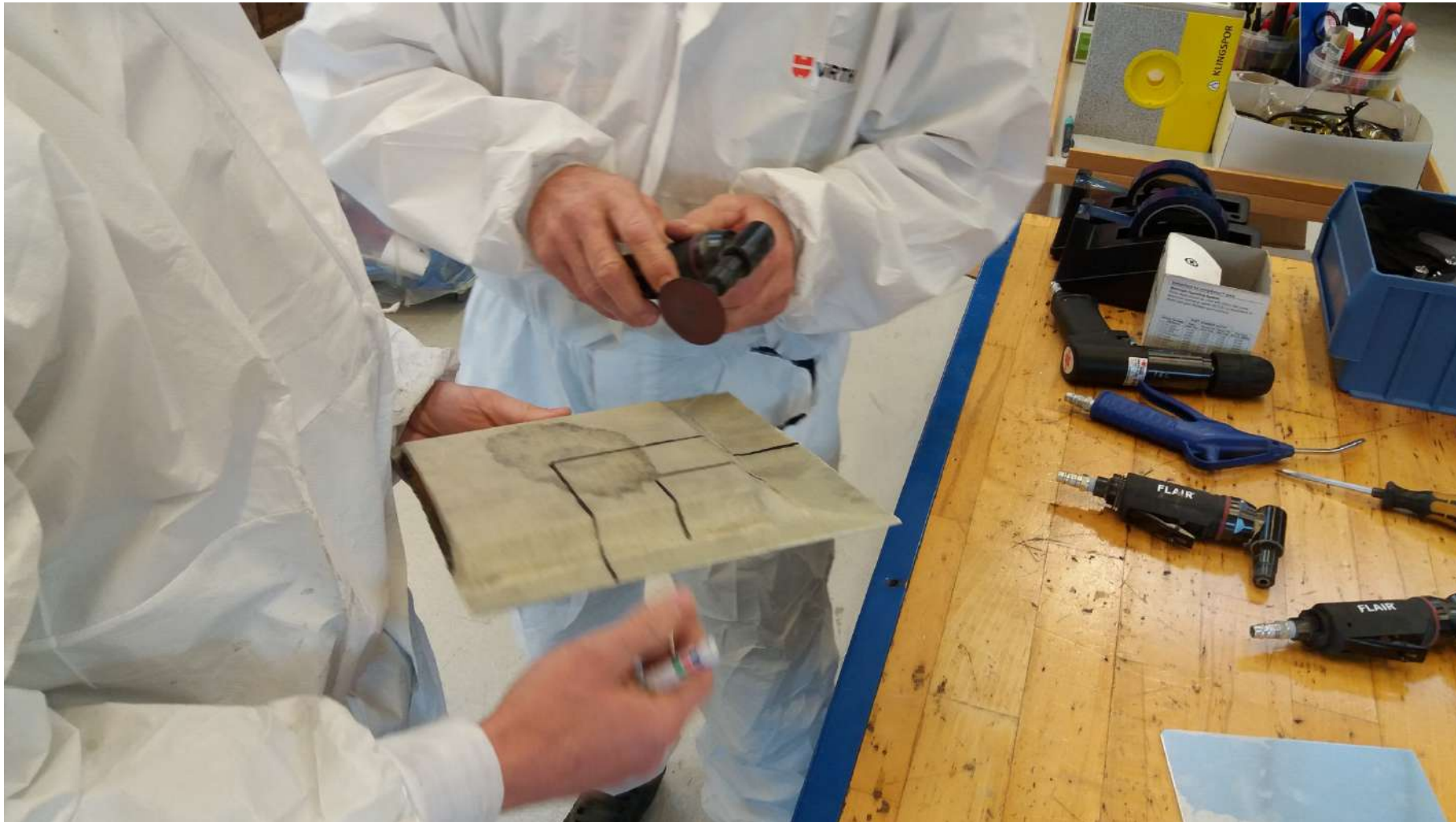






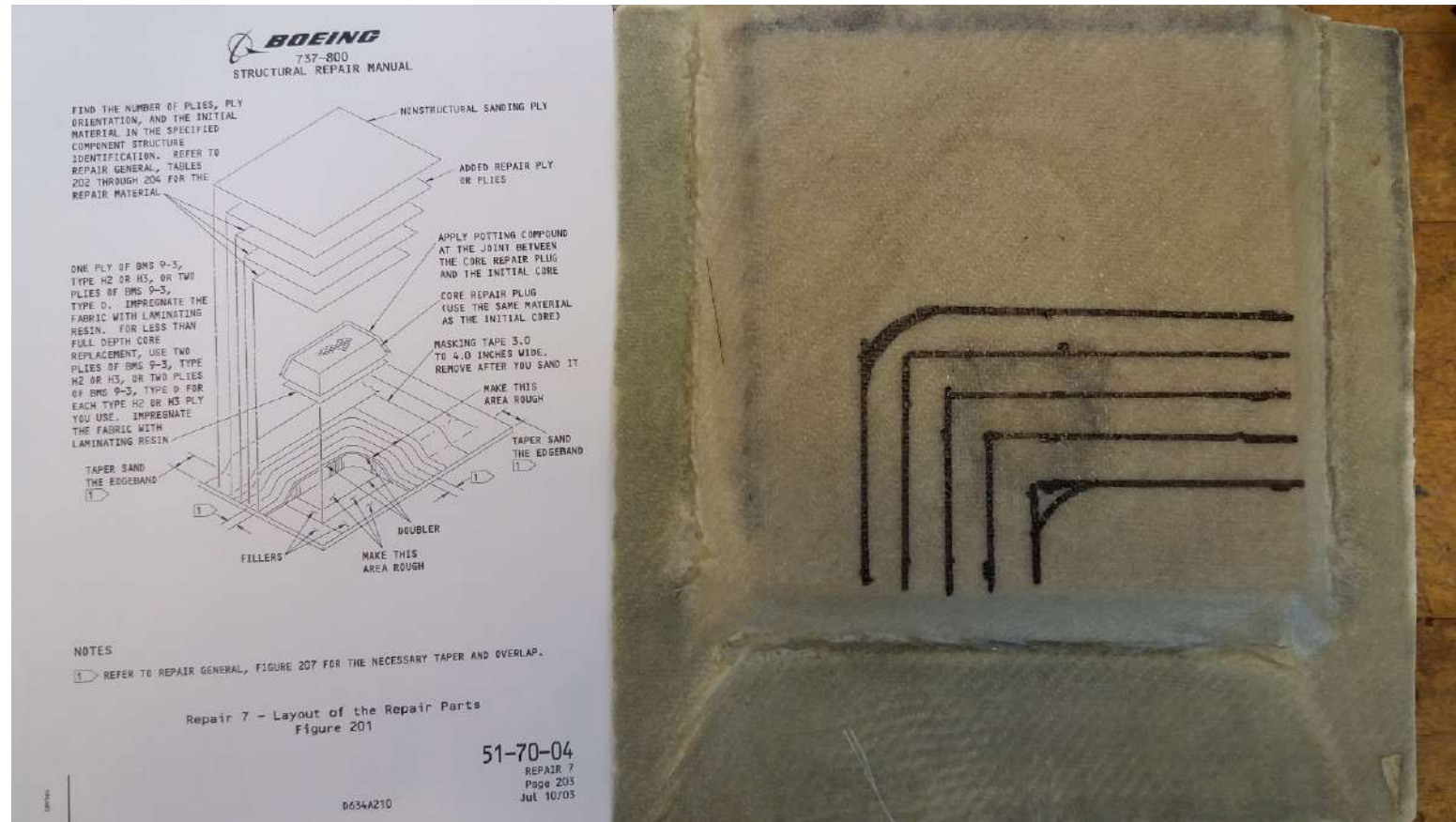


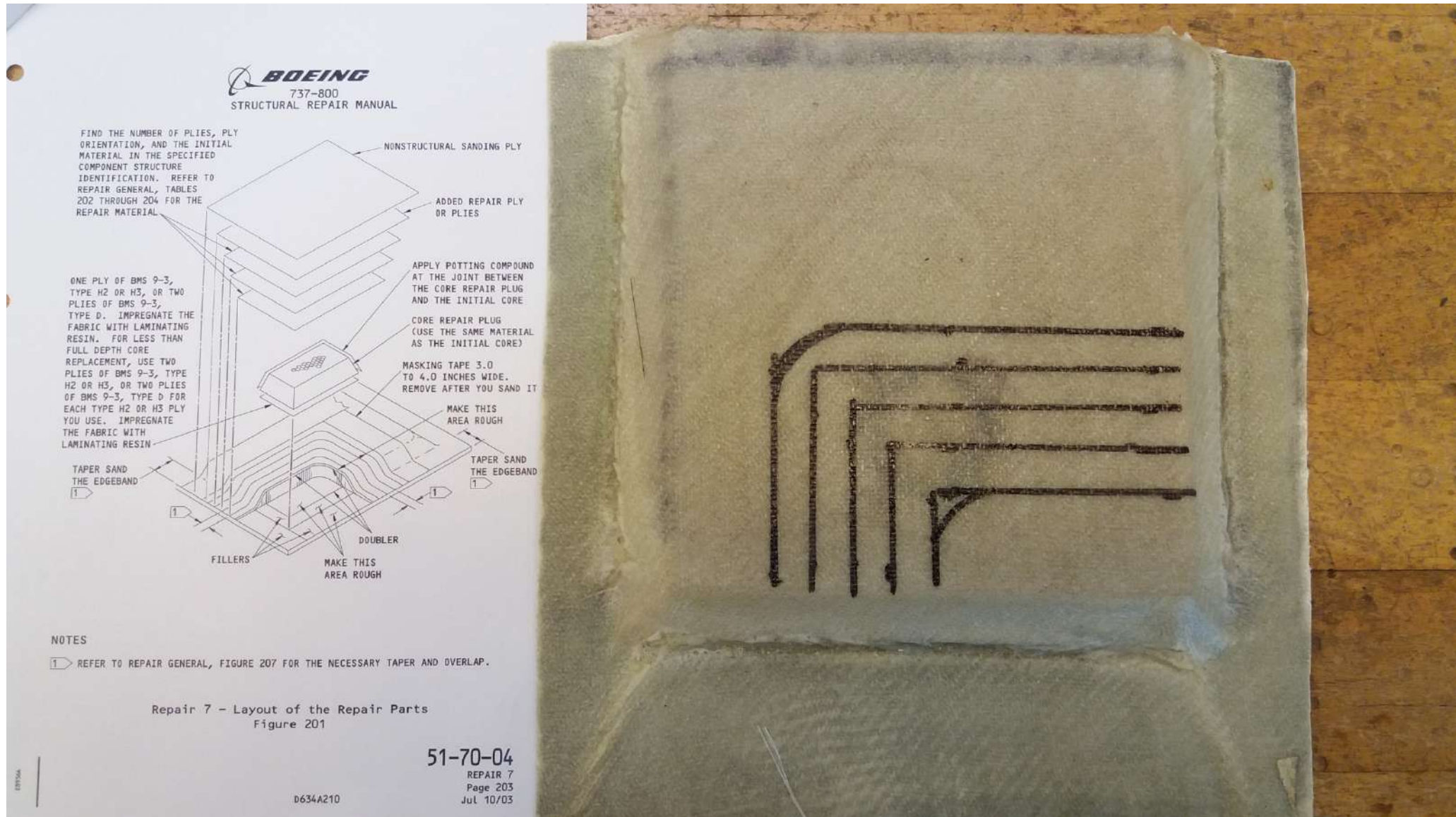












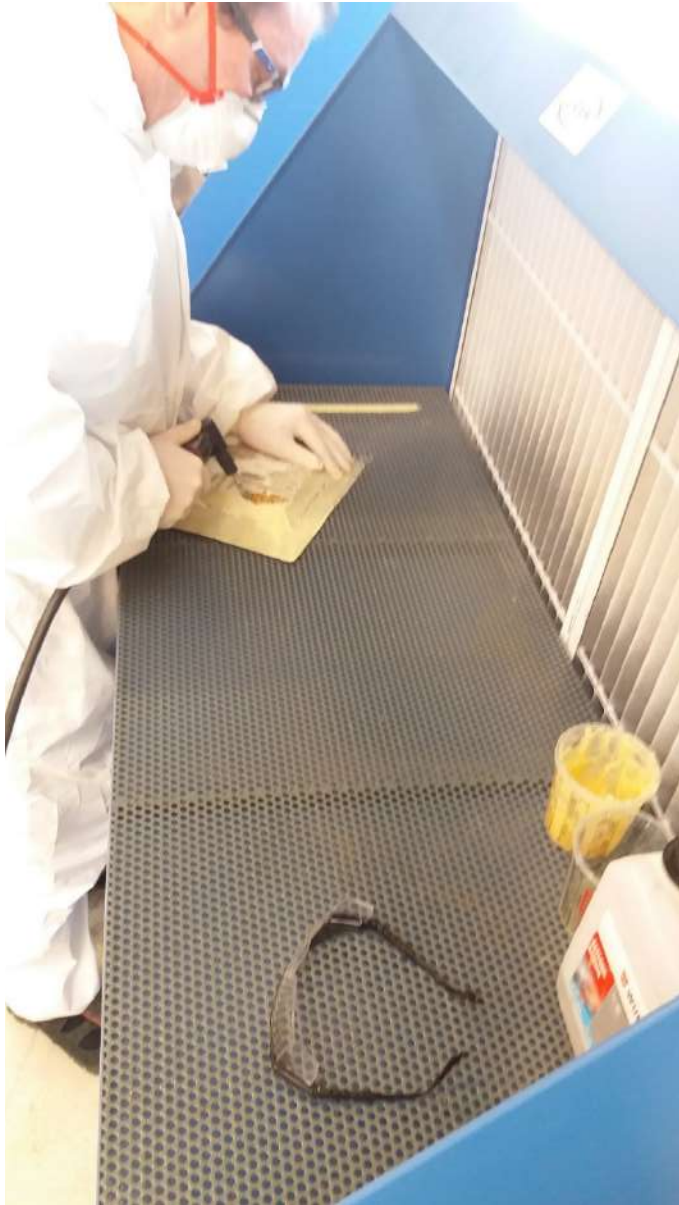












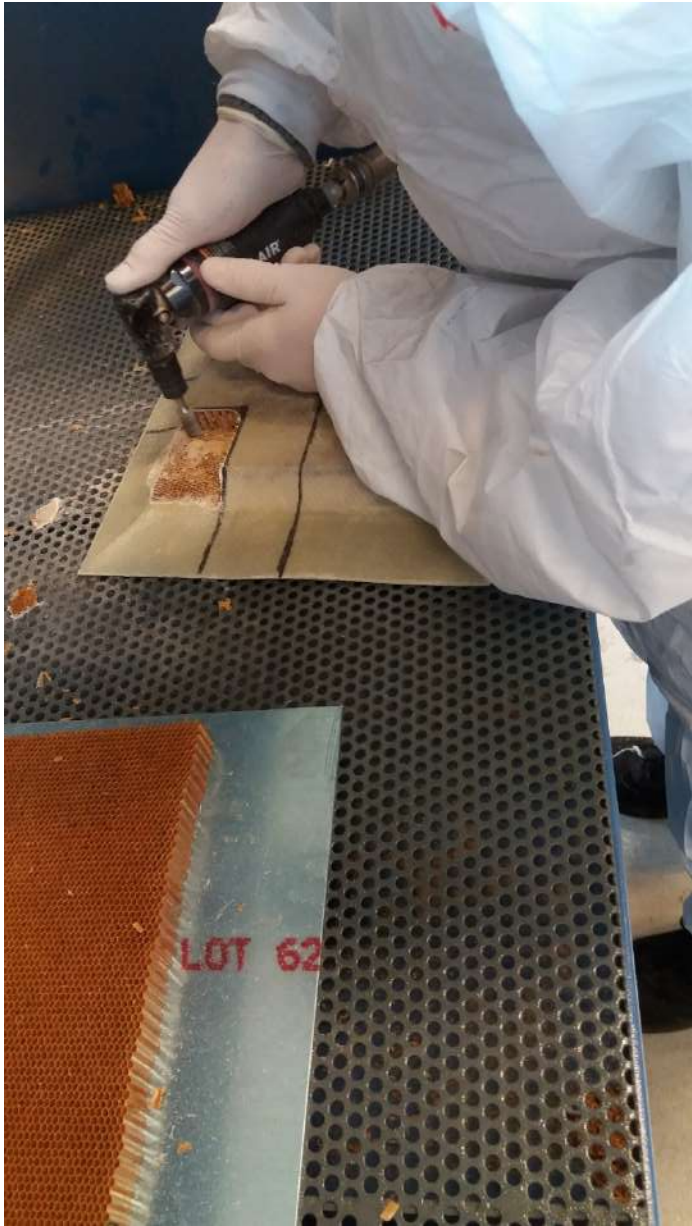








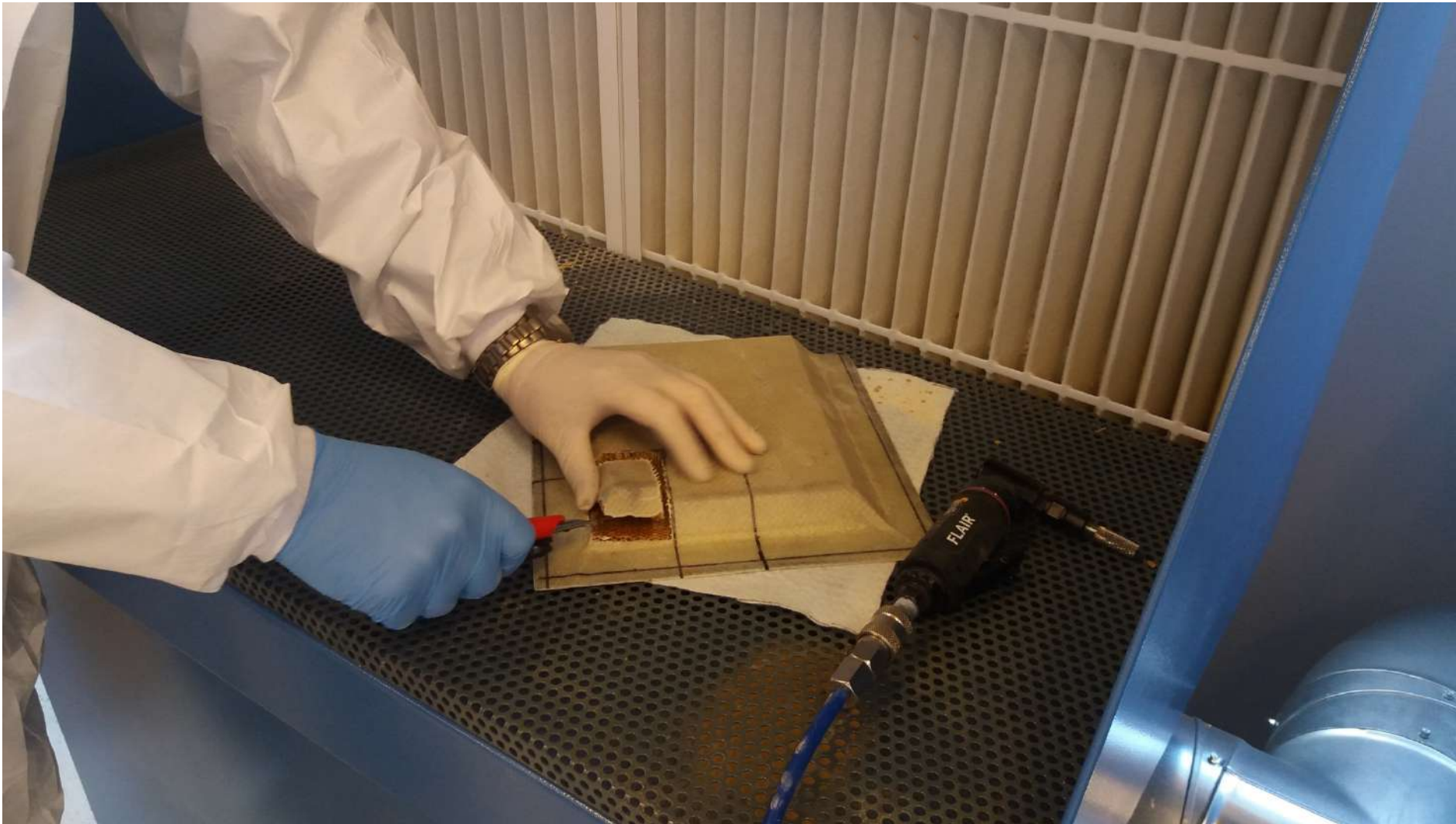




Co-funded by the
Erasmus+ Programme
of the European Union



TÉC TECHNICAL
EDUCATION
COPENHAGEN

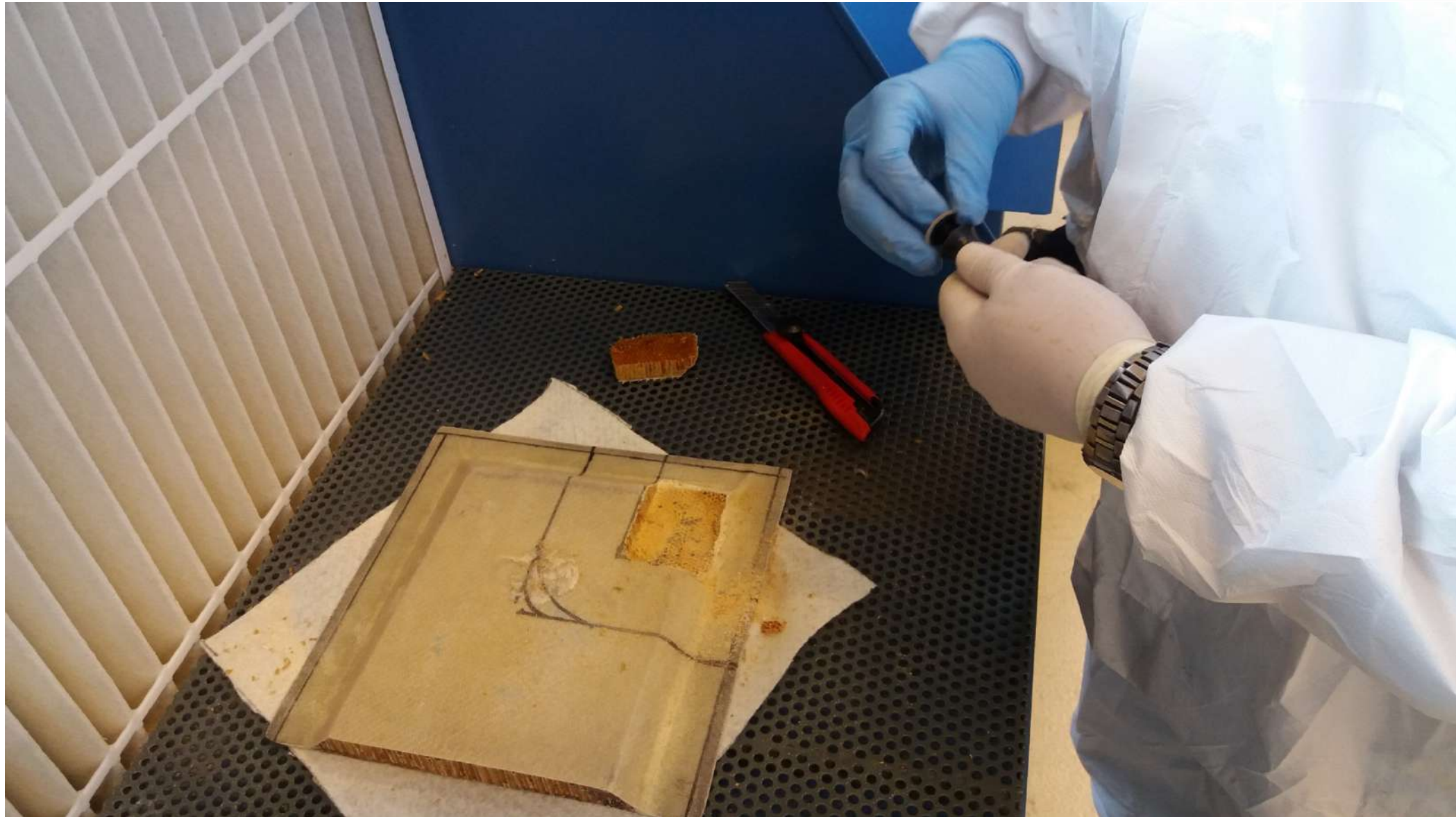




















