SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

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FRANCE
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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 55

TITLE: STABILIZERS - VERTICAL STABILIZERS AND RUDDER - INSPECT THE RUDDER SERVO ACTUATOR ATTACHMENT-STRUCTURE FOR DAMAGE DUE TO SERVO DE-SYNCHRONIZATION

MODIFICATION No.: None

This page transmits Revision No.04 of Service Bulletin No.A300-55-0044

ADDITIONAL WORK

****CONF ALL**

Additional work is required by this revision for aircraft inspected by any previous revision of this Service Bulletin.

The additional work consists in the necessity to do a fleet evaluation and the change from one time to repetitive inspections as given in the accomplishment timescale of this Service Bulletin.

Unless otherwise stated by an Airworthiness Directive, AIRBUS recommends the additional work to be accomplished within one year after the issue of this revision.

REASON

Revision No. 04 issued to update the compliance times.

The compliance times have been changed from a one time inspection to repetitive inspections. To ensure to detect all cracks which may occurred after the accomplishment of the one time inspection between 2003 and the issuance of the Revision No. 04 of this Service Bulletin, a fleet evaluation procedure has been implemented in this Revision.

CHANGES

NOTE: Revised text and layout changes of this revision are not identified with revision bars.

SUMMARY		
MODIFICATIONS	Minor editorial or document structure change	N
REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES	Minor editorial or document structure change	N

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GENERAL EVALUATION	Minor editorial or document structure change	N
MATERIAL PRICE INFORMATION	Minor editorial or document structure change	N
EFFECTIVITY	Minor editorial or document structure change	N
CONCURRENT REQUIREMENTS	Minor editorial or document structure change	N
REFERENCES / REPERCUSSIONS	Minor editorial or document structure change	N
NATURE OF THE WORK	Minor editorial or document structure change	N
MANPOWER	Minor editorial or document structure change	N
APPENDICES	Minor editorial or document structure change	N
Fig. A-GSAAA	Minor editorial or document structure change	N
Fig. A-GSAAA Sheet 01	Minor editorial or document structure change	N
PLANNING INFORMATION		
EFFECTIVITY	Minor editorial or document structure change	N
Configuration definition	Minor editorial or document structure change	N
CONF 001	Minor editorial or document structure change	N
Material Effectivity	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
CONCURRENT REQUIREMENTS	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
REASON	Minor editorial or document structure change	N
History	Minor editorial or document structure change	N
Objective/Action	Minor editorial or document structure change	N
Advantages	Minor editorial or document structure change	N
Operational/Maintenance Consequences	Minor editorial or document structure change	N
DESCRIPTION	Minor editorial or document structure change	N
COMPLIANCE	Minor editorial or document structure change	N
Classification	Minor editorial or document structure change	N
Accomplishment Timescale	Minor editorial or document structure change	N
APPROVAL	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
MANPOWER	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
WEIGHT AND BALANCE	Minor editorial or document structure change	N
ELECTRICAL LOAD DATA	Minor editorial or document structure change	N
REFERENCES	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
PUBLICATION AFFECTED	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
INTERCHANGEABILITY/MIXABILITY	Minor editorial or document structure change	N
SPARES	Minor editorial or document structure change	N

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MATERIAL INFORMATION		
MATERIAL - PRICE AND AVAILABILITY	Minor editorial or document structure change	N
Procurement Addresses	Minor editorial or document structure change	N
Price and Availability	Minor editorial or document structure change	N
INDUSTRY SUPPORT INFORMATION	Minor editorial or document structure change	N
LIST OF COMPONENTS	Minor editorial or document structure change	N
LIST OF MATERIALS - OPERATOR SUPPLIED	Minor editorial or document structure change	N
Consumable Materials	Minor editorial or document structure change	N
Consumable CMLD10	Minor editorial or document structure change	N
Consumable CMLD20	Minor editorial or document structure change	N
Components	Minor editorial or document structure change	N
Component COMPD01	Minor editorial or document structure change	N
Component COMPD02	Minor editorial or document structure change	N
Equipment	Minor editorial or document structure change	N
PARTS TO BE RE-IDENTIFIED BY OPERATOR	Minor editorial or document structure change	N
TOOLING	Minor editorial or document structure change	N
Tooling - Price and Availability	Minor editorial or document structure change	N
Procurement Addresses	Minor editorial or document structure change	N
Price and Availability	Minor editorial or document structure change	N
Tools	Minor editorial or document structure change	N
Standard tool TOOLD01	Minor editorial or document structure change	N
Standard tool TOOLD02	Minor editorial or document structure change	N
Special Tools	Minor editorial or document structure change	N
ACCOMPLISHMENT INSTRUCTIONS		
TASK 550044- 832-849-001-Inspection	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 550044-839-201-001	Minor editorial or document structure change	N
Subtask 550044-832-202-001	Minor editorial or document structure change	N
TASK 550044- 832-850-001-Inspection	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 550044-910-201-001	Minor editorial or document structure change	N
Subtask 550044-839-202-001	Minor editorial or document structure change	N
Subtask 550044-941-201-001	Minor editorial or document structure change	N
Subtask 550044-832-204-001	Minor editorial or document structure change	N
Subtask 550044-942-209-001	Minor editorial or document structure change	N
TASK 550044- 832-851-001-Inspection	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 550044-910-202-001	Minor editorial or document structure change	N
Subtask 550044-839-203-001	Minor editorial or document structure change	N

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Subtask 550044-941-202-001	Minor editorial or document structure change	N
Subtask 550044-832-205-001	Minor editorial or document structure change	N
Subtask 550044-942-210-001	Minor editorial or document structure change	N
TASK 550044- 832-852-001-Inspection	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 550044-910-203-001	Minor editorial or document structure change	N
Subtask 550044-839-204-001	Minor editorial or document structure change	N
Subtask 550044-941-203-001	Minor editorial or document structure change	N
Subtask 550044-832-206-001	Minor editorial or document structure change	N
Subtask 550044-942-211-001	Minor editorial or document structure change	N
TASK 550044- 832-853-001-Inspection	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 550044-910-204-001	Minor editorial or document structure change	N
Subtask 550044-839-205-001	Minor editorial or document structure change	N
Subtask 550044-941-204-001	Minor editorial or document structure change	N
Subtask 550044-832-207-001	Minor editorial or document structure change	N
Subtask 550044-942-212-001	Minor editorial or document structure change	N
Fig. A-GFAAA	Minor editorial or document structure change	N
Fig. A-GFAAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GFBAA	Minor editorial or document structure change	N
Fig. A-GFBAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GFCAA	Minor editorial or document structure change	N
Fig. A-GFCAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GFEAA	Minor editorial or document structure change	N
Fig. A-GFEAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GFNAA	Minor editorial or document structure change	N
Fig. A-GFNAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBAAA	Minor editorial or document structure change	N
Fig. A-GBAAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBAAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBAAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBBAA	Minor editorial or document structure change	N
Fig. A-GBBAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBBAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBBAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBEAA	Minor editorial or document structure change	N
Fig. A-GBEAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBEAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBEAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBNAA	Minor editorial or document structure change	N
Fig. A-GBNAA Sheet 01	Minor editorial or document structure change	N

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Fig. A-GBOAA	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 04	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 05	Minor editorial or document structure change	N
Fig. A-GBOAA Sheet 06	Minor editorial or document structure change	N
Fig. A-GBPAA	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 04	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 05	Minor editorial or document structure change	N
Fig. A-GBPAA Sheet 06	Minor editorial or document structure change	N
Fig. A-GBRAA	Minor editorial or document structure change	N
Fig. A-GBRAA Sheet 01	Minor editorial or document structure change	N
Fig. A-GBRAA Sheet 02	Minor editorial or document structure change	N
Fig. A-GBRAA Sheet 03	Minor editorial or document structure change	N
Fig. A-GBRAA Sheet 04	Minor editorial or document structure change	N

FILING INSTRUCTIONS

This Service Bulletin has been generated electronically and is reissued as a complete document. Replace the complete document.

Put this Revision transmittal Sheet in front of the Service Bulletin.

HISTORY OF PREVIOUS REVISIONS

NOTE: This is only applicable for Revision No. 03 and subsequent. If information is required for Revisions issued previous to this, please check your copies of Revision Transmittal Sheets or contact AIRBUS.

REVISION SEQUENCE

ORIGINAL: Oct 22/96

REVISION No. : 04 - Dec 14/17

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SERVICE BULLETIN
SUMMARY

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This summary is for information only and is not approved for modification of the aircraft.

MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 55

TITLE: STABILIZERS - VERTICAL STABILIZERS AND RUDDER - INSPECT THE RUDDER SERVO ACTUATOR ATTACHMENT-STRUCTURE FOR DAMAGE DUE TO SERVO DE-SYNCHRONIZATION

****CONF ALL**

MODIFICATIONS

None

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

Several cases of servo control de-synchronization have been reported after the accomplishment of Service Bulletin A300-27-0188. Investigations have shown that due to the de-synchronization or freeplay or springrod disconnection, structural damage of the attachment fittings may occur.

This Service Bulletin has been issued for the inspection of the attachment fittings for cracks, when the limits described in SB 27-0188 are exceeded.

Accomplishment of this Service Bulletin will contribute to detect structural damage of the attachment fittings which might occur after de-synchronization of the rudder servo actuators. Early detection of damaged attachment fittings is leading to restoration of structural integrity and will avoid costly and time consuming repairs.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	MANDATORY (1)	CANCELS INSPECTION SB	NO
POTENTIAL AD	YES	A/C OPERATION AFFECTED	NO
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	NO	VENDOR SB INVOLVED	NO

NOTE (1): Service Bulletin must be accomplished.

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MATERIAL PRICE INFORMATION

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Component COMPD01	1	See SB	Fastener
Component COMPD02	1	See SB	Fastener
Standard tool TOOLD01	1	See SB	
Standard tool TOOLD02	1	See SB	

EFFECTIVITY

This Service Bulletin is applicable to this (these) operator(s) :

62N 81T A2S AFG F2I GAK GLY IAW IRA IRM MSR QFA RUN STR TIW TNO

CONCURRENT REQUIREMENTS

Accomplishment of this Service Bulletin requires the prior accomplishment of :

Service Bulletin No. A300-27-0188

NOTE: Service Bulletin A300-27-0188 - RUDDER HYDRAULIC ACTUATION - INSPECT FOR CORRECT RUDDER SYNCHRONIZATION

REFERENCES / REPERCUSSIONS

TFU	None
OEB	None
AOT	None
SIL	None
ISI	None
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None
OTHERS	OIT AI/SE/999.0143/96/BC

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

Task 550044-832-849-001: Inspection	
TOTAL MANHOURS	1.00
ELAPSED TIME (HOURS)	1.00

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Task 550044-832-850-001: Inspection	
TOTAL MANHOURS	7.50
ELAPSED TIME (HOURS)	5.00

Task 550044-832-851-001: Inspection	
TOTAL MANHOURS	10.50
ELAPSED TIME (HOURS)	9.25

Task 550044-832-852-001: Inspection	
TOTAL MANHOURS	12.00
ELAPSED TIME (HOURS)	9.25

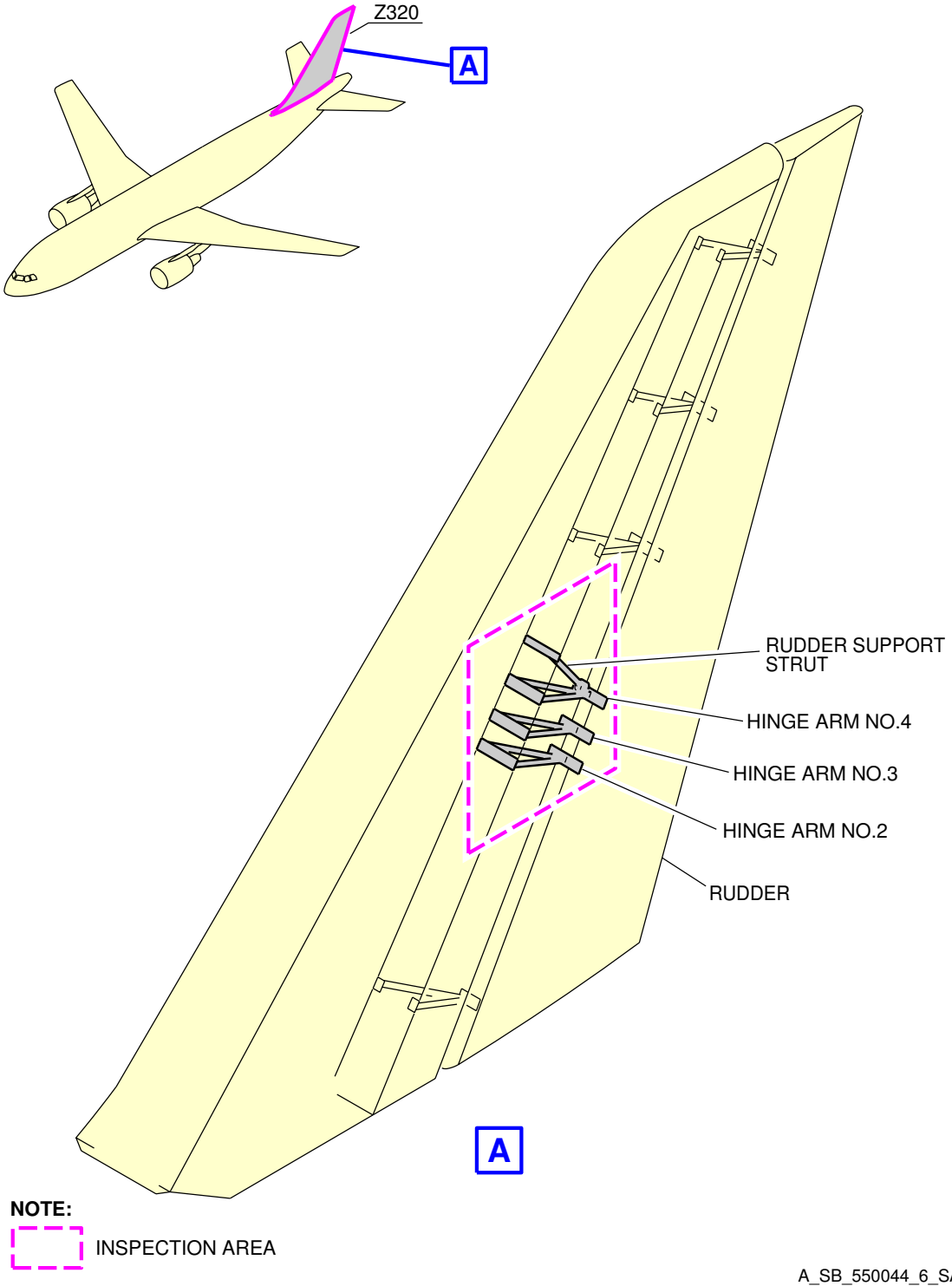
Task 550044-832-853-001: Inspection	
TOTAL MANHOURS	8.00
ELAPSED TIME (HOURS)	6.00

APPENDICES

None

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**CONF ALL



NOTE:

INSPECTION AREA

A_SB_550044_6_SAAA_01_00

Figure A-GSAAA - Sheet 01

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ATA SYSTEM: 55

TITLE: STABILIZERS - VERTICAL STABILIZERS AND RUDDER - INSPECT THE RUDDER SERVO ACTUATOR ATTACHMENT-STRUCTURE FOR DAMAGE DUE TO SERVO DE-SYNCHRONIZATION

MODIFICATION No.: None

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE (01): It is the responsibility of the operator to examine which stabilizer/rudder configuration is currently installed on the aircraft before the inspection is done.

NOTE (02): To find out the fin box/rudder part numbers, refer to the TASK 550044-832-850 001 Inspection of this Service Bulletin.

(1) Models

B2-203 B2K-3C B4-103 B4-203 B4-2C C4-203 F4-203

(2) Effectivity by MSN

0045 0075 0080 0085 0090 0107 0126 0139 0141 0151-0152 0154 0157 0160 0173 0175 0180 0183 0185 0203 0210 0212 0218 0220 0226-0227 0234-0236 0239 0244 0247 0255-0256 0259 0261 0274 0277 0292 0299 0302

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(3) Effectivity by Operator

The Operator/MSN relationship is provided for information only and is correct at the time of issue in accordance with the information available to AIRBUS. Any future changes resulting from transfer of an aircraft from one operator to another will not be reflected in this list unless the Service Bulletin is revised for another reason.

OPERATOR	MSN
62N	0183
81T	0126 0157 0277 0292
A2S	0203
AFG	0180
F2I	0235
GAK	0212
GLY	0085 0141
IAW	0239
IRA	0080 0139 0151 0173 0185 0226 0256 0299 0302
IRM	0090 0160 0175 0244
MSR	0255
QFA	0218
RUN	0075 0107 0154
STR	0236
TIW	0152 0220 0234 0259 0261 0274
TNO	0045 0210 0227 0247

(4) Configuration by MSN

MSN	CONFIGURATION
0045 0075 0080 0085 0090 0107 0126 0139 0141 0151 0152 0154 0157 0160 0173 0175 0180 0183 0185 0203 0210 0212 0218 0220 0226 0227 0234 0235 0236 0239 0244 0247 0255 0256 0259 0261 0274 0277 0292 0299 0302	001

(5) Configuration definition

**CONF 001

(6) Material Effectivity

MATERIAL	QTY PER A/C	SEE NOTES
Component COMPD01	1	
Component COMPD02	1	
Consumable CMLD10	1	
Consumable CMLD20	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

B. CONCURRENT REQUIREMENTS

Accomplishment of this Service Bulletin requires the prior accomplishment of :

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Service Bulletin No. A300-27-0188

NOTE: Service Bulletin A300-27-0188 - RUDDER HYDRAULIC ACTUATION - INSPECT FOR CORRECT RUDDER SYNCHRONIZATION

C. REASON

(1) History

Several cases of servo control de-synchronization have been reported after the accomplishment of Service Bulletin A300-27-0188. Investigations have shown that due to the de-synchronization or freeplay or springrod disconnection, structural damage of the attachment fittings may occur.

(2) Objective/Action

This Service Bulletin has been issued for the inspection of the attachment fittings for cracks, when the limits described in SB 27-0188 are exceeded.

(3) Advantages

Accomplishment of this Service Bulletin will contribute to detect structural damage of the attachment fittings which might occur after de-synchronization of the rudder servo actuators. Early detection of damaged attachment fittings is leading to restoration of structural integrity and will avoid costly and time consuming repairs.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

Task 550044-832-849-001: Inspection

(1) Do the Fleet Evaluation

Task 550044-832-850-001: Inspection

(1) Identify the Fin Box and Rudder Design Configuration

Task 550044-832-851-001: Inspection

(1) Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with forged Attachment Fittings)

Task 550044-832-852-001: Inspection

(1) Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with milled Attachment Fittings)

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Task 550044-832-853-001: Inspection

(1) Do the inspection of the Servo Control Attachment Fittings (Metallic Rudder and Metallic Attachment Fittings)

E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

This Service Bulletin has been classified Mandatory by the issue of an Airworthiness Directive (AD) published by the European Aviation Safety Agency (EASA). The AD must be used as the reference document for the mandated accomplishment timescale.

NOTE: You must inspect all three fin box servo control fittings and three rudder side servo control attachment fittings as per designed configuration.

Due to the large number of affected fittings and different configurations, it is impossible to implement repair solutions into this Service Bulletin and to define a general allowable crack limit. Therefore any findings of damage will be treated by AIRBUS on a case by case basis.

Table 1, Config. ALL - Fleet Evaluation

Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
All aircraft	Check the maintenance records regarding the accomplishment of the Service Bulletin 27-0188 and of this Service Bulletin	Within 3000 FC or 30 months after the issuance of this Service Bulletin	None
This Service Bulletin or Service Bulletin 27-0188 condition unknown	Refer to table 2	Within 3000 FC or 30 months after the issuance of this Service Bulletin	None
Service Bulletin 27-0188 accomplished	Check the inspection results of the Service Bulletin 27-0188	Within 3000 FC or 30 months after the issuance of this Service Bulletin	None
Inspection results of the Service Bulletin 27-0188 within the limits	No further action in accordance with this Service Bulletin	None	None
Inspection results of the Service Bulletin 27-0188 out of the limits or SB 55-2026 accomplished	Refer to table 2	Within 3000 FC or 30 months after the issuance of this Service Bulletin	None

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Table 2, Config. ALL - Entry points for Service Bulletin accomplishment			
Condition	Action	Compliance time (Whichever occurs first)	Repetitive interval
This Service Bulletin or Service Bulletin 27-0188 condition unknown	Identify the design configuration of the fin box and the rudder, refer to the TASK 550044-832-850 001 Inspection Continue with table 3 and 4 for the fin box and table 5 for the rudder configuration	Within 3000 FC or 30 months after the issuance of this Service Bulletin	None
Service Bulletin 27-0188 accomplished with inspection result out of the limits	Identify the design configuration of the fin box and the rudder, refer to the TASK 550044-832-850 001 Inspection Continue with table 3 and 4 for the fin box and table 5 for the rudder configuration	Before next flight	None

Table 3, Config. ALL - Fin box inspection			
Condition	Action	Compliance time	Repetitive interval
Metallic fin box and metallic attachment with forged fittings installed TASK 550044-832-851 001 Inspection	On the hinge arms No. 2,3 and 4 Do an ultrasonic (US) inspection	Before next flight	Every 6000 FC from first US inspection
	OR		
	On the hinge arms No. 2,3 and 4 Do an High Frequency Eddy Current (HFEC) inspection	Before next flight	Every 300 FC from first HFEC inspection
Findings during inspection	Contact AIRBUS	Before next flight	None
No findings during inspection	Repeat the inspection	None	In accordance with the applicable repetitive interval

NOTE: The inspection intervals begin whenever an Service Bulletin 27-0188 result out of limits was found. Any further Service Bulletin 27-0188 finding resets the existing interval of this Service Bulletin to the full range of 300 FC or 6000 FC.

Table 4, Config. ALL - Fin box inspection			
Condition	Action	Compliance time	Repetitive interval

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Metallic fin box and metallic attachment with milled fittings TASK 550044-832-852 001 Inspection	Do an Eddy Current Roto Test inspection	Before next flight	Every 6000 FC from first Roto Test inspection
	OR		
	Do a DET inspection	Before next flight	Every 300 FC from first DET inspection
	OR		
	Do an Eddy Current Roto Test inspection AND Do the cold working of rivet holes	Before next flight	Repeat if the Service Bulletin 27-0188 inspection results are out of limits
Findings during inspection	Contact AIRBUS	Before next flight	None
No findings during inspection	Repeat the inspection	None	In accordance with the applicable repetitive interval

NOTE: The inspection intervals begin whenever an Service Bulletin 27-0188 result out of limits was found. Any further Service Bulletin 27-0188 finding resets the existing interval of this Service Bulletin to the full range of 300 FC or 6000 FC.

Table 5, Config. ALL - Rudder inspection			
Condition	Action	Compliance time	Repetitive interval
Metallic rudder with machined metallic fittings TASK 550044-832-853 001 Inspection	Do an High Frequency Eddy Current (HFEC) inspection	Before next flight	Every 6000 FC from first HFEC inspection
	OR		
	Do a DET inspection	Before next flight	Every 300 FC from first DET inspection
Findings during inspection	Contact AIRBUS	Before next flight	None
No findings during inspection	Repeat the inspection	None	In accordance with the applicable repetitive interval

NOTE: The inspection intervals begin whenever an Service Bulletin 27-0188 result out of limits was found. Any further Service Bulletin 27-0188 finding resets the existing interval of this Service Bulletin to the full range of 300 FC or 6000 FC.

F. APPROVAL

Approved under EASA Design Organisation Approval No. EASA.21J.031.

If an aircraft listed in the effectivity has a modification or repair embodied that is not of AIRBUS origin, and which affects the content of this Service Bulletin, the operator is responsible for obtaining approval by its airworthiness authority for any adaptation necessary before incorporation of the Service Bulletin.

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G. MANPOWER

The manpower estimates given in this Service Bulletin are based on the direct labor cost to do the work. These estimates assume that the work will be done by experienced personnel, and may need to be revised upwards to suit operator's circumstances. The estimates do not include the time to prepare, plan or inspect the work. Manufacture and procurement of parts and tools, drying times for paints, sealants, etc., and general administration work are also not included.

Task 550044-832-849-001: Inspection	
On Aircraft	
Do the Fleet Evaluation	1.00
TOTAL MANHOURS	1.00
ELAPSED TIME (HOURS)	1.00

Task 550044-832-850-001: Inspection	
Get Access	3.50
On Aircraft	
Identify the Fin Box and Rudder Design Configuration	0.50
Close-Up	3.50
TOTAL MANHOURS	7.50
ELAPSED TIME (HOURS)	5.00

Task 550044-832-851-001: Inspection	
Get Access	3.50
On Aircraft	
Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with forged Attachment Fittings)	2.00
Close-Up	5.00
TOTAL MANHOURS	10.50
ELAPSED TIME (HOURS)	9.25

Task 550044-832-852-001: Inspection	
Get Access	3.50
On Aircraft	
Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with milled Attachment Fittings)	3.50
Close-Up	5.00
TOTAL MANHOURS	12.00
ELAPSED TIME (HOURS)	9.25

Task 550044-832-853-001: Inspection	
Get Access	3.50
On Aircraft	

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Task 550044-832-853-001: Inspection	
Do the inspection of the Servo Control Attachment Fittings (Metallic Rudder and Metallic Attachment Fittings)	1.00
Close-Up	3.50
TOTAL MANHOURS	8.00
ELAPSED TIME (HOURS)	6.00

H. WEIGHT AND BALANCE

None

I. ELECTRICAL LOAD DATA

None

J. REFERENCES

Aircraft Maintenance Manual (AMM)	06-41-55 20-16-00 24-00-00 27-24-11 55-33-13 55-40-00 55-42-13
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-55-00
In Service Information (ISI)	ISI 51.48.00001
Non Destructive Test Manual (NTM)	51-10-08 51-30-10 55-36-00
Service Bulletin (SB)	A300-27-0188
Standards Manual (SM)	
Structural Repair Manual (SRM)	51-30-47 51-40-41

K. PUBLICATION AFFECTED

Aircraft Maintenance Manual (AMM)	55-40-00

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

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2. MATERIAL INFORMATION

****CONF ALL**

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

Customers with aircraft shown in the effectivity of this Service Bulletin should send a purchase order to AIRBUS. Quote the number of this Service Bulletin. The address is:

Component COMPD01 Component COMPD02	AIRBUS Material, Logistics and Suppliers IFD - In Flight Desk Weg beim Jaeger 150 D-22335 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by fax: +49 40 50 76 4012 For ordering by E-mail: ifd.spares@airbus.com

(2) Price and Availability

No AIRBUS kit will be provided.

Operator supplied AIRBUS parts required to accomplish this Service Bulletin are to be purchased by a spares purchase order.

B. INDUSTRY SUPPORT INFORMATION

AIRBUS will not provide industry support for accomplishment of this Service Bulletin.

C. LIST OF COMPONENTS

No Kit

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLD10

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner-General - -	08BAA9	As required	
	Textile-Lint Free Cotton -	14SBA1	As required	

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Consumable CMLD20

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-General Purpose Brushable -	06AAA1	As required	
	Non Aqueous Cleaner-General - -	08BAA9	As required	
	Textile-Lint Free Cotton -	14SBA1	As required	

(2) Components

Component COMPD01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
34	NSA5042-05-156	12	BOLT				
35	NAS679C4M	12	NUT				
40	DAN8-8-7	12	PIN				
51	DAN12-8	12	COLLAR				
52	LN9199-6400CF	9	RIVET				
100	NAS1149C1690R	10	WASHER				
101	NSA5454-16RH	6	NUT				
102	A5537015820600	6	WASHER				
103	NSA5060-6	6	NUT				
104	MS24665-300	6	PIN				
105	E0092-10-220NN	3	LEAD				
106	NAS6703U1	6	BOLT				
107	NAS1149C0363R	3	WASHER				
108	NAS1726C3P	3	NUT				
109	NSA5060-4	6	NUT				
110	NSA5056-4	3	WASHER				
111	NAS1149F0432P	3	WASHER				
112	MS24665-134	6	PIN				

NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

Component COMPD02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
41	DAN5-6-8	4	PIN				
42	LN9198-48	2	RIVET				
50	DAN12-6	4	COLLAR				

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NOTE: If you find part numbers of hardware components in the related kit(s) which you cannot identify in the LIST OF COMPONENTS of this Service Bulletin, refer to Standards Manual (SM). The SM will give you the correct part number to part number relationship.

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the Fatigue Technology Inc. (FTI) tool kits should contact:

Standard tool TOOLD01	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Internet: www.fatiguetech.com Phone: (206) 2462010 Fax: (206) 2449886

Operators interested in obtaining the West Coast Industries Inc. (WCI) tool kits should contact:

Standard tool TOOLD02	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 USA Phone: (206) 365-7513 Fax: (206) 365-7483 Email: info@coldwork.com Europe, Middle-East, Africa, India and Russia: customer@capaero.com / +33 5 61 82 04 91 (France)

(b) Price and Availability

Standard tool TOOLD01

Procurement to be negotiated directly with Fatigue Technology Inc. (FTI).

Standard tool TOOLD02

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Procurement to be negotiated directly with West Coast Industries Inc. (WCI).

(2) Tools

To accomplish this Service Bulletin it will be necessary to use the tools and equipment listed in NTM 51-30-10 Part 1, NTM Task 51-10-08, Page Block 601, and NTM 55-36-00, Page Block 401.

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	FTIA300550044-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. FTI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	WCIA300550044-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

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NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. WCI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

(3) Special Tools

None

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3. ACCOMPLISHMENT INSTRUCTIONS

Task 550044-832-849-001 - Inspection

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS:

PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.

REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words 'refer to' are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words 'in accordance with' are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: This Service Bulletin is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions contained herein, contact Airbus for further instructions and approval.

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NOTE: The purpose of flowcharts is to supplement the information given in the Procedure and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

Manpower	
TOTAL MANHOURS	1.00
ELAPSED TIME (HOURS)	1.00

A. GENERAL

(1) Subtask 550044-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in this Service Bulletin.

B. PREPARATION

None

C. PROCEDURE

(1) Subtask 550044-832-202-001 - Do the Fleet Evaluation

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON SPECIFIC

References	
Service Bulletin (SB)	A300-27-0188
Fig. A-GFAAA Fleet evaluation	Sheet 01

(a) Check the aircraft maintenance records regarding the accomplishment of this Service Bulletin and the accomplishment of the Service Bulletin A300-27-0188, refer to the Flow Chart Fig. A-GFAAA Sheet 01.

1 Check if this Service Bulletin or the Service Bulletin A300-27-0188 have been accomplished.

a If the accomplishment is unknown:

Continue with the TASK 550044-832-850 001 Inspection .

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b If the Service Bulletin A300-27-0188 has been accomplished and the inspection result is within the given limits:

No further action is necessary in accordance with this Service Bulletin.

NOTE: Obey the repetitive inspection intervals given in the accomplishment timescale tables Para 1.E.(2) of the Service Bulletin A300-27-0188.

c If the inspection result is out of the given limits:

Continue with the TASK 550044-832-850 001 Inspection .

d If the this Service Bulletin has been accomplished:

Continue with the TASK 550044-832-850 001 Inspection .

D. TEST

None

E. CLOSE-UP

None

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Task 550044-832-850-001 - Inspection

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS:

PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.

REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IF THERE IS CONTAMINATION REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words 'refer to' are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words 'in accordance with' are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: This Service Bulletin is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions contained herein, contact Airbus for further instructions and approval.

NOTE: The purpose of flowcharts is to supplement the information given in the Procedure

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and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

Manpower	
TOTAL MANHOURS	7.50
ELAPSED TIME (HOURS)	5.00

A. GENERAL

(1) Subtask 550044-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-41-55, Page Block 001 20-16-00, Page Block 201
Consumable Material List (CML)	

(a) For location of the access panels, refer to AMM 06-41-55, Page Block 001.

(b) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Materials List (CML).

(c) For circuit breaker safety practices, refer to AMM 20-16-00, Page Block 201.

(2) Subtask 550044-839-202-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in this Service Bulletin.

B. PREPARATION

(1) Subtask 550044-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

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- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM 24-00-00, Page Block 301.

(b) In the cockpit, put warning notices in position to tell persons not to operate the flight controls.

(c) Do the rudder inspection/check Job Set-up procedure, refer to AMM 55-40-00, Page Block 601, , Para 1.B.(1)(a) thru (d).

(d) In the cockpit, put a warning notice in position to tell persons not to pressurize the hydraulic systems.

(e) To get access to the fin box and rudder placards, remove the access panel 325BL, refer to AMM 55-33-13, Page Block 401.

(f) Remove the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(g) Remove the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

C. PROCEDURE

(1) Subtask 550044-832-204-001 - Identify the Fin Box and Rudder Design Configuration

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON SPECIFIC

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References	
Service Bulletin (SB)	A300-27-0188
Fig. A-GFBAA Fin box and rudder design configuration identification	Sheet 01
Fig. A-GBNAA Placard identification	Sheet 01

(a) Identify the fin box and rudder design configuration, refer to the Flow Chart Fig. A-GFBAA Sheet 01.

1 Check the fin box and the rudder placards to identify the PN of the fin box and the rudder, refer to Fig. A-GBNAA Sheet 01.

2 If a placard is missing, contact AIRBUS for further instructions.

3 After the fin box and rudder P/N identification, refer to the subsequent tables to identify the correct inspection tasks to be performed.

NOTE: Two inspection tasks need to be performed for each aircraft:

- One task for the fin box inspection.
- One task for the rudder inspection.

a For the fin box attachment fitting inspection, refer to the subsequent table to find the correct inspection task.

Fin box and attachment fitting inspection task table		
Material of fin box and attachment fittings	Fin box Part Number	Fin box inspection task
Metallic fin box and metallic attachment with forged fittings	A5507850000000/00200/00600 /00800/01000/01400 /01800/02000 A5507852000000/00200/00400 /00600/00800/01000 /01200/01400/01600 /01800/02000/02200 A5507852900000/00200/00400 /00800/01000/01200 /01400/02600/03600	550044-832-851-001
Metallic fin box and metallic attachment with milled fittings	A5507852900600/02000/02200 /02400/02800/03000 /03200/03400	550044-832-852-001

b For the rudder attachment fitting inspection, refer to the subsequent table to find the correct inspection task.

Rudder and attachment fitting inspection task table		
Rudder and attachment fittings material	Rudder Part Number	Rudder inspection task

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Rudder and attachment fitting inspection task table		
Metallic rudder with metallic machined fittings	A5547000000000/00200/00600 00800/01000/01200 01400/01600 01800/02000 A5547001000000/00200/00400 00600/00800/01000	550044-832-853-001

D. TEST

None

E. CLOSE-UP

(1) Subtask 550044-942-209-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

NOTE: For the Close-up procedure, refer to the appropriate inspection task.

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Task 550044-832-851-001 - Inspection

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS:

PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.

REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IN CASE OF CONTAMINATION REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words 'refer to' are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words 'in accordance with' are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: This Service Bulletin is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions contained herein, contact Airbus for further instructions and approval.

NOTE: The purpose of flowcharts is to supplement the information given in the Procedure

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and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

Manpower	
TOTAL MANHOURS	10.50
ELAPSED TIME (HOURS)	9.25

A. GENERAL

(1) Subtask 550044-910-202-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-41-55, Page Block 001 20-16-00, Page Block 201
Consumable Material List (CML)	

(a) For location of the access panels, refer to AMM 06-41-55, Page Block 001.

(b) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Materials List (CML).

(c) For circuit breaker safety practices, refer to AMM 20-16-00, Page Block 201.

(2) Subtask 550044-839-203-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in this Service Bulletin.

B. PREPARATION

(1) Subtask 550044-941-202-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish this Inspection Task during the same layover period as the associated Inspection Task 552026-832-849-001 (fin box and rudder design configuration identification), the subsequent

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Preparation procedure is not necessary.

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM 24-00-00, Page Block 301.

(b) In the cockpit, put warning notices in position to tell persons not to operate the flight controls.

(c) Do the rudder inspection/check Job Set-up procedure, refer to AMM 55-40-00, Page Block 601, Para 1.B.(1)(a) thru (d).

(d) In the cockpit, put a warning notice in position to tell persons not to pressurize the hydraulic systems.

(e) Remove the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(f) Remove the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

C. PROCEDURE

(1) Subtask 550044-832-205-001 - Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with forged Attachment Fittings)

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	NON DESTRUCTIVE TESTING

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Material necessary to do the job

Consumable CMLD10				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner-General - -	08BAA9	As required	
	Textile-Lint Free Cotton -	14SBA1	As required	

References	
Non Destructive Test Manual (NTM)	51-10-08 , Page Block 601 51-30-10 Part 1 55-36-00 , Page Block 401
Service Bulletin (SB)	A300-27-0188
Structural Repair Manual (SRM)	51-30-47
Fig. A-GBAAA Inspection areas of a metallic fin box and forged metallic attachment fittings	Sheet 01 Sheet 02 Sheet 03
Fig. A-GFCAA Inspection of a metallic fin box and forged metallic attachment fittings	Sheet 01

(a) Clean the inspection areas with:

Non Aqueous Cleaner-General - -	08BAA9	As required
Textile-Lint Free Cotton -	14SBA1	As required

(b) On all three fin box servo control fittings, do one of the subsequent Special Detailed Inspections (SDI) in the areas shown on Fig. A-GBAAA Sheet 01 thru Fig. A-GBAAA Sheet 03 and in accordance with the Flow Chart Fig. A-GFCAA Sheet 01:

1 On the hinge arms No. 2, 3 and 4:

Do an ultrasonic inspection in accordance with the NTM 55-36-00 , Page Block 401.

OR

Do an High Frequency Eddy Current (HFEC) inspection in accordance with NTM 51-10-08 , Page Block 601.

(c) In case of findings, contact AIRBUS before next flight for further instructions.

(d) In case of no findings, accomplish the Service Bulletin A300-27-0188.

D. TEST

None

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E. CLOSE-UP

(1) Subtask 550044-942-210-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish an associated Inspection Task during the same layover period, the subsequent Close-up procedure is not necessary.

(a) Do the rudder inspection/check Job Close-up procedure, refer to AMM 55-40-00, Page Block 601.

(b) Install the access panel 325BL, refer to AMM 55-33-13, Page Block 401.

(c) Install the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(d) Install the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

(e) In the cockpit, remove all warning notices.

(f) Put the aircraft back to its initial configuration.

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Task 550044-832-852-001 - Inspection

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS:

PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.

REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IN CASE OF CONTAMINATION REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words 'refer to' are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words 'in accordance with' are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: This Service Bulletin is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions contained herein, contact Airbus for further instructions and approval.

NOTE: The purpose of flowcharts is to supplement the information given in the Procedure

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and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

Manpower	
TOTAL MANHOURS	12.00
ELAPSED TIME (HOURS)	9.25

A. GENERAL

(1) Subtask 550044-910-203-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-41-55, Page Block 001 20-16-00, Page Block 201
Consumable Material List (CML)	

(a) For location of the access panels, refer to AMM 06-41-55, Page Block 001.

(b) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Materials List (CML).

(c) For circuit breaker safety practices, refer to AMM 20-16-00, Page Block 201.

(2) Subtask 550044-839-204-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in this Service Bulletin.

B. PREPARATION

(1) Subtask 550044-941-203-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish this Inspection Task during the same layover period as the associated Inspection Task 552026-832-849-001 (fin box and rudder design configuration identification), the subsequent

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Preparation procedure is not necessary.

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM 24-00-00, Page Block 301.

(b) In the cockpit, put warning notices in position to tell persons not to operate the flight controls.

(c) Do the rudder inspection/check Job Set-up procedure, refer to AMM 55-40-00, Page Block 601, Para 1.B.(1)(a) thru (d).

(d) In the cockpit, put a warning notice in position to tell persons not to pressurize the hydraulic systems.

(e) Remove the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(f) Remove the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

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C. PROCEDURE

(1) Subtask 550044-832-206-001 - Do the inspection of the Servo Control Attachment Fittings (Metallic Fin Box with milled Attachment Fittings)

Manpower Resources	
Manhours	3.50
Minimum number of person	1
Subtask elapsed time	3.50
Skills	NON DESTRUCTIVE TESTING AIRFRAME

Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	NSA5042-05-156	12	BOLT	
35	NAS679C4M	12	NUT	
40	DAN8-8-7	12	PIN	
51	DAN12-8	12	COLLAR	
52	LN9199-6400CF	9	RIVET	
100	NAS1149C1690R	9	WASHER	
101	NSA5454-16RH	5	NUT	
102	A5537015820600	5	WASHER	
103	NSA5060-6	5	NUT	
104	MS24665-300	5	PIN	
105	E0092-10-220NN	3	LEAD	
106	NAS6703U1	6	BOLT	
107	NAS1149C0363R	3	WASHER	
108	NAS1726C3P	3	NUT	
109	NSA5060-4	6	NUT	
110	NSA5056-4	3	WASHER	
111	NAS1149F0432P	3	WASHER	
112	MS24665-134	6	PIN	

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

Consumable CMLD20				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-General Purpose Brushable -	06AAA1	As required	
	Non Aqueous Cleaner-General - -	08BAA9	As required	
	Textile-Lint Free Cotton -	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	FTIA300550044-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. FTI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	WCIA300550044-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

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The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. WCI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Aircraft Maintenance Manual (AMM)	27-24-11, Page Block 401
Non Destructive Test Manual (NTM)	51-30-10 Part 1
Service Bulletin (SB)	A300-27-0188
Structural Repair Manual (SRM)	51-30-47 51-40-41
Fig. A-GBBAA Inspection areas of a metallic fin box and milled metallic attachment fittings	Sheet 01 Sheet 02 Sheet 03
Fig. A-GFEAA Inspection of a metallic fin box and milled metallic attachment fittings	Sheet 01
Fig. A-GBPAA Cold expansion	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06
Fig. A-GBOAA CFRP fin box and metallic attachment fittings - removal/installation of the servo controls	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Clean the inspection areas with:

Non Aqueous Cleaner-General - -	08BAA9	As required
Textile-Lint Free Cotton -	14SBA1	As required

(b) If necessary, remove the servo controls to get access to the inspection areas, refer to Fig. A-GBOAA and refer to AMM 27-24-11, Page Block 401:

1 From the servo controls, remove as shown on Fig. A-GBOAA Sheet 06, View G:

6	Pin, cotter	Item (112)	Discard

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6	Nut		Item (109)	Discard
3	Washer		Item (110)	Discard
3	Washer		Item (111)	Discard
3	Bolt	A2727023000000	Item (126)	Retain
3	Flange	A2727073020000	Item (127)	Retain
3	Rod Assy-Spring	A2727086500200	Item (114)	Retain

2 From the attachment fittings of the hinge arms No. 2 and 3, remove as shown on Fig. A-GBOAA Sheet 04, View E:

2	Pin, cotter		Item (104)	Discard
2	Nut		Item (103)	Discard
2	Washer		Item (102)	Discard
2	Nut		Item (101)	Discard
2	Washer		Item (100)	Discard
2	Bushing-Flanged	A5537162521800	Item (120)	Retain
2	Bolt	A5537163020200	Item (118)	Retain
2	Bolt	A5537163220000	Item (117)	Retain
2	Locking Device Assy	F5537108700400	Item (116)	Retain
2	Bushing-Shouldered	F5537046320200	Item (119)	Retain

3 From the attachment fitting of the hinge arm No. 4, remove as shown on Fig. A-GBOAA Sheet 04, View D:

1	Pin, cotter		Item (104)	Discard
1	Nut		Item (103)	Discard
1	Washer		Item (102)	Discard
1	Nut		Item (101)	Discard
1	Washer		Item (100)	Discard

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1	Bushing-Flanged	A5537162521800	Item (120)	Retain
1	Bolt	A5537163020200	Item (118)	Retain
1	Bolt	A5537163220000	Item (117)	Retain
1	Locking Device	F5537009720000	Item (115)	Retain
1	Bushing-Shouldered	F5537046320200	Item (119)	Retain

4 From the attachment fittings of the hinge arms No. 2, 3 and 4, remove as shown on Fig. A-GBOAA Sheet 05, View F:

3	Pin, cotter		Item (104)	Discard
3	Nut		Item (103)	Discard
3	Washer		Item (102)	Discard
3	Nut		Item (101)	Discard
6	Washer		Item (100)	Discard
3	Bushing-Flanged	A5537162521800	Item (120)	Retain
3	Bolt	A5537163020600	Item (124)	Retain
3	Bolt	A5537163221400	Item (123)	Retain
3	Locking Device Assy	F5537108700600	Item (122)	Retain
6	Bolt		Item (106)	Discard
3	Nut		Item (108)	Discard
3	Washer		Item (107)	Discard
3	Bonding strap		Item (105)	Discard
3	Angle-Bonding	A5537170600600	Item (121)	Retain
3	Bushing-Shouldered	F5537046400000	Item (125)	Retain

5 Move the servo controls, item (113), to get access to the inspection areas.

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(c) On all three fin box servo control fittings, do one of the subsequent Special Detailed Inspections (SDI) in the areas shown on Fig. A-GBBAA Sheet 01 thru Fig. A-GBBAA Sheet 03 and in accordance with the Flow Chart Fig. A-GFEAA Sheet 01:

1 Do a Detailed Visual Inspection (DET).

2 OR

Do an Eddy Current Roto Test inspection.

a Remove the fasteners in the inspection area.

b Do an Eddy Current Roto Test inspection in accordance with NTM 51-30-10 Part 1.

c Install the fasteners.

3 OR

Do an Eddy Current Roto Test inspection and the cold expansion of the related fastener holes:

a From the servo control fittings No. 2, 3 and 4, remove as shown on Fig. A-GBPAA Sheet 03 thru Fig. A-GBPAA Sheet 05:

12	Bolt	Item (40)	Discard
12	Nut	Item (51)	Discard
9	Rivet	Item (52)	Discard
12	Bolt	Item (34)	Discard
12	Nut	Item (35)	Discard

b Clean the surfaces with

Non Aqueous Cleaner-General - -	08BAA9	As required
Textile-Lint Free Cotton -	14SBA1	As required

c Do an Eddy Current Roto Test inspection in accordance with NTM 51-30-10 Part 1.

d Do the cold expansion of the related fastener holes in accordance with the SRM 51-40-41 and as shown on Fig. A-GBPAA Sheet 04 and Fig. A-GBPAA Sheet 05.

Use the FTI tools No.:

EKA300550044-1 Expendable Tooling 1

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DKA300550044-1	Durable Tooling	1
FTIA300550044-1	Capital Tooling	1

Use the WCI tools No,:

EKA300550044-1	Expendable Tooling	1
DKA300550044-1	Durable Tooling	1
WCIA300550044-1	Capital Tooling	1

In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.

e Install as shown on Fig. A-GBPAA Sheet 03 thru Fig. A-GBPAA Sheet 06:

12	Pin	DAN8-8-7	Item 40
12	Collar	DAN12-8	Item 51
12	Bolt	NSA5042-05-156	Item 34
12	Nut	NAS679C4M	Item 35
9	Rivet	LN9199-6400CF	Item 52

with

Polysulfide Sealant-General Purpose Brushable -	06AAA1	As required

NOTE: For the installation of alternative fasteners, refer to the SRM 51-30-47.

(d) In case of findings, contact AIRBUS before next flight for further instructions.

(e) If removed, install the servo controls, refer to Fig. A-GBOAA and refer to AMM 27-24-11, Page Block 401:

1 Move the servo controls back in position into the hinge fittings.

2 On the attachment fittings of the hinge arms No. 2 and 3, item (113), install as shown on Fig. A-GBOAA Sheet 04,View E:

2	Bushing-Shouldered	F5537046320200	Item (119)	Retained at removal
2	Locking Device Assy	F5537108700400	Item (116)	Retained at removal

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2	Bolt	A5537163220000	Item (117)	Retained at removal
2	Bolt	A5537163020200	Item (118)	Retained at removal
2	Bushing-Flanged	A5537162521800	Item (120)	Retained at removal
2	Washer	NAS1149C1690R	Item 100	
2	Nut Assy	NSA5454-16RH	Item 101	
2	Washer	A5537015820600	Item 102	
2	Nut	NSA5060-6	Item 103	
2	Pin-Cotter	MS24665-300	Item 104	

3 On the attachment fitting of the hinge arm No. 4, item (113), install as shown on Fig. A-GBOAA Sheet 04, View D:

1	Bushing-Shouldered	F5537046320200	Item (119)	Retained at removal
1	Locking Device	F5537009720000	Item (115)	Retained at removal
1	Bolt	A5537163220000	Item (117)	Retained at removal
1	Bolt	A5537163020200	Item (118)	Retained at removal
1	Bushing-Flanged	A5537162521800	Item (120)	Retained at removal
1	Washer	NAS1149C1690R	Item 100	
1	Nut Assy	NSA5454-16RH	Item 101	
1	Washer	A5537015820600	Item 102	
1	Nut	NSA5060-6	Item 103	
1	Pin-Cotter	MS24665-300	Item 104	

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4 On the attachment fittings of the hinge arms No. 2 and 3 and 4, item (113), install as shown on Fig. A-GBOAA Sheet 04, View F:

3	Bushing-Shouldered	F5537046400000	Item (125)	Retained at removal
6	Washer	NAS1149C1690R	Item 100	
3	Angle-Bonding	A5537170600600	Item (121)	Retained at removal
3	Locking Device Assy	F5537108700600	Item (122)	Retained at removal
3	Bolt	A5537163221400	Item (123)	Retained at removal
3	Bolt	A5537163020600	Item (124)	Retained at removal
3	Bushing-Flanged	A5537162521800	Item (120)	Retained at removal
2	Nut Assy	NSA5454-16RH	Item 101	
2	Washer	A5537015820600	Item 102	
2	Nut	NSA5060-6	Item 103	
2	Pin-Cotter	MS24665-300	Item 104	
3	Bonding Lead	E0092-10-220NN	Item 105	
6	Bolt	NAS6703U1	Item 106	
3	Washer	NAS1149C0363R	Item 107	
3	Nut	NAS1726C3P	Item 108	

5 On the servo controls, install as shown on Fig. A-GBOAA Sheet 06, View G:

3	Rod Assy-Spring	A2727086500200	Item (114)	Retained at removal
3	Bolt	A2727023000000	Item (126)	Retained at removal
3	Flange	A2727073020000	Item (127)	Retained at removal
3	Washer	NSA5056-4	Item 110	

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3	Washer-Flat	NAS1149F0432P	Item 111
6	Nut	NSA5060-4	Item 109
6	Pin-Cotter	MS24665-134	Item 112

(f) In case of no findings, accomplish the Service Bulletin A300-27-0188.

D. TEST

None

E. CLOSE-UP

(1) Subtask 550044-942-211-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish an associated Inspection Task during the same layover period, the subsequent Close-up procedure is not necessary.

(a) Do the rudder inspection/check Job Close-up procedure, refer to AMM 55-40-00, Page Block 601.

(b) Install the access panel 325BL, refer to AMM 55-33-13, Page Block 401.

(c) Install the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(d) Install the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

(e) In the cockpit, remove all warning notices.

(f) Put the aircraft back to its initial configuration.

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Task 550044-832-853-001 - Inspection

WARNING: MAKE SURE THAT YOU OBEY ALL THE WARNINGS AND ALL THE CAUTIONS INCLUDED IN THE REFERENCED PROCEDURES.

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO MAINTENANCE WORK, REPAIRS OR MODIFICATIONS, ALWAYS KEEP ELECTRICAL WIRING, COMPONENTS AND THE WORK AREA AS CLEAN AS POSSIBLE. TO DO THIS:

PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.

REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

THESE PRECAUTIONS WILL DECREASE THE RISK OF CONTAMINATION AND DAMAGE TO THE ELECTRICAL WIRING INSTALLATION.

IN CASE OF CONTAMINATION REFER TO ESPM 20-55-00.

NOTE: The accomplishment instructions of this Service Bulletin include procedures given in other documents or in other sections of the Service Bulletin. When the words 'refer to' are used and the operator has a procedure accepted by the local authority he belongs to, the accepted alternative procedure can be used. When the words 'in accordance with' are used then the given procedure must be followed.

NOTE: The access and close-up instructions, not comprising return to service tests, in this Service Bulletin do not constitute or affect the technical intent of the Service Bulletin. Operators can therefore, as deemed necessary, omit or add access and/or close-up steps to add flexibility to their maintenance operations as long as the technical intent of the Service Bulletin is met within the set parameters.

NOTE: Manual titles given in the accomplishment instructions are referred to by acronyms. Refer to paragraph 1.J., References, for the definition of acronyms.

NOTE: This Service Bulletin is classified mandatory or expected to be classified mandatory by an Airworthiness Directive (AD). The paragraphs 3.C. and 3.D. in these accomplishment instructions are Required for Compliance (RC) and must be done to comply with the AD. Other paragraphs are recommended and may be deviated from, done as part of other actions or done with accepted methods different from those given in the Service Bulletin, as long as the RC paragraphs can be done and the aircraft can be put back into a serviceable condition.

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions contained herein, contact Airbus for further instructions and approval.

NOTE: The purpose of flowcharts is to supplement the information given in the Procedure

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and Compliance paragraphs and not to serve as the primary source for tasks or compliance times given in this Service Bulletin.

Task Associated Data

Manpower	
TOTAL MANHOURS	8.00
ELAPSED TIME (HOURS)	6.00

A. GENERAL

(1) Subtask 550044-910-204-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-41-55, Page Block 001 20-16-00, Page Block 201
Consumable Material List (CML)	

(a) For location of the access panels, refer to AMM 06-41-55, Page Block 001.

(b) For the specification of materials (Mat. No.) given in this Service Bulletin, refer to the Consumable Materials List (CML).

(c) For circuit breaker safety practices, refer to AMM 20-16-00, Page Block 201.

(2) Subtask 550044-839-205-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

Write in the applicable aircraft records that you have done all the work given in this Service Bulletin.

B. PREPARATION

(1) Subtask 550044-941-204-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	24-00-00, Page Block 301 55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish this Inspection Task during the same layover period as the associated Inspection Task 552026-832-849-001 (fin box and rudder design configuration identification), the subsequent

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Preparation procedure is not necessary.

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

- Aircraft on the ground resting on landing gear (the ground safety locks and the wheel chocks are in position on the landing gear)
- Engine shut down, thrust reversers closed and locked
- Aircraft in clean configuration
- Parking brake applied
- Aircraft electrical network de-energized
- Hydraulic systems depressurized
- Access to the cockpit and cabin is available
- All circuit breakers are in closed position
- All controls in NORM, AUTO or OFF position.

(a) Make sure that the aircraft is electrically grounded, refer to AMM 24-00-00, Page Block 301.

(b) In the cockpit, put warning notices in position to tell persons not to operate the flight controls.

(c) Do the rudder inspection/check Job Set-up procedure, refer to AMM 55-40-00, Page Block 601, , Para 1.B.(1)(a) thru (d).

(d) To get access to the fin box and rudder placards, remove the access panel 325BL, refer to AMM 55-33-13, Page Block 401)

(e) Remove the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

(f) Remove the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

(g) In the cockpit, put a warning notice in position to tell persons not to pressurize the hydraulic systems.

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C. PROCEDURE

(1) Subtask 550044-832-207-001 - Do the inspection of the Servo Control Attachment Fittings (Metallic Rudder and Metallic Attachment Fittings)

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING AIRFRAME

Material necessary to do the job

Component COMPD02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
41	DAN5-6-8	4	PIN	
42	LN9198-48	2	RIVET	
50	DAN12-6	4	COLLAR	

NOTE: The above list of components is not an AIRBUS Kit, the required parts shall be ordered as necessary through the given channel.

Consumable CMLD20

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant-General Purpose Brushable -	06AAA1	As required	
	Non Aqueous Cleaner-General - -	08BAA9	As required	
	Textile-Lint Free Cotton -	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	FTIA300550044-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

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The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. FTI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA300550044-1	Durable Tooling	1	(1)
	EKA300550044-1	Expendable Tooling	1	(2)
	WCIA300550044-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the following tool kit numbers for cold expansion: For the definition of capital, durable and expendable tools refer to ISI 51.48.00001.

NOTE (1): Durable tooling: Ref. DK-A300-55-0044-1

The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): Expendable tooling: Ref. EK-A300-55-0044-1

The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): Capital tooling: Ref. WCI-A300-55-0044-1

The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

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References	
Non Destructive Test Manual (NTM)	51-10-08 , Page Block 601 51-30-10 Part 1
Service Bulletin (SB)	A300-27-0188
Structural Repair Manual (SRM)	51-30-47
Fig. A-GBEAA Inspection areas of a metallic rudder and metallic attachment fittings	Sheet 01 Sheet 02 Sheet 03
Fig. A-GFNAA Inspection of a metallic rudder and metallic attachment fittings	Sheet 01
Fig. A-GBRAA Cold expansion	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Clean the inspection areas with:

Non Aqueous Cleaner-General - -	08BAA9	As required
Textile-Lint Free Cotton -	14SBA1	As required

(b) On all three fin box servo control fittings, do one of the subsequent Special Detailed Inspections (SDI) in the areas shown on Fig. A-GBEAA Sheet 01 thru Fig. A-GBEAA Sheet 03, and in accordance with the Flow Chart Fig. A-GFNAA Sheet 01:

1 Do a Detailed Visual Inspection (DET).

OR

Do an High Frequency Eddy Current inspection in accordance with the NTM 51-10-08 , Page Block 601.

OR

Do an Eddy Current Roto Test inspection and the cold expansion of the related fastener holes:

a From the servo control fittings No. 2, 3 and 4, remove as shown on Fig. A-GBRAA Sheet 03:

4	Bolt	Item (41)	Discard
4	Nut	Item (50)	Discard
2	Rivet	Item (42)	Discard

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b Clean the surfaces with

Non Aqueous Cleaner-General - -	08BAA9	As required
Textile-Lint Free Cotton -	14SBA1	As required

c Do an Eddy Current Roto Test inspection in accordance with NTM 51-30-10 Part 1.

d Do the cold expansion of the related fastener holes in accordance with the SRM 51-30-47 and as shown on Fig. A-GBRAA Sheet 03.

Use the FTI tools No.:

EKA300550044-1	Expendable Tooling	1
DKA300550044-1	Durable Tooling	1
FTIA300550044-1	Capital Tooling	1

Use the WCI tools No,:

EKA300550044-1	Expendable Tooling	1
DKA300550044-1	Durable Tooling	1
WCIA300550044-1	Capital Tooling	1

In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.

e Install as shown on Fig. A-GBRAA Sheet 03 and Fig. A-GBRAA Sheet 04:

4	Pin	DAN5-6-8	Item 41
4	Collar	DAN12-6	Item 50
2	Rivet	LN9198-48	Item 42

with

Polysulfide Sealant-General Purpose Brushable -	06AAA1	As required

NOTE: For the installation of alternative fasteners, refer to SRM 51-30-47.

(c) In case of findings, contact AIRBUS before next flight for further instructions.

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(d) In case of no findings, accomplish the Service Bulletin A300-27-0188.

D. TEST

None

E. CLOSE-UP

(1) Subtask 550044-942-212-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	55-33-13, Page Block 401 55-40-00, Page Block 601 55-42-13, Page Block 401

NOTE: If you intend to accomplish an associated Inspection Task during the same layover period, the subsequent Close-up procedure is not necessary.

(a) Do the rudder inspection/check Job Close-up procedure, refer to AMM 55-40-00, Page Block 601.

(b) Install the access panel 325BL, refer to AMM 55-33-13, Page Block 401.

(c) Install the trailing edge access panels 325CL and 325CR, refer to AMM 55-33-13, Page Block 401.

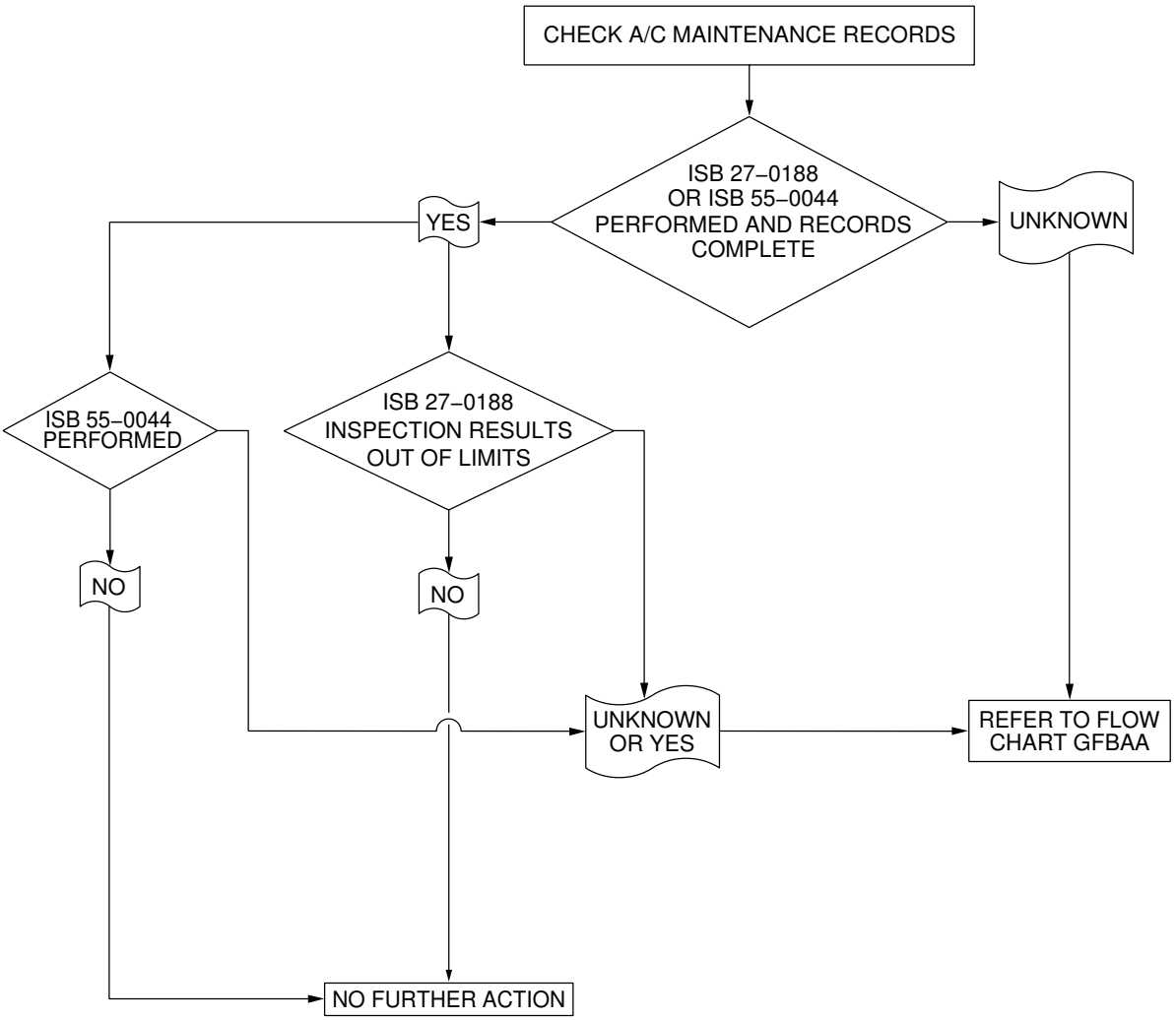
(d) Install the access panels 326DL and 326DR, refer to AMM 55-42-13, Page Block 401.

(e) In the cockpit, remove all warning notices.

(f) Put the aircraft back to its initial configuration.

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NOTE:
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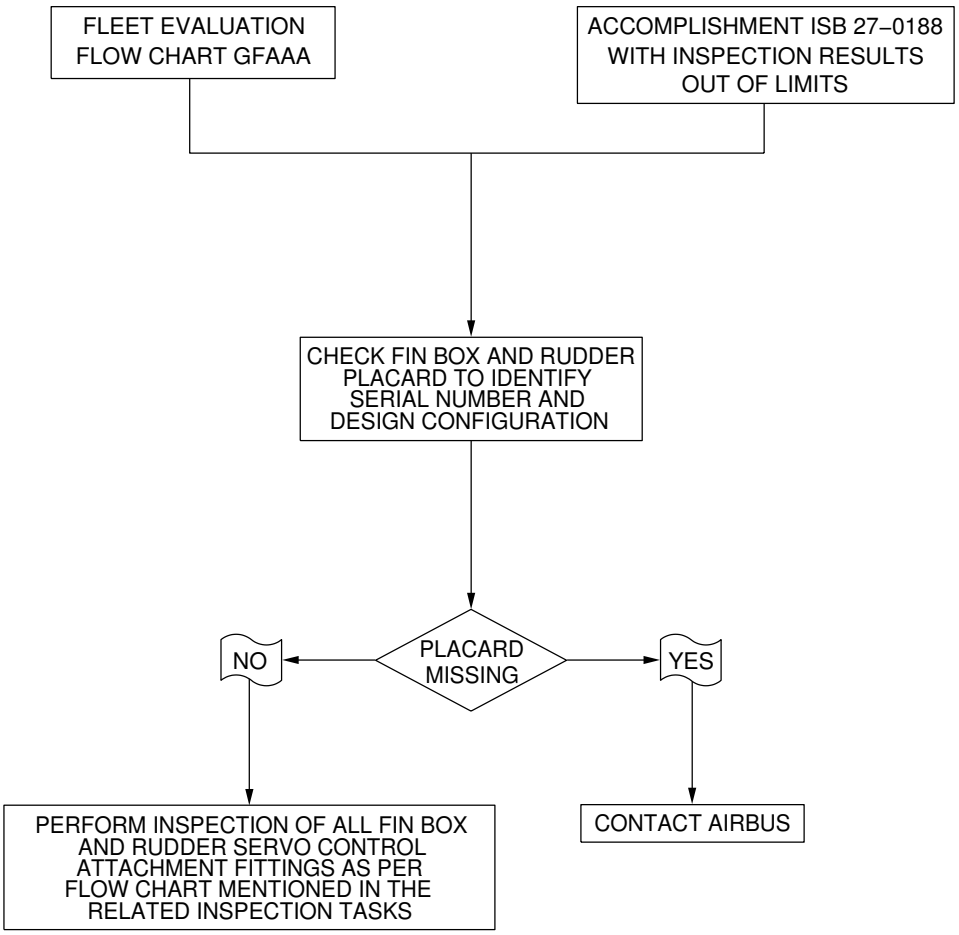
FOR THE COMPLIANCE TIMES, REFER TO THE ACCOMPLISHMENT TIMESCALE PARA 1.E.(2).

A_SB_550044_6_FAAA_01_01

Figure A-GFAAA - Sheet 01
Fleet evaluation

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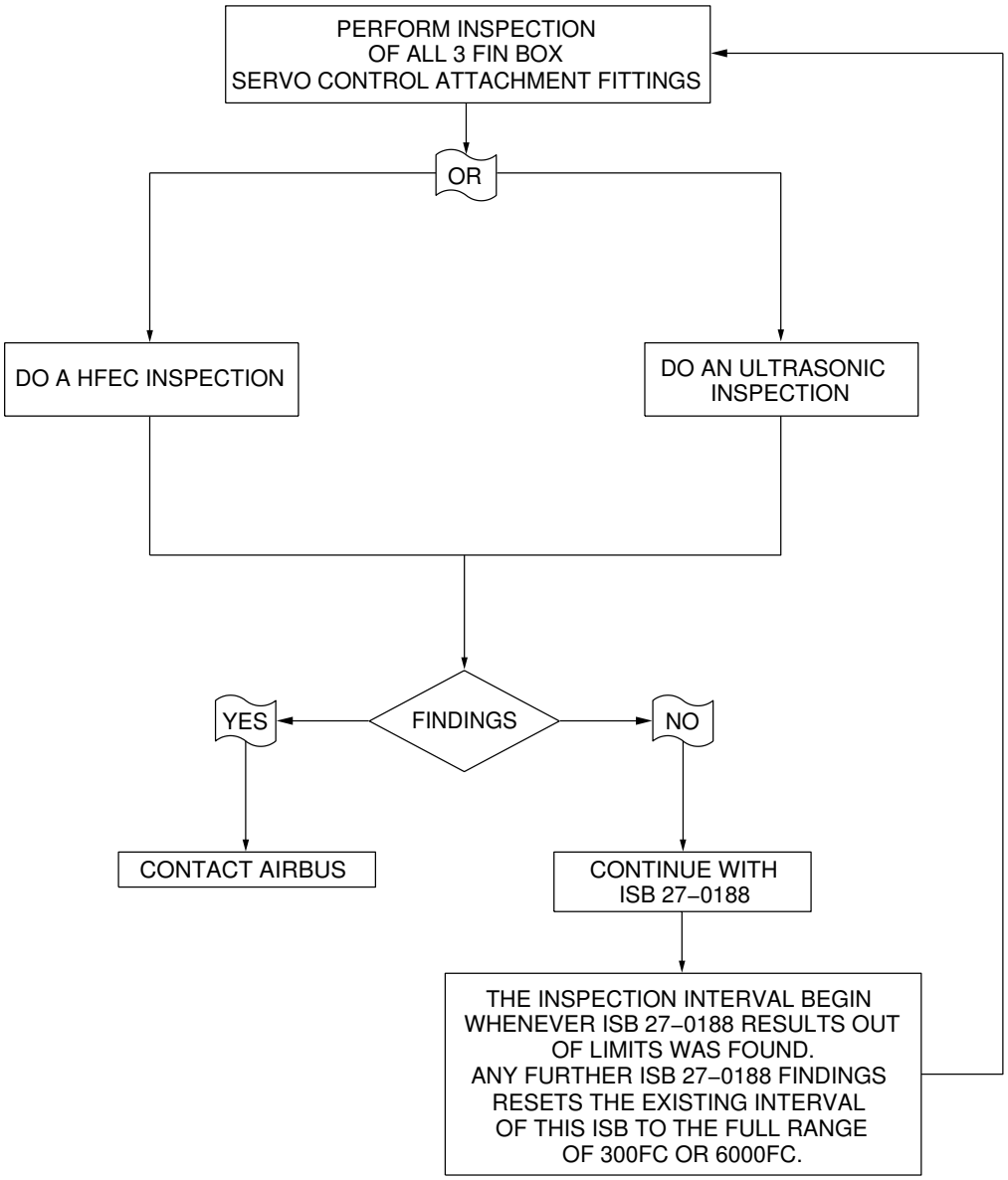
FOR THE COMPLIANCE TIMES, REFER TO THE ACCOMPLISHMENT TIMESCALE PARA 1.E.(2).

A_SB_550044_6_FBAA_01_00

Figure A-GFBAA - Sheet 01
Fin box and rudder design configuration identification

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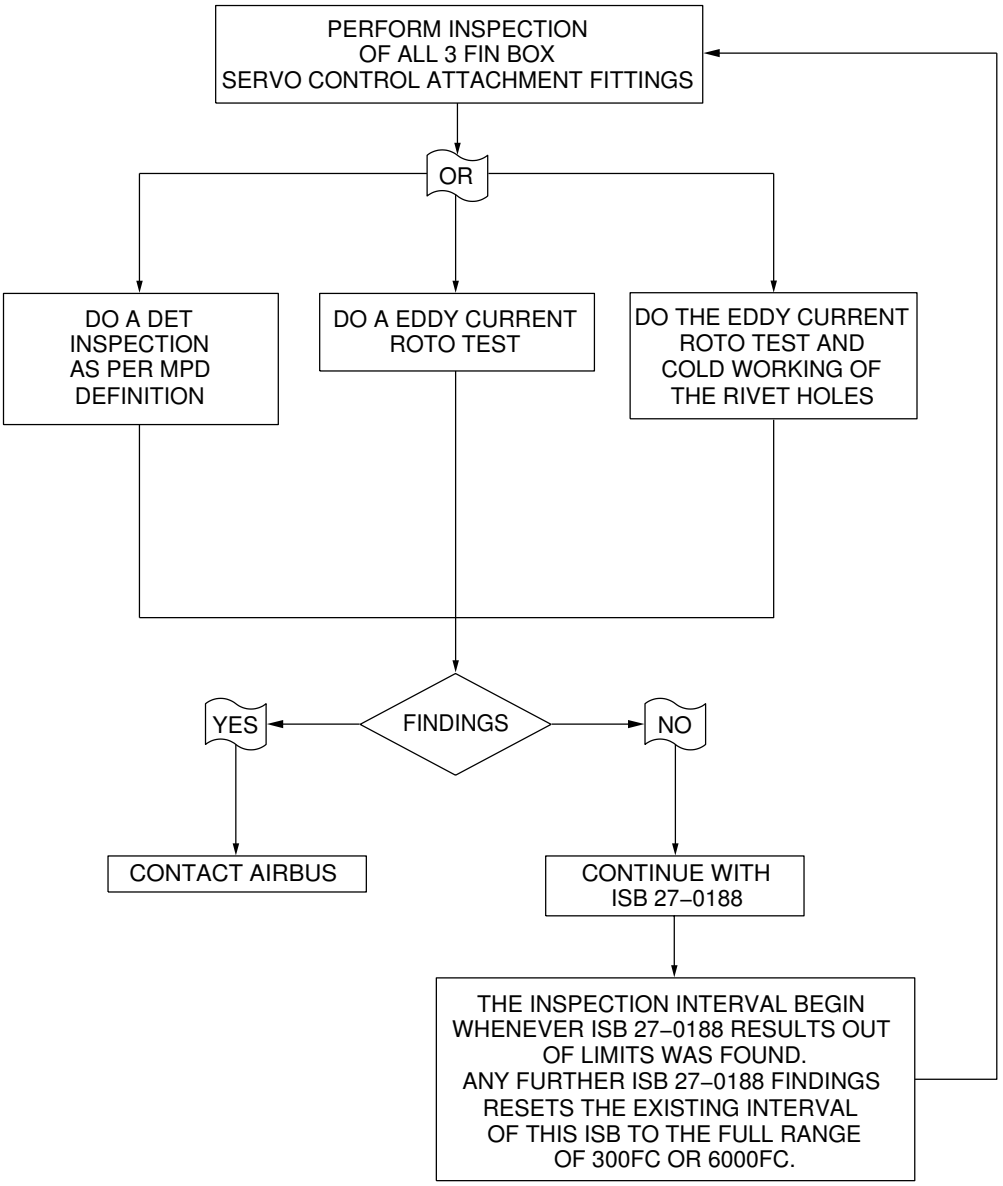
FOR THE COMPLIANCE TIMES, REFER TO THE ACCOMPLISHMENT TIMESCALE PARA 1.E.(2).

A_SB_550044_6_FCAA_01_01

Figure A-GFCAA - Sheet 01
Inspection of a metallic fin box and forged metallic attachment fittings

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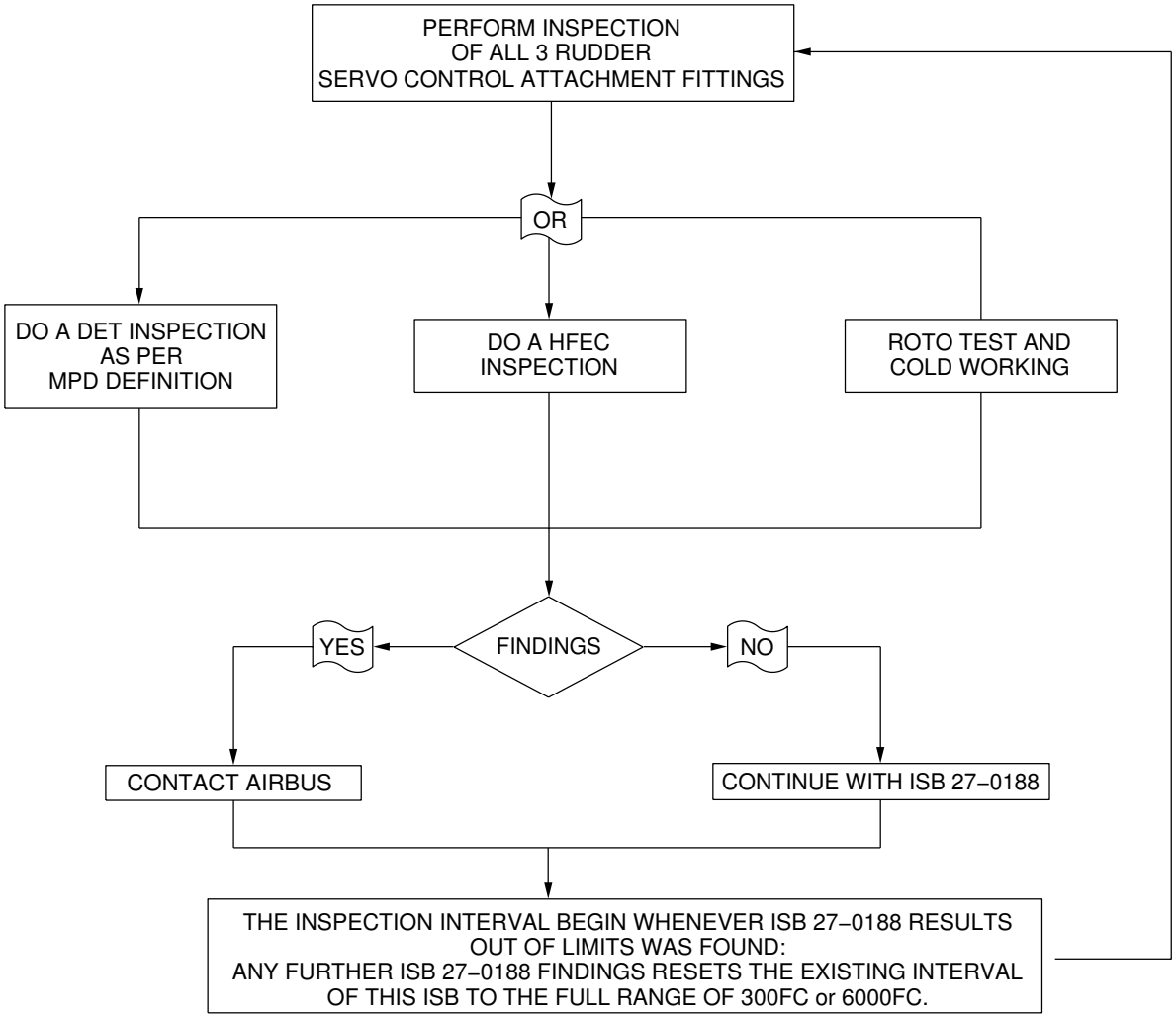
FOR THE COMPLIANCE TIMES, REFER TO THE ACCOMPLISHMENT TIMESCALE PARA 1.E.(2).

A_SB_550044_6_FEAA_01_01

Figure A-GFEAA - Sheet 01
Inspection of a metallic fin box and milled metallic attachment fittings

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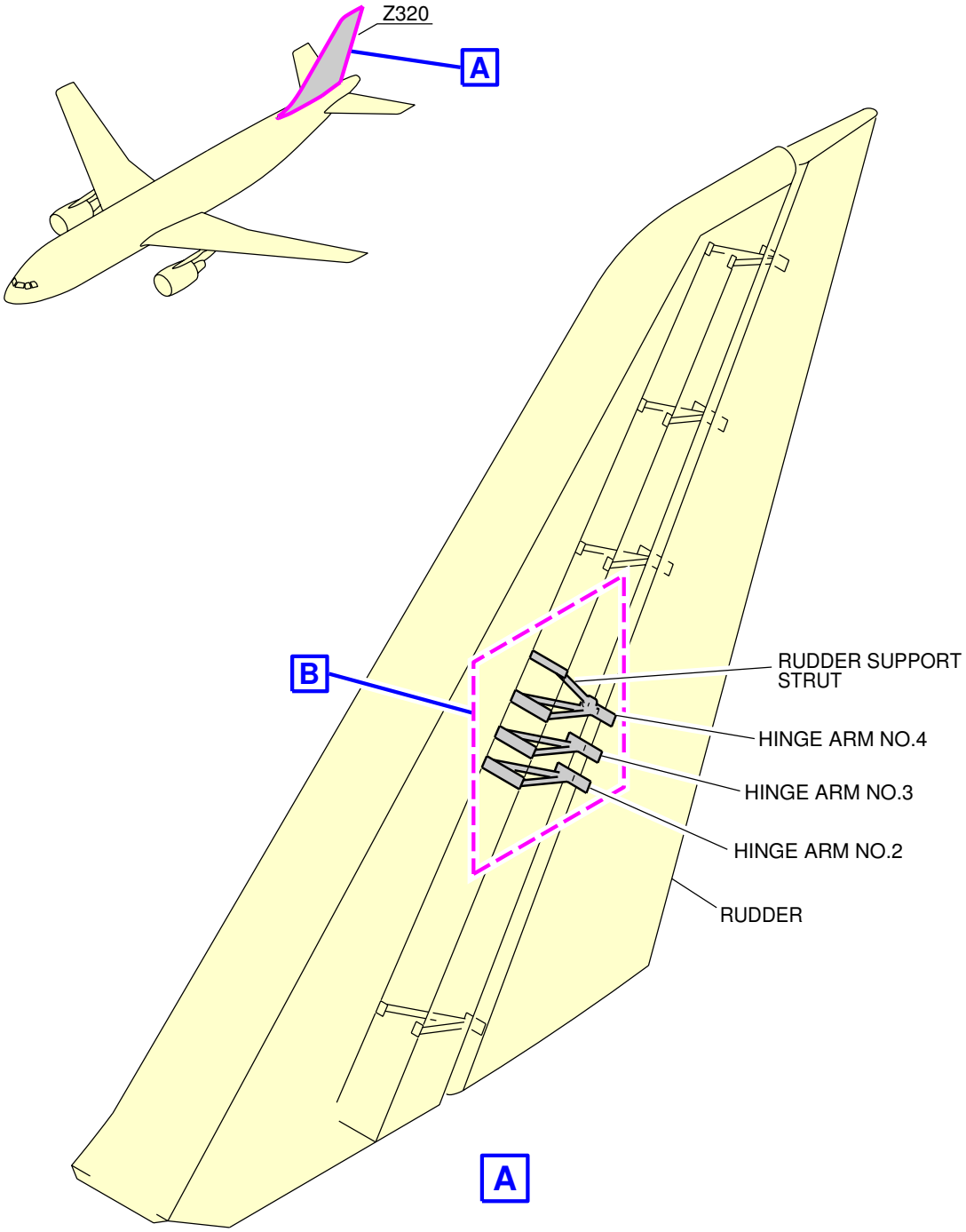
FOR THE COMPLIANCE TIMES, REFER TO THE ACCOMPLISHMENT TIMESCALE PARA 1.E.(2).

A_SB_550044_6_FNAA_01_01

Figure A-GFNAA - Sheet 01
Inspection of a metallic rudder and metallic attachment fittings

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A_SB_550044_6_BAAA_01_00

Figure A-GBAAA - Sheet 01
Inspection areas of a metallic fin box and forged metallic attachment fittings

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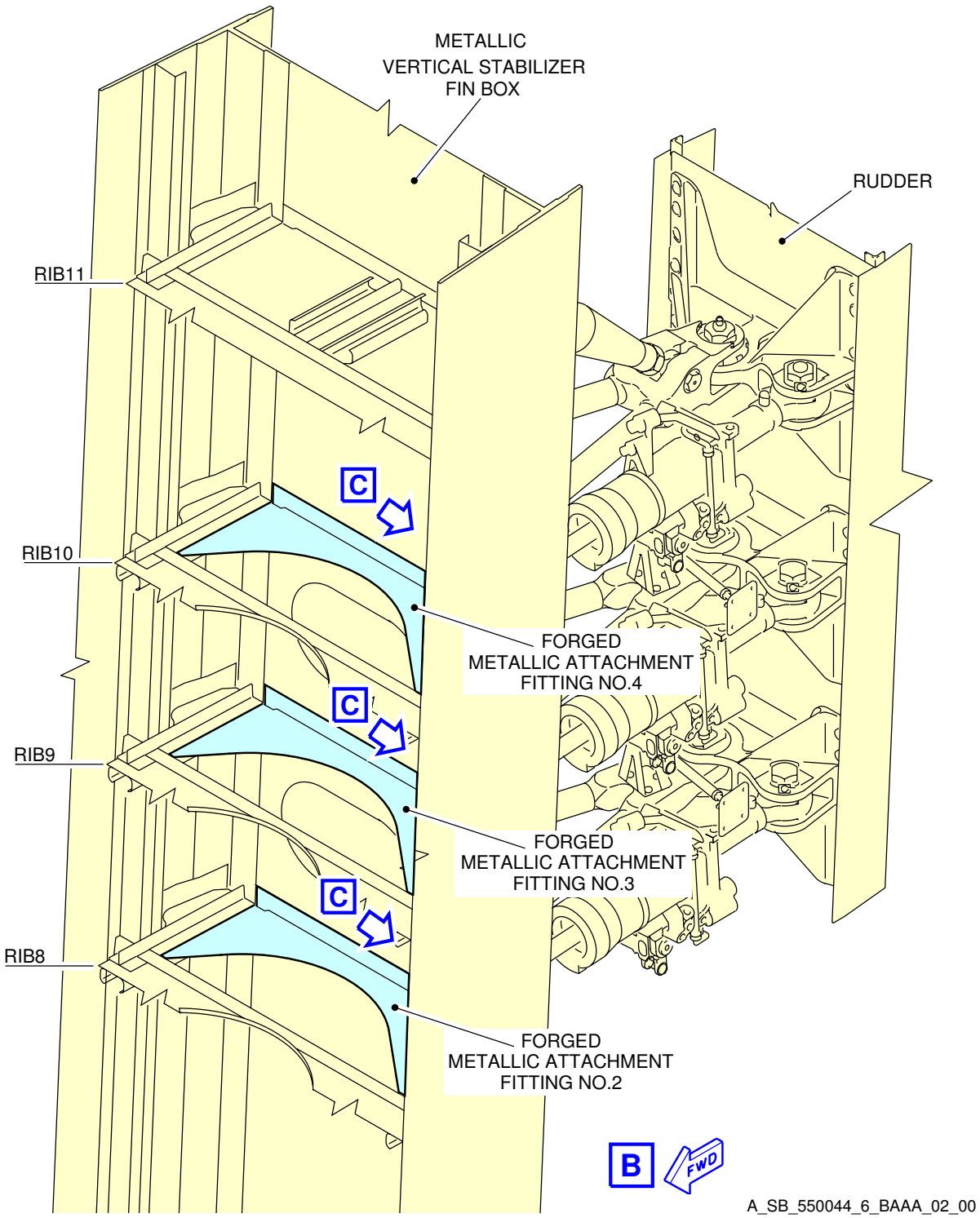
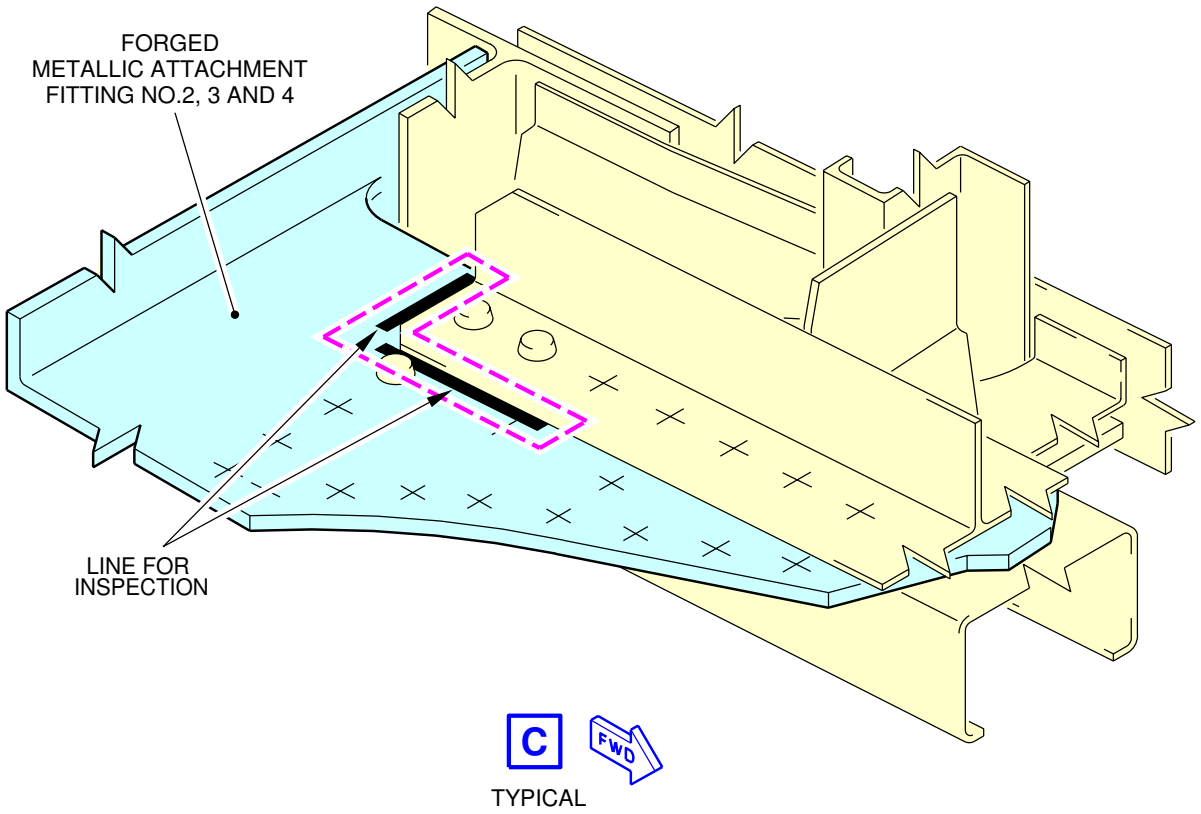


Figure A-GBAAA - Sheet 02
Inspection areas of a metallic fin box and forged metallic attachment fittings

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NOTE:

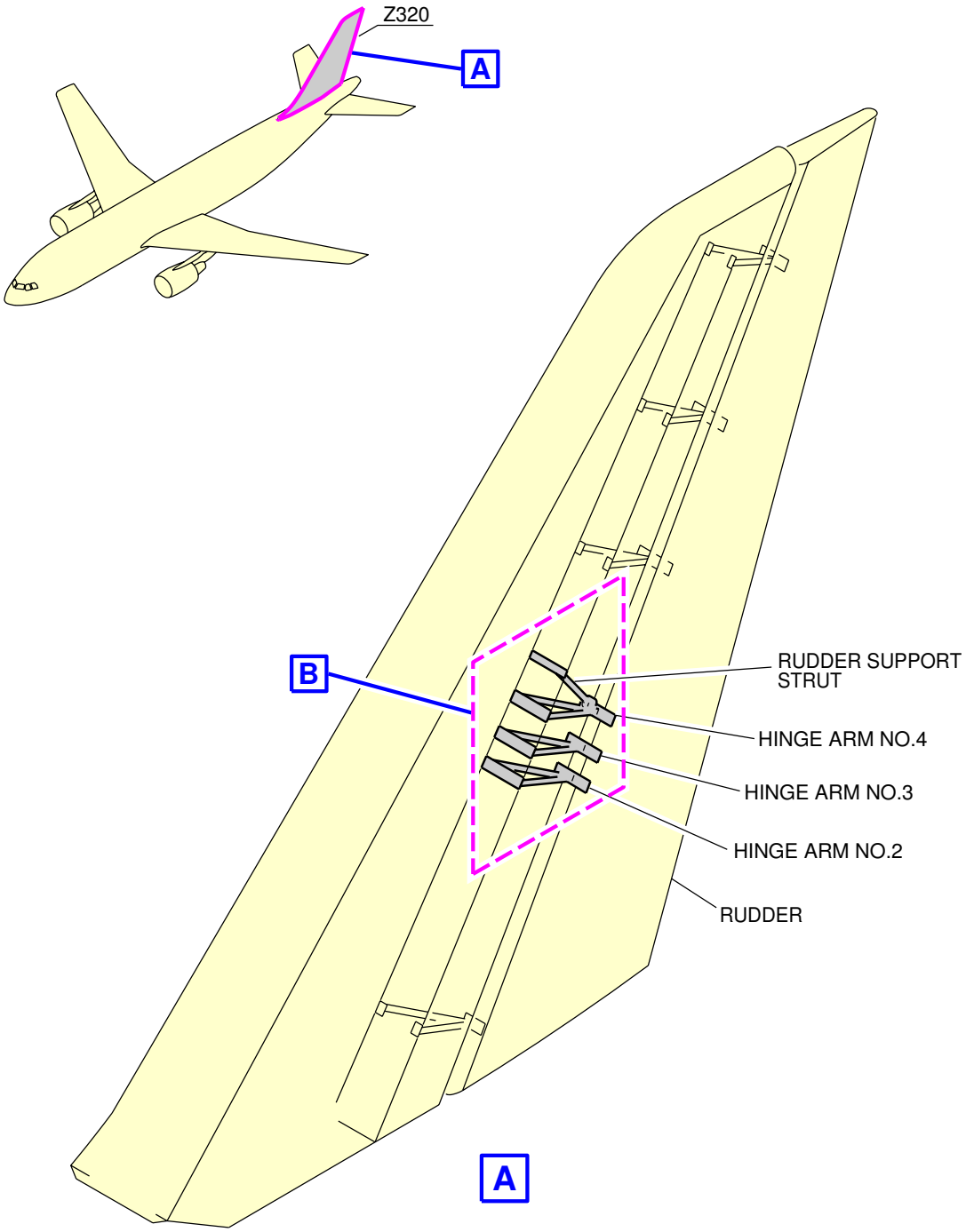
INSPECTION AREA

A_SB_550044_6_BAAA_03_00

Figure A-GBAAA - Sheet 03
Inspection areas of a metallic fin box and forged metallic attachment fittings

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A_SB_550044_6_BBAA_01_00

Figure A-GBBAA - Sheet 01
Inspection areas of a metallic fin box and milled metallic attachment fittings

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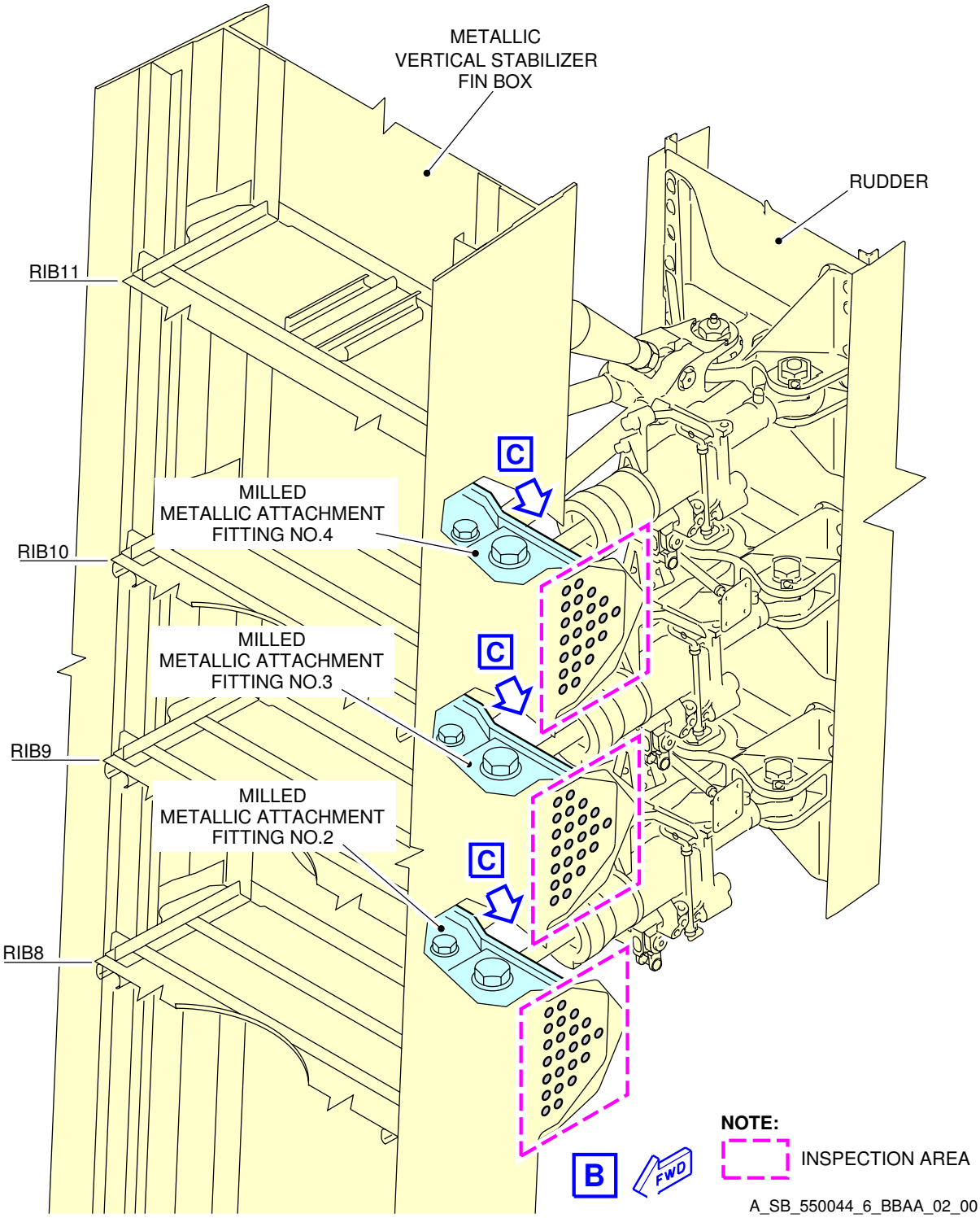
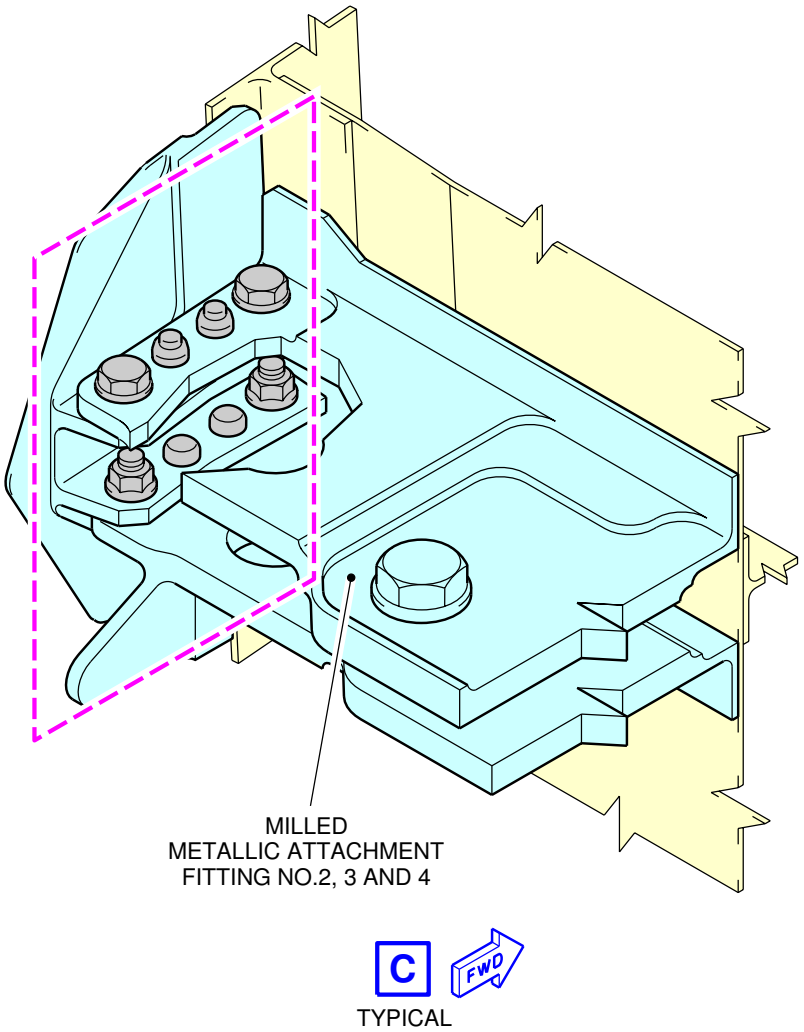


Figure A-GBBAA - Sheet 02
Inspection areas of a metallic fin box and milled metallic attachment fittings

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NOTE:

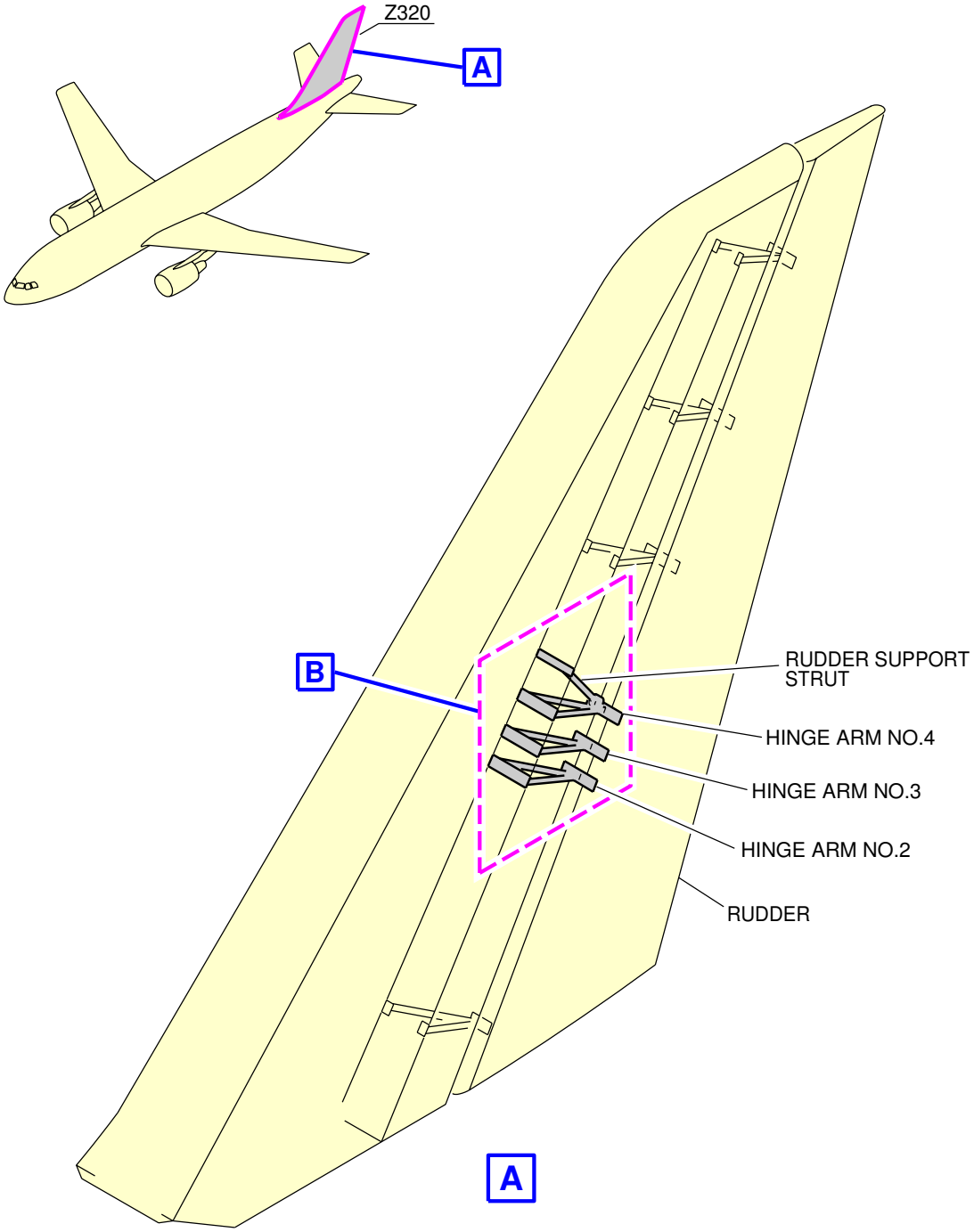
INSPECTION AREA

A_SB_550044_6_BBAA_03_00

Figure A-GBBAA - Sheet 03
Inspection areas of a metallic fin box and milled metallic attachment fittings

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A_SB_550044_6_BEAA_01_00

Figure A-GBEAA - Sheet 01
Inspection areas of a metallic rudder and metallic attachment fittings

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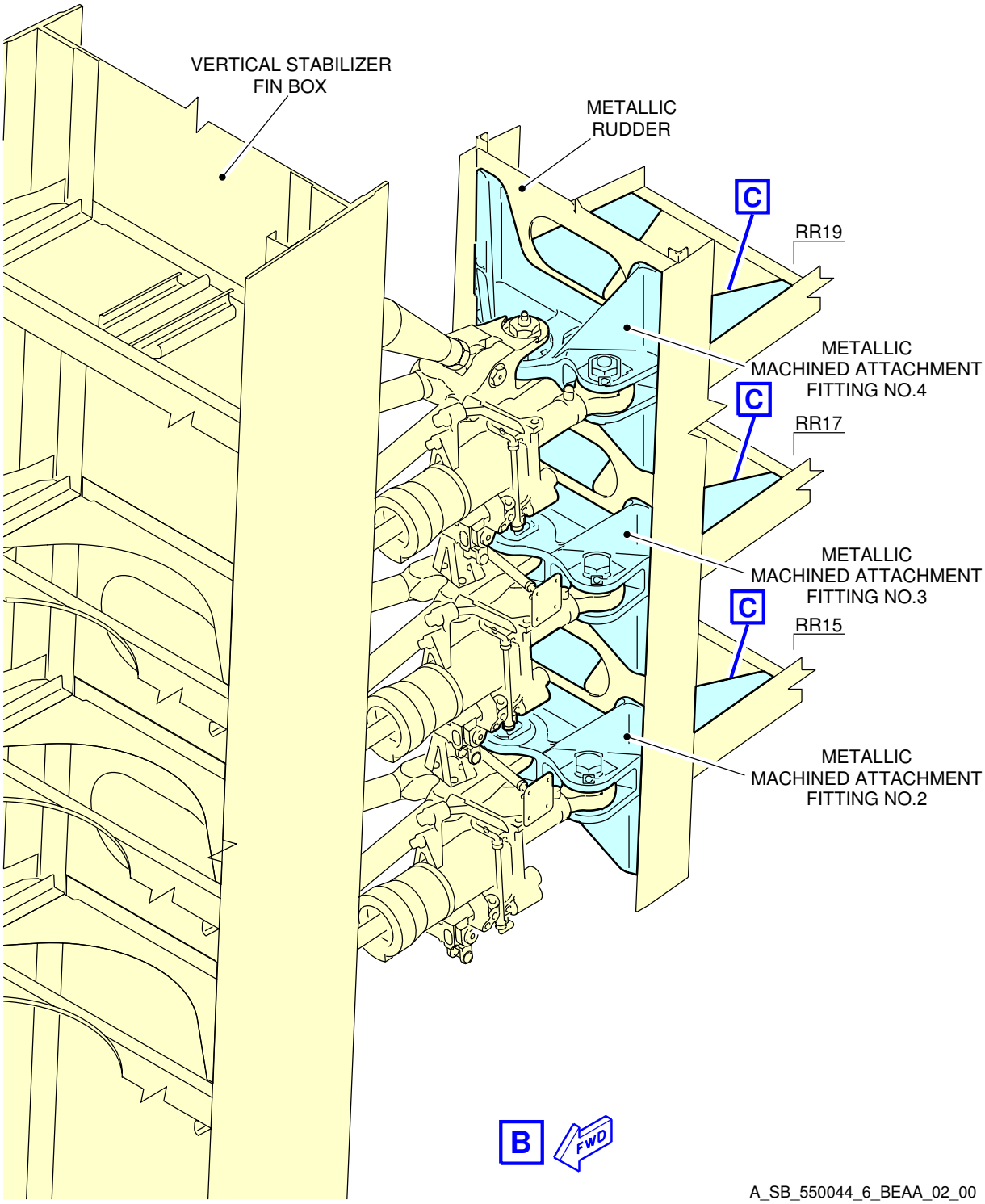
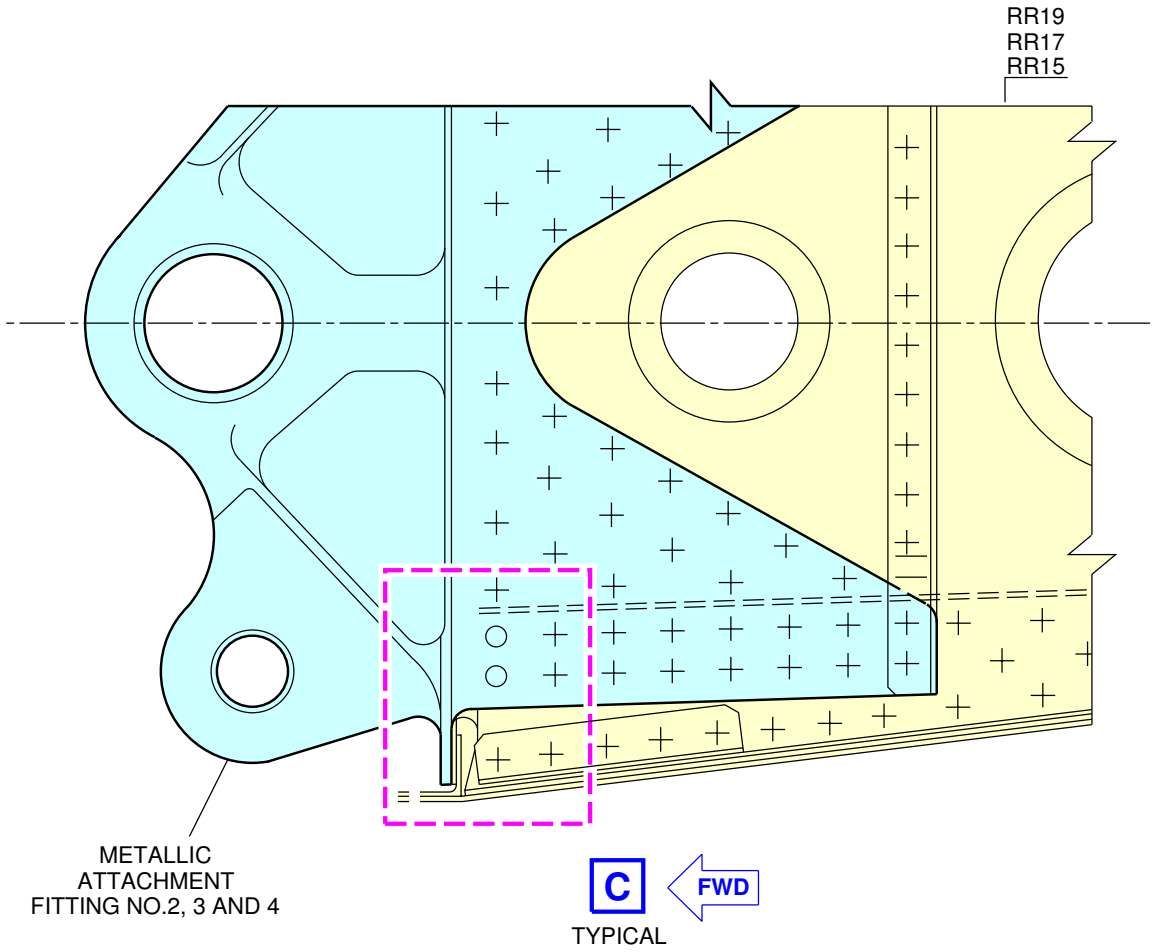


Figure A-GBEAA - Sheet 02
Inspection areas of a metallic rudder and metallic attachment fittings

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NOTE:

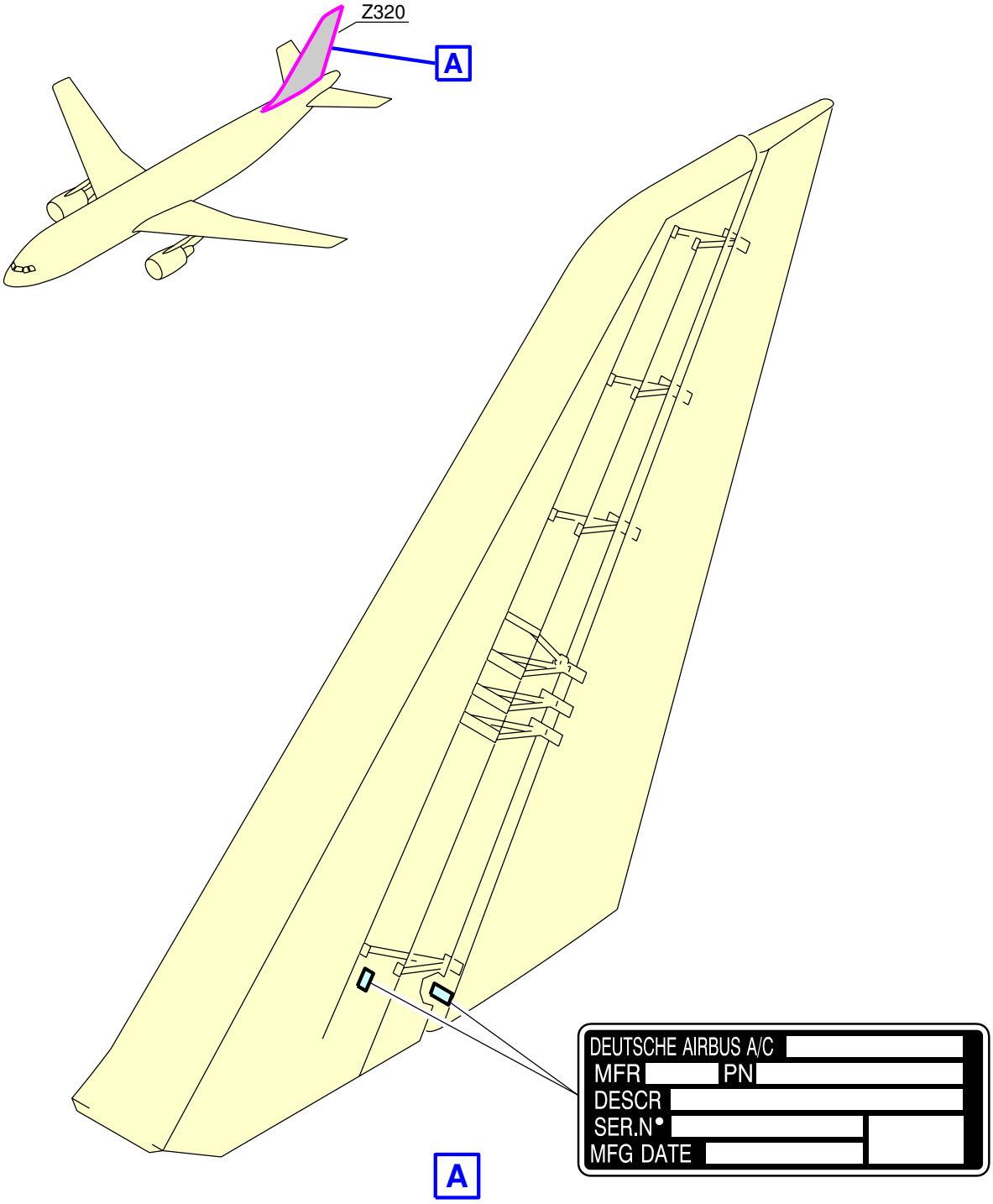
INSPECTION AREA

A_SB_550044_6_BEAA_03_01

Figure A-GBEAA - Sheet 03
Inspection areas of a metallic rudder and metallic attachment fittings

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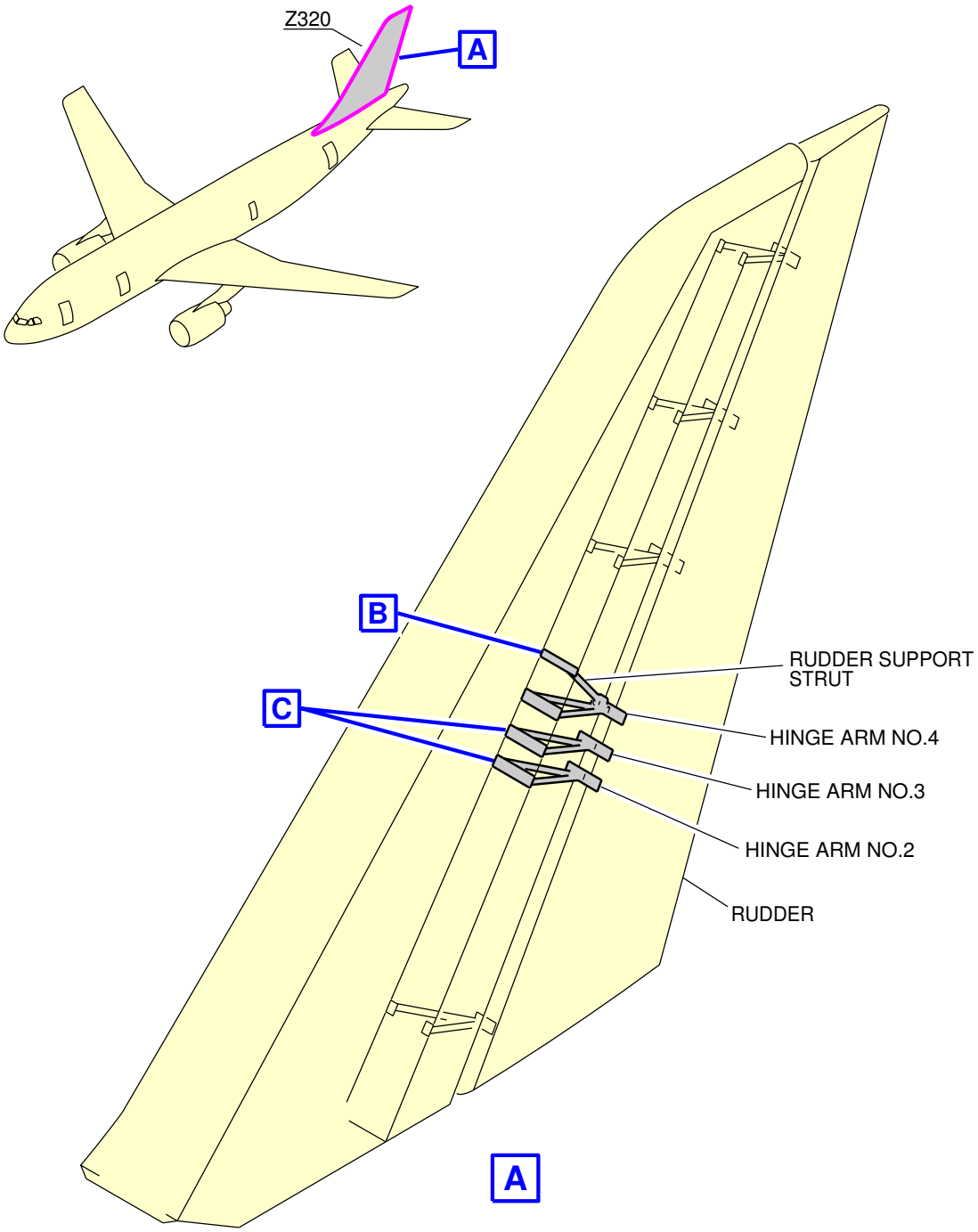


A_SB_550044_6_BNAA_01_00

Figure A-GBNAA - Sheet 01
Placard identification

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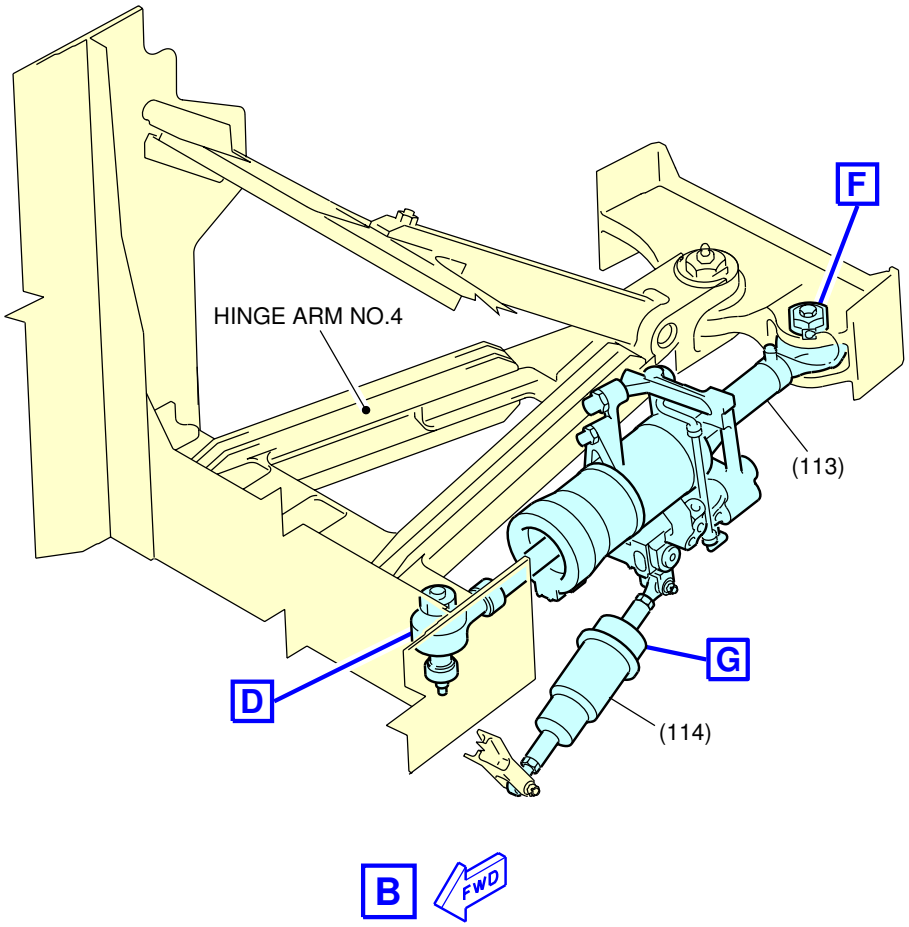


A_SB_550044_6_BOAA_01_00

Figure A-GBOAA - Sheet 01
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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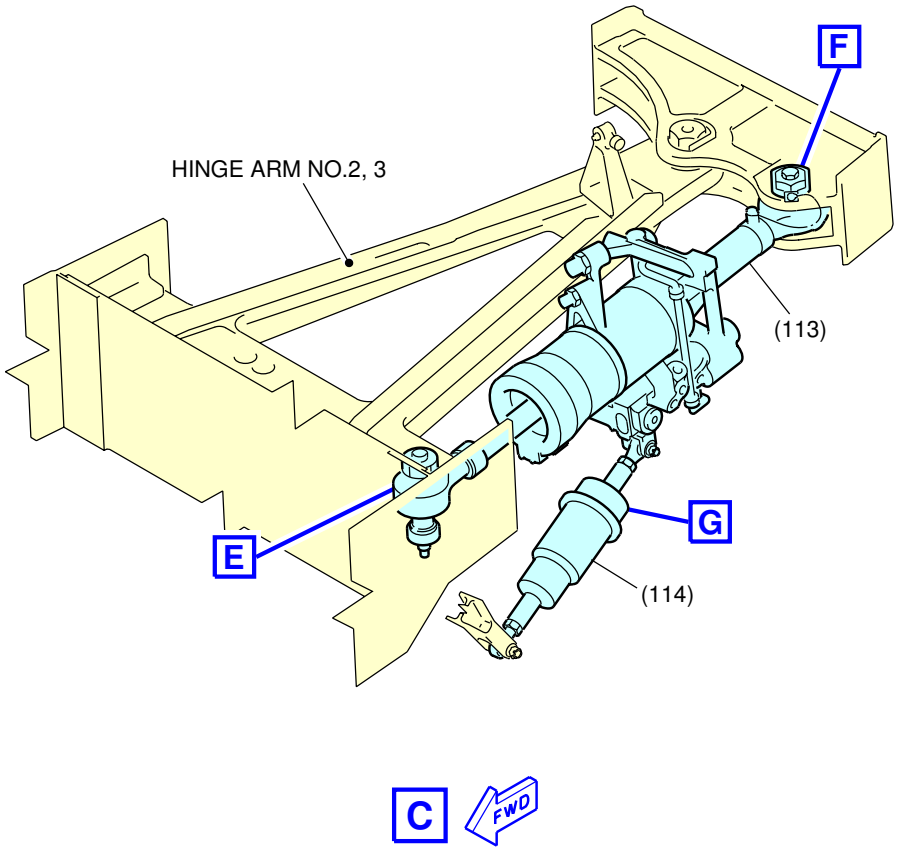


A_SB_550044_6_BOAA_02_00

Figure A-GBOAA - Sheet 02
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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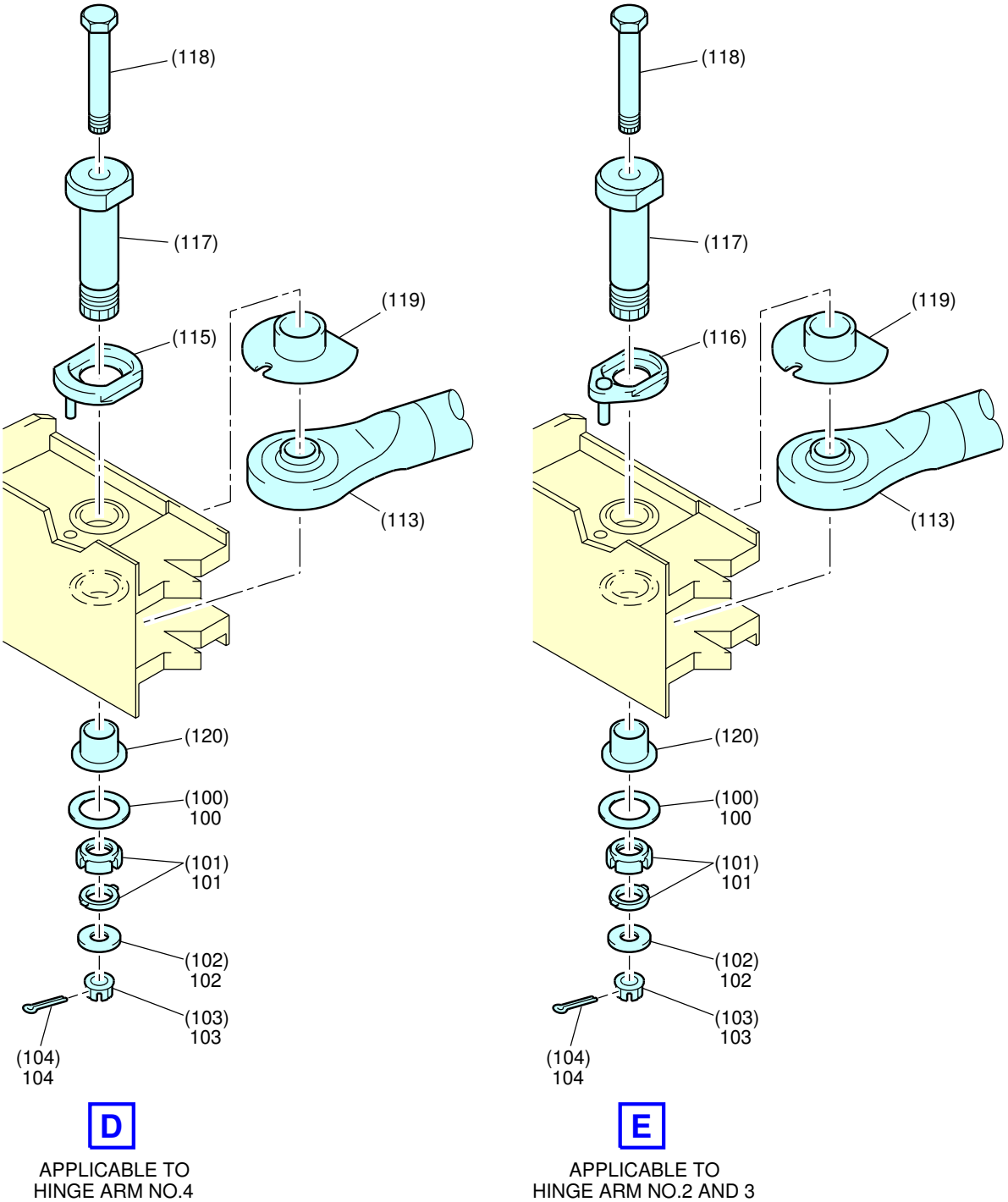


A_SB_550044_6_BOAA_03_00

Figure A-GBOAA - Sheet 03
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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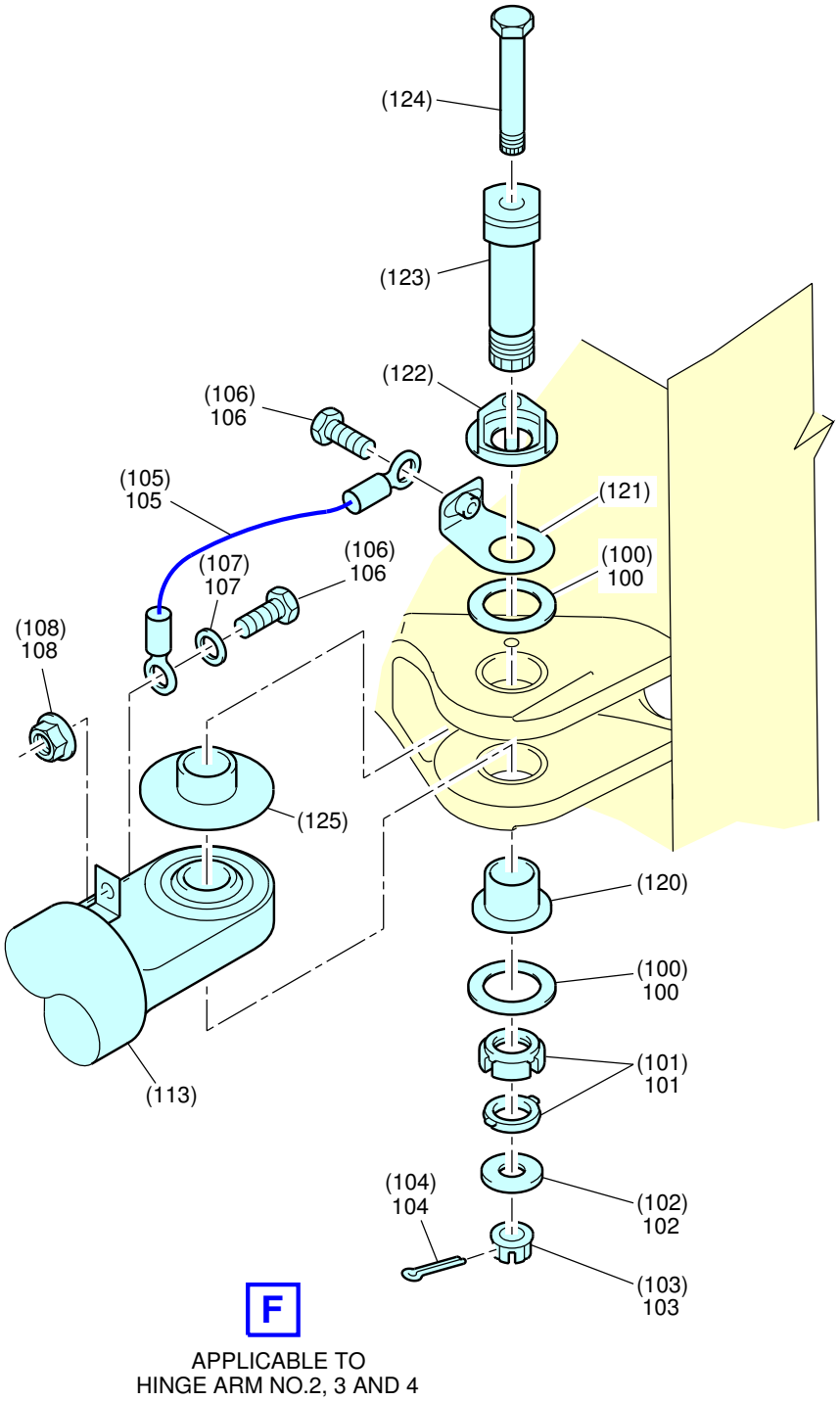


A_SB_550044_6_BOAA_04_00

Figure A-GBOAA - Sheet 04
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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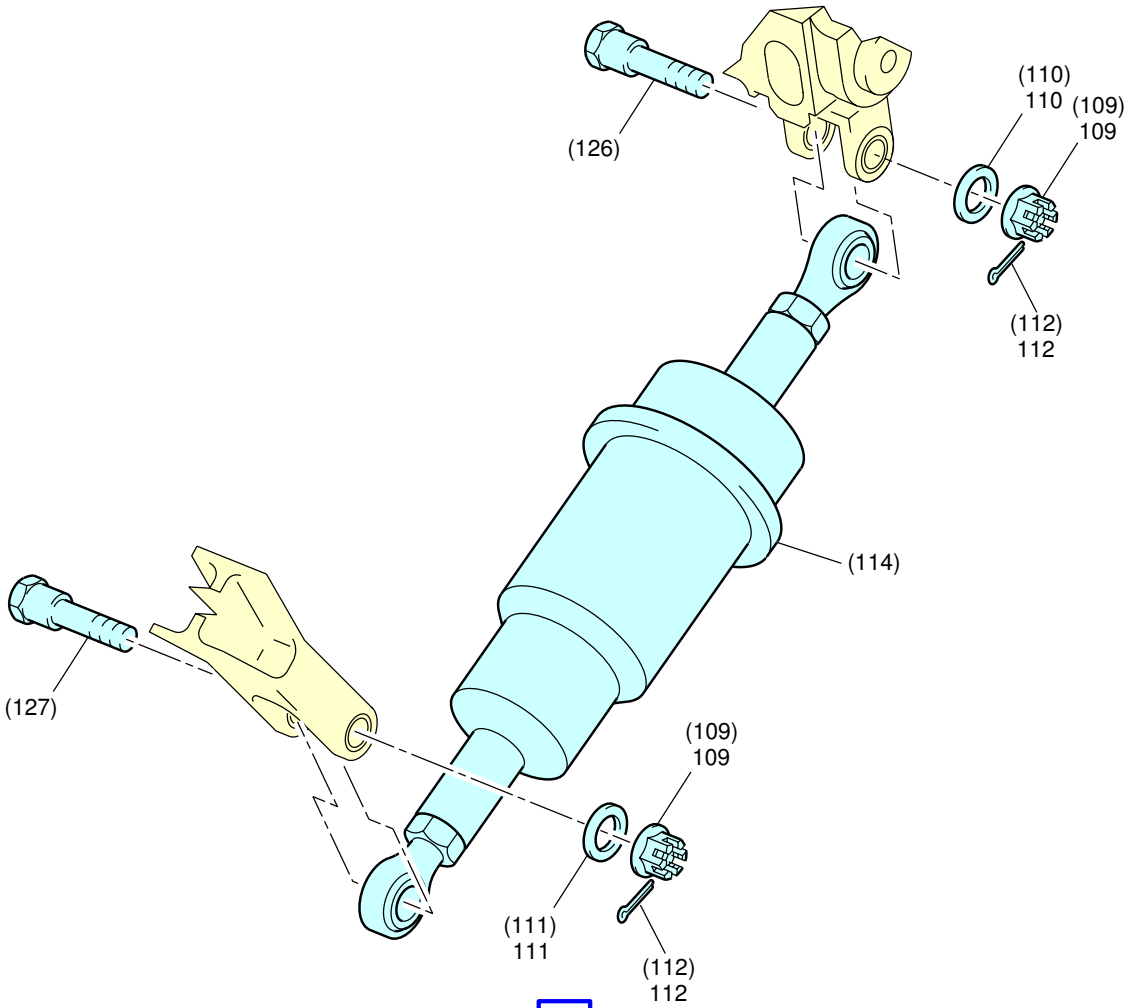


A_SB_550044_6_BOAA_05_00

Figure A-GBOAA - Sheet 05
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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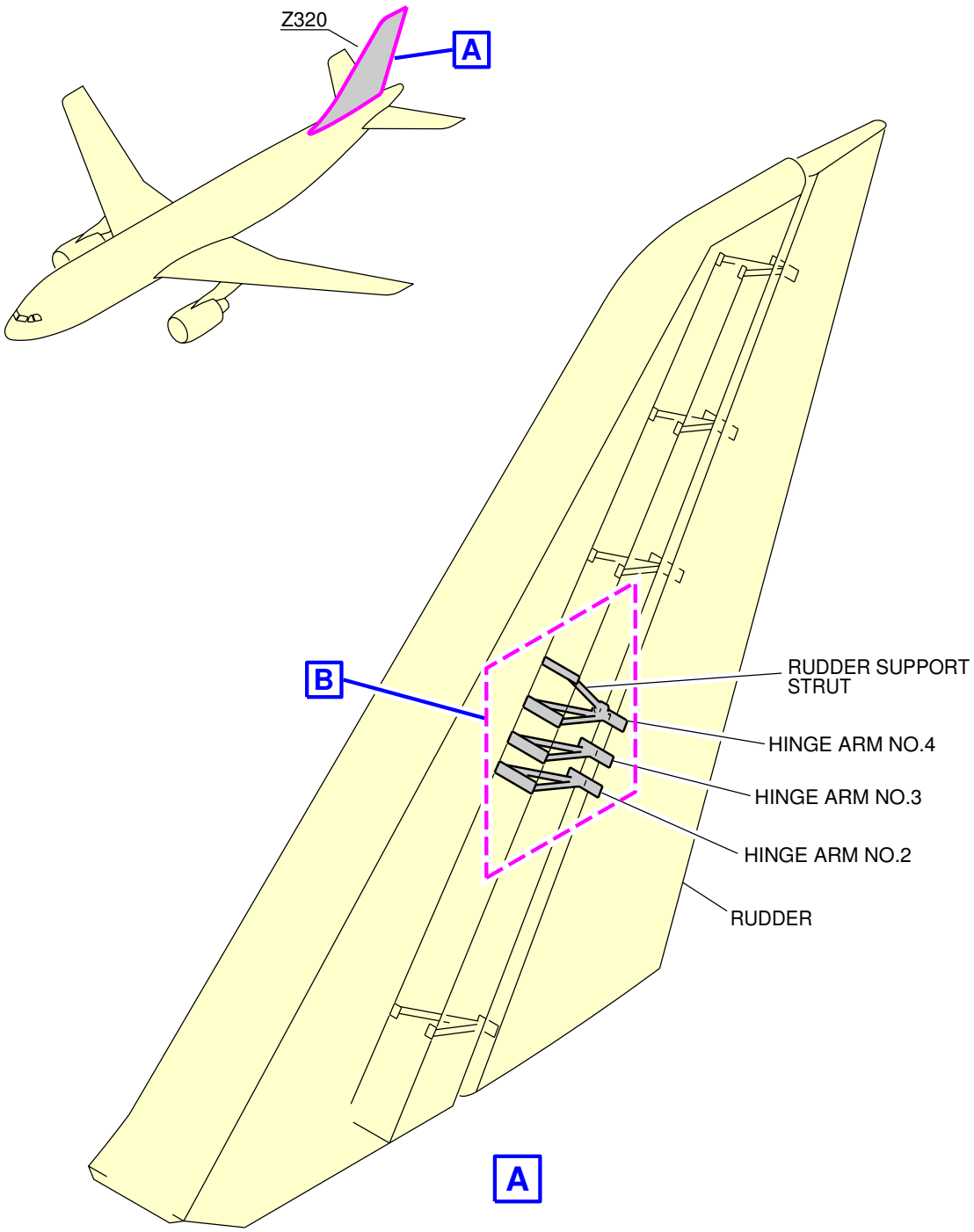
APPLICABLE TO
HINGE ARM NO.2, 3 AND 4

A_SB_550044_6_BOAA_06_00

Figure A-GBOAA - Sheet 06
CFRP fin box and metallic attachment fittings - removal/installation of the servo controls

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A_SB_550044_6_BPAA_01_00

Figure A-GBPAA - Sheet 01
Cold expansion

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**CONF ALL

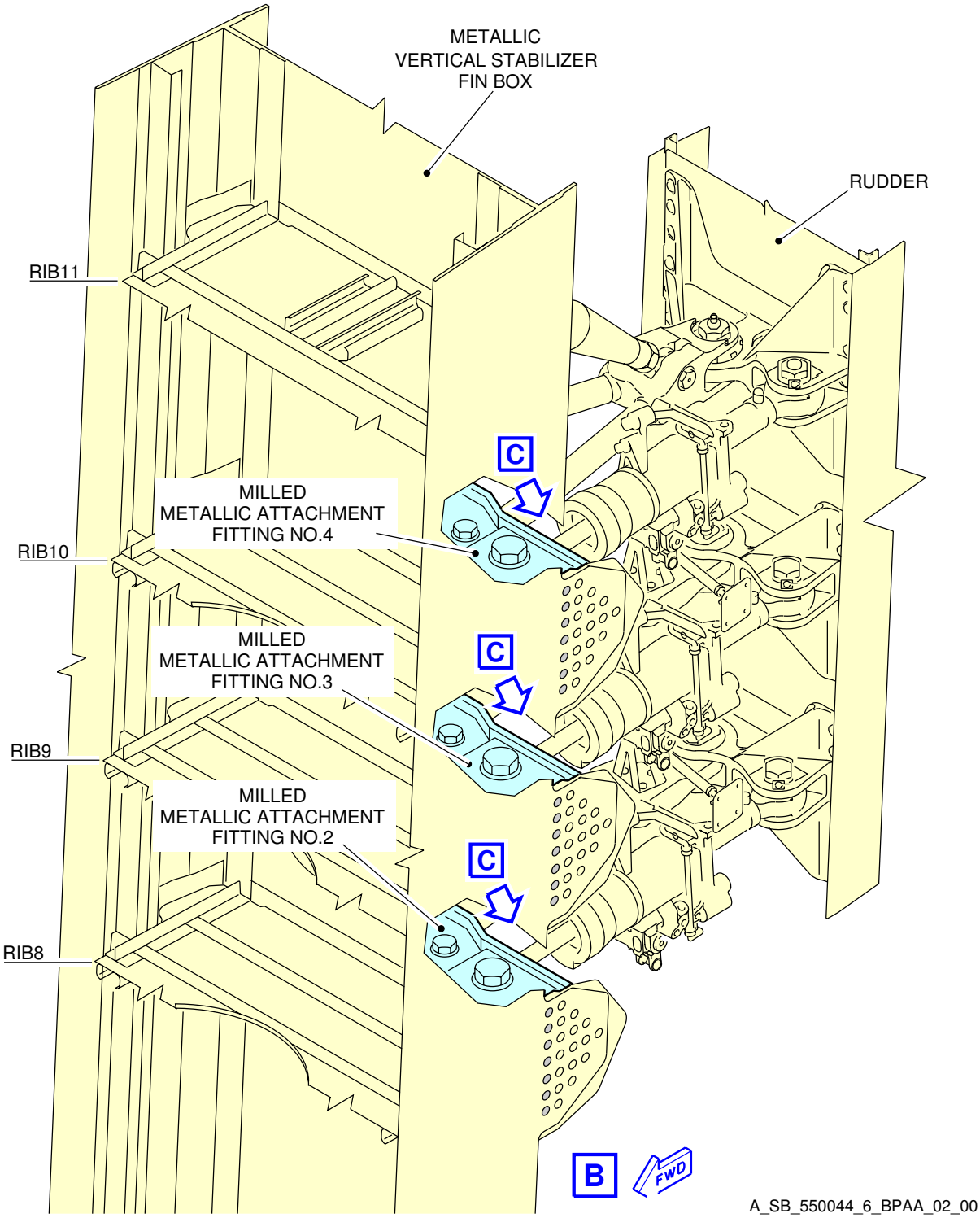
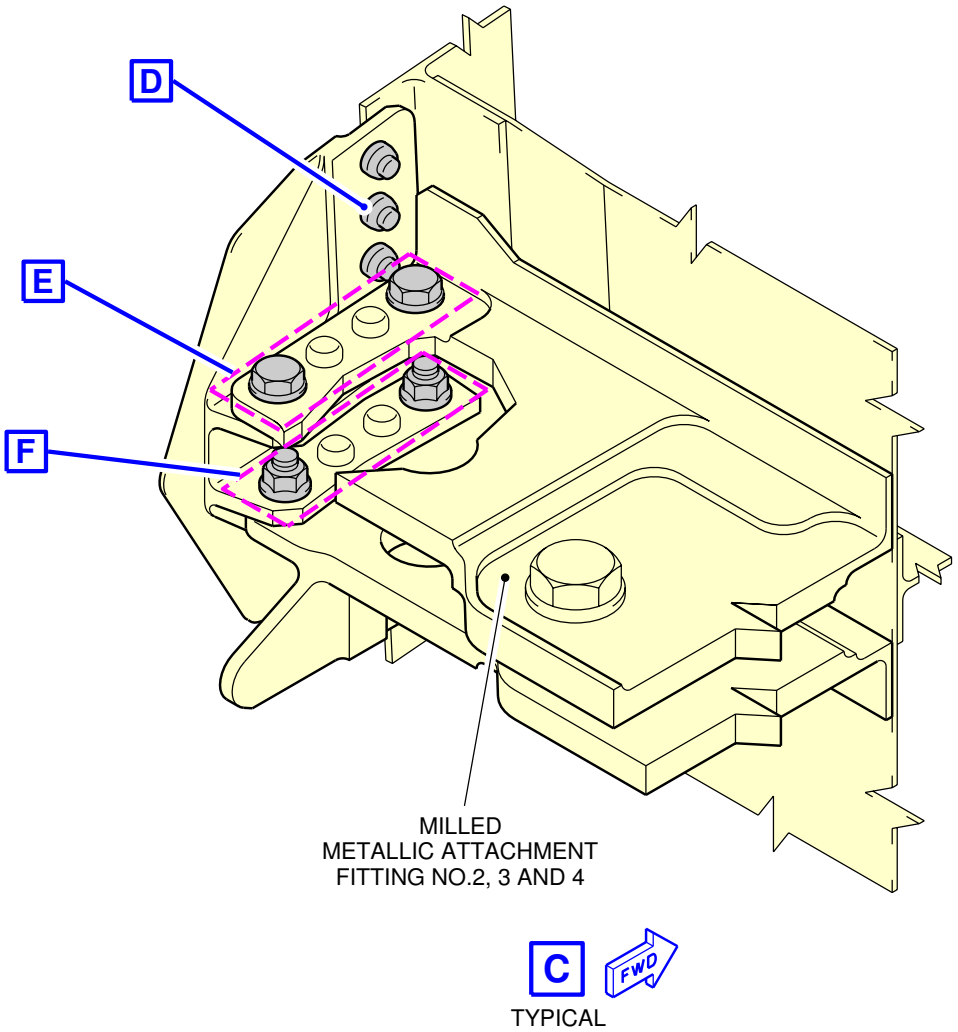


Figure A-GBPAA - Sheet 02
Cold expansion

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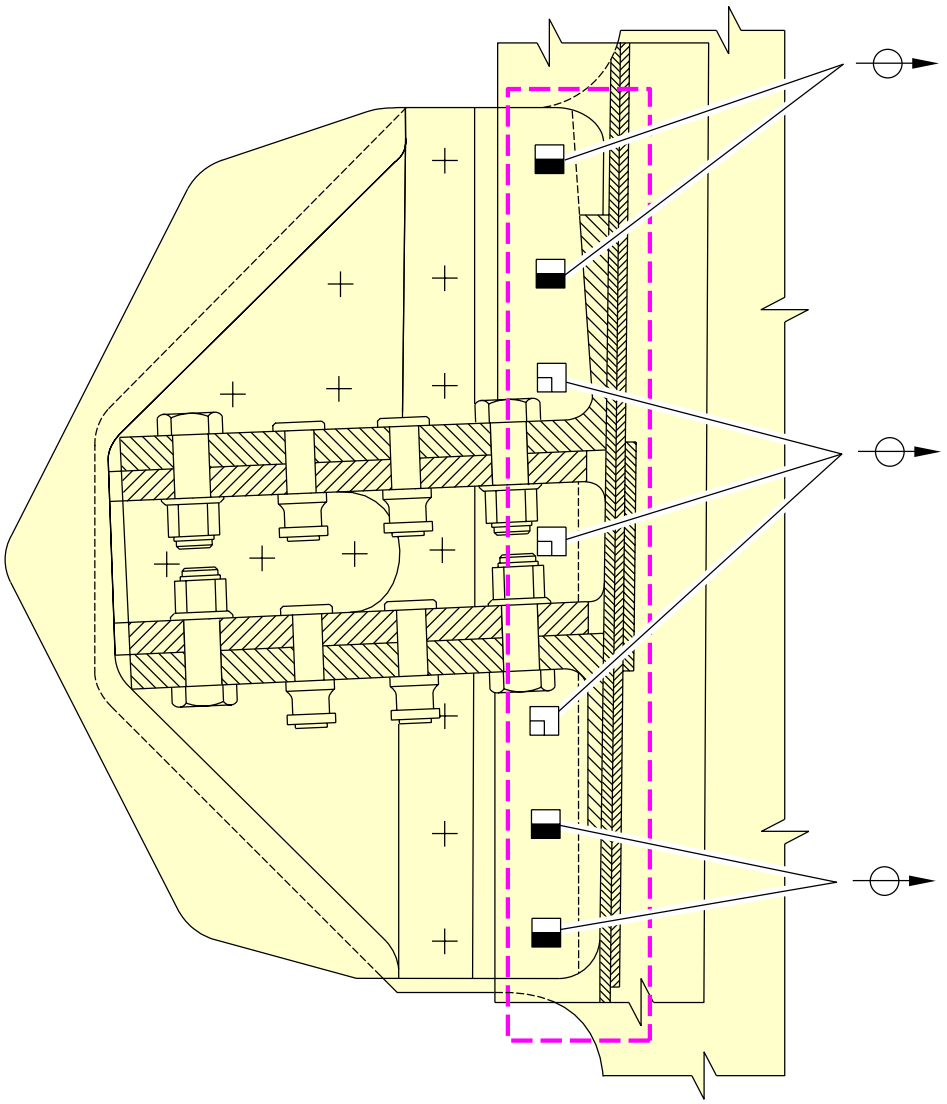


A_SB_550044_6_BPAA_03_00

Figure A-GBPAA - Sheet 03
Cold expansion

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D 01

VIEW LOOKING OUTBOARD

FWD

NOTE:

FASTENER SYMBOL, REFER TO SHEET 06

01 VALID FOR BR2, BR3 AND BR4

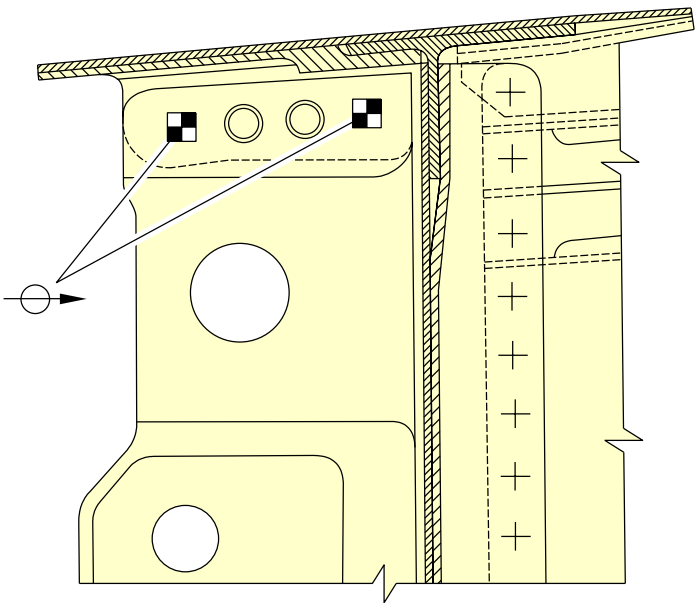
POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

A_SB_550044_6_BPAA_04_00

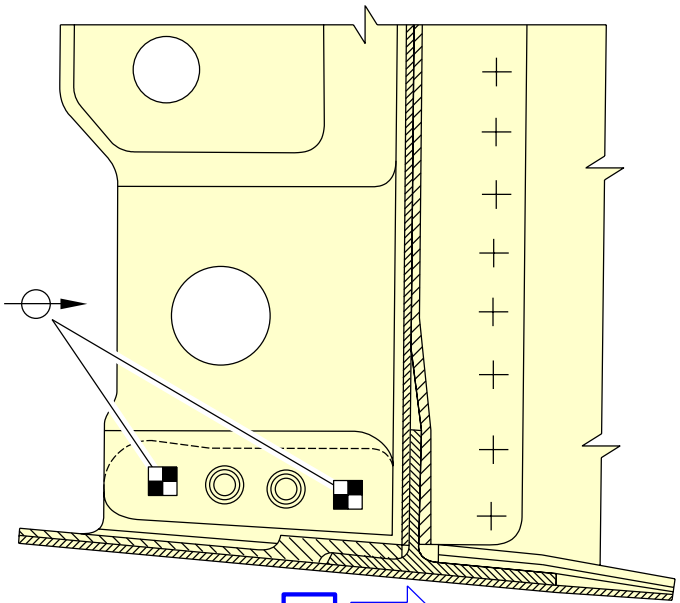
Figure A-GBPAA - Sheet 04
Cold expansion

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****CONF ALL**



VIEW LOOKING DOWN



VIEW LOOKING UP

NOTE:

FASTENER SYMBOL, REFER TO SHEET 06

01 VALID FOR BR2, BR3 AND BR4

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

A_SB_550044_6_BPAA_05_00

Figure A-GBPAA - Sheet 05
Cold expansion

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HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
⬓	(40)	40	DAN8–8–7	BOLT	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2280 in)	6.310 mm (0.2484 in)	6.350 mm (0.2500 in)	NOMINAL SIZE TRANSITION FIT	02 03
	(51)	51	DAN12–8	NUT							
⬔	(34)	34	NSA5042–05–156	BOLT	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2280 in)	6.310 mm (0.2484 in)	6.350 mm (0.2500 in)	NOMINAL SIZE TRANSITION FIT	02 03
	(35)	35	NAS679C4M	NUT							
◱	(52)	52	LN9199–6400CF	RIVET	6–3–N	5.720 mm (0.2252 in)	5.790 mm (0.2280 in)	6.310 mm (0.2484 in)	6.350 mm (0.2500 in)	NOMINAL SIZE TRANSITION FIT	02 03 04
+	EXISTING FASTENER										

NOTE:

02 WET INSTALLED WITH SEALANT (MAT.NO.06AAC1)

03 REFER TO SRM 51–30–47

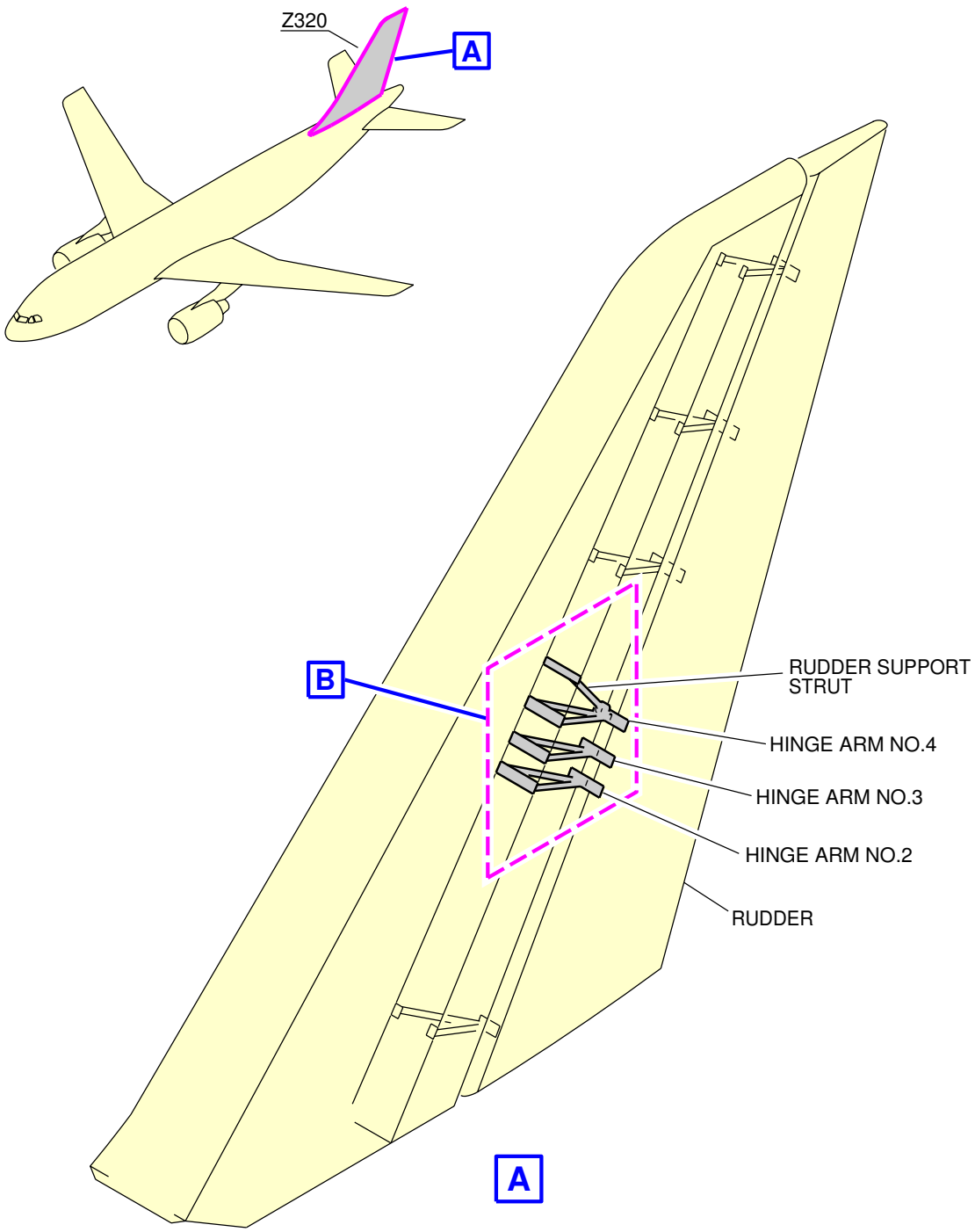
04 REFER TO SRM 51–30–40

A_SB_550044_6_BPAA_06_00

Figure A-GBPAA - Sheet 06
Cold expansion

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A_SB_550044_6_BRAA_01_00

Figure A-GBRAA - Sheet 01
Cold expansion

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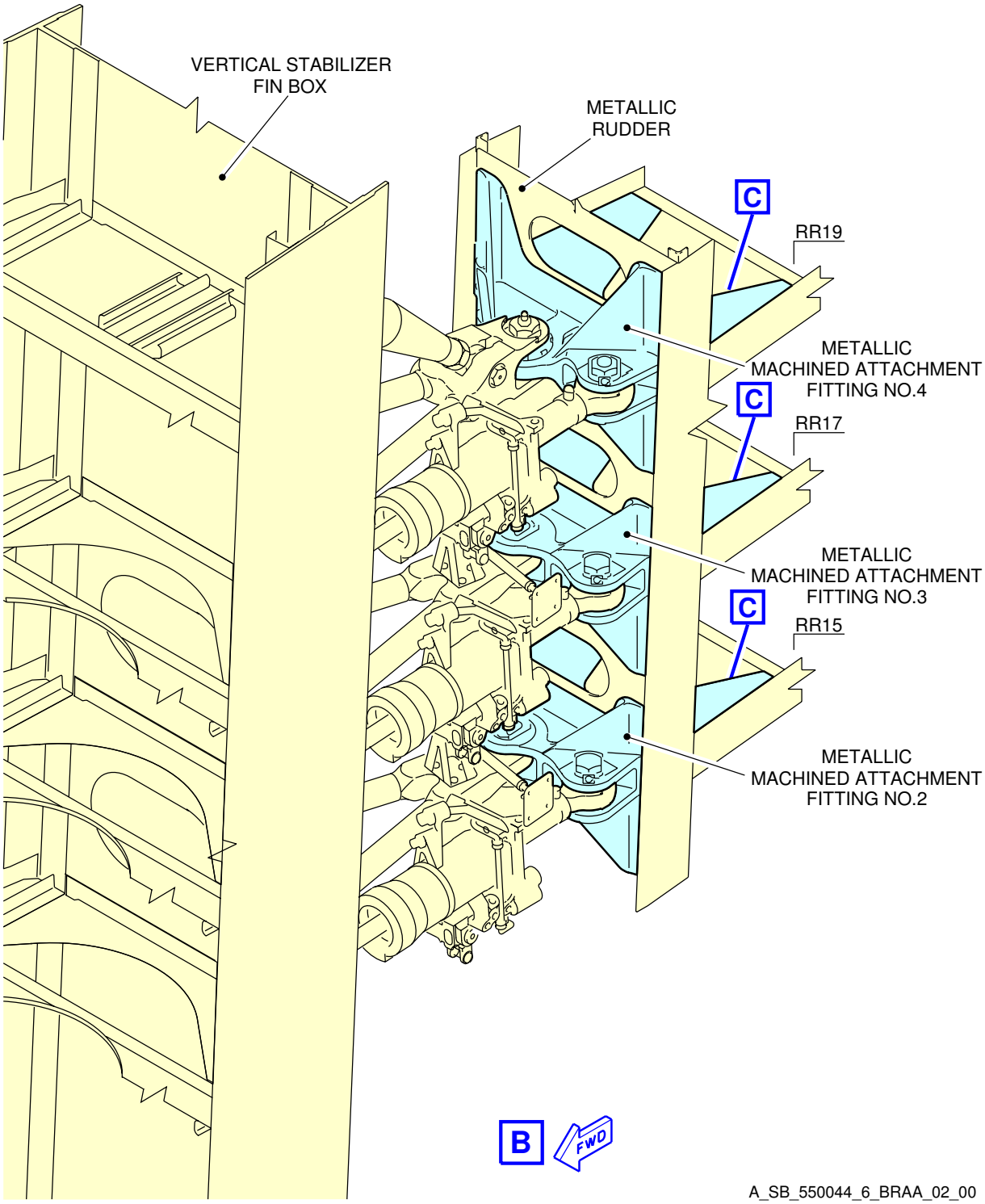
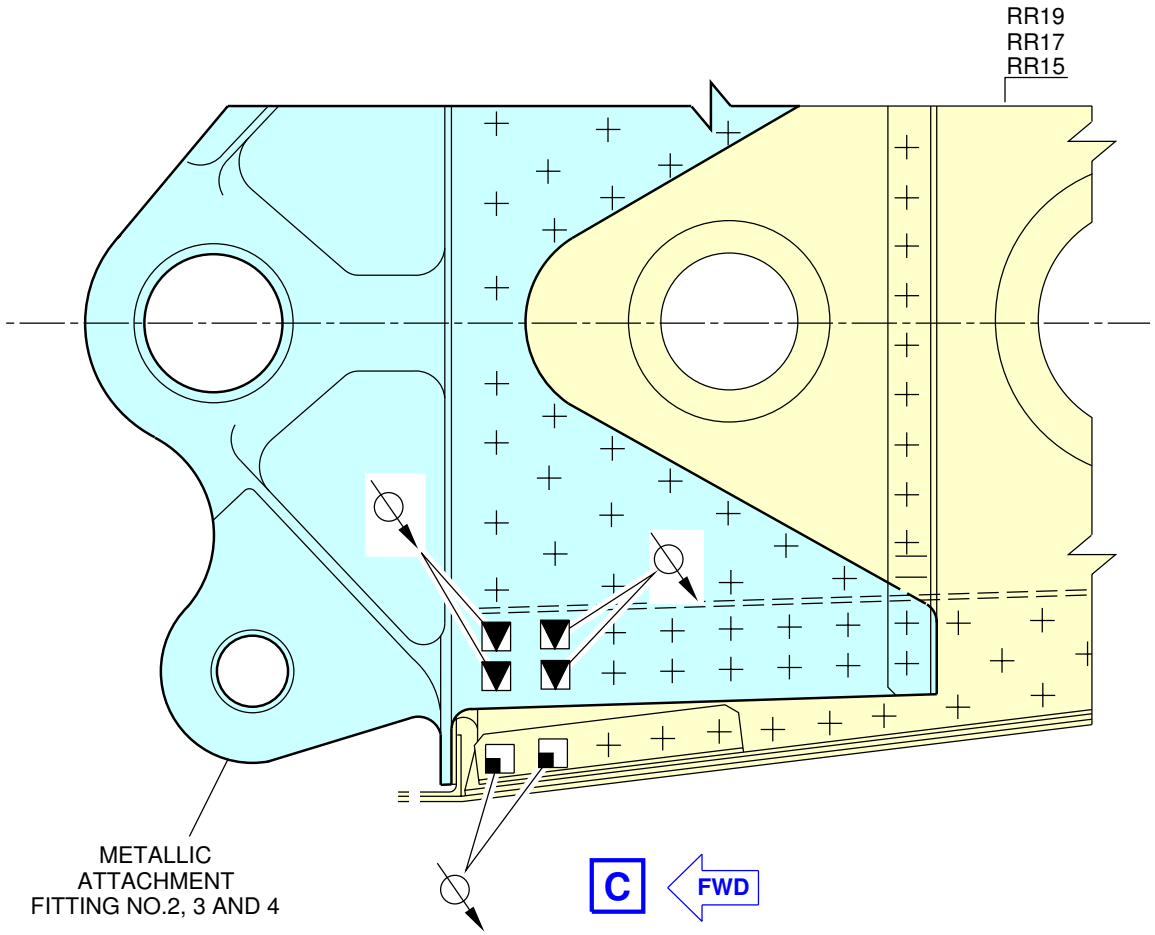


Figure A-GBRAA - Sheet 02
Cold expansion

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NOTE:

FOR FASTENER SYMBOLS, REFER TO SHEET 04

POSITION OF SPLIT IN EXPANSION
DURING COLD EXPANSION

A_SB_550044_6_BRAA_03_00

Figure A-GBRAA - Sheet 03
Cold expansion

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HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
▼	(41)	41	DAN5–6–8	BOLT	6–0–N	4.500 mm (0.1772 in)	4.570 mm (0.1779 in)	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT	02 03
	(50)	50	DAN12–6	NUT							
◪	(42)	42	LN9198–48	RIVET	6–0–N	4.500 mm (0.1772 in)	4.570 mm (0.1779 in)	4.780 mm (0.1882 in)	4.821 mm (0.1898 in)	NOMINAL SIZE TRANSITION FIT	02 03 04

NOTE:
02 WET INSTALLED WITH SEALANT (MAT.NO.06AAC1)
03 REFER TO SRM 51–30–47
04 REFER TO SRM 51–30–40

A_SB_550044_6_BRAA_04_01

Figure A-GBRAA - Sheet 04
Cold expansion

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TITLE: STABILIZERS - VERTICAL STABILIZERS AND RUDDER - INSPECT THE RUDDER SERVO ACTUATOR ATTACHMENT-STRUCTURE FOR DAMAGE DUE TO SERVO DE-SYNCHRONIZATION

MODIFICATION No.: None

SB Reporting status

This Service Bulletin will only be incorporated into affected customized Maintenance and Flight Operations Products if it is duly reported to Airbus.

General information

The SB Reporting policy is published in ISI 00.00.00135. This document provides information regarding: the SB Reporting means and benefits, the update of customized Maintenance Products and customized Flight Operations Products.

If this Service Bulletin has an operational impact, refer to paragraph "Flight Operations Products" for further information on the update of affected Flight Operations Products.

SB Reporting procedure

Standard practice to report SB is to use the online reporting application on AirbusWorld.

Refer to ISI 00.00.00179:
- For complete information on reporting means to Airbus. Question 2 "What are the standard practices for SB reporting?"
- If this SB requires previous or simultaneous accomplishment of other SBs, Question 3 "What about the reporting of prerequisite Service Bulletin?"

NOTE: ISI 00.00.00179 covers all the frequently asked questions about SB Reporting. It is revised on a regular basis.

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QUALITY PERCEPTION FORM

Use this form to tell us what is your perception of the quality of this Service Bulletin. The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletins.
We thank you for the time you have taken in completing this form.

(Please rate on a scale of 1 to 4, with 4 being the highest score)

- Quality rating of this SB	4	3	2	1
- Quality rating of the Accomplishment Instructions	4	3	2	1
- Quality rating of the Illustrations	4	3	2	1
- Is this SB easy to understand ?	Y / N			

If you have had difficulties in the accomplishment of this SB please quote below the area(s) and give a short description of the issue.

	Planning		Material		Instructions
X	Effectivity	X	Kit content	X	Preparation
X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Industry support	X	Test
X	References	X	Re-identification	X	Close-Up
X	Publication	X	Tooling	X	Illustrations

Comments:

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