SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

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ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 (CENTER WING BOX)

MODIFICATION No.: 152104K15182

This page transmits Revision No.02 of Service Bulletin No.A320-53-1240

ADDITIONAL WORK

****CONF ALL**

No additional work is required by this revision for aircraft modified by any previous issue.

REASON

Revision No. 02 issued to incorporate the validation report findings after accomplishment of this Service Bulletin on aircraft with Manufacturer Serial Number (MSN) 0111.

CHANGES

The main changes of this revision are:

- Service Bulletin effectivity updated
- NOTES added to ACCOMPLISHMENT INSTRUCTIONS paragraph
- GENERAL EVALUATION TABLE updated
- MANPOWER TABLE updated
- Job Set-up paragraph updated
- Subtask 'Remove the Fasteners in the Pressure Panel at FR36' updated
- Subtasks within the PROCEDURE split in to Left Hand (LH) and Right Hand (RH) sides
- Preparation for Test paragraph updated
- Close-up paragraph updated
- Figures A-GCAAA, A-GCAAB and A-GCAAC revised

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- Figures A-GBAAA, A-GBAAB and A-GBAAC removed

- Appendix 01 - Manpower Gantt Chart updated.

FRONT MATTER		
FUSELAGE - CENTER FUSELAGE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 (CENTER WING BOX)	CONFIGURATION UPDATED	R
SUMMARY		
GENERAL EVALUATION	GENERAL EVALUATION TABLE UPDATED	R
EFFECTIVITY	OPERATOR LIST UPDATED	R
CONCURRENT REQUIREMENTS	CONCURRENT REQUIREMENTS UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
APPENDICES	APPENDICES UPDATED	R
PLANNING INFORMATION		
EFFECTIVITY	EFFECTIVITY RELATED INFORMATION UPDATED	R
Configuration definition		
CONF 002	CONFIGURATION DEFINITION UPDATED	R
CONF 003	CONFIGURATION DEFINITION UPDATED	R
CONF 004	CONFIGURATION DEFINITION UPDATED	R
CONCURRENT REQUIREMENTS	CONCURRENT SB LIST UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
REFERENCES	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
MATERIAL INFORMATION		
LIST OF MATERIALS - OPERATOR SUPPLIED		
Consumable Materials		
Consumable CMLD01	CONSUMABLE MATERIAL SET UPDATED QUANTITY UPDATED CONSUMABLE UPDATED	R
TOOLING		
Tools	TOOLS UPDATED	R

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ACCOMPLISHMENT INSTRUCTIONS		
TASK 531240- 831-848-001-Modification	TASK SOLUTION UPDATED NOTE UPDATED CAUTION UPDATED	R
Task associated data - 001	ZