AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
FRANCE
Tel : (33) 5 61 93 33 33
Telex : AIRBU 530526F
Fax : (33) 5 61 93 42 51

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

ATA SYSTEM: 53

TITLE: FUSELAGE - REAR FUSELAGE - REMOVE TSA IN THE FINAL HOLES OF S17 BULK CARGO DOOR FRAME C67 AND C69

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	None				
MINOR	206409D52230				

NOTE: As per EASA IR 21, a minor change is one that has no appreciable effect on the mass, balance, structural strength, reliability, operational characteristics affecting the airworthiness of the product. All other changes are major changes.

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

During A330 Extended Service Goal (ESG) justification, fatigue analysis of bulk cargo door frames shows some thresholds below Design Service Goal (DSG) values.

It has been identified that Tartaric Sulfuric Anodizing (TSA) / Chromic Acid Anodizing (CAA) surface treatment is present in the door fittings attachment holes of FR67 and FR69 of the lower side shell RH in Section 17. This leads to a detrimental effect on fatigue behavior.

This condition, if not detected and corrected, could lead to critical cracks in the primary structure.

This Service Bulletin details the necessary instructions to remove the TSA in the final holes of the bulk door frames FR67 and FR69.

The accomplishment of this Service Bulletin will contribute to maintain the structural integrity in the frames of the bulk cargo door.

Accomplishment of this Service Bulletin cancels the requirements of Inspection Service Bulletin (ISB) No. A330-53-3278.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	RECOMMENDED (1)	CANCELS INSPECTION SB	YES
POTENTIAL AD	NO	A/C OPERATION AFFECTED	NO

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EVALUATION TABLE			
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	YES	VENDOR SB INVOLVED	NO

NOTE (1): Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533275D01R03	1	5,100.00	Bushes, bolts, nuts, collars, washers, tape
Component COMPD01	1	See SB	Rivets
Standard tool TOOLD01	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD02	1	See SB	WCI tooling for cold expansion

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533275D01R03	1	5,100.00	Bushes, bolts, nuts, collars, washers, tape
Component COMPD01	1	See SB	Rivets
Standard tool TOOLD01	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD02	1	See SB	WCI tooling for cold expansion

EFFECTIVITY

****CONF ALL**

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

18P	38W	41N	43P	56O	64N	83V	96U	98W	AAL	AAR	AAW	ACA
ACI	AEA	AFL	AFR	AIB	ALD	ALK	ARA	ARG	ASL	ASY	AVA	AZA
AZU	BEC	BEL	BER	BGH	CAL	CBJ	CCA	CEB	CES	CHH	CPA	CRK
CRL	CSA	CSC	CSN	DAH	DAL	DGA	DLH	EDW	EIN	ETD	EVA	EVE
F2I	FBU	FIN	FJI	FWI	GCR	GFA	GIA	GRL	HAL	HDA	HFY	HKC
HVN	IAW	IBE	IRA	JAI	JAV	KAC	KAL	KLM	LAA	LNI	MAS	MAU
MEA	MLM	MNB	MOV	MSR	NMB	NWS	OBS	OHY	OMA	ONE	PAL	PLM
QAF	QFA	QTR	RJA	RSF	RSY	RWD	RZO	SAA	SAF	SAI	SAS	SEY
SIA	SVA	SWR	SXD	TAE	TAM	TAP	TAR	TBA	TCX	THA	THY	TNA
TOW	TPA	TSC	U6A	UAE	UAF	VIR	VKG	VOZ	WOW	WRC	XAX	XLF

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CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

TFU	53.40.00.005
OEB	None
AOT	None
SIL	None
ISI	51.48.00001
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None
OTHER	None

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

****CONF 001**

Task 533275-831-848-001: Modification	
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

****CONF 002**

Task 533275-831-848-001: Modification	
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

APPENDICES

****CONF ALL**

Appendix 01 - Manpower Gantt Chart

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**CONF ALL

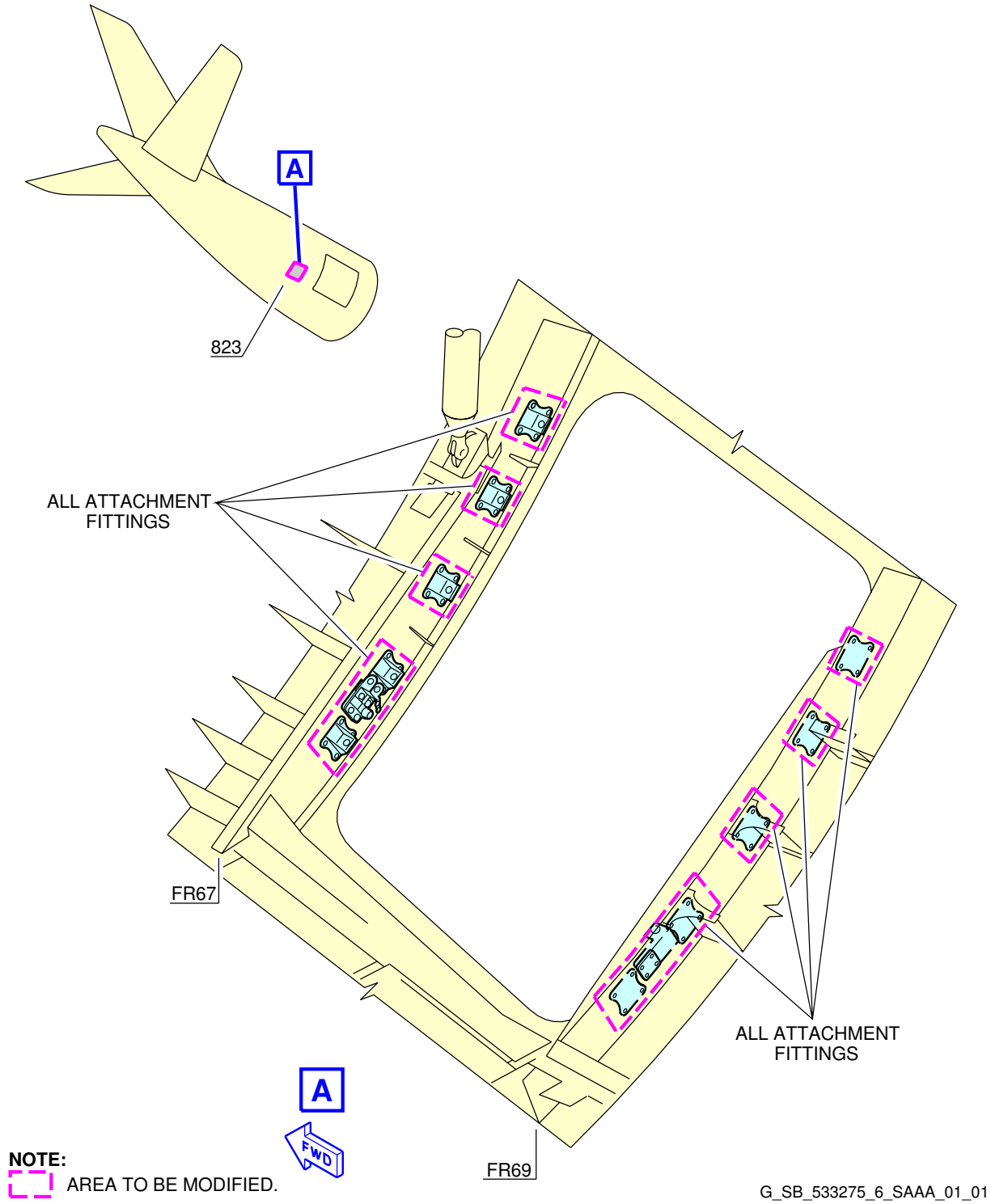


Figure A-GSAAA - Sheet 01

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ATA SYSTEM: 53

TITLE: FUSELAGE - REAR FUSELAGE - REMOVE TSA IN THE FINAL HOLES OF S17 BULK CARGO DOOR FRAME C67 AND C69

MODIFICATION No.: 206409D52230

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: The intent of this modification is achieved in production on aircraft with Manufacturer Serial Number (MSN) 1824 and subsequent through modification No. 206221/D52229.

(1) Models

330-202 330-203 330-223 330-223F 330-243 330-243F 330-301 330-302
330-303 330-321 330-322 330-323 330-341 330-342 330-343

(2) Effectivity by MSN

0012 0017 0030 0037 0045 0050 0054-0055 0060 0062 0065 0070-0072 0082-0083
0086-0087 0095-0096 0098-0099 0102 0106 0109 0111-0113 0116 0118 0120-0122
0127 0132 0138 0140 0143-0144 0148 0153 0155 0162 0165 0171-0172 0177 0181
0195 0200 0206 0209 0211 0219 0222-0224 0226 0229-0232 0234 0238 0240-0241
0244 0247-0251 0253-0256 0258-0259 0261-0262 0265-0267 0269 0271-0272
0275-0277 0279 0281 0283-0288 0290-0291 0293 0295-0296 0300-0301 0303
0305-0306 0308-0309 0311-0317 0320 0322-0324 0326 0328 0330 0333-0334
0337-0340 0342-0346 0348-0351 0353 0356-0358 0361-0362 0364-0366 0368-0370
0372 0375 0380 0382 0384 0386 0388-0389 0392-0393 0396-0398 0400-0401
0403-0405 0407-0409 0412 0418-0423 0425 0427-0428 0432 0437 0439 0441

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0443-0444 0448 0451-0452 0454-0456 0458 0461-0463 0465-0466 0469 0472-0473
0476-0477 0479-0481 0484 0486-0487 0489-0491 0493-0494 0496-0498 0500-0513
0515-0516 0518-0519 0521-0522 0524-0527 0529-0530 0532-0533 0535-0536 0539
0542 0548-0553 0555 0558 0564-0565 0567-0568 0570-0571 0573-0574 0576
0578-0579 0581 0584 0587-0588 0591 0593 0595 0597 0600 0602-0603 0605 0607
0609-0610 0612 0614 0616 0618 0620-0621 0623 0625 0627 0629 0631-0638
0640-0642 0644-0645 0647-0650 0652-0659 0661-0667 0669-0671 0673-0676
0678-0680 0682-0684 0686-0688 0690-0693 0695-0697 0699-0701 0703-0705
0707-0709 0711-0714 0716-0718 0720-0722 0724-0726 0728-0730 0732-0735
0737-0739 0741-0743 0745-0747 0749-0752 0754-0756 0758-0760 0769-0770
0772-0774 0776-0778 0780-0782 0784-0786 0788-0789 0791-0792 0795-0797 0799
0801-0803 0805-0807 0809-0811 0813-0815 0817-0828 0830-0834 0836 0838-0843
0845 0847 0849-0855 0857-0863 0865-0869 0871 0873-0877 0879 0881-0885
0887-0893 0895-0896 0898-0901 0903-0909 0911 0913-0916 0918-0920 0922-0923
0925-0928 0930-0932 0934-0937 0939-0952 0954 0956-0959 0961-0971 0973-0980
0982-0986 0988-0992 0994-0998 1000-1004 1006-1016 1018-1023 1025-1026
1028-1029 1031-1039 1041-1049 1051-1055 1057-1063 1065-1067 1069-1078
1080-1082 1084-1090 1092-1101 1103-1108 1110 1112 1114-1116 1118 1120
1123-1124 1126-1127 1129-1133 1135-1138 1141 1143 1145-1151 1153 1155-1157
1159-1161 1163-1165 1167-1175 1177-1178 1180-1181 1183-1184 1186-1193
1195-1196 1198-1206 1208-1241 1243-1252 1254-1256 1258-1272 1274-1423
1425-1521 1523-1651 1653-1660 1662-1681 1684-1701 1703-1704 1706 1708-1716
1718-1779

(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
18P	1321
38W	0401
41N	1676
43P	1053
56O	0116 0127
64N	1751
83V	0171
96U	0396
98W	0054
AAL	0315 0323 0333 0337 0342 0370 0375 0380 0388 1011 1022 1041 1069 1076 1095 1100 1415 1417 1441 1455 1480 1502 1512 1526
AAR	0640 0676 0708 0772 0803 0845 1001 1055 1151 1211 1326 1340 1435 1464 1518
AAW	1043 1472 1535
ACA	0277 0279 0284 0344 0400 0408 0412 0419
ACI	0507 0510
AEA	0461 0505 0526 0733 0745 0749 0814 0931 0950 0992 1097 1574
AFL	0963 0973 1014 1045 1047 1058 1065 1072 1077 1103 1232 1247 1264 1270 1284 1299 1301 1323 1328 1345 1356 1371

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OPERATOR	MSN
AFR	0422 0443 0448 0458 0465 0481 0498 0500 0502 0503 0516 0519 0567 0584 0657
AIB	0871
ALD	0326 0328 0392
ALK	0303 0306 0311 0313 0456 0627 1564 1583 1604 1650 1669 1687 1689
ARA	0891 0927
ARG	0290 0300 0358 0364 0587 0634 1605 1623 1737 1748
ASL	0885
ASY	0747 0892 0898 0951 0969 1036 1183
AVA	1009 1016 1073 1208 1224 1279 1342 1400 1492
AZA	0272 0339 0463 0825 0831 1123 1135 1218 1225 1252 1283 1308 1313 1327 1354
AZU	0365 0372 0462 0494 0527 0529 0532
BEC	0863
BEL	0030 0037 0045 0082 0095 0229 0249 0291 0324 1085
BER	0288 0322 0403 0432 0444 0454 0469 0476 0493 0665 0739 0802 0822 0828 0911 0968 1112
BGH	0255
CAL	0602 0607 0641 0671 0675 0691 0699 0707 0714 0725 0752 0769 0805 0823 0838 0861 0920 1177 1272 1278 1346 1367 1450 1539
CBJ	0988 1020 1028 1052 1753 1763 1775
CCA	0750 0756 0759 0780 0785 0797 0810 0815 0839 0860 0867 0873 0884 0890 0903 0909 0930 0941 0944 0957 1087 1110 1130 1187 1199 1216 1237 1260 1282 1304 1330 1333 1353 1373 1383 1396 1413 1434 1444 1459 1471 1493 1509 1525 1538 1541 1563 1570 1587 1658 1673 1685 1695 1752 1765
CEB	1420 1445 1495 1527 1552 1602 1712
CES	0713 0720 0728 0732 0735 0773 0777 0781 0782 0791 0821 0830 0836 0851 0862 0866 0916 0928 0936 0942 1262 1267 1280 1291 1303 1324 1331 1372 1375 1402 1421 1429 1440 1461 1468 1479 1484 1500 1520 1537 1547 1551 1569 1588 1595 1603 1617 1632 1639 1655 1664
CHH	0875 0881 0906 0982 1159 1168 1178 1190 1255 1325 1438 1532 1558 1573 1591 1614 1634 1656 1663 1677 1686 1703
CPA	0102 0113 0121 0386 0389 0393 0418 0420 0421 0423 0439 0539 0548 0565 0679 0776 0850 0855 0895 0915 0959 1163 1196 1222 1239 1285 1317 1343 1349 1362 1366 1387 1409 1436 1443 1567 1618 1621
CRK	1031 1034 1039 1042 1051 1054 1059 1062 1099 1105 1107 1115 1124 1146 1157 1175 1277 1286 1322 1358 1369 1384 1398 1668
CRL	0285 0320 1359 1376
CSA	0425
CSC	1082 1138 1241 1397 1432 1528 1579 1662 1746
CSN	0649 0652 0656 0664 0818 0840 0879 0889 0908 0935 0937 0954 0958 0964 1096 1116 1129 1202 1220 1233 1244 1297 1309 1335 1392 1425 1430 1494 1519 1536 1575 1593 1625 1636 1645 1699 1714 1760 1776

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OPERATOR	MSN
DAH	0644 0647 0650 0653 0667 1613 1630 1649
DAL	0524 0533 0542 0549 0552 0578 0588 0591 0609 0614 0618 0620 0621 0631 0633 0663 0674 0690 0718 0722 0778 0784 0796 0799 0806 0817 0827 0843 0857 0858 0859 0865 1627 1628 1637 1679 1701 1716 1720 1721 1769
DGA	0240 1735
DLH	0570 0576 0579 0629 0636 0642 0645 0648 0687 0701 0896 0905 0913 0922 0989 1292 1305 1314 1497
EDW	1193 1711
EIN	0269 0330 0397 0841 0847 0985 1025 1106 1742 1744
ETD	0658 0688 0717 0724 0729 0730 0737 0788 0809 0824 0832 0852 0854 0868 0975 0991 1032 1070 1071 1081 1167 1205 1226 1245 1414 1486 1521 1524 1772
EVA	0661 0678 0693 0755 1254 1268 1274 1684 1690 1767 1778
EVE	0670 1691
F2I	0055 0070 0072 0087 0200
FBU	1727
FIN	0994 1007 1013 1023 1067 1078 1088 1173
FJI	1394 1416 1465 1692
FWI	0253 0343 0758 0965 1021 1265
GCR	0919 1756 1758 1773
GFA	0276 0281 0286 0287 0334 0340
GIA	0138 0140 0144 0148 0153 0165 1184 1214 1261 1288 1364 1410 1446 1474 1548 1560 1577 1585 1654 1671 1698 1709 1723 1733
GRL	0230
HAL	1104 1114 1171 1217 1259 1295 1302 1310 1316 1389 1399 1404 1422 1469 1488 1496 1511 1530 1565 1606 1615 1672 1732
HDA	0012 0017 0071 0083 0099 0106 0109 0118 0155 0234 0244 0405 0479 0512 0581 0669 0673 1457 1503 1523 1545 1557 1598
HFY	0211 0262 1008
HKC	1320
HVN	0275 0366 0943 0946 0962 1019 1256 1266
IAW	1339
IBE	1377 1385 1405 1426 1437 1490 1507 1515 1694 1700 1710 1719 1728 1736 1740 1747 1755 1761 1777
IRA	1540 1586
JAI	0888 0923 0947 0956 1351 1361 1370 1391
JAV	0409
KAC	1626 1643 1653 1678 1681
KAL	0162 0172 0206 0219 0222 0226 0241 0256 0258 0267 0338 0350 0351 0368 0428 0484 0490 0550 1133 1155 1200 1203 1393 1556 1576 1590 1611 1638 1647
KLM	0682 0686 0703 0738 0770 0801 0925 1161 1287 1294 1300 1381 1580
LAA	1412 1505 1543
LNI	1675 1680 1693

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OPERATOR	MSN
MAS	1136 1148 1180 1209 1219 1229 1234 1243 1281 1318 1336 1337 1347 1388 1395 1431 1470 1489
MAU	0883 1057
MEA	0926 0984 0995 0998 1725
MLM	0451
MNB	1332
MOV	0535 0655
MSR	0600 0610 0666 0683 0696 0709 0726 1143 1230 1238 1246
NMB	1451 1466
NWS	1213 1221
OBS	0833
OHY	0098 0316 0345 0353 0362 0404 0437 0625 0632
OMA	1038 1044 1049 1063 1093 1120 1227 1572 1582 1599
ONE	1506 1508 1608 1657
PAL	1449 1456 1460 1463 1467 1475 1482 1504 1510 1531 1546 1553 1559 1566 1568
PLM	0261 0265 0551
QAF	0487 0605
QFA	0506 0508 0513 0522 0553 0558 0564 0574 0593 0595 0603 0695 0705 0712 0842 0853 0887 0940 0945 0976 1061 1094 1169 1174 1198 1251 1258 1365
QTR	0441 0473 0489 0511 0521 0571 0623 0637 0638 0659 0680 0711 0721 0734 0743 0746 0760 0789 0792 0813 0820 0826 0849 0893 0907 0918 1350 1386 1406 1578 1584 1594 1688 1708
RJA	0979 1002 1164
RSF	0980 0996 1235 1379 1478 1516
RSY	0096 0120 0283 0293 0295
RWD	1741 1759
RZO	0970
SAA	1191 1210 1223 1236 1249 1271 1745 1754 1757 1779
SAF	1667 1762
SAI	0086 0811 0819 0834 0900
SAS	0496 0497 0515 0568 1660 1665 1697 1715
SEY	0751 0807
SIA	0978 0983 0986 1010 1015 1132 1149 1156 1382 1401 1427 1447 1453 1477 1485 1517 1544 1562 1597 1609 1633 1648 1666
SVA	1108 1127 1137 1141 1147 1153 1189 1192 1454 1462 1473 1513 1724 1726 1729 1731 1734 1738 1739 1743 1749 1764 1766 1770 1774
SWR	1000 1018 1026 1029 1084 1089 1101 1145 1181 1188 1276 1290 1355 1403
SXD	0530 0555 0573 0612 0616 0684
TAE	0348
TAM	0232 0238 0247 0259 0361 0466 0472 0700
TAP	0181 0195 0223 0305 0308 0312 0317 0477 0486 0877 0899 0904 0914 0934 0997 1006 1012
TAR	1631 1641

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OPERATOR	MSN
TBA	1730 1771
TCX	0254 0266 0301 0398 0948 0967
THA	0050 0060 0062 0112 0122 0209 0231 0346 0990 1003 1035 1037 1060 1074 1086 1090 1263 1269 1289 1338 1348 1374 1408
THY	0504 0697 0704 0742 0754 0774 0869 0874 0876 0882 0901 0932 0939 0949 0961 0977 1004 1092 1118 1150 1160 1170 1172 1204 1212 1228 1240 1298 1307 1311 1344 1418 1442 1458 1476 1483 1487 1491 1499 1501 1514 1529 1542 1550 1554 1571 1592 1616 1620 1622 1629 1635 1640 1642 1644 1651 1696 1704 1706 1713 1718 1722 1750 1768
TNA	1357 1378
TOW	1033 1046 1248 1275 1312 1334 1363 1390 1419 1439 1498 1555 1601 1610
TPA	1368 1380 1428 1448 1534
TSC	0111 0132 0177 0248 0250 0251 0271 0314 0369 0407 0427 0455 0480 0518 0536 0795 0966 0971
U6A	0065 0143 0224
UAE	0382 0384 0452 0491 0509 0525
UAF	1080 1186 1250
VIR	1195 1201 1206 1215 1231 1296 1315 1329 1341 1352
VKG	0309 0349 0356 0357
VOZ	1293 1306 1319 1407 1452 1561
WOW	1098 1607 1624
WRC	0296
XAX	0654 0662 0692 0716 0741 0786 0952 0974 1048 1066 1075 1126 1131 1165 1411 1423 1433 1481 1533 1549 1581 1589 1596 1600 1612 1619 1646 1659 1670 1674
XLF	0501 0597 0635 1360

(4) Configuration by MSN

MSN	CONFIGURATION
0012 0017 0030 0037 0045 0050 0054 0055 0060 0062 0065 0070 0071 0072 0082 0083 0086 0087 0095 0096 0098 0099 0102 0106 0109 0111 0112 0113 0116 0118 0120 0121 0122 0127 0132 0138 0140 0143 0144 0148 0153 0155 0162 0165 0171 0172 0177 0200 0206 0209 0219 0224 0231 0234 0241 0244 1004 1032 1051 1062 1070 1092 1115 1136 1148 1164 1175 1180 1320 1332 1344 1350 1368 1380 1386 1406 1414 1418 1428 1442 1448 1506 1524 1534 1550 1578 1584 1594 1688 1708 1722 1750 1768 1772	002

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MSN	CONFIGURATION
0181 0195 0211 0222 0223 0226 0229 0230 0232 0238 0240 0247 0248 0249 0250 0251 0253 0254 0255 0256 0258 0259 0261 0262 0265 0266 0267 0269 0271 0272 0275 0276 0277 0279 0281 0283 0284 0285 0286 0287 0288 0290 0291 0293 0295 0296 0300 0301 0303 0305 0306 0308 0309 0311 0312 0313 0314 0315 0316 0317 0320 0322 0323 0324 0326 0328 0330 0333 0334 0337 0338 0339 0340 0342 0343 0344 0345 0346 0348 0349 0350 0351 0353 0356 0357 0358 0361 0362 0364 0365 0366 0368 0369 0370 0372 0375 0380 0382 0384 0386 0388 0389 0392 0393 0396 0397 0398 0400 0401 0403 0404 0405 0407 0408 0409 0412 0418 0419 0420 0421 0422 0423 0425 0427 0428 0432 0437 0439 0441 0443 0444 0448 0451 0452 0454 0455 0456 0458 0461 0462 0463 0465 0466 0469 0472 0473 0476 0477 0479 0480 0481 0484 0486 0487 0489 0490 0491 0493 0494 0496 0497 0498 0500 0501 0502 0503 0504 0505 0506 0507 0508 0509 0510 0511 0512 0513 0515 0516 0518 0519 0521 0522 0524 0525 0526 0527 0529 0530 0532 0533 0535 0536 0539 0542 0548 0549 0550 0551 0552 0553 0555 0558 0564 0565 0567 0568 0570 0571 0573 0574 0576 0578 0579 0581 0584 0587 0588 0591 0593 0595 0597 0600 0602 0603 0605 0607 0609 0610 0612 0614 0616 0618 0620 0621 0623 0625 0627 0629 0631 0632 0633 0634 0635 0636 0637 0638 0640 0641 0642 0644 0645 0647 0648 0649 0650 0652 0653 0654 0655 0656 0657 0658 0659 0661 0662 0663 0664 0665 0666 0667 0669 0670 0671 0673 0674 0675 0676 0678 0679 0680 0682 0683 0684 0686 0687 0688 0690 0691 0692 0693 0695 0696 0697 0699 0700 0701 0703 0704 0705 0707 0708 0709 0711 0712 0713 0714 0716 0717 0718 0720 0721 0722 0724 0725 0726 0728 0729 0730 0732 0733 0734 0735 0737 0738 0739 0741 0742 0743 0745 0746 0747 0749 0750 0751 0752 0754 0755 0756 0758 0759 0760 0769 0770 0772 0773 0774 0776 0777 0778 0780 0781 0782 0784 0785 0786 0788 0789 0791 0792 0795 0796 0797 0799 0801 0802 0803 0805 0806 0807 0809 0810 0811 0813 0814 0815 0817 0818 0819 0820 0821 0822 0823 0824 0825 0826 0827 0828 0830 0831 0832 0833 0834 0836 0838 0839 0840 0841 0842 0843 0845 0847 0849 0850 0851 0852 0853 0854 0855 0857 0858 0859 0860 0861 0862 0863 0865 0866 0867 0868 0869 0871 0873 0874 0875 0876 0877 0879 0881 0882 0883 0884 0885 0887 0888 0889 0890 0891 0892 0893 0895 0896 0898 0899 0900 0901 0903 0904 0905 0906 0907 0908 0909 0911 0913 0914 0915 0916 0918 0919 0920 0922 0923 0925 0926 0927 0928 0930 0931 0932 0934 0935 0936 0937 0939 0940 0941 0942 0943 0944 0945 0946 0947 0948 0949 0950 0951 0952 0954 0956 0957 0958 0959 0961 0962 0963 0964 0965 0966 0967 0968 0969 0970 0971 0973 0974 0975 0976 0977 0978 0979 0980 0982 0983 0984 0985 0986 0988 0989 0990 0991 0992 0994 0995 0996 0997 0998 1000 1001 1002 1003 1006 1007 1008 1009 1010 1011 1012 1013 1014	001

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MSN	CONFIGURATION
1015 1016 1018 1019 1020 1021 1022 1023 1025 1026 1028 1029 1031 1033 1034 1035 1036 1037 1038 1039 1041 1042 1043 1044 1045 1046 1047 1048 1049 1052 1053 1054 1055 1057 1058 1059 1060 1061 1063 1065 1066 1067 1069 1071 1072 1073 1074 1075 1076 1077 1078 1080 1081 1082 1084 1085 1086 1087 1088 1089 1090 1093 1094 1095 1096 1097 1098 1099 1100 1101 1103 1104 1105 1106 1107 1108 1110 1112 1114 1116 1118 1120 1123 1124 1126 1127 1129 1130 1131 1132 1133 1135 1137 1138 1141 1143 1145 1146 1147 1149 1150 1151 1153 1155 1156 1157 1159 1160 1161 1163 1165 1167 1168 1169 1170 1171 1172 1173 1174 1177 1178 1181 1183 1184 1186 1187 1188 1189 1190 1191 1192 1193 1195 1196 1198 1199 1200 1201 1202 1203 1204 1205 1206 1208 1209 1210 1211 1212 1213 1214 1215 1216 1217 1218 1219 1220 1221 1222 1223 1224 1225 1226 1227 1228 1229 1230 1231 1232 1233 1234 1235 1236 1237 1238 1239 1240 1241 1243 1244 1245 1246 1247 1248 1249 1250 1251 1252 1254 1255 1256 1258 1259 1260 1261 1262 1263 1264 1265 1266 1267 1268 1269 1270 1271 1272 1274 1275 1276 1277 1278 1279 1280 1281 1282 1283 1284 1285 1286 1287 1288 1289 1290 1291 1292 1293 1294 1295 1296 1297 1298 1299 1300 1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312 1313 1314 1315 1316 1317 1318 1319 1321 1322 1323 1324 1325 1326 1327 1328 1329 1330 1331 1333 1334 1335 1336 1337 1338 1339 1340 1341 1342 1343 1345 1346 1347 1348 1349 1351 1352 1353 1354 1355 1356 1357 1358 1359 1360 1361 1362 1363 1364 1365 1366 1367 1369 1370 1371 1372 1373 1374 1375 1376 1377 1378 1379 1381 1382 1383 1384 1385 1387 1388 1389 1390 1391 1392 1393 1394 1395 1396 1397 1398 1399 1400 1401 1402 1403 1404 1405 1407 1408 1409 1410 1411 1412 1413 1415 1416 1417 1419 1420 1421 1422 1423 1425 1426 1427 1429 1430 1431 1432 1433 1434 1435 1436 1437 1438 1439 1440 1441 1443 1444 1445 1446 1447 1449 1450 1451 1452 1453 1454 1455 1456 1457 1458 1459 1460 1461 1462 1463 1464 1465 1466 1467 1468 1469 1470 1471 1472 1473 1474 1475 1476 1477 1478 1479 1480 1481 1482 1483 1484 1485 1486 1487 1488 1489 1490 1491 1492 1493 1494 1495 1496 1497 1498 1499 1500 1501 1502 1503 1504 1505 1507 1508 1509 1510 1511 1512 1513 1514 1515 1516 1517 1518 1519 1520 1521 1523 1525 1526 1527 1528 1529 1530 1531 1532 1533 1535 1536 1537 1538 1539 1540 1541 1542 1543 1544 1545 1546 1547 1548 1549 1551 1552 1553 1554 1555 1556 1557 1558 1559 1560 1561 1562 1563 1564 1565 1566 1567 1568 1569 1570 1571 1572 1573 1574 1575 1576 1577 1579 1580 1581 1582 1583 1585 1586 1587 1588 1589 1590 1591 1592 1593 1595 1596 1597 1598 1599 1600 1601 1602 1603 1604 1605 1606 1607 1608 1609 1610 1611 1612 1613 1614 1615 1616 1617 1618 1619 1620 1621 1622 1623 1624 1625 1626 1627 1628 1629 1630 1631 1632 1633 1634 1635 1636 1637 1638 1639 1640 1641 1642 1643 1644 1645 1646 1647 1648 1649 1650 1651	001

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MSN	CONFIGURATION
1653 1654 1655 1656 1657 1658 1659 1660 1662 1663 1664 1665 1666 1667 1668 1669 1670 1671 1672 1673 1674 1675 1676 1677 1678 1679 1680 1681 1684 1685 1686 1687 1689 1690 1691 1692 1693 1694 1695 1696 1697 1698 1699 1700 1701 1703 1704 1706 1709 1710 1711 1712 1713 1714 1715 1716 1718 1719 1720 1721 1723 1724 1725 1726 1727 1728 1729 1730 1731 1732 1733 1734 1735 1736 1737 1738 1739 1740 1741 1742 1743 1744 1745 1746 1747 1748 1749 1751 1752 1753 1754 1755 1756 1757 1758 1759 1760 1761 1762 1763 1764 1765 1766 1767 1769 1770 1771 1773 1774 1775 1776 1777 1778 1779	001

(5) Configuration definition

**CONF 001
Config. 001 is valid for all the A330-200 (with center tank) and A330-300 aircraft given in the effectivity of this Service Bulletin as a standard configuration.

**CONF 002
Config. 002 is valid for all the A330-200 (without center tank) aircraft given in the effectivity of this Service Bulletin as a standard configuration.

(6) Material Effectivity

MATERIAL	QTY PER A/C	SEE NOTES
Kit 533275D01R03	1	
Component COMPD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	
Consumable CMLD01	1	
Reidentified part set REIDD01	1	
Reidentified part set REIDD02	1	

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

During A330 Extended Service Goal (ESG) justification, fatigue analysis of bulk cargo door frames shows some thresholds below Design Service Goal (DSG) values.

It has been identified that Tartaric Sulfuric Anodizing (TSA) / Chromic Acid Anodizing (CAA) surface treatment is present in the door fittings attachment holes of FR67 and FR69 of the lower side shell RH in Section 17. This leads to a detrimental effect on fatigue behavior.

This condition, if not detected and corrected, could lead to critical cracks in the primary structure.

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(2) Objective/Action

This Service Bulletin details the necessary instructions to remove the TSA in the final holes of the bulk door frames FR67 and FR69.

(3) Advantages

The accomplishment of this Service Bulletin will contribute to maintain the structural integrity in the frames of the bulk cargo door.

Accomplishment of this Service Bulletin cancels the requirements of Inspection Service Bulletin (ISB) No. A330-53-3278.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 533275-831-848-001: Modification

(1) Get Access at the Location of the Door Support Fitting-Upper FR67

(2) Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67

(3) Get Access at the Location of the Door Support Fitting-Upper FR69

(4) Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69

(5) Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67

(6) Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69

(7) Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)

(8) Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)

(9) Do the Installation of the Support and Spigot Assemblies at FR67

(10) Do the Installation of the Support and Spigot Assemblies at FR69

(11) Re-identify the Support Assembly and Serrated Plate on FR67

(12) Re-identify the Support Assembly on FR69

(13) Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69

(14) Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67

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(15) Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69

**CONF 002

Task 533275-831-848-001: Modification

(1) Get Access at the Location of the Door Support Fitting-Upper FR67

(2) Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67

(3) Get Access at the Location of the Door Support Fitting-Upper FR69

(4) Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69

(5) Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67

(6) Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69

(7) Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)

(8) Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)

(9) Do the Installation of the Support and Spigot Assemblies at FR67

(10) Do the Installation of the Support and Spigot Assemblies at FR69

(11) Re-identify the Support Assembly and Serrated Plate on FR67

(12) Re-identify the Support Assembly on FR69

(13) Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69

(14) Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67

(15) Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69

**CONF ALL

E. COMPLIANCE

(1) Classification

RECOMMENDED: Service Bulletin recommended to be accomplished to prevent significant operational disruptions.

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin is recommended at the earliest opportunity where manpower and facilities are available.

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F. APPROVAL

The technical content of this document is approved under the authority of 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.

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.

****CONF 001**

Task 533275-831-848-001: Modification	
Get Access	3.00
On Aircraft	
Get Access at the Location of the Door Support Fitting-Upper FR67	1.00
Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67	1.50
Get Access at the Location of the Door Support Fitting-Upper FR69	1.50
Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69	1.50
Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67	1.00
Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69	1.00
Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)	3.00
Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)	3.00
Do the Installation of the Support and Spigot Assemblies at FR67	3.00
Do the Installation of the Support and Spigot Assemblies at FR69	3.00
Re-identify the Support Assembly and Serrated Plate on FR67	0.50
Re-identify the Support Assembly on FR69	0.25
Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69	2.00

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Task 533275-831-848-001: Modification	
Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67	1.00
Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69	1.50
Tests	0.50
Close-Up	3.00
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAA given in Appendix 01 - Manpower Gantt Chart .

****CONF 002**

Task 533275-831-848-001: Modification	
Get Access	3.00
On Aircraft	
Get Access at the Location of the Door Support Fitting-Upper FR67	1.00
Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67	1.50
Get Access at the Location of the Door Support Fitting-Upper FR69	1.50
Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69	1.50
Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67	1.00
Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69	1.00
Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)	3.00
Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)	3.00
Do the Installation of the Support and Spigot Assemblies at FR67	3.00
Do the Installation of the Support and Spigot Assemblies at FR69	3.00
Re-identify the Support Assembly and Serrated Plate on FR67	0.50
Re-identify the Support Assembly on FR69	0.25
Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69	2.00
Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67	1.00
Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69	1.50

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Task 533275-831-848-001: Modification	
Tests	0.50
Close-Up	3.00
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAA given in Appendix 01 - Manpower Gantt Chart .

**CONF ALL

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

**CONF 001

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11	06-31-53 52-33-32	12-34-24 53-43-11
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)	51-10-01		
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12		
Service Bulletin (SB)	A330-53-3278		
Service Information Letter (SIL)	SIL 51-012		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-48-00	51-23-12 51-42-00 51-44-11 51-75-12	51-24-00 51-43-00 51-46-11 51-76-11

NOTE: SIL 51-012 has been migrated into ISI article 51.48.00001.

**CONF 002

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11	06-31-53 52-33-32	12-34-24 53-43-11
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)	51-10-01		
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12		

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Service Bulletin (SB)	A330-53-3278		
Service Information Letter (SIL)	SIL 51-012		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-00 51-40-00 51-44-00 51-48-00	51-23-12 51-42-00 51-44-11 51-75-12	51-24-00 51-43-00 51-46-11 51-76-11

NOTE: SIL 51-012 has been migrated into ISI article 51.48.00001.

**CONF ALL

K. PUBLICATION AFFECTED

Aircraft Maintenance Manual (AMM)	52-33-32
Illustrated Parts Catalog (IPC)	52-33-32

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:

Kit 533275D01R03	AIRBUS Material, Logistics and Suppliers ATP II B Hein-Sass-Weg 24 21129 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by E-mail: airbus.kit@airbus.com Telephone Hotline: +49 40 743 51616

For standard hardware the purchase order shall be addressed to AIRBUS. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference. Please send your request to:

Component COMPD01	AIRBUS Material, Logistics and Suppliers Standard Parts For ordering by internet: http://spares.airbus.com or via SPEC2000 For ordering by E-mail: standard.parts@airbus.com Phone: +49 (0) 40 50 76 40 03

(2) Price and Availability

Kit 533275D01R03	
Cost	5,100.00 USD
Availability	210 calendar days from receipt of order

The availability given above is the standard lead time from the date of your purchase order. If items are required before this time, please include a retrofit planning schedule with your order so that we can try to comply with your requirements.

The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.

Component COMPD01

Operator supplied standard hardware parts required to accomplish this Service Bulletin are to be supplied from the operator's stock.

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B. INDUSTRY SUPPORT INFORMATION

For aircraft under warranty at Jun 02/16:

- AIRBUS will share the costs of accomplishment of this Service Bulletin by providing the kits at no charge for orders placed before Jul 01/19

- AIRBUS will credit the man hours indicated in this Service Bulletin at the agreed in-house warranty labor rate for claims received no later than 90 days after completion of the last affected aircraft of your fleet, for the accomplishment of this Service Bulletin before Jul 01/19.

This Service Bulletin is the subject of an AIRBUS monitored retrofit campaign.

For the organization of this retrofit, you are kindly requested to contact AIRBUS retrofit management department.

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
France
E-mail: monitored.retrofit@airbus.com

C. LIST OF COMPONENTS

Kit 533275D01R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5327127020200	4	BUSH				
3	NAS1149C0332R	4	WASHER				
4	NAS1149C0432R	4	WASHER				
5	F5347598420000	1	TAPE				
6	NAS1726-3E	4	NUT				
7	NAS1726-4E	44	NUT				
8	NSA5031-3-8	2	BOLT				
9	NSA5031-3-10	2	BOLT				
10	ABS0114T4-5Y	20	BOLT				
11	ABS0114T4-7Y	20	BOLT				
12	NSA5031-4-8	2	BOLT				
13	NSA5031-4-10	2	BOLT				
14	DIN65399-2412BF	2	RIVET				
15	NSA5075W6	4	COLLAR				
17	DAN6-6-6	4	PIN				
32	F5327127020800	4	BUSH				

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.

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D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	
	Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane-Gray Internal Structure	04JME4	As required	
	Coating-Flexible Structure	04QAB2	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet	06AAB1	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Hardening Jointing Putty	06LCB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	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
50	DIN65399-4020BF	16	RIVET				
52	NAS1921B05S03U	3	RIVET				

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

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E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

Reidentified part set REIDD01

ITEM	NEW PART N°	KEYWORD	ITEM	OLD PART N°	SEE NOTES
19	A5397802600800	SUPPORT	(19)	A5397802600400	
26	A5397805221600	PLATE	(26)	A5397805221200	

Reidentified part set REIDD02

ITEM	NEW PART N°	KEYWORD	ITEM	OLD PART N°	SEE NOTES
20	A5397802601000	SUPPORT	(20)	A5397802600600	

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit should contact:

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

Operators interested in obtaining the West Coast Industries (WCI) tool kit should contact:

Standard tool TOOLD02	West Coast Industries Inc. 14900 Whitman Ave. N SEATTLE WA 98133 USA Email: info@coldwork.com Phone: (206) 365-7513 Fax: (206) 365-7483 Europe, Middle East, Africa and Russia: customer@capaero.com / +33 5 61 92 04 91 (France)

(b) Price and Availability

Procurement to be negotiated directly with Fatigue Technology Incorporated (FTI)

or

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

(2) Tools

To accomplish this Service Bulletin it will be necessary to use the tools and equipment listed in NTM Task 51-10-01-250-801.

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	FTIA330533275-1	Capital Tooling	1	(3)

NOTE: Fatigue Technology Incorporated (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. FTIA330533275-1

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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	WCIA330533275-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): Durable Tooling: Ref. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. WCIA330533275-1

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 533275-831-848-001 - Modification

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 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: Discarded parts must be managed at the operator's discretion.

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Task Associated Data

****CONF 001**

Zone	
823	
Manpower	
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

****CONF 002**

Zone	
823	
Manpower	
TOTAL MANHOURS	31.25
ELAPSED TIME (HOURS)	16.50

****CONF ALL**

A. GENERAL

****CONF 001**

(1) Subtask 533275-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-801
Consumable Material List (CML)	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12
Structural Repair Manual (SRM)	51-21-00 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-44-11 51-46-11 51-48-00 51-75-12 51-76-11

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

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(b) If you find process and material specifications that you do not know in the design drawings, refer to the cross-reference list in the Process and Material Specification (PMS).

(c) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.

(d) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(e) Do the removal and installation of fasteners in accordance with SRM 51-42-00.

(f) Do the cold working of the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill deburr data in accordance with SRM 51-44-00 and SRM 51-44-11.

(h) Protect the areas to prevent damage to the equipment and structure and all the parts.

(i) Do sealant application in accordance with SRM 51-24-00 and SRM 51-76-11.

(j) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-801.

(k) Get alternative and substitute fastener data in accordance with SRM 51-43-00.

(l) In case alternative and substitute fasteners are to be used, you must check that the associated nut/collar are compatible in accordance with SRM 51-40-00.

(m) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(n) Get countersinking of fastener holes data in accordance with SRM 51-46-11.

(o) Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(p) Renew the protective finish in accordance with SRM 51-75-12.

(q) Apply protective treatments in accordance with SRM 51-21-00.

(r) Part mark with indelible ink in accordance with Process and Material Specification (PMS) 01-06-12.

(2) Subtask 533275-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

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**CONF 002

(1) Subtask 533275-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-801
Consumable Material List (CML)	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12
Structural Repair Manual (SRM)	51-21-00 51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-44-11 51-46-11 51-48-00 51-75-12 51-76-11

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

(b) If you find process and material specifications that you do not know in the design drawings, refer to the cross-reference list in the Process and Material Specification (PMS).

(c) For the Frame (FR) identification, refer to AMM 06-31-53, Page Block 001.

(d) For the identification of zones, refer to AMM 06-20-00, Page Block 001.

(e) Do the removal and installation of fasteners in accordance with SRM 51-42-00.

(f) Do the cold working of the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill deburr data in accordance with SRM 51-44-00 and SRM 51-44-11.

(h) Protect the areas to prevent damage to the equipment and structure and all the parts.

(i) Do sealant application in accordance with SRM 51-24-00 and SRM 51-76-11.

(j) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-801.

(k) Get alternative and substitute fastener data in accordance with SRM 51-43-00.

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(l) In case alternative and substitute fasteners are to be used, you must check that the associated nut/collar are compatible in accordance with SRM 51-40-00.

(m) If the length of any fastener specified in this Service Bulletin does not meet installation standards given in SRM Chapter 51, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in SRM Chapter 51 may be used. In addition, washers may be installed for fastener grip length in accordance with SRM Chapter 51.

(n) Get countersinking of fastener holes data in accordance with SRM 51-46-11.

(o) Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(p) Renew the protective finish in accordance with SRM 51-75-12.

(q) Apply protective treatments in accordance with SRM 51-21-00.

(r) Part mark with indelible ink in accordance with Process and Material Specification (PMS) 01-06-12.

(2) Subtask 533275-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF ALL**

B. PREPARATION

****CONF 001**

(1) Subtask 533275-941-201-001 - Job Set-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802 Task 52-33-32-000-801 Task 52-33-32-000-802

NOTE: For the basic Aircraft configuration, refer to AMM Chapter 'Introduction - Aircraft status for maintenance' in Manual Front Matter section.

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(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-860-802.

(b) Put access platforms in position at bulk cargo door 823 RH at Frame 67 and Frame 69.

(c) Do the job set-up as specified in the removal of the support assembly, refer to AMM Task 52-33-32-000-801.

(d) Do the job set-up as specified in the removal of the latch spigot assembly, refer to AMM Task 52-33-32-000-802.

**CONF 002

(1) Subtask 533275-941-201-001 - Job Set-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802 Task 52-33-32-000-801 Task 52-33-32-000-802

NOTE: For the basic Aircraft configuration, refer to AMM Chapter 'Introduction - Aircraft status for maintenance' in Manual Front Matter section.

(a) Make sure that the aircraft is electrically grounded, refer to AMM Task 12-34-24-860-802.

(b) Put access platforms in position at bulk cargo door 823 RH at Frame 67 and Frame 69.

(c) Do the job set-up as specified in the removal of the support assembly, refer to AMM Task 52-33-32-000-801.

(d) Do the job set-up as specified in the removal of the latch spigot assembly, refer to AMM Task 52-33-32-000-802.

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**CONF ALL

C. PROCEDURE

**CONF 001

(1) Subtask 533275-010-201-001 - Get Access at the Location of the Door Support Fitting-Upper FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

Material necessary to do the job

Consumable CMLD01				
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	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-000-801
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove the cover at Frame 67 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 02, View B and in accordance with SRM 51-42-00:

1 Remove:

1	Cover	Item (51)	Retain
	attached with:		
3	Rivet	Item (52)	Discard
8	Rivet	Item (50)	Discard

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2 Remove the old sealant with a plastic scrapper.

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

4

CAUTION: DO NOT REMOVE THE ATTACHMENT PARTS OF THE RH SUPPORT STRUTS AT FRAME 67 AND FRAME 69 AT THE SAME TIME. IF YOU DO NOT SUPPORT THE CABIN FLOOR STRUCTURE BEFORE THE REMOVAL OF TWO ADJACENT STRUTS, YOU CAN CAUSE STRUCTURAL FAILURE OF THE CABIN FLOOR STRUCTURE.

Remove the lower attachment parts of the RH support strut at Frame 67, refer to AMM Task 53-43-11-000-801.

5 Move the lower end of the support strut to get access to the modification area.

(2) Subtask 533275-831-201-001 - Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

References	
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

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(a) Remove the fasteners and the support assembly at the bulk cargo door Frame 67.

1 At Frame 67 between positions STGR37 and STGR43 remove, as shown on Fig. A-GBAAA Sheet 01, View A and Fig. A-GBAAA Sheet 04, View F, Section D-D:

20	Nut	NAS1726-4E	Item (7)	Discard
10	Bolt	NSA5031-4-5	Item (10)	Discard
10	Bolt	NSA5031-4-7	Item (11)	Discard
5	Support Assy	A5397802600400	Item (19)	Retain

(b) Remove the fasteners and the spigot assembly at the bulk cargo door Frame 67.

1 At Frame 67 at position STGR42A remove, as shown on Fig. A-GBAAA Sheet 01, View A and Fig. A-GBAAA Sheet 04, View F, Section E-E and Fig. A-GBAAA Sheet 05 View J:

2	Nut	NAS1726-4E	Item (7)	Discard
2	Bolt	NSA5031-4-7	Item (11)	Discard
2	Bolt	NSA5031-3-10	Item (9)	Discard
2	Nut	NAS1726-3E	Item (6)	Discard
2	Pin Hi-Lok	DAN6-5-6	Item (17)	Discard
2	Collar	NSA5075W5	Item (15)	Discard
1	Spigot Assy-Latch	F5347597600600	Item (23)	Retain
1	Plate-Serrated	A5397805220800	Item (25)	Retain
1	Plate-Serrated	A5397805221200	Item (26)	Retain
2	Rivet	DIN65399-2400BF	Item (14)	Discard
1	Nut-Plate	MS21059L06	Item (27)	Retain
2	Bush	F5327127020200	Item (1)	Discard
2	Bush	F5327127020800	Item (32)	Discard

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(3) Subtask 533275-010-202-001 - Get Access at the Location of the Door Support Fitting-Upper FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
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	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-000-801
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove the cover at Frame 69 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 03, View C and in accordance with SRM 51-42-00:

1 Remove:

1	Cover	Item (53)	Retain

attached with:

1	Screw	Item (55)	Retain
1	Washer	Item (56)	Retain

and as per the applicable alternative installation shown on Fig. A-GBBAA Sheet 03, View C, with:

8	Rivet	Item (50)	Discard

or

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7	Rivet		Item (50)	Discard

2 Remove the old sealant with a plastic scrapper.

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

(b) Remove the section between Frame 69 and Frame 71 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 04, View D and in accordance with SRM 51-42-00:

1 Remove:

1	Section		Item (54)	Retain

attached with:

4	Screw	NAS1102E3-8	Item (55)	Retain
4	Washer	NAS1169-10L	Item (56)	Retain
3	Nut	NAS1291C3M	Item (58)	Retain
3	Washer	NAS1149D1165K	Item (57)	Retain
1	Screw	NAS1102E08-7	Item (59)	Retain
1	Washer	NAS1169C8L	Item (60)	Retain

2 Remove the old sealant with a plastic scrapper.

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

4

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CAUTION: DO NOT REMOVE THE ATTACHMENT PARTS OF THE RH SUPPORT STRUTS AT FRAME 67 AND FRAME 69 AT THE SAME TIME. IF YOU DO NOT SUPPORT THE CABIN FLOOR STRUCTURE BEFORE THE REMOVAL OF TWO ADJACENT STRUTS, YOU CAN CAUSE STRUCTURAL FAILURE OF THE CABIN FLOOR STRUCTURE.

Remove the lower attachment parts of the RH support strut at Frame 69, refer to AMM Task 53-43-11-000-801.

5 Move the lower end of the support strut to get access to the modification area.

(4) Subtask 533275-831-204-001 - Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

References	
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

(a) Remove the fasteners and the support assembly at the bulk cargo door Frame 69.

1 At Frame 69 between positions STGR38 and STGR45 remove, as shown on Fig. A-GBAAA Sheet 01, View A and Fig. A-GBAAA Sheet 02, View B, Section B-B:

20	Nut	NAS1726-4E	Item (7)	Discard
10	Bolt	NSA5031-4-5	Item (10)	Discard
10	Bolt	NSA5031-4-7	Item (11)	Discard
5	Support Assy	A5397802600600	Item (20)	Retain

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(b) Remove the fasteners and the spigot assembly at the bulk cargo door Frame 69.

1 At Frame 69 at position STGR44 remove, as shown on Fig. A-GBAAA Sheet 01, View A and Fig. A-GBAAA Sheet 02, View B, Section C-C:

2	Nut	NAS1726-4E	Item (7)	Discard
2	Bolt	NSA5031-4-7	Item (11)	Discard
2	Bolt	NSA5031-3-10	Item (9)	Discard
2	Nut	NAS1726-3E	Item (6)	Discard
2	Pin Hi-Lok	DAN6-5-6	Item (17)	Discard
2	Collar	NSA5075W5	Item (15)	Discard
1	Spigot Assy-Latch	F5347598000400	Item (21)	Retain
1	Plate-Serrated	A5397805220800	Item (25)	Retain
1	Plate-Serrated	A5397805221200	Item (26)	Retain
2	Bush	F5327127020200	Item (1)	Discard
2	Bush	F5327127020800	Item (32)	Discard

(5) Subtask 533275-250-201-001 - Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

Material necessary to do the job

Consumable CMLD01				
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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References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801 Procedure A
Service Bulletin (SB)	A330-53-3278
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

NOTE: If this Service Bulletin is applied at the same time as Inspection Service Bulletin No. A330-53-3278, then this subtask is not necessary.

(a) Clean the working area Frame 67 with:

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

(b) Do the Eddy Current Rotating Probe Testing of the support fittings and the frame holes at Frame 67 between positions STGR37 and STGR43, as shown on Fig. A-GBAAA Sheet 05 and in accordance with NTM Task 51-10-01-250-801 Procedure A.

1 In case of no crack finding, continue with the accomplishment of the modification.

2 In case of crack finding, contact AIRBUS.

(6) Subtask 533275-250-202-001 - Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

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

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Material necessary to do the job

Consumable CMLD01				
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)	Task 51-10-01-250-801 Procedure A
Service Bulletin (SB)	A330-53-3278
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

NOTE: If this Service Bulletin is applied at the same time as Inspection Service Bulletin No. A330-53-3278, then this subtask is not necessary.

(a) Clean the working area Frame 69 with:

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

(b) Do the Eddy Current Rotating Probe Testing of the support fittings and the frame holes at Frame 69 between positions STGR38 and STGR45, as shown on Fig. A-GBAAA Sheet 03 and in accordance with NTM Task 51-10-01-250-801 Procedure A.

1 In case of no crack finding, continue with the accomplishment of the modification.

2 In case of crack finding, contact AIRBUS.

(7) Subtask 533275-831-203-001 - Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	FTIA330533275-1	Capital Tooling	1	(3)

NOTE: Fatigue Technology Incorporated (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. FTIA330533275-1

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.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	WCIA330533275-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. WCIA330533275-1

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	
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

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(a) Clean the working area with:

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

(b) Measure the size of the fastener holes and define the next stage of drill hole diameter in accordance with SRM 51-48-00 for cold working and as shown on Fig. A-GBAAA Sheet 06.

(c) Drill and ream the fastener holes for cold working with the correct start drill/reamer, refer to Fig. A-GBAAA Sheet 06.

(d) Cold expand the fastener holes in accordance with SRM 51-48-00 and Fig. A-GBAAA Sheet 04, Views F, G and H:

1 Refer to FTI tool list No.

DKA330533275-1	Durable Tooling	1

or

Refer to WCI tool list No.

DKA330533275-1	Durable Tooling	1

2 Clean the working area with:

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

3 Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA330533275-1	Expendable Tooling	1

or

Refer to WCI tool list No.

EKA330533275-1	Expendable Tooling	1

4 Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

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FTIA330533275-1 Capital Tooling 1

or

Refer to WCI tool list No.

WCIA330533275-1 Capital Tooling 1

5 Remove the sleeves.

6 Ream and deburr the fastener holes with the correct gage finish reamer, refer to Fig. A-GBAAA Sheet 06 and in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA330533275-1 Durable Tooling 1

or

Refer to WCI tool list No.

DKA330533275-1 Durable Tooling 1

7 Clean the drilled area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

8 Apply protection to the frame fastener holes with:

Wash Primer	04CMA2	As required

(8) Subtask 533275-831-205-001 - Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

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Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	FTIA330533275-1	Capital Tooling	1	(3)

NOTE: Fatigue Technology Incorporated (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. FTIA330533275-1

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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	WCIA330533275-1	Capital Tooling	1	(3)

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NOTE: West Coast Industries (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. WCIA330533275-1

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	
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

(a) Clean the working area with:

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

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(b) Measure the size of the fastener holes and define the next stage of drill hole diameter in accordance with SRM 51-48-00 for cold working and as shown on Fig. A-GBAAA Sheet 06.

(c) Drill and ream the fastener holes for cold working with the correct start drill/reamer, refer to Fig. A-GBAAA Sheet 06.

(d) Cold expand the fastener holes in accordance with SRM 51-48-00 and Fig. A-GBAAA Sheet 02, Views B, C and D:

1 Refer to FTI tool list No.

DKA330533275-1	Durable Tooling	1

or

Refer to WCI tool list No.

DKA330533275-1	Durable Tooling	1

2 Clean the working area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

3 Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA330533275-1	Expendable Tooling	1

or

Refer to WCI tool list No.

EKA330533275-1	Expendable Tooling	1

4 Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

FTIA330533275-1	Capital Tooling	1

or

Refer to WCI tool list No.

WCIA330533275-1	Capital Tooling	1

5 Remove the sleeves.

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6 Ream and deburr the fastener holes with the correct gage finish reamer, refer to Fig. A-GBAAA Sheet 06 and in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA330533275-1 Durable Tooling 1

or

Refer to WCI tool list No.

DKA330533275-1 Durable Tooling 1

7 Clean the drilled area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

8 Apply protection to the frame fastener holes with:

Wash Primer	04CMA2	As required

(9) Subtask 533275-831-208-001 - Do the Installation of the Support and Spigot Assemblies at FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533275D01R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5327127020200	2	BUSH	
3	NAS1149C0332R	2	WASHER	
4	NAS1149C0432R	2	WASHER	
5	F5347598420000	1	TAPE	
6	NAS1726-3E	2	NUT	
7	NAS1726-4E	22	NUT	
9	NSA5031-3-10	2	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ABS0114T4-5Y	10	BOLT	
11	ABS0114T4-7Y	10	BOLT	
13	NSA5031-4-10	2	BOLT	
14	DIN65399-2412BF	2	RIVET	
15	NSA5075W6	2	COLLAR	
17	DAN6-6-6	2	PIN	
32	F5327127020800	2	BUSH	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Hardening Jointing Putty	06LCB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-44-00
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Clean the installation areas with:

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

(b) Oversize to clearance fit the 4 fastener holes in the Support Assembly, Item (19), in accordance with SRM 51-44-00.

Refer to Fig. A-GBAAA Sheet 03, View F, Section D-D.

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(c) Apply protection to the support assembly fastener holes with:

Wash Primer	04CMA2	As required

(d) Do the installation of the support assembly on the fuselage Frame 67 between positions STGR37 and STGR43:

1 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAA Sheet 03, View F, Section D-D.

Install:

5	Support Assy	A5397802600400	Item (19)	Retained at removal
10	Bolt	ABS0114T4-5Y	Item 10	
10	Bolt	ABS0114T4-7Y	Item 11	
20	Nut	NAS1726-4E	Item 7	

NOTE: Wet assemble the Bolts, Items 10 and 11, with:

Non Hardening Jointing Putty	06LCB1	As required

2 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Item 7, refer to AMM 52-33-32-400-801.

3 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(e) Do the installation of the spigot assembly on the fuselage Frame 67 at position STGR42A, refer to Fig. A-GBAAA Sheet 04, View F, Section E-E and Fig. A-GBAAA Sheet 05, View J:

1 Install:

2	Bush	F5327127020200	Item 1
2	Bush	F5327127020800	Item 32

2 Final Drill/Ream, refer to Fig. A-GBAAA Sheet 04, View F, Section E-E and Fig. A-GBAAA Sheet 05, View J.

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3 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAA Sheet 04, View F, Section E-E and Fig. A-GBAAA Sheet 05, View J.

Install:

1	Spigot Assy-Latch	F5347597600600	Item (23)	Retained at removal
1	Plate-Serrated	A5397805220800	Item (25)	Retained at removal
1	Plate-Serrated	A5397805221200	Item (26)	Retained at removal
2	Bolt	NSA5031-4-10	Item 13	
2	Washer	NAS1149C0432R	Item 4	
2	Nut	NAS1726-4E	Item 7	
2	Pin Hi-Lok	DAN6-6-6	Item 17	
2	Collar	NSA5075W6	Item 15	
2	Bolt	NSA5031-3-10	Item 9	
2	Washer	NAS1149C0332R	Item 3	
2	Nut	NAS1726-3E	Item 6	

NOTE: Wet assemble the Bolts, Items 9 and 13, and the Pins Hi-Lok, Item 17, with:

Non Hardening Jointing Putty	06LCB1	As required

4 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Items 6 and 7, refer to AMM 52-33-32-400-801.

5 Torque the Nuts, Item 6, to between 0.35 and 0.45 daNm (31 and 39.9 lbf in).

6 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(f) Install (if necessary):

Refer to Fig. A-GBAAA Sheet 04, View F, Section F-F:

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1	Tape	F5347598420000	Item 5	

(g) Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAA Sheet 04, View F.

Install:

1	Nut-Plate	MS21059L06	Item (27)	Retained at removal

with:

2	Rivet	DIN65399-2412BF	Item 14

(10) Subtask 533275-831-209-001 - Do the Installation of the Support and Spigot Assemblies at FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533275D01R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5327127020200	2	BUSH	
3	NAS1149C0332R	2	WASHER	
4	NAS1149C0432R	2	WASHER	
6	NAS1726-3E	2	NUT	
7	NAS1726-4E	22	NUT	
8	NSA5031-3-8	2	BOLT	
10	ABS0114T4-5Y	10	BOLT	
11	ABS0114T4-7Y	10	BOLT	
12	NSA5031-4-8	2	BOLT	
15	NSA5075W6	2	COLLAR	
17	DAN6-6-6	2	PIN	
32	F5327127020800	2	BUSH	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Hardening Jointing Putty	06LCB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-44-00
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Clean the installation areas with:

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

(b) Oversize to clearance fit the 4 fastener holes in the Support Assembly, Item (20), in accordance with SRM 51-44-00.

Refer to Fig. A-GBAAA Sheet 02, View B, Section B-B.

(c) Apply protection to the support assembly fastener holes with:

Wash Primer	04CMA2	As required

(d) Do the installation of the support assembly on the fuselage Frame 69 between positions STGR38 and STGR45:

1 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

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In accordance with SRM 51-24-00 and refer to Fig. A-GBAAA Sheet 02, View B, Section B-B.

Install:

5	Support Assy	A5397802600600	Item (20)	Retained at removal
10	Bolt	ABS0114T4-5Y	Item 10	
10	Bolt	ABS0114T4-7Y	Item 11	
20	Nut	NAS1726-4E	Item 7	

NOTE: Wet assemble the Bolts, Items 10 and 11, with:

Non Hardening Jointing Putty	06LCB1	As required

2 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Item 7, refer to AMM 52-33-32-400-801.

3 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(e) Do the installation of the spigot assembly on the fuselage Frame 69 at position STGR44:

1 Install:

2	Bush	F5327127020200	Item 1	
2	Bush	F5327127020800	Item 32	

2 Final Drill/Ream, refer to Fig. A-GBAAA Sheet 02, View B and View E and Section C-C.

3 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAA Sheet 02, View B, Section C-C.

Install:

1	Spigot Assy-Latch	F5347598000400	Item (21)	Retained at removal
1	Plate-Serrated	A5397805220800	Item (25)	Retained at removal

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1	Plate-Serrated	A5397805221200	Item (26)	Retained at removal
2	Bolt	NSA5031-4-8	Item 12	
2	Washer	NAS1149C0432R	Item 4	
2	Nut	NAS1726-4E	Item 7	
2	Pin Hi-Lok	DAN6-6-6	Item 17	
2	Collar	NSA5075W6	Item 15	
2	Bolt	NSA5031-3-8	Item 8	
2	Washer	NAS1149C0332R	Item 3	
2	Nut	NAS1726-3E	Item 6	

NOTE: Wet assemble the Bolts, Items 8 and 12, and the Pins Hi-Lok, Item 17, with:

Non Hardening Jointing Putty	06LCB1	As required

4 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Items 6 and 7, refer to AMM 52-33-32-400-801.

5 Torque the Nuts, Item 6, to between 0.35 and 0.45 daNm (31 and 39.9 lbf in).

6 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(11) Subtask 533275-930-201-001 - Re-identify the Support Assembly and Serrated Plate on FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

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Material necessary to do the job

Reidentified part set REIDD01					
ITEM	NEW PART N˚	KEYWORD	ITEM	OLD PART N˚	SEE NOTES
19	A5397802600800	SUPPORT	(19)	A5397802600400	
26	A5397805221600	PLATE	(26)	A5397805221200	

References	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12

(a) Re-identify the items that follow, refer to Process and Material Specification (PMS) 01-06-12:

1	Support Assy	A5397802600400	Item (19)
	becomes:		
1	Support Assy	A5397802600800	Item 19
	and		
1	Plate-Serrated	A5397805221200	Item (26)
	becomes:		
1	Plate-Serrated	A5397805221600	Item 26

(12) Subtask 533275-930-202-001 - Re-identify the Support Assembly on FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Reidentified part set REIDD02					
ITEM	NEW PART N˚	KEYWORD	ITEM	OLD PART N˚	SEE NOTES
20	A5397802601000	SUPPORT	(20)	A5397802600600	

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References	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12

(a) Re-identify the item that follows, refer to Process and Material Specification (PMS) 01-06-12:

1	Support Assy	A5397802600600	Item (20)
	becomes:		
1	Support Assy	A5397802601000	Item 20

(13) Subtask 533275-914-201-001 - Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Coating-Flexible Structure	04QAB2	As required	
	Polysulfide Sealant-General Purpose Fillet	06AAB1	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12
Fig. A-GBAAA Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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NOTE: Do this subtask after the adjustment/test procedure as specified in SUBTASK 533275-700-201 001 Test .

(a) Apply the Sealants and Corrosion Preventive Compounds.

Refer to Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03, Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06.

1 Do a fillet seal around the support assembly with:

Polysulfide Sealant-General Purpose Fillet	06AAB1	As required

2 Renew the protective finish:

Refer to Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03, Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06 and in accordance with SRM 51-75-12:

Coating-Flexible Structure	04QAB2	As required

3 Apply corrosion preventive compound to all exposed surfaces:

Refer to Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03, Fig. A-GBAAA Sheet 04, Fig. A-GBAAA Sheet 05 and Fig. A-GBAAA Sheet 06 and in accordance with SRM 51-23-12:

Corrosion Preventive Compound-Soft	12ABC1	As required
or		
Corrosion Preventive Compound-Hard	12ABB1	As required

(14) Subtask 533275-410-201-001 - Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

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Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	DIN65399-4020BF	8	RIVET	
52	NAS1921B05S03U	3	RIVET	

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

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane-Gray Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-400-801
Structural Repair Manual (SRM)	51-24-00 51-42-00 51-75-12
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Install the lower attachment parts of the RH support strut at Frame 67, refer to AMM Task 53-43-11-400-801.

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(b) Install the cover at Frame 67, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 02, View B and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Wet install the rivets in the step below with:

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 Install:

1	Cover		Item (51)	Retained at removal
	attach with:			
8	Rivet	DIN65399-4020BF	Item 50	
3	Rivet	NAS1921B05S03U	Item 52	

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required
made moist with:		
Non Aqueous Cleaner-General	08BAA9	As required

4 Renew the protective finish of the rivets in accordance with SRM 51-75-12:

Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane-Gray Internal Structure	04JME4	As required

5 Apply to all exposed surfaces which you touched or moved:

Corrosion Preventive Compound-Soft	12ABC1	As required
or		
Corrosion Preventive Compound-Hard	12ABB1	As required

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(15) Subtask 533275-410-202-001 - Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	DIN65399-4020BF	8	RIVET	

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

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane-Gray Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet	06AAB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-400-801
Structural Repair Manual (SRM)	51-24-00 51-42-00 51-75-12

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References	
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Install the lower attachment parts of the RH support strut at Frame 69, refer to AMM Task 53-43-11-400-801.

(b) Install the section between Frame 69 and Frame 71, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 04, View D and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Apply between the structure at Frame 69 and the Section, item (54):

Polysulfide Sealant-General Purpose Fillet	06AAB1	As required

2 Install:

1	Cover		Item (54)	Retained at removal
	attach with:			
4	Screw	NAS1102E3-8	Item (55)	Retained at removal
4	Washer	NAS1169-10L	Item (56)	Retained at removal
3	Nut	NAS1291C3M	Item (58)	Retained at removal
3	Washer	NAS1149D1165K	Item (57)	Retained at removal
1	Screw	NAS1102E08-7	Item (59)	Retained at removal
1	Washer	NAS1169C8L	Item (60)	Retained at removal

(c) Install the cover at Frame 69, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 03, View C and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Install:

1	Cover		Item (53)	Retained at removal

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attach with:

1	Screw	NAS1102E3-8	Item (55)	Retained at removal
1	Washer	NAS1169-10L	Item (56)	Retained at removal

and as per the applicable alternative installation shown on Fig. A-GBBAA Sheet 03, View C, with:

8	Rivet	DIN65399-4020BF	Item 50

or

7	Rivet	DIN65399-4020BF	Item 50

2 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

3 Renew the protective finish of the rivets in accordance with SRM 51-75-12:

Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane-Gray Internal Structure	04JME4	As required

4 Apply to all exposed surfaces which you touched or moved:

Corrosion Preventive Compound-Soft	12ABC1	As required

or

Corrosion Preventive Compound-Hard	12ABB1	As required

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**CONF 002

(1) Subtask 533275-010-201-001 - Get Access at the Location of the Door Support Fitting-Upper FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

Material necessary to do the job

Consumable CMLD01				
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	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-000-801
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove the cover at Frame 67 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 02, View B and in accordance with SRM 51-42-00:

1 Remove:

1	Cover	Item (51)	Retain
	attached with:		
3	Rivet	Item (52)	Discard
8	Rivet	Item (50)	Discard

2 Remove the old sealant with a plastic scrapper.

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3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

4

CAUTION: DO NOT REMOVE THE ATTACHMENT PARTS OF THE RH SUPPORT STRUTS AT FRAME 67 AND FRAME 69 AT THE SAME TIME. IF YOU DO NOT SUPPORT THE CABIN FLOOR STRUCTURE BEFORE THE REMOVAL OF TWO ADJACENT STRUTS, YOU CAN CAUSE STRUCTURAL FAILURE OF THE CABIN FLOOR STRUCTURE.

Remove the lower attachment parts of the RH support strut at Frame 67, refer to AMM Task 53-43-11-000-801.

5 Move the lower end of the support strut to get access to the modification area.

(2) Subtask 533275-831-201-002 - Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

References	
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

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(a) Remove the fasteners and the support assembly at the bulk cargo doorFrame 67.

1 At Frame 67 between positions STGR37 and STGR43 remove, as shown on Fig. A-GBAAB Sheet 01, View A and Fig. A-GBAAB Sheet 04, View F, Section D-D:

20	Nut	NAS1726-4E	Item (7)	Discard
10	Bolt	NSA5031-4-5	Item (10)	Discard
10	Bolt	NSA5031-4-7	Item (11)	Discard
5	Support Assy	A5397802600400	Item (19)	Retain

(b) Remove the fasteners and the spigot assembly at the bulk cargo door Frame 67.

1 At Frame 67 at position STGR42A remove, as shown on Fig. A-GBAAB Sheet 01, View A and Fig. A-GBAAB Sheet 04, View F, Section E-E:

2	Nut	NAS1726-4E	Item (7)	Discard
2	Bolt	NSA5031-4-7	Item (11)	Discard
2	Bolt	NSA5031-3-10	Item (9)	Discard
2	Nut	NAS1726-3E	Item (6)	Discard
2	Pin Hi-Lok	DAN6-5-6	Item (17)	Discard
2	Collar	NSA5075W5	Item (15)	Discard
1	Spigot Assy	F5347597601000	Item (24)	Retain
1	Plate-Serrated	A5397805220800	Item (25)	Retain
1	Plate-Serrated	A5397805221200	Item (26)	Retain
2	Rivet	DIN65399-2400BF	Item (14)	Discard
1	Nut-Plate	MS21059L06	Item (27)	Retain
2	Bush	F5327127020200	Item (1)	Discard
2	Bush	F5327127020800	Item (32)	Discard

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(3) Subtask 533275-010-202-001 - Get Access at the Location of the Door Support Fitting-Upper FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
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	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-000-801
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove the cover at Frame 69 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 03, View C and in accordance with SRM 51-42-00:

1 Remove:

1	Cover	Item (53)	Retain

attached with:

1	Screw	Item (55)	Retain
1	Washer	Item (56)	Retain

and as per the applicable alternative installation shown on Fig. A-GBBAA Sheet 03, View C, with:

8	Rivet	Item (50)	Discard

or

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7	Rivet		Item (50)	Discard

2 Remove the old sealant with a plastic scrapper.

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

(b) Remove the section between Frame 69 and Frame 71 to get access to the modification area, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 04, View D and in accordance with SRM 51-42-00:

1 Remove:

1	Section		Item (54)	Retain

attached with:

4	Screw	NAS1102E3-8	Item (55)	Retain
4	Washer	NAS1169-10L	Item (56)	Retain
3	Nut	NAS1291C3M	Item (58)	Retain
3	Washer	NAS1149D1165K	Item (57)	Retain
1	Screw	NAS1102E08-7	Item (59)	Retain
1	Washer	NAS1169C8L	Item (60)	Retain

2 Remove the old sealant with a plastic scrapper.

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

4

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CAUTION: DO NOT REMOVE THE ATTACHMENT PARTS OF THE RH SUPPORT STRUTS AT FRAME 67 AND FRAME 69 AT THE SAME TIME. IF YOU DO NOT SUPPORT THE CABIN FLOOR STRUCTURE BEFORE THE REMOVAL OF TWO ADJACENT STRUTS, YOU CAN CAUSE STRUCTURAL FAILURE OF THE CABIN FLOOR STRUCTURE.

Remove the lower attachment parts of the RH support strut at Frame 69, refer to AMM Task 53-43-11-000-801.

5 Move the lower end of the support strut to get access to the modification area.

(4) Subtask 533275-831-204-002 - Remove the Fasteners and the Support Assemblies at the Bulk Cargo Door FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

References	
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

(a) Remove the fasteners and the support assembly at the bulk cargo door Frame 69.

1 At Frame 69 between positions STGR38 and STGR45 remove, as shown on Fig. A-GBAAB Sheet 01, View A and Fig. A-GBAAB Sheet 02, View B, Section B-B:

20	Nut	NAS1726-4E	Item (7)	Discard
10	Bolt	NSA5031-4-5	Item (10)	Discard
10	Bolt	NSA5031-4-7	Item (11)	Discard
5	Support Assy	A5397802600600	Item (20)	Retain

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(b) Remove the fasteners and the spigot assembly at the bulk cargo door Frame 69.

1 At Frame 69 at position STGR44 remove, as shown on Fig. A-GBAAB Sheet 01, View A and Fig. A-GBAAB Sheet 02, View B, Section C-C:

2	Nut	NAS1726-4E	Item (7)	Discard
2	Bolt	NSA5031-4-7	Item (11)	Discard
2	Bolt	NSA5031-3-10	Item (9)	Discard
2	Nut	NAS1726-3E	Item (6)	Discard
2	Pin Hi-Lok	DAN6-5-6	Item (17)	Discard
2	Collar	NSA5075W5	Item (15)	Discard
1	Spigot Assy	F5347598000800	Item (22)	Retain
1	Plate-Serrated	A5397805220800	Item (25)	Retain
1	Plate-Serrated	A5397805221200	Item (26)	Retain
2	Bush	F5327127020200	Item (1)	Discard
2	Bush	F5327127020800	Item (32)	Discard

(5) Subtask 533275-250-201-002 - Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

Material necessary to do the job

Consumable CMLD01				
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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References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801 Procedure A
Service Bulletin (SB)	A330-53-3278
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

NOTE: If this Service Bulletin is applied at the same time as Inspection Service Bulletin No. A330-53-3278, then this subtask is not necessary.

(a) Clean the working area Frame 67 with:

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

(b) Do the Eddy Current Rotating Probe Testing of the support fittings and the frame holes at Frame 67 between positions STGR37 and STGR43, as shown on Fig. A-GBAAB Sheet 04 and in accordance with NTM Task 51-10-01-250-801 Procedure A.

1 In case of no crack finding, continue with the accomplishment of the modification.

2 In case of crack finding, contact AIRBUS.

(6) Subtask 533275-250-202-002 - Do the Eddy Current Rotating Probe Inspection of the Fastener Holes at FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

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

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Material necessary to do the job

Consumable CMLD01				
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)	Task 51-10-01-250-801 Procedure A
Service Bulletin (SB)	A330-53-3278
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

NOTE: If this Service Bulletin is applied at the same time as Inspection Service Bulletin No. A330-53-3278, then this subtask is not necessary.

(a) Clean the working area Frame 69 with:

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

(b) Do the Eddy Current Rotating Probe Testing of the support fittings and the frame holes at Frame 69 between positions STGR38 and STGR45, as shown on Fig. A-GBAAB Sheet 02 and in accordance with NTM Task 51-10-01-250-801 Procedure A.

1 In case of no crack finding, continue with the accomplishment of the modification.

2 In case of crack finding, contact AIRBUS.

(7) Subtask 533275-831-203-002 - Do the Cold Working Process of the Fastener Holes at FR67 (Fuselage Frame Only)

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	FTIA330533275-1	Capital Tooling	1	(3)

NOTE: Fatigue Technology Incorporated (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. FTIA330533275-1

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.

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	WCIA330533275-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. WCIA330533275-1

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	
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

(a) Clean the working area with:

Non Aqueous Cleaner-General	08BAA9	As required

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and

Textile-Lint Free Cotton	14SBA1	As required

(b) Measure the size of the fastener holes and define the next stage of drill hole diameter in accordance with SRM 51-48-00 for cold working and as shown on Fig. A-GBAAB Sheet 06.

(c) Drill and ream the fastener holes for cold working with the correct start drill/reamer, refer to Fig. A-GBAAB Sheet 06.

(d) Cold expand the fastener holes in accordance with SRM 51-48-00 and Fig. A-GBAAB Sheet 04, Views F, G and H:

1 Refer to FTI tool list No.

DKA330533275-1	Durable Tooling	1

or

Refer to WCI tool list No.

DKA330533275-1	Durable Tooling	1

2 Clean the working area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

3 Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA330533275-1	Expendable Tooling	1

or

Refer to WCI tool list No.

EKA330533275-1	Expendable Tooling	1

4 Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

FTIA330533275-1	Capital Tooling	1

or

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Refer to WCI tool list No.

WCIA330533275-1 Capital Tooling 1

5 Remove the sleeves.

6 Ream and deburr the fastener holes with the correct gage finish reamer, refer to Fig. A-GBAAB Sheet 06 and in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA330533275-1 Durable Tooling 1

or

Refer to WCI tool list No.

DKA330533275-1 Durable Tooling 1

7 Clean the drilled area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

8 Apply protection to the frame fastener holes with:

Wash Primer	04CMA2	As required

(8) Subtask 533275-831-205-002 - Do the Cold Working Process of the Fastener Holes at FR69 (Fuselage Frame Only)

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	

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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	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	FTIA330533275-1	Capital Tooling	1	(3)

NOTE: Fatigue Technology Incorporated (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. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. FTIA330533275-1

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
	DKA330533275-1	Durable Tooling	1	(1)
	EKA330533275-1	Expendable Tooling	1	(2)
	WCIA330533275-1	Capital Tooling	1	(3)

NOTE: West Coast Industries (WCI) has allocated the following tool kit numbers for cold expansion:

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For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): Durable Tooling: Ref. DKA330533275-1

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 SIL 51-012 (corresponding to ISI 51.48.00001).

NOTE (2): Expendable Tooling: Ref. EKA330533275-1

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. WCIA330533275-1

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	
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-48-00
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

CAUTION: MAKE SURE THAT THE FASTENER HOLE EDGE DISTANCE IS CORRECT BEFORE INSTALLATION OF THE FINAL FASTENERS TO AVOID EXTENSIVE REPAIRS IN THE FUSELAGE MODIFICATION AREA.

(a) Clean the working area with:

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

(b) Measure the size of the fastener holes and define the next stage of drill hole diameter in accordance with SRM 51-48-00 for cold working and as shown on Fig. A-GBAAB Sheet 06.

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(c) Drill and ream the fastener holes for cold working with the correct start drill/reamer, refer to Fig. A-GBAAB Sheet 06.

(d) Cold expand the fastener holes in accordance with SRM 51-48-00 and Fig. A-GBAAB Sheet 02, Views B, C and D:

1 Refer to FTI tool list No.

DKA330533275-1	Durable Tooling	1

or

Refer to WCI tool list No.

DKA330533275-1	Durable Tooling	1

2 Clean the working area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

3 Install the sleeves in accordance with SRM 51-48-00.

Refer to FTI tool list No.

EKA330533275-1	Expendable Tooling	1

or

Refer to WCI tool list No.

EKA330533275-1	Expendable Tooling	1

4 Do the cold expansion of the fastener holes in accordance with SRM 51-48-00.

Refer to FTI tool list No.

FTIA330533275-1	Capital Tooling	1

or

Refer to WCI tool list No.

WCIA330533275-1	Capital Tooling	1

5 Remove the sleeves.

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6 Ream and deburr the fastener holes with the correct gage finish reamer, refer to Fig. A-GBAAB Sheet 06 and in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DKA330533275-1 Durable Tooling 1

or

Refer to WCI tool list No.

DKA330533275-1 Durable Tooling 1

7 Clean the drilled area with:

Non Aqueous Cleaner-General	08BAA9	As required

and

Textile-Lint Free Cotton	14SBA1	As required

8 Apply protection to the frame fastener holes with:

Wash Primer	04CMA2	As required

(9) Subtask 533275-831-208-002 - Do the Installation of the Support and Spigot Assemblies at FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533275D01R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5327127020200	2	BUSH	
3	NAS1149C0332R	2	WASHER	
4	NAS1149C0432R	2	WASHER	
5	F5347598420000	1	TAPE	
6	NAS1726-3E	2	NUT	
7	NAS1726-4E	22	NUT	
9	NSA5031-3-10	2	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	ABS0114T4-5Y	10	BOLT	
11	ABS0114T4-7Y	10	BOLT	
13	NSA5031-4-10	2	BOLT	
14	DIN65399-2412BF	2	RIVET	
15	NSA5075W6	2	COLLAR	
17	DAN6-6-6	2	PIN	
32	F5327127020800	2	BUSH	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Hardening Jointing Putty	06LCB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-44-00
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Clean the installation areas with:

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

(b) Oversize to clearance fit the 4 fastener holes in the Support Assembly, Item (19), in accordance with SRM 51-44-00.

Refer to Fig. A-GBAAB Sheet 04, View F, Section D-D.

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(c) Apply protection to the support assembly fastener holes with:

Wash Primer	04CMA2	As required

(d) Do the installation of the support assembly on the fuselage Frame 67 between positions STGR37 and STGR43:

1 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAB Sheet 04, View F, Section D-D.

Install:

5	Support Assy	A5397802600400	Item (19)	Retained at removal
10	Bolt	ABS0114T4-5Y	Item 10	
10	Bolt	ABS0114T4-7Y	Item 11	
20	Nut	NAS1726-4E	Item 7	

NOTE: Wet assemble the Bolts, Items 10 and 11, with:

Non Hardening Jointing Putty	06LCB1	As required

2 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Item 7, refer to AMM 52-33-32-400-801.

3 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(e) Do the installation of the spigot assembly on the fuselage Frame 67 at position STGR42A, refer to Fig. A-GBAAB Sheet 04, View F, Section E-E and Fig. A-GBAAB Sheet 05, View J:

1 Install:

2	Bush	F5327127020200	Item 1
2	Bush	F5327127020800	Item 32

2 Final Drill/Ream, refer to Fig. A-GBAAB Sheet 04, View F, Section E-E and Fig. A-GBAAB Sheet 05, View J.

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3 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAB Sheet 04, View F, Section E-E and Fig. A-GBAAB Sheet 05, View J.

Install:

1	Spigot Assy	F5347597601000	Item (24)	Retained at removal
1	Plate-Serrated	A5397805220800	Item (25)	Retained at removal
1	Plate-Serrated	A5397805221200	Item (26)	Retained at removal
2	Bolt	NSA5031-4-10	Item 13	
2	Washer	NAS1149C0432R	Item 4	
2	Nut	NAS1726-4E	Item 7	
2	Pin Hi-Lok	DAN6-6-6	Item 17	
2	Collar	NSA5075W6	Item 15	
2	Bolt	NSA5031-3-10	Item 9	
2	Washer	NAS1149C0332R	Item 3	
2	Nut	NAS1726-3E	Item 6	

NOTE: Wet assemble the Bolts, Items 9 and 13, and the Pins Hi-Lok, Item 18, with:

Non Hardening Jointing Putty	06LCB1	As required

4 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Items 6 and 7, refer to AMM 52-33-32-400-801.

5 Torque the Nuts, Item 6, to between 0.35 and 0.45 daNm (31 and 39.9 lbf in).

6 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(f) Install (if necessary):

Refer to Fig. A-GBAAB Sheet 04, View F, Section F-F:

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1	Tape	F5347598420000	Item 5	

(g) Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAB Sheet 04, View F.

Install:

1	Nut-Plate	MS21059L06	Item (27)	Retained at removal

with:

2	Rivet	DIN65399-2412BF	Item 14

(10) Subtask 533275-831-209-002 - Do the Installation of the Support and Spigot Assemblies at FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533275D01R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5327127020200	2	BUSH	
3	NAS1149C0332R	2	WASHER	
4	NAS1149C0432R	2	WASHER	
6	NAS1726-3E	2	NUT	
7	NAS1726-4E	22	NUT	
8	NSA5031-3-8	2	BOLT	
10	ABS0114T4-5Y	10	BOLT	
11	ABS0114T4-7Y	10	BOLT	
12	NSA5031-4-8	2	BOLT	
15	NSA5075W6	2	COLLAR	
17	DAN6-6-6	2	PIN	
32	F5327127020800	2	BUSH	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer	04CMA2	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Hardening Jointing Putty	06LCB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-44-00
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Clean the installation areas with:

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

(b) Oversize to clearance fit the 4 fastener holes in the Support Assembly, Item (20), in accordance with SRM 51-44-00.

Refer to Fig. A-GBAAB Sheet 02, View B, Section B-B.

(c) Apply protection to the support assembly fastener holes with:

Wash Primer	04CMA2	As required

(d) Do the installation of the support assembly on the fuselage Frame 69 between positions STGR38 and STGR45:

1 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

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In accordance with SRM 51-24-00 and refer to Fig. A-GBAAB Sheet 02, View B, Section B-B.

Install:

5	Support Assy	A5397802600600	Item (20)	Retained at removal
10	Bolt	ABS0114T4-5Y	Item 10	
10	Bolt	ABS0114T4-7Y	Item 11	
20	Nut	NAS1726-4E	Item 7	

NOTE: Wet assemble the Bolts, Items 10 and 11, with:

Non Hardening Jointing Putty	06LCB1	As required

2 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Item 7, refer to AMM 52-33-32-400-801.

3 Torque the Nuts, Item 7 to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(e) Do the installation of the spigot assembly on the fuselage Frame 69 at position STGR44:

1 Install:

2	Bush	F5327127020200	Item 1	
2	Bush	F5327127020800	Item 32	

2 Final Drill/Ream, refer to Fig. A-GBAAB Sheet 02, View B and View E and Section C-C.

3 Apply:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

In accordance with SRM 51-24-00 and refer to Fig. A-GBAAB Sheet 02, View B, Section C-C.

Install:

1	Spigot Assy	F5347598000800	Item (22)	Retained at removal
1	Plate-Serrated	A5397805220800	Item (25)	Retained at removal

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1	Plate-Serrated	A5397805221200	Item (26)	Retained at removal
2	Bolt	NSA5031-4-8	Item 12	
2	Washer	NAS1149C0432R	Item 4	
2	Nut	NAS1726-4E	Item 7	
2	Pin Hi-Lok	DAN6-6-6	Item 17	
2	Collar	NSA5075W6	Item 15	
2	Bolt	NSA5031-3-8	Item 8	
2	Washer	NAS1149C0332R	Item 3	
2	Nut	NAS1726-3E	Item 6	

NOTE: Wet assemble the Bolts, Items 8 and 12, and the Pins Hi-Lok, Item 17, with:

Non Hardening Jointing Putty	06LCB1	As required

4 Do the adjustment/test procedure as specified in the installation of the support assembly before you apply the torque to the Nuts, Items 6 and 7, refer to AMM 52-33-32-400-801.

5 Torque the Nuts, Item 6, to between 0.35 and 0.45 daNm (31 and 39.9 lbf in).

6 Torque the Nuts, Item 7, to between 0.70 and 0.80 daNm (62 and 71 lbf in).

(11) Subtask 533275-930-201-002 - Re-identify the Support Assembly and Serrated Plate on FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

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Material necessary to do the job

Reidentified part set REIDD01					
ITEM	NEW PART N˚	KEYWORD	ITEM	OLD PART N˚	SEE NOTES
19	A5397802600800	SUPPORT	(19)	A5397802600400	
26	A5397805221600	PLATE	(26)	A5397805221200	

References	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12

(a) Re-identify the items that follow, refer to Process and Material Specification (PMS) 01-06-12:

1	Support Assy	A5397802600400	Item (19)
	becomes:		
1	Support Assy	A5397802600800	Item 19
	and		
1	Plate-Serrated	A5397805221200	Item (26)
	becomes:		
1	Plate-Serrated	A5397805221600	Item 26

(12) Subtask 533275-930-202-002 - Re-identify the Support Assembly on FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	0.25
Minimum number of person	1
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Reidentified part set REIDD02					
ITEM	NEW PART N˚	KEYWORD	ITEM	OLD PART N˚	SEE NOTES
20	A5397802601000	SUPPORT	(20)	A5397802600600	

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References	
Process and Material Specification (PMS)	Process and Material Specification (PMS) 01-06-12

(a) Re-identify the item that follows, refer to Process and Material Specification (PMS) 01-06-12:

1	Support Assy	A5397802600600	Item (20)
	becomes:		
1	Support Assy	A5397802601000	Item 20

(13) Subtask 533275-914-201-002 - Apply the Sealants and Corrosion Preventive Compounds to the Support and Spigot Assemblies at FR67 and FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Coating-Flexible Structure	04QAB2	As required	
	Polysulfide Sealant-General Purpose Fillet	06AAB1	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	

References	
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-23-12 51-75-12
Fig. A-GBAAB Modification of the Bulk Cargo Door Frames at FR67 and FR69	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

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NOTE: Do this subtask after the adjustment/test procedure as specified in SUBTASK 533275-700-201 001 Test .

(a) Apply the Sealants and Corrosion Preventive Compounds.

Refer to Fig. A-GBAAB Sheet 02, Fig. A-GBAAB Sheet 03, Fig. A-GBAAB Sheet 04 and Fig. A-GBAAB Sheet 05.

1 Do a fillet seal around the support assembly with:

Polysulfide Sealant-General Purpose Fillet	06AAB1	As required

2 Renew the protective finish:

Refer to Fig. A-GBAAB Sheet 02, Fig. A-GBAAB Sheet 03, Fig. A-GBAAB Sheet 04 and Fig. A-GBAAB Sheet 05 and in accordance with SRM 51-75-12:

Coating-Flexible Structure	04QAB2	As required

3 Apply corrosion preventive compound to all exposed surfaces:

Refer to Fig. A-GBAAB Sheet 02, Fig. A-GBAAB Sheet 03, Fig. A-GBAAB Sheet 04 and Fig. A-GBAAB Sheet 05 and in accordance withSRM 51-23-12:

Corrosion Preventive Compound-Soft	12ABC1	As required
or		
Corrosion Preventive Compound-Hard	12ABB1	As required

(14) Subtask 533275-410-201-001 - Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR67

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67

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

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Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	DIN65399-4020BF	8	RIVET	
52	NAS1921B05S03U	3	RIVET	

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

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane-Gray Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-400-801
Structural Repair Manual (SRM)	51-24-00 51-42-00 51-75-12
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Install the lower attachment parts of the RH support strut at Frame 67, refer to AMM Task 53-43-11-400-801.

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(b) Install the cover at Frame 67, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 02, View B and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Wet install the rivets in the step below with:

Polysulfide Sealant-General Purpose Brushable	06AAA1	As required

2 Install:

1	Cover		Item (51)	Retained at removal
	attach with:			
8	Rivet	DIN65399-4020BF	Item 50	
3	Rivet	NAS1921B05S03U	Item 52	

3 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required
made moist with:		
Non Aqueous Cleaner-General	08BAA9	As required

4 Renew the protective finish of the rivets in accordance with SRM 51-75-12:

Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane-Gray Internal Structure	04JME4	As required

5 Apply to all exposed surfaces which you touched or moved:

Corrosion Preventive Compound-Soft	12ABC1	As required
or		
Corrosion Preventive Compound-Hard	12ABB1	As required

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(15) Subtask 533275-410-202-001 - Install the Items Removed for Access at the Location of the Door Support Fitting-Upper FR69

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 69

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	AIRFRAME

Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
50	DIN65399-4020BF	8	RIVET	

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

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane-Gray Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet	06AAB1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Corrosion Preventive Compound-Hard	12ABB1	As required	
	Corrosion Preventive Compound-Soft	12ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-43-11-400-801
Structural Repair Manual (SRM)	51-24-00 51-42-00 51-75-12

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References	
Fig. A-GBBAA Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Install the lower attachment parts of the RH support strut at Frame 69, refer to AMM Task 53-43-11-400-801.

(b) Install the section between Frame 69 and Frame 71, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 04, View D and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Apply between the structure at Frame 69 and the Section, item (54):

Polysulfide Sealant-General Purpose Fillet	06AAB1	As required

2 Install:

1	Cover		Item (54)	Retained at removal
	attach with:			
4	Screw	NAS1102E3-8	Item (55)	Retained at removal
4	Washer	NAS1169-10L	Item (56)	Retained at removal
3	Nut	NAS1291C3M	Item (58)	Retained at removal
3	Washer	NAS1149D1165K	Item (57)	Retained at removal
1	Screw	NAS1102E08-7	Item (59)	Retained at removal
1	Washer	NAS1169C8L	Item (60)	Retained at removal

(c) Install the cover at Frame 69, refer to Fig. A-GBBAA Sheet 01, View A and Fig. A-GBBAA Sheet 03, View C and in accordance with SRM 51-24-00 and SRM 51-42-00:

1 Install:

1	Cover		Item (53)	Retained at removal

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attach with:

1	Screw	NAS1102E3-8	Item (55)	Retained at removal
1	Washer	NAS1169-10L	Item (56)	Retained at removal

and as per the applicable alternative installation shown on Fig. A-GBBAA Sheet 03, View C, with:

8	Rivet	DIN65399-4020BF	Item 50

or

7	Rivet	DIN65399-4020BF	Item 50

2 Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with:

Non Aqueous Cleaner-General	08BAA9	As required

3 Renew the protective finish of the rivets in accordance with SRM 51-75-12:

Primer Epoxy Paint-Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane-Gray Internal Structure	04JME4	As required

4 Apply to all exposed surfaces which you touched or moved:

Corrosion Preventive Compound-Soft	12ABC1	As required

or

Corrosion Preventive Compound-Hard	12ABB1	As required

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**CONF ALL

D. TEST

**CONF 001

(1) Subtask 533275-700-201-001 - Test

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801 Task 52-33-32-400-802

(a) Do the adjustment/test procedure as specified in the installation of the support assembly, refer to AMM Task 52-33-32-400-801.

(b) Do the operational test procedures as specified in the installation of the latch spigot assembly, refer to AMM Task 52-33-32-400-802.

**CONF 002

(1) Subtask 533275-700-201-001 - Test

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801 Task 52-33-32-400-802

(a) Do the adjustment/test procedure as specified in the installation of the support assembly, refer to AMM Task 52-33-32-400-801.

(b) Do the operational test procedures as specified in the installation of the latch spigot assembly, refer to AMM Task 52-33-32-400-802.

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**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 533275-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801 Task 52-33-32-400-802

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

(b) Do the close-up procedure as specified in the installation of the latch spigot assembly, refer to AMM Task 52-33-32-400-802.

(c) Do the close-up procedure as specified in the installation of the support assembly, refer to AMM Task 52-33-32-400-801.

(d) Remove the access platform(s).

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

**CONF 002

(1) Subtask 533275-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	823	Work location	Frame 67 Frame 69

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 52-33-32-400-801 Task 52-33-32-400-802

(a) Make sure that the work areas are clean and clear of tools and other items of equipment.

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(b) Do the close-up procedure as specified in the installation of the latch spigot assembly, refer to AMM Task 52-33-32-400-802.

(c) Do the close-up procedure as specified in the installation of the support assembly, refer to AMM Task 52-33-32-400-801.

(d) Remove the access platform(s).

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

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**CONF 001

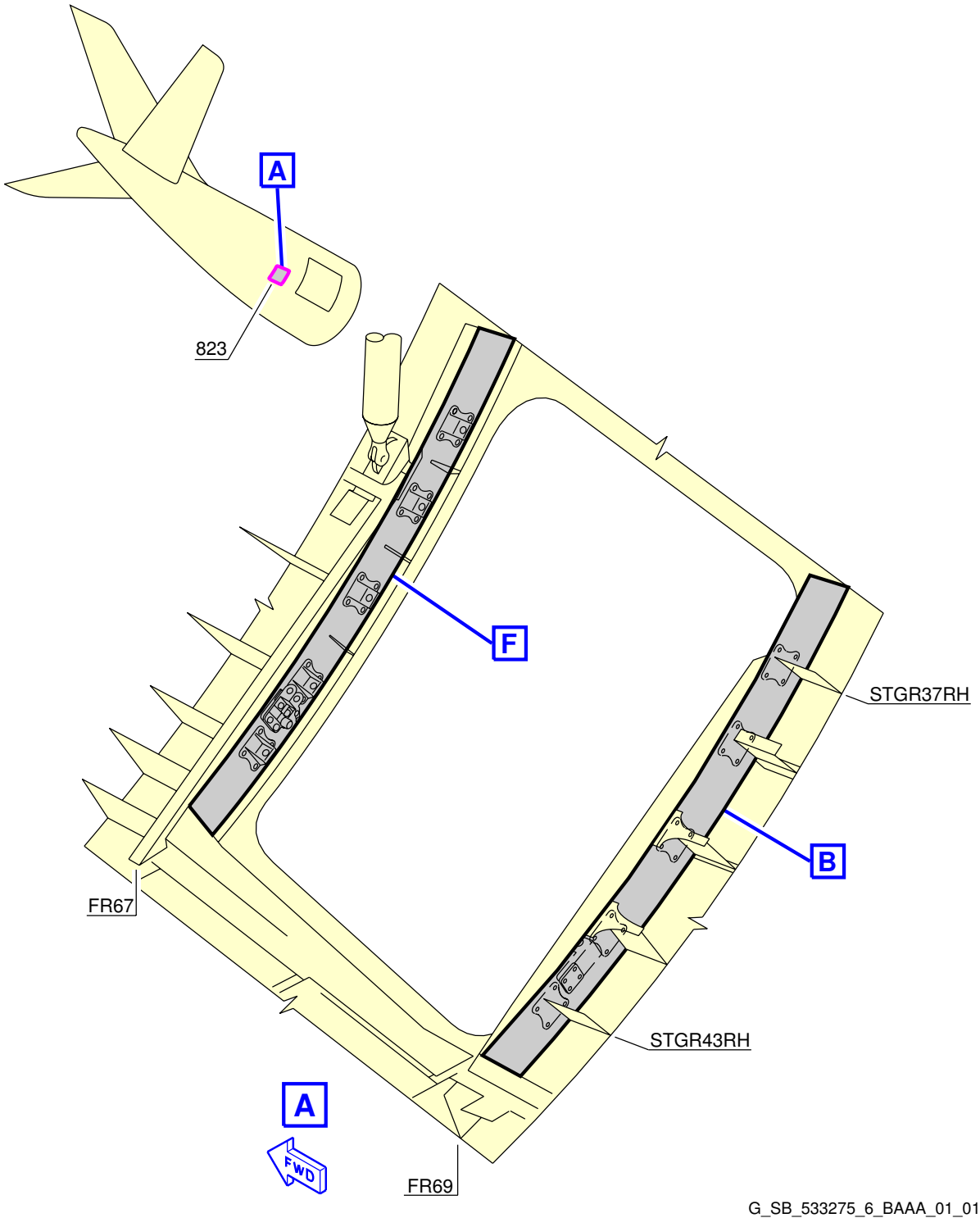
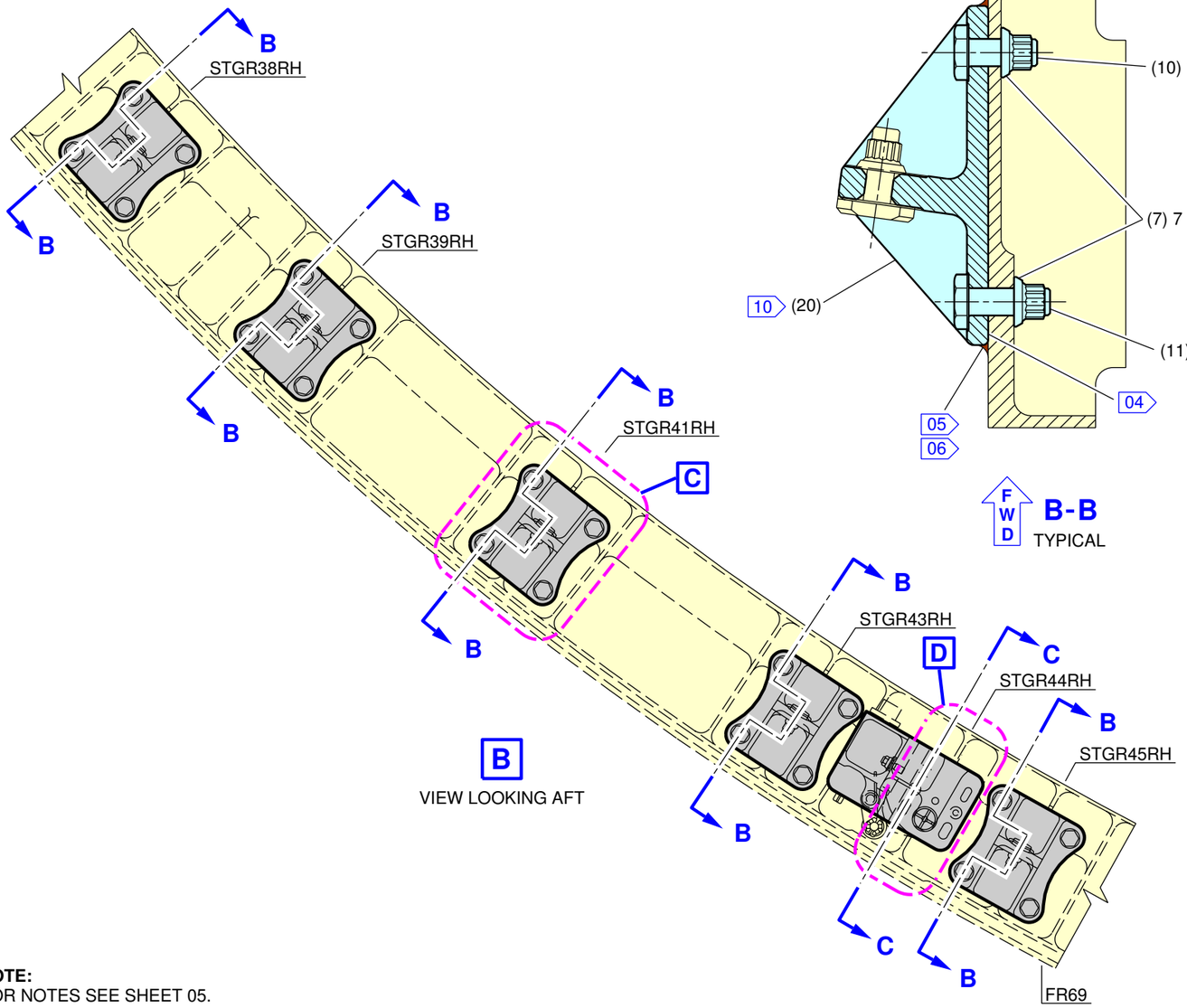
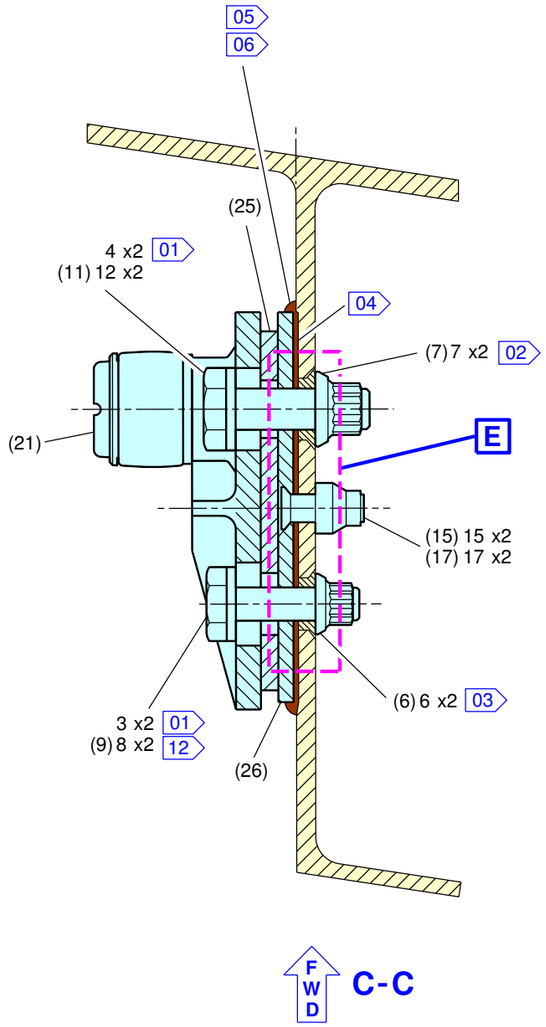


Figure A-GBAAA - Sheet 01
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 001





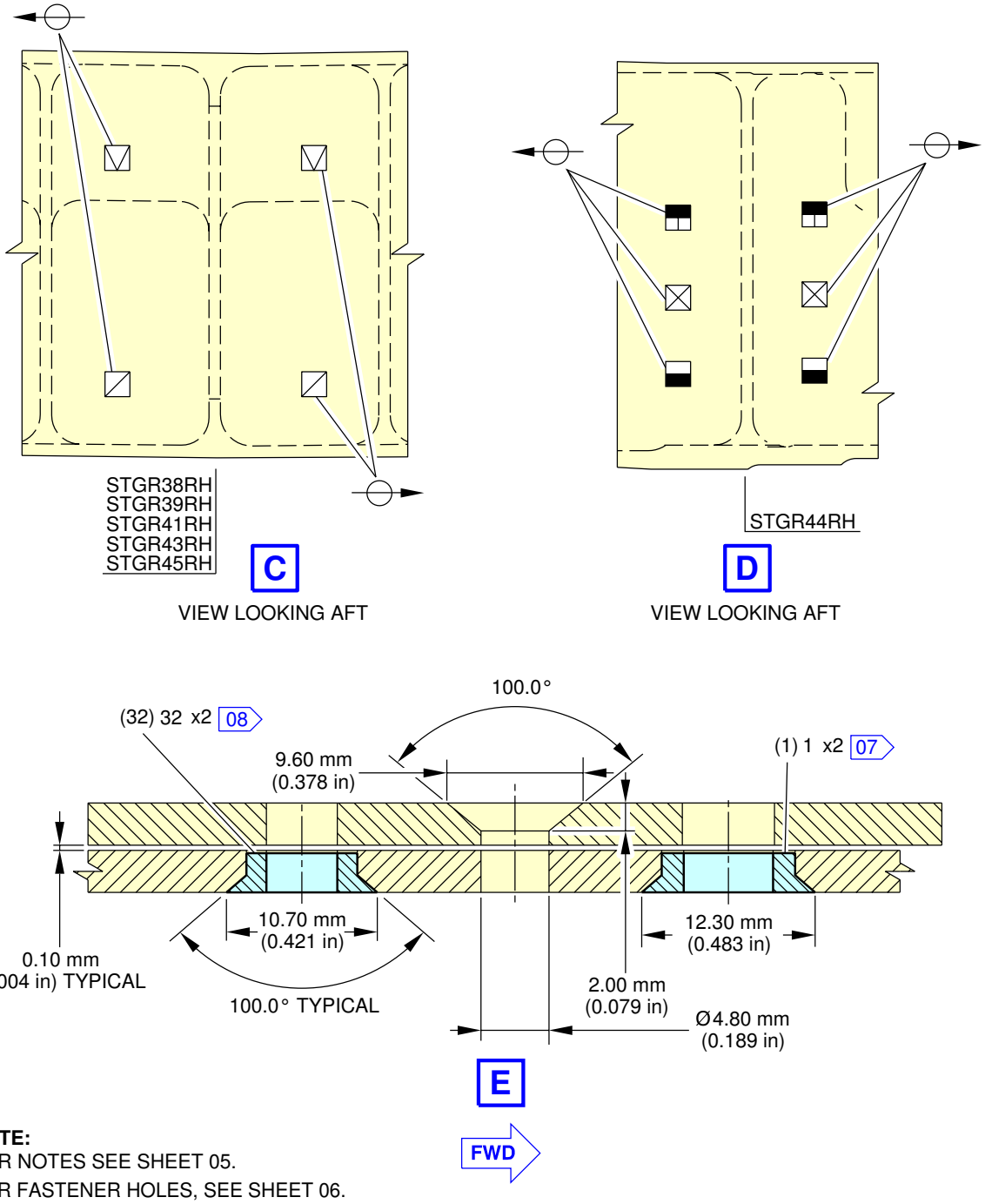
NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

G_SB_533275_6_BAAA_02_05

Figure A-GBAAA - Sheet 02
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 001



NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

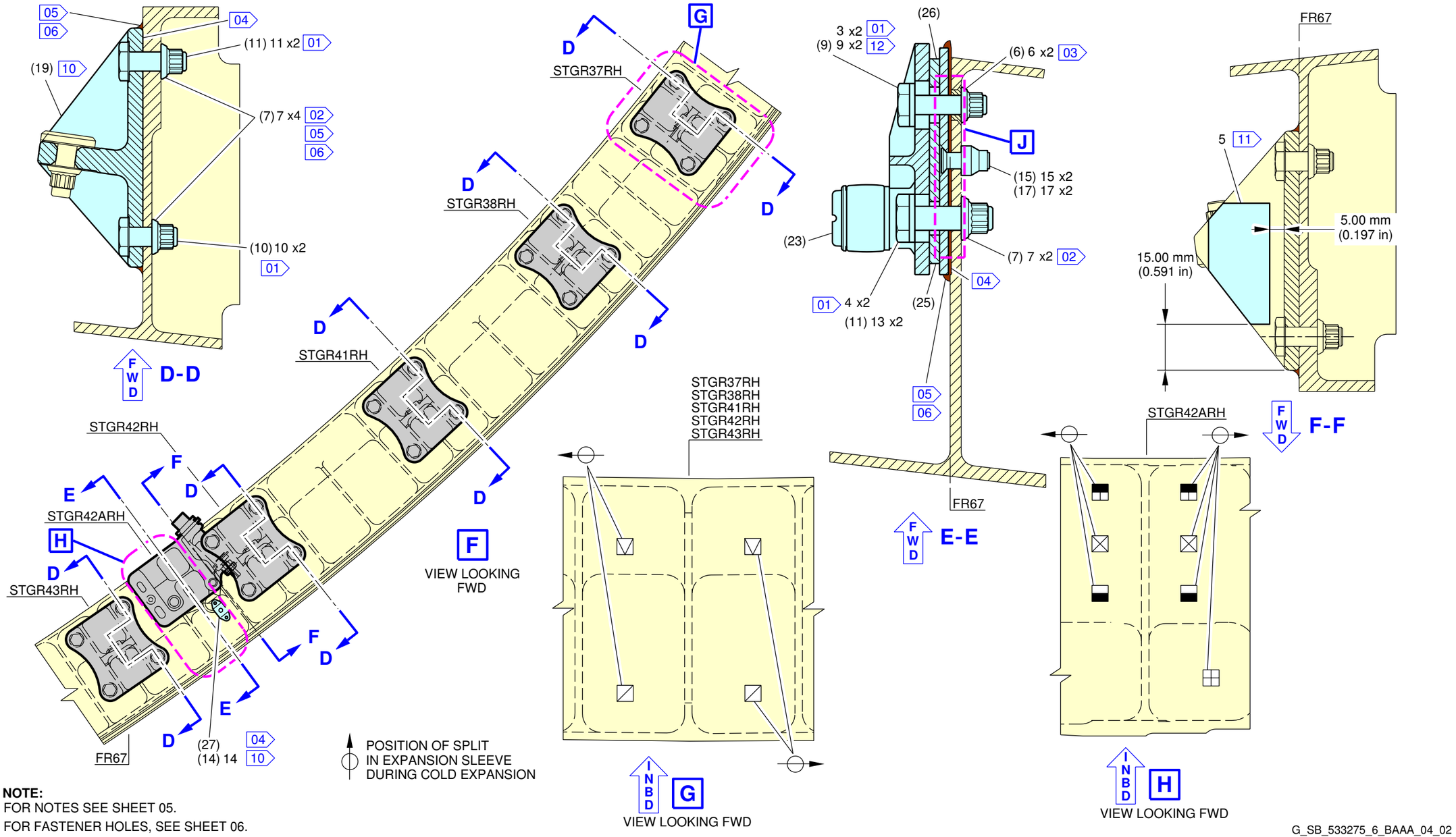
POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

G_SB_533275_6_BAAA_03_06

Figure A-GBAAA - Sheet 03
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 001



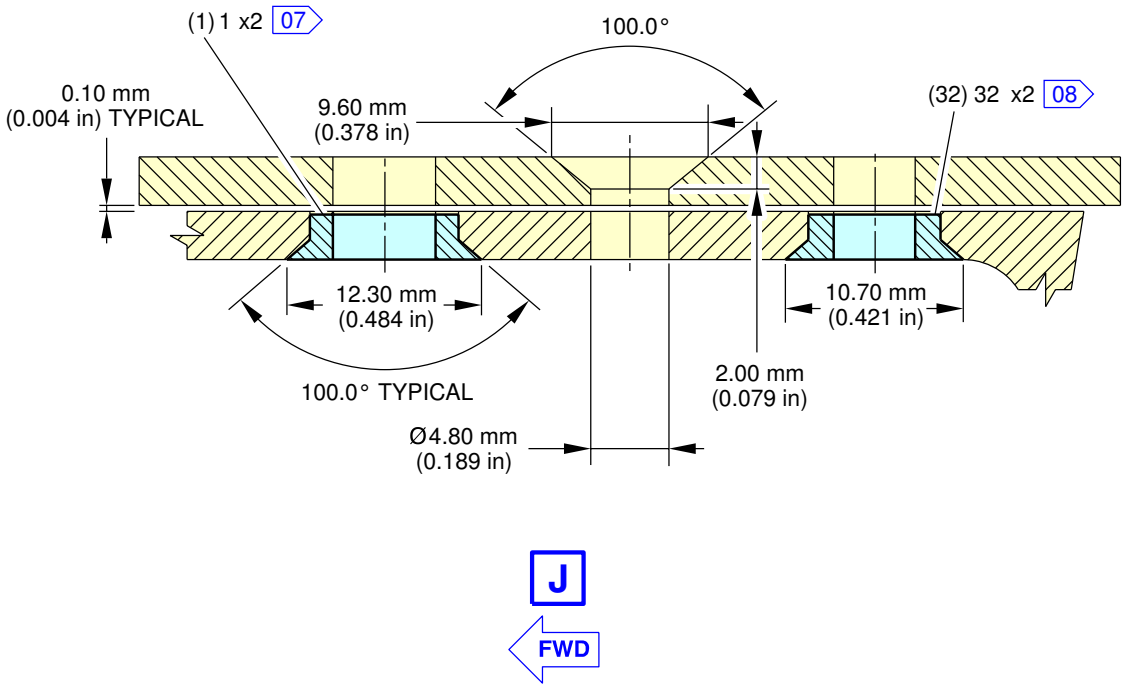
NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

G_SB_533275_6_BAAA_04_02

Figure A-GBAAA - Sheet 04
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 001



NOTE:

01 INSTALL WITH JOINT PUTTY MATERIAL No 06LCB1.

02 TORQUE 0.70 – 0.80 daNm (31 – 39.9 lbf in).

03 TORQUE 0.35 – 0.45 daNm (62 – 71 lbf in).

04 INSTALL WITH INTERFAY SEALANT MATERIAL No 06AAC1.

05 AFTER INSTALLATION APPLY FILLET SEALANT MATERIAL No 06AAB1.

06 APPLY FLEXIBLE COATING MATERIAL No 04QAB2 AND CORROSION PREVENTATIVE COMPOUND MATERIAL No 12ABC1 OR 12ABB1.

07 6.500 mm (0.2559 in) DRILLING IN BUSH AFTER INSTALLATION.

08 5.000 mm (0.1968 in) DRILLING IN BUSH AFTER INSTALLATION.

09 AFTER INSTALLATION APPLY CORROSION PREVENTATIVE COMPOUND MATERIAL No 12ABC1 TO RIVET HEADS.

10 REAM HOLES TO 7.130 mm (0.2807 in) MIN TO 7.205 mm (0.2837 in) MAX.

11 CHAFING PATCH RENEW IF NECESSARY.

G_SB_533275_6_BAAA_05_03

Figure A-GBAAA - Sheet 05
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 001

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	START HOLE DIAMETER MIN	START HOLE DIAMETER MAX	STDN	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE FIT TYPE	REMARKS
☒	(17)	17	DAN6–6–6	HI–LOK	4.500 mm (0.1772 in)	4.575 mm (0.1801 in)	6–0–N	4.730 mm (0.1862 in)	4.805 mm (0.1891 in)	FIRST OVERSIZE	N/A 12
	(15)	15	NSA5075W6	NUT							
⊘	(10)	10	ABS0114T4–5Y	BOLT	6.760 mm (0.2661 in)	6.835 mm (0.2691 in)	8–2–N	7.300 mm (0.2874 in)	7.375 mm (0.2903 in)	FIRST OVERSIZE	N/A 12
	(7)	7	NAS1726–4E	NUT							
▽	(11)	11	ABS0114T4–7Y	BOLT	6.760 mm (0.2661 in)	6.835 mm (0.2691 in)	8–2–N	7.300 mm (0.2874 in)	7.375 mm (0.2903 in)	FIRST OVERSIZE	N/A 12
	(7)	7	NAS1726–4E	NUT							
▬	(1)	1	F5327127020800	BUSH	8.740 mm (0.3441 in)	8.815 mm (0.3471 in)	10–3–N	9.400 mm (0.3701 in)	9.412 mm (0.3706 in)	FIRST OVERSIZE	DRILL/REAM BUSH AFTER INSTALLATION TO 6.500 mm (0.2559 in) 12
▬	(32)	32	F5327127020200	BUSH	7.190 mm (0.2831 in)	7.265 mm (0.2860 in)	8–3–N	7.800 mm (0.3071 in)	7.812 mm (0.3076 in)	FIRST OVERSIZE	DRILL/REAM BUSH AFTER INSTALLATION TO 5.000 mm (0.1968 in) 12
⊞	–	–	MS21059106	NUT–PLATE HOLE	5.310 mm (0.2090 in)	5.385 mm (0.2120 in)	6–2–N	5.540 mm (0.2184 in)	5.615 mm (0.2211 in)	FIRST OVERSIZE	NUT–PLATE, ITEM (27) REMOVED BEFORE COLD WORKING 12

NOTE:
12 COLD WORK ONLY THE FRAME IN ACCORDANCE WITH SRM 51–48–00, 4% EXPANSION.

G_SB_533275_6_BAAA_06_00

Figure A-GBAAA - Sheet 06
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002

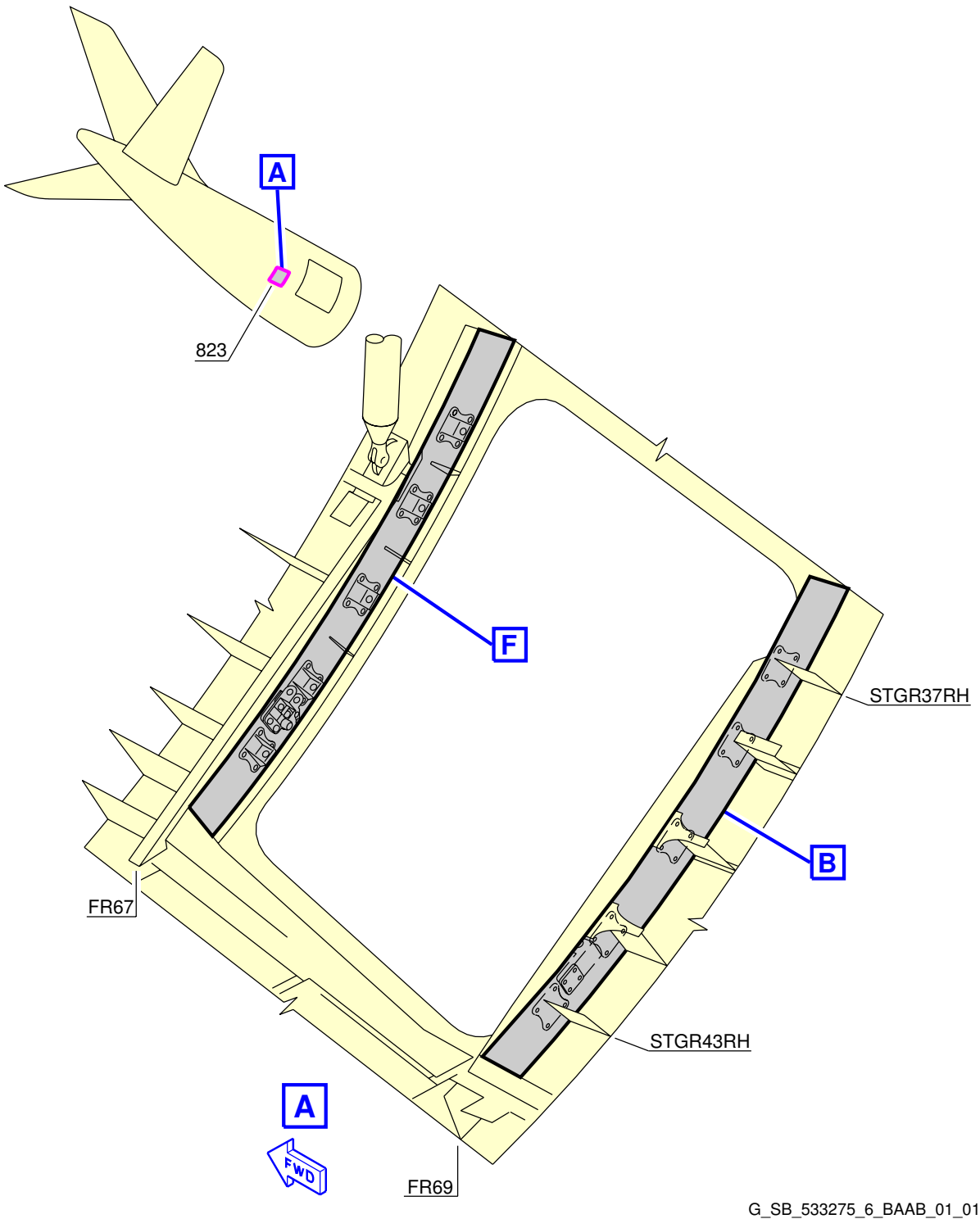
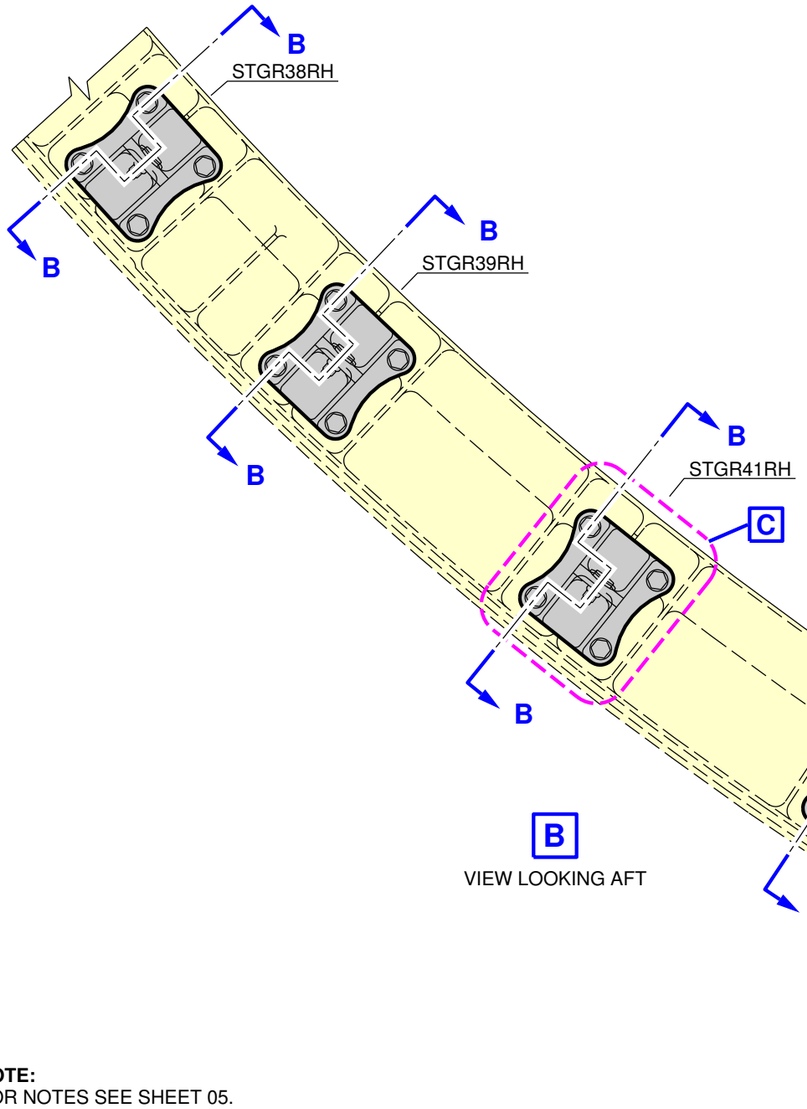
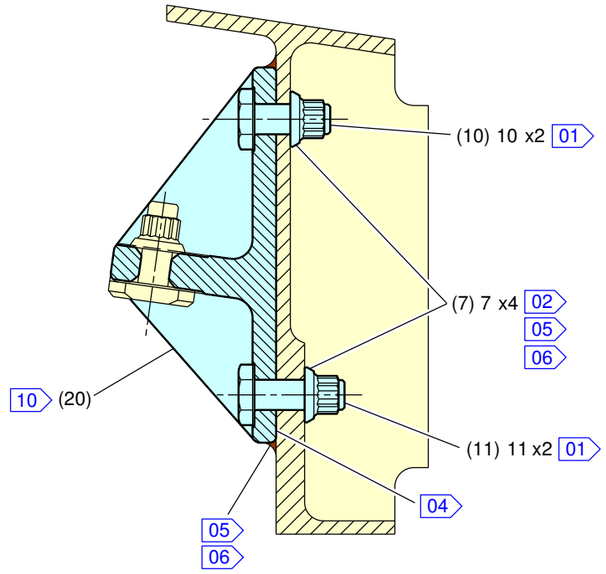


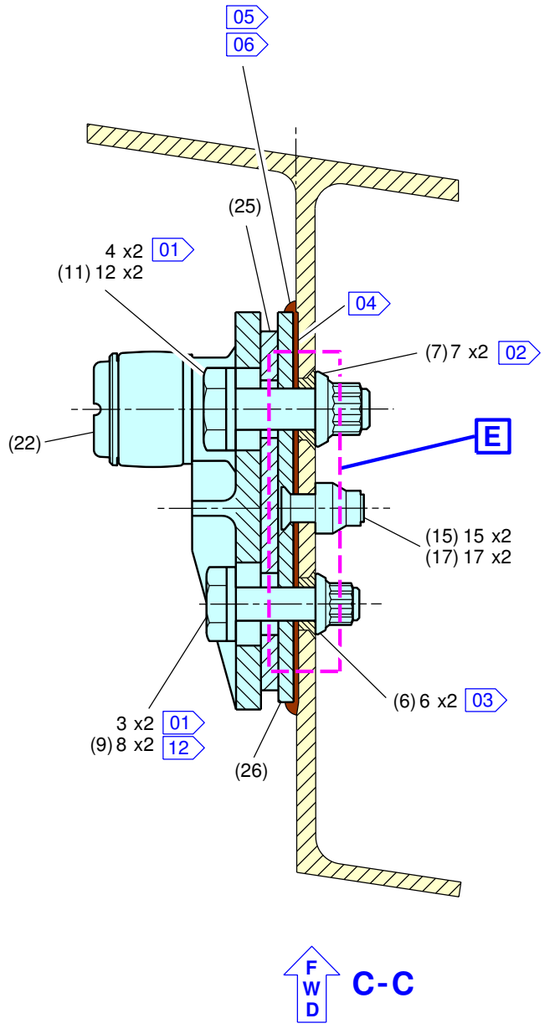
Figure A-GBAAB - Sheet 01
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002







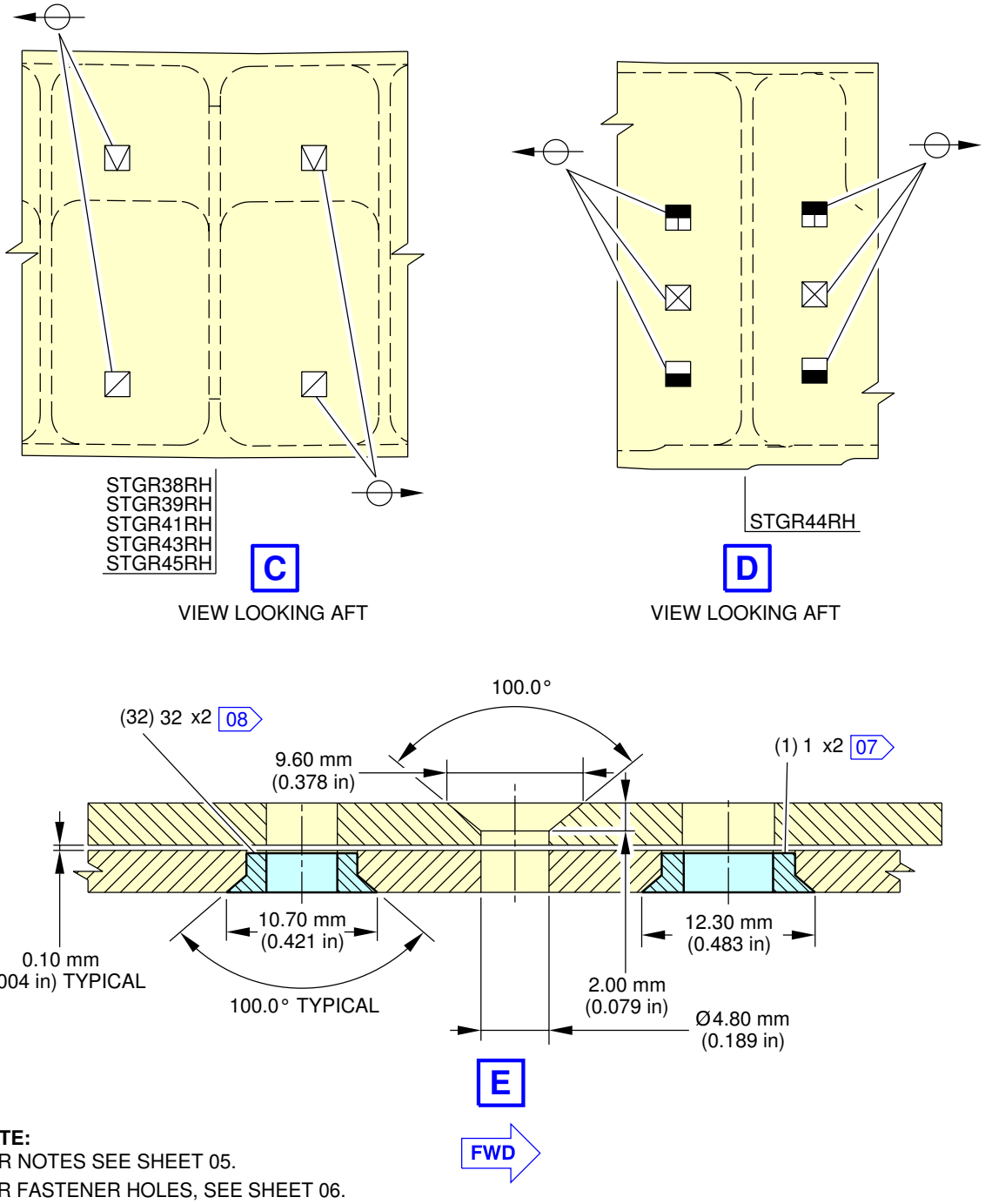
NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

G_SB_533275_6_BAAB_02_05

Figure A-GBAAB - Sheet 02
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002



NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

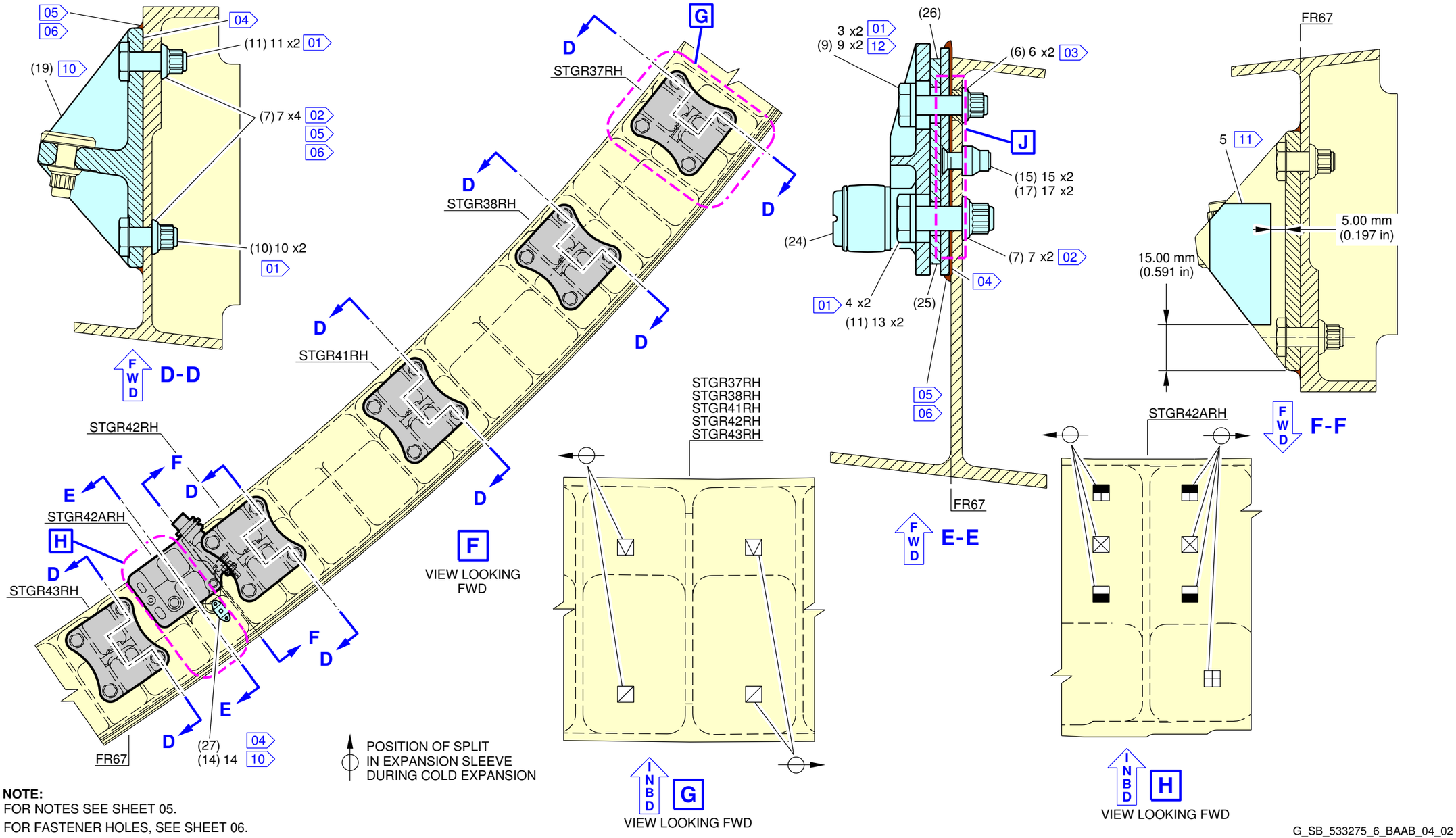
POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION

G_SB_533275_6_BAAB_03_06

Figure A-GBAAB - Sheet 03
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002



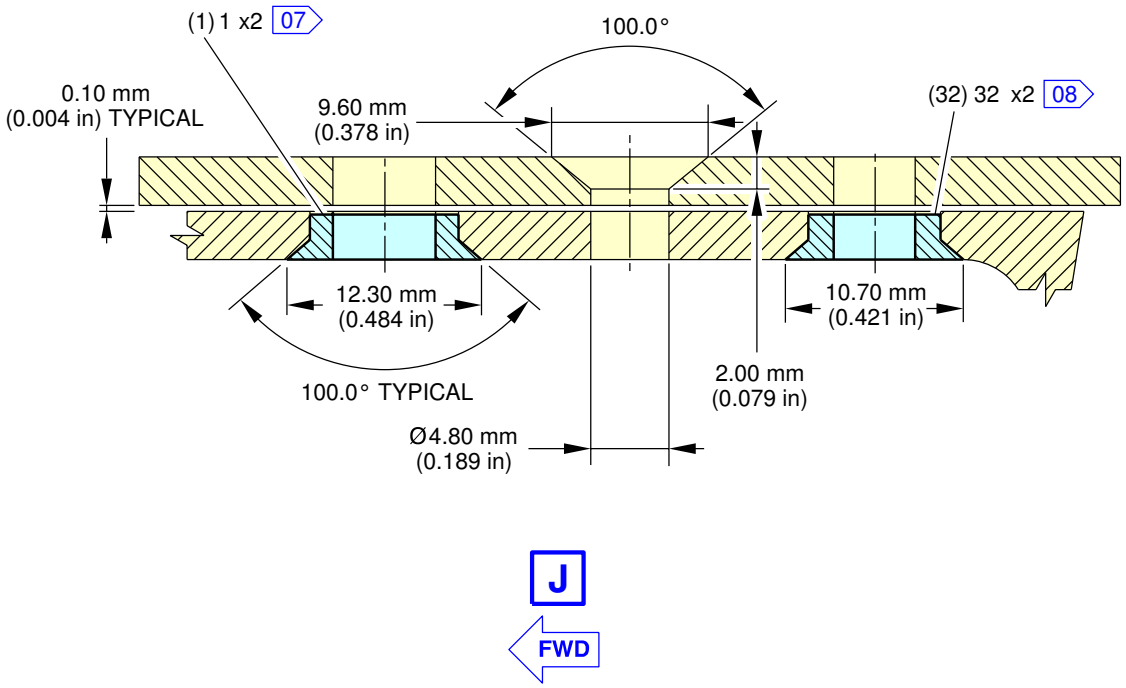
NOTE:
FOR NOTES SEE SHEET 05.
FOR FASTENER HOLES, SEE SHEET 06.

G_SB_533275_6_BAAB_04_02

Figure A-GBAAB - Sheet 04
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002



NOTE:

01 INSTALL WITH JOINT PUTTY MATERIAL No 06LCB1.

02 TORQUE 0.70 – 0.80 daNm (31 – 39.9 lbf in).

03 TORQUE 0.35 – 0.45 daNm (62 – 71 lbf in).

04 INSTALL WITH INTERFAY SEALANT MATERIAL No 06AAC1.

05 AFTER INSTALLATION APPLY FILLET SEALANT MATERIAL No 06AAB1.

06 APPLY FLEXIBLE COATING MATERIAL No 04QAB2 AND CORROSION PREVENTATIVE COMPOUND MATERIAL No 12ABC1 OR 12ABB1.

07 6.500 mm (0.2559 in) DRILLING IN BUSH AFTER INSTALLATION.

08 5.000 mm (0.1968 in) DRILLING IN BUSH AFTER INSTALLATION.

09 AFTER INSTALLATION APPLY CORROSION PREVENTATIVE COMPOUND MATERIAL No 12ABC1 TO RIVET HEADS.

10 REAM HOLES TO 7.130 mm (0.2807 in) MIN TO 7.205 mm (0.2837 in) MAX.

11 CHAFING PATCH RENEW IF NECESSARY.

G_SB_533275_6_BAAB_05_03

Figure A-GBAAB - Sheet 05
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF 002

HOLE SYMBOL	OLD ITEM	NEW ITEM	PART NUMBER	DESCRIPTION	START HOLE DIAMETER MIN	START HOLE DIAMETER MAX	STDN	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE FIT TYPE	REMARKS
⊠	(17)	17	DAN6–6–6	HI–LOK	4.500 mm (0.1772 in)	4.575 mm (0.1801 in)	6–0–N	4.730 mm (0.1862 in)	4.805 mm (0.1891 in)	FIRST OVERSIZE	N/A 12
	(15)	15	NSA5075W6	NUT							
⊘	(10)	10	ABS0114T4–5Y	BOLT	6.760 mm (0.2661 in)	6.835 mm (0.2691 in)	8–2–N	7.300 mm (0.2874 in)	7.375 mm (0.2903 in)	FIRST OVERSIZE	N/A 12
	(7)	7	NAS1726–4E	NUT							
▽	(11)	11	ABS0114T4–7Y	BOLT	6.760 mm (0.2661 in)	6.835 mm (0.2691 in)	8–2–N	7.300 mm (0.2874 in)	7.375 mm (0.2903 in)	FIRST OVERSIZE	N/A 12
	(7)	7	NAS1726–4E	NUT							
▬	(1)	1	F5327127020800	BUSH	8.740 mm (0.3441 in)	8.815 mm (0.3471 in)	10–3–N	9.400 mm (0.3701 in)	9.412 mm (0.3706 in)	FIRST OVERSIZE	DRILL/REAM BUSH AFTER INSTALLATION TO 6.500 mm (0.2559 in) 12
⊟	(32)	32	F5327127020200	BUSH	7.190 mm (0.2831 in)	7.265 mm (0.2860 in)	8–3–N	7.800 mm (0.3071 in)	7.812 mm (0.3076 in)	FIRST OVERSIZE	DRILL/REAM BUSH AFTER INSTALLATION TO 5.000 mm (0.1968 in) 12
⊞	–	–	MS21059106	NUT–PLATE HOLE	5.310 mm (0.2090 in)	5.385 mm (0.2120 in)	6–2–N	5.540 mm (0.2184 in)	5.615 mm (0.2211 in)	FIRST OVERSIZE	NUT–PLATE, ITEM (27) REMOVED BEFORE COLD WORKING 12

NOTE:
12 COLD WORK ONLY THE FRAME IN ACCORDANCE WITH SRM 51–48–00, 4% EXPANSION.

G_SB_533275_6_BAAB_06_00

Figure A-GBAAB - Sheet 06
Modification of the Bulk Cargo Door Frames at FR67 and FR69

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**CONF ALL

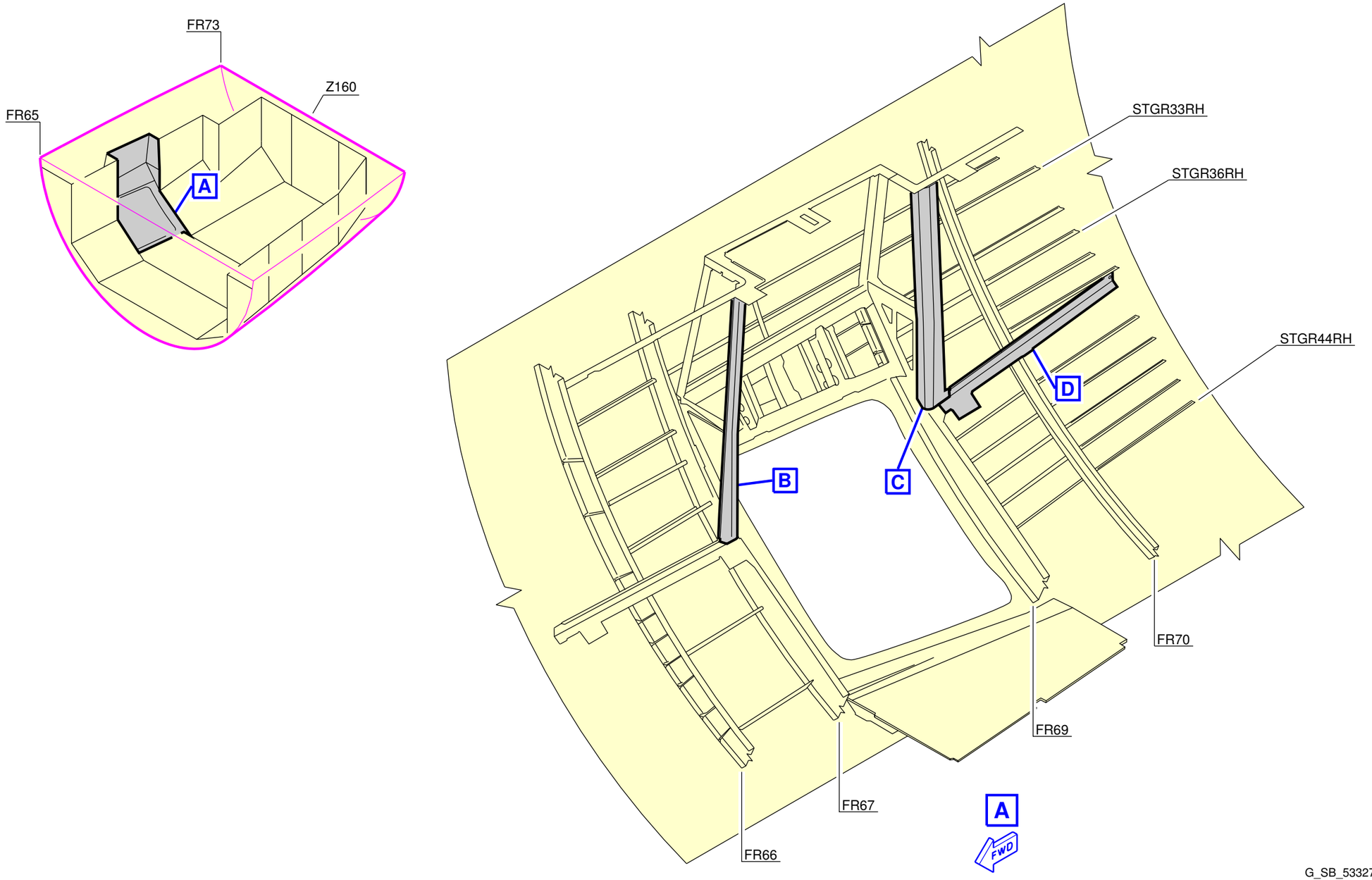
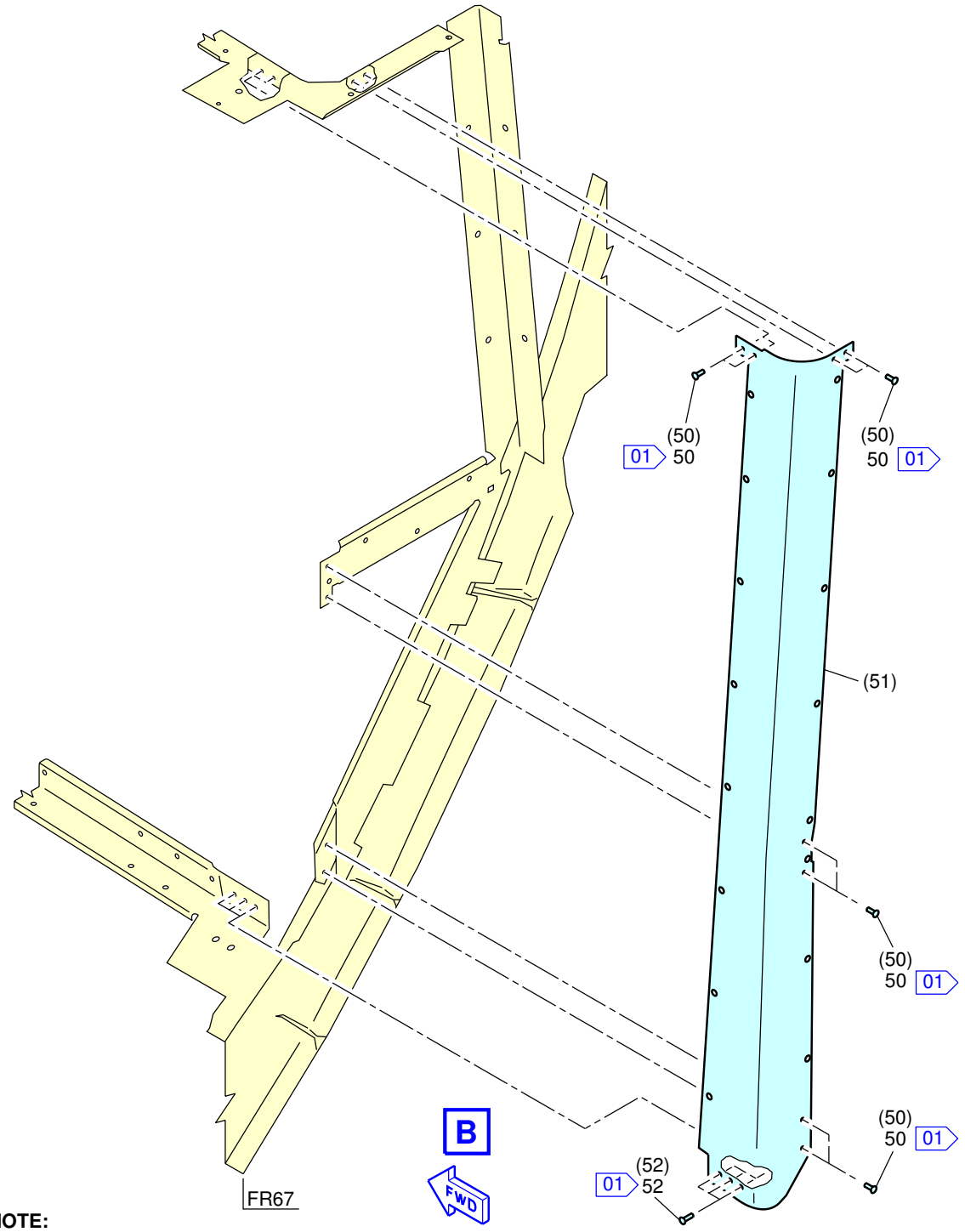


Figure A-GBBAA - Sheet 01
Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper

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**CONF ALL



NOTE:

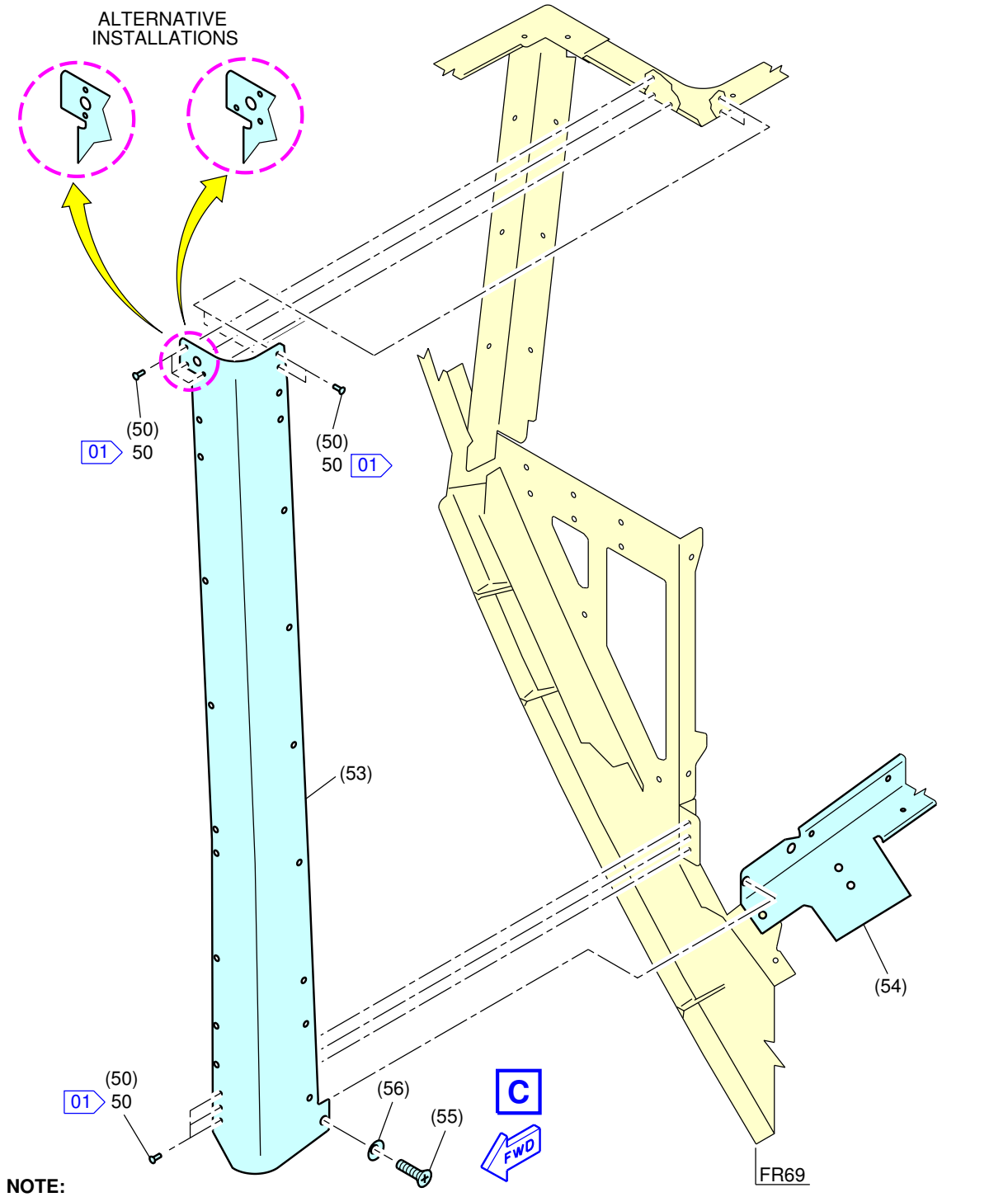
01 WET INSTALL WITH SEALANT MATERIAL No 06AAA1.

G_SB_533275_6_BBAA_02_00

Figure A-GBBAA - Sheet 02
Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper

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**CONF ALL



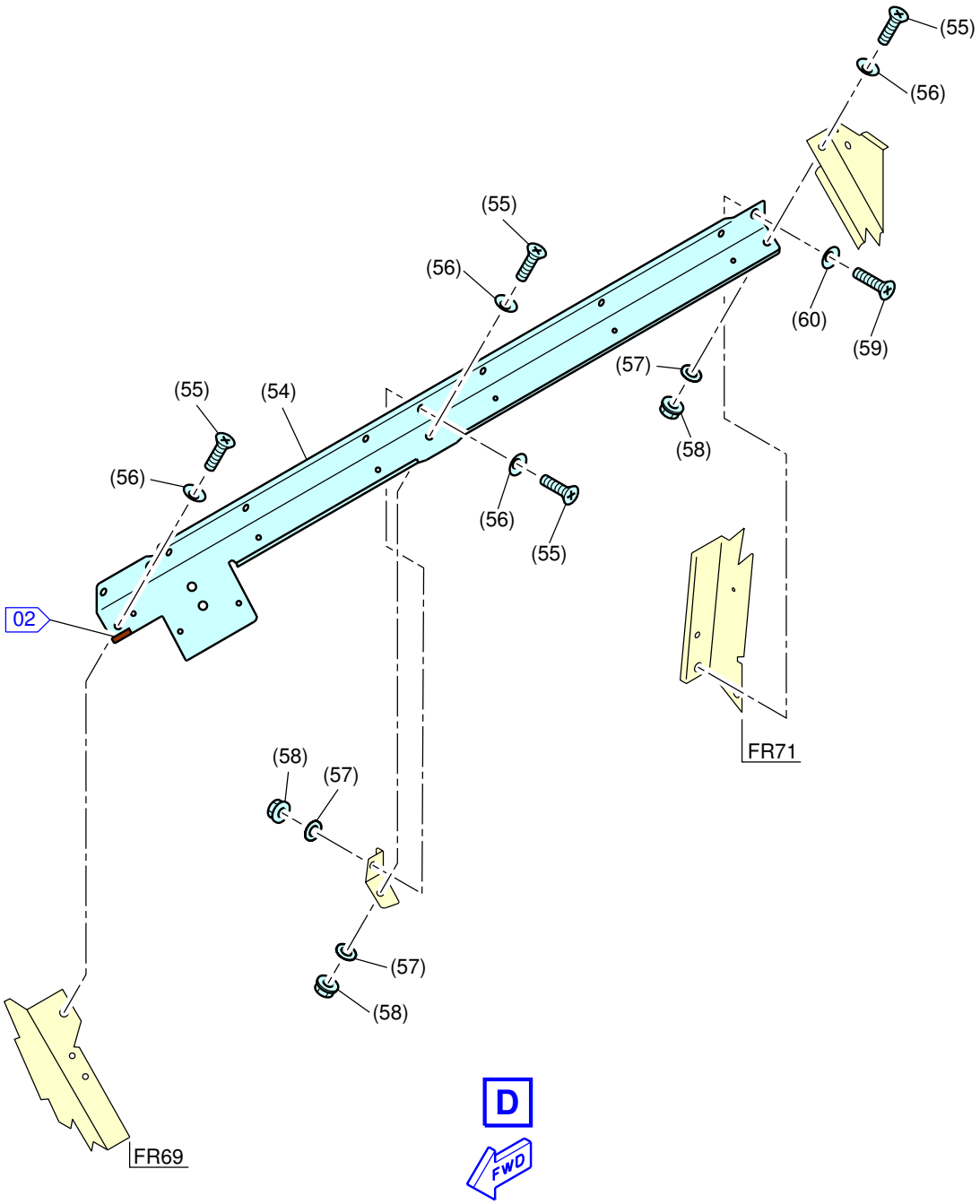
NOTE:

01 WET INSTALL WITH SEALANT MATERIAL No 06AAA1.

Figure A-GBBAA - Sheet 03
Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper

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**CONF ALL



NOTE:

02 APPLY INTERFAY SEALANT AND A BEAD OF SEALANT ON THE LOWER EDGE MATERIAL No 06AAB1.

G_SB_533275_6_BBAA_04_00

Figure A-GBBAA - Sheet 04
Removal/Installation of the Covers for Modification of FR67 and FR69 at the Location of the Door Support Fittings-Upper

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**CONF ALL

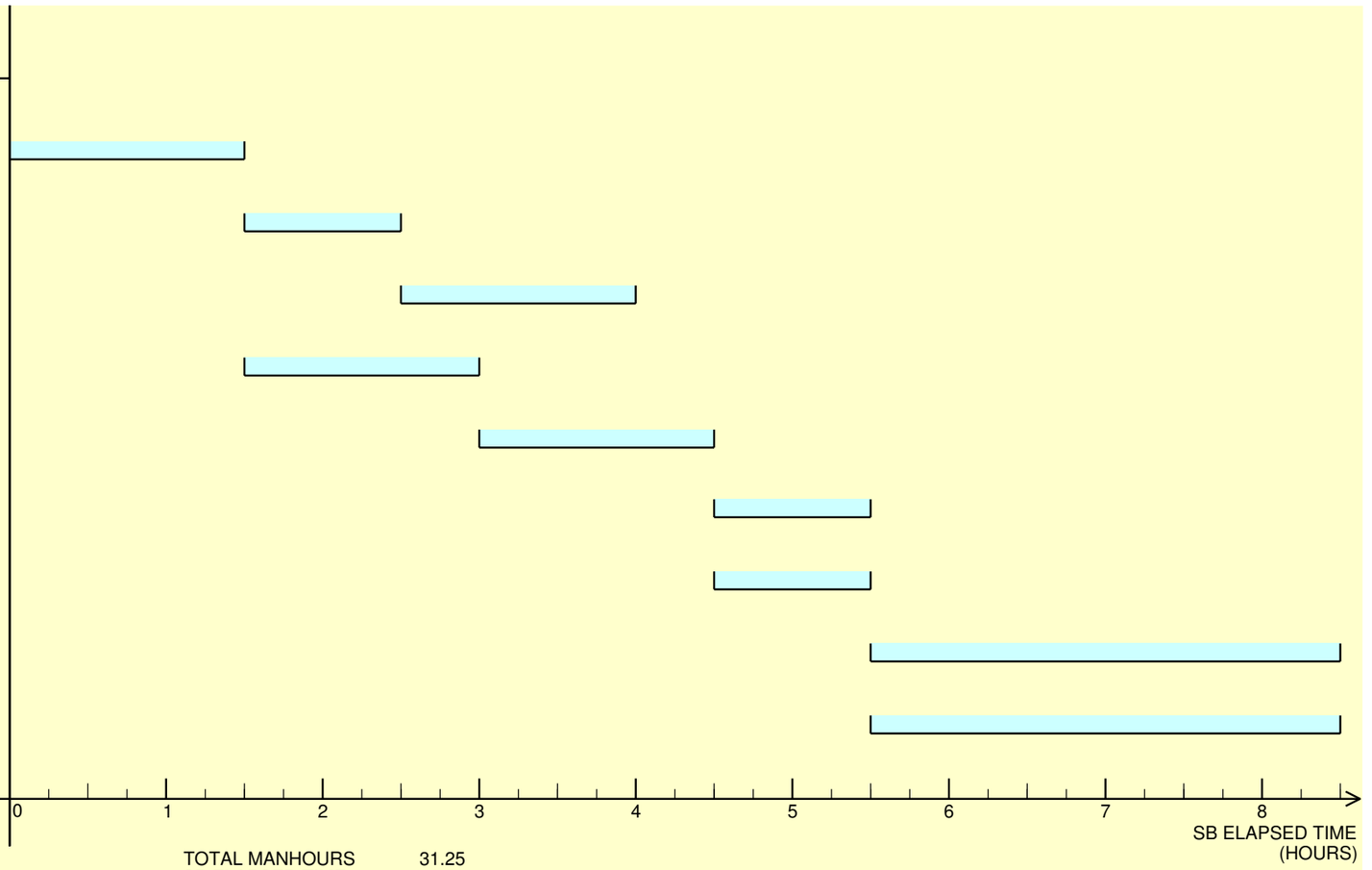
For an explanation of the manhours and elapsed time, refer to the next page(s).

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**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A330–53–3275 01 02

STEPS	MH	PER	ET/S
GET ACCESS	3.00	2	1.50
GET ACCESS AT THE LOCATION OF THE DOOR SUPPORT FITTING–UPPER FR67	1.00	1	1.00
REMOVE THE FASTENERS AND THE SUPPORT ASSEMBLIES AT THE BULK CARGO DOOR FR67	1.50	1	1.50
GET ACCESS AT THE LOCATION OF THE DOOR SUPPORT FITTING–UPPER FR69	1.50	1	1.50
REMOVE THE FASTENERS AND THE SUPPORT ASSEMBLIES AT THE BULK CARGO DOOR FR69	1.50	1	1.50
DO THE EDDY CURRENT ROTATING PROBE INSPECTION OF THE FASTENERS HOLES AT FR67	1.00	1	1.00
DO THE EDDY CURRENT ROTATING PROBE INSPECTION OF THE FASTENERS HOLES AT FR69	1.00	1	1.00
DO THE COLD WORKING PROCESS OF THE FASTENER HOLES AT FR67 (FUSELAGE FRAME ONLY)	3.00	1	3.00
DO THE COLD WORKING PROCESS OF THE FASTENER HOLES AT FR69 (FUSELAGE FRAME ONLY)	3.00	1	3.00



TOTAL MANHOURS 31.25
SB ELAPSED TIME 16.50

NOTE:

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

G_SB_533275_6_AAAA_01_03

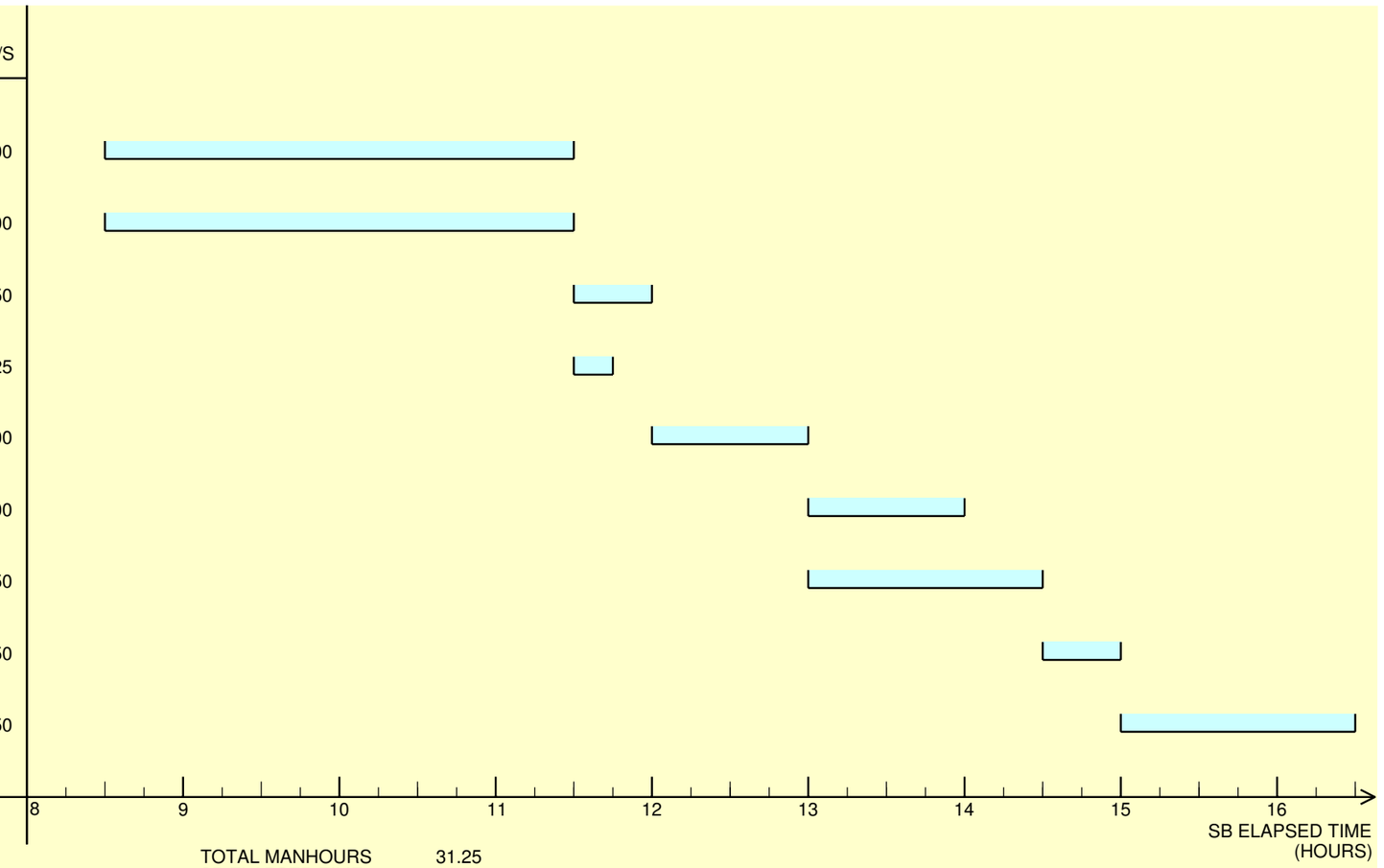
Figure A-GAAAA - Sheet 01
Manpower Gantt Chart

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**CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A330–53–3275 01 02

STEPS	MH	PER	ET/S
DO THE INSTALLATION OF THE SUPPORT AND SPIGOT ASSEMBLIES AT FR67	3.00	1	3.00
DO THE INSTALLATION OF THE SUPPORT AND SPIGOT ASSEMBLIES AT FR69	3.00	1	3.00
RE–IDENTIFY THE SUPPORT ASSEMBLY AND SERRATED PLATE ON FR67	0.50	1	0.50
RE–IDENTIFY THE SUPPORT ASSEMBLY ON FR69	0.25	1	0.25
APPLY THE SEALANTS AND CORROSION PREVENTATIVE COMPOUNDS AT FR67 AND FR69	2.00	2	1.00
INSTALL THE ITEMS REMOVED FOR ACCESS AT THE LOCATION OF THE DOOR SUPPORT FITTING–UPPER FR67	1.00	1	1.00
INSTALL THE ITEMS REMOVED FOR ACCESS AT THE LOCATION OF THE DOOR SUPPORT FITTING–UPPER FR69	1.50	1	1.50
TEST	0.50	1	0.50
CLOSE–UP	3.00	2	1.50
TOTAL MANHOURS	31.25		
SB ELAPSED TIME	16.50		



NOTE:

01 THIS CHART IS ONLY A PROPOSAL.
OPERATORS MAY DETERMINE THAT ANOTHER WAY TO DO THE WORK IS MORE SUITABLE FOR THEM.

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

MH : MANHOURS
PER : NUMBER OF PERSONS
ET/S: ELAPSED TIME PER STEP

G_SB_533275_6_AAAA_02_00

Figure A-GAAAA - Sheet 02
Manpower Gantt Chart

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TITLE: FUSELAGE - REAR FUSELAGE - REMOVE TSA IN THE FINAL HOLES OF S17 BULK CARGO DOOR FRAME C67 AND C69

MODIFICATION No.: 206409D52230

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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SERVICE BULLETIN
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:

Operator: Date:

Name/Title:

Please return this form to:

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE

Attn : SEM4 Service Bulletins Management
FAX : (33) 5 61 93 42 51

Or via your Resident Customer Support Office.

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