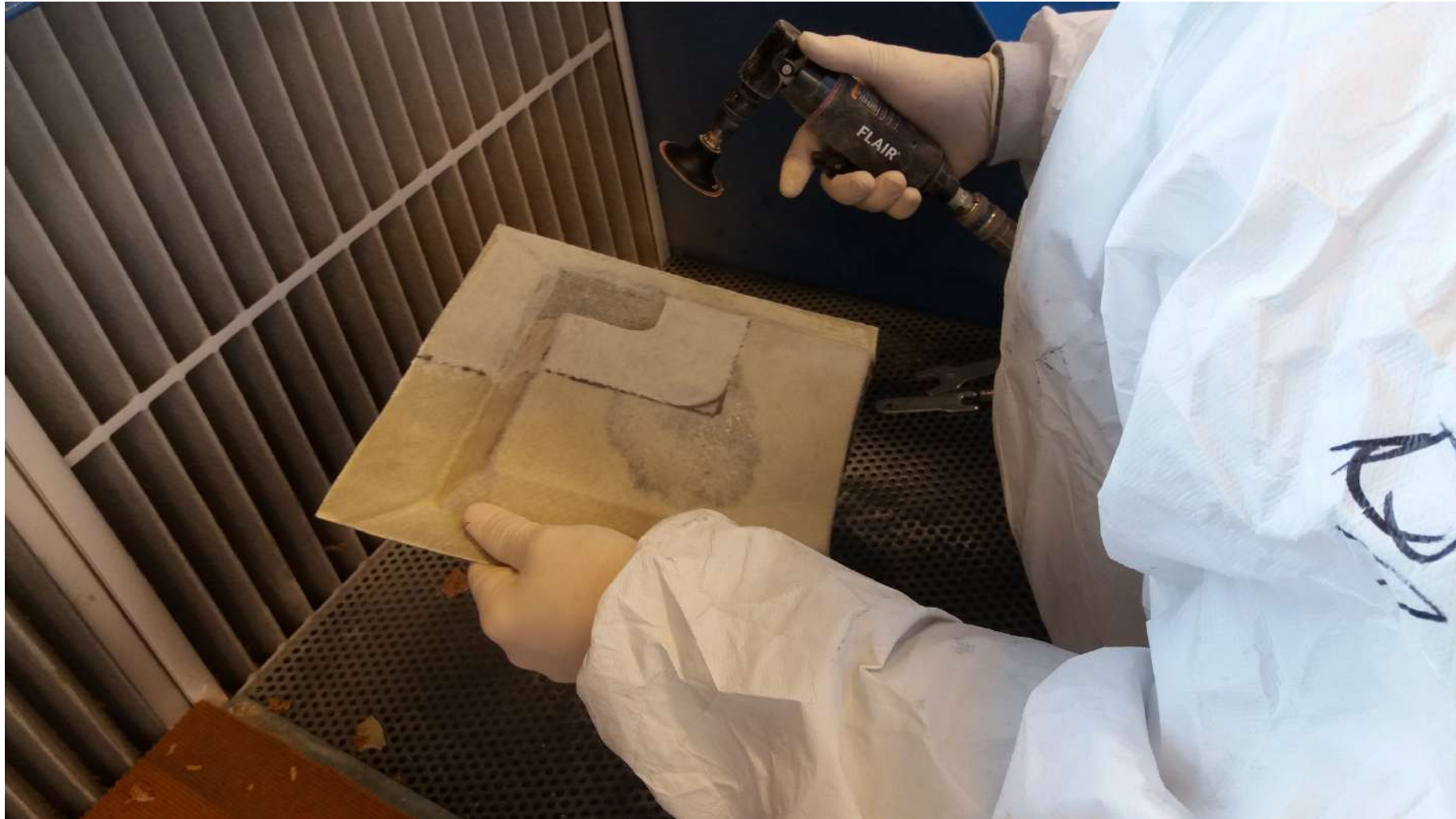










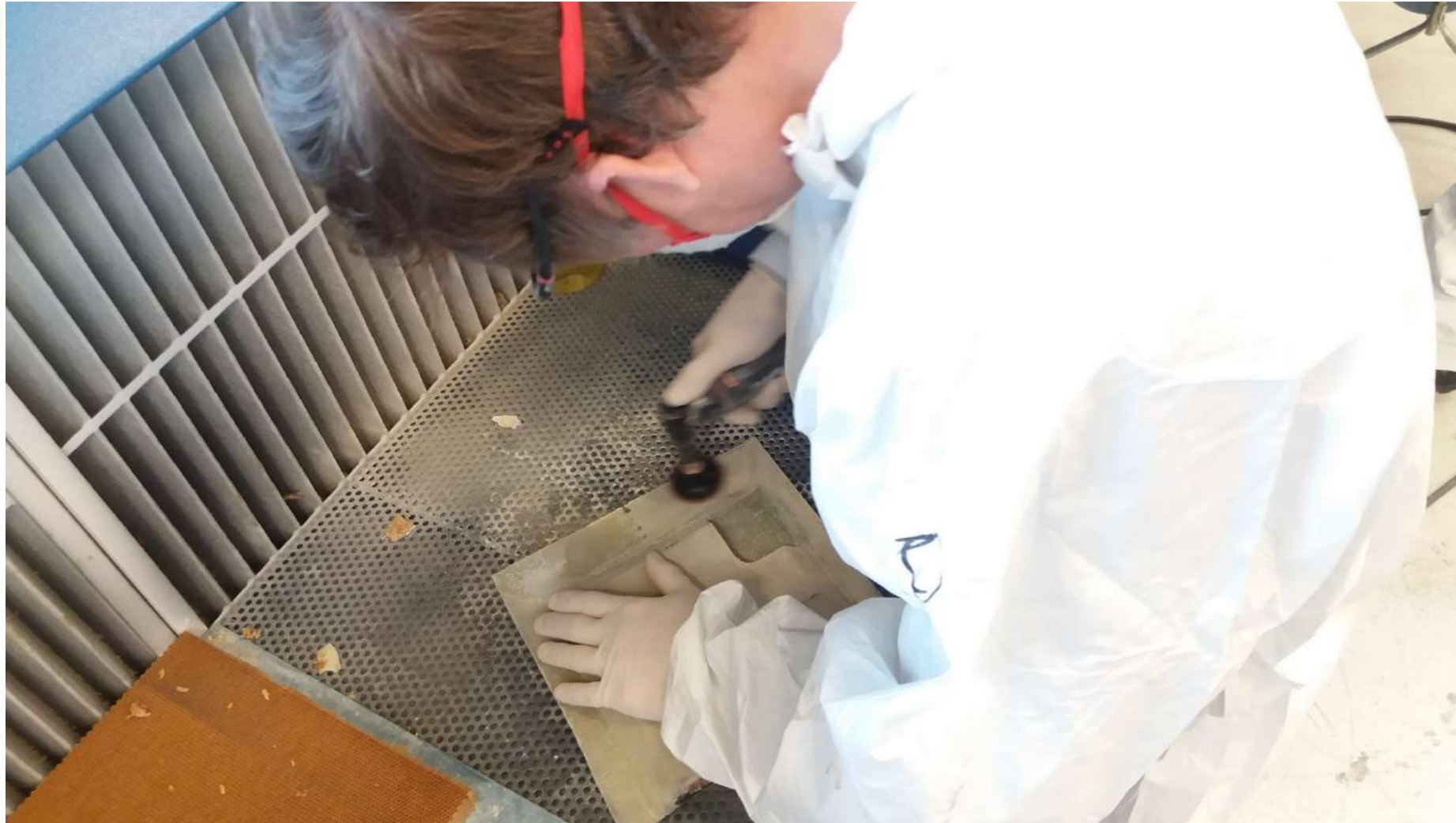




Co-funded by the
Erasmus+ Programme
of the European Union



TÉC TECHNICAL
EDUCATION
COPENHAGEN





Co-funded by the
Erasmus+ Programme
of the European Union



TÉC TECHNICAL
EDUCATION
COPENHAGEN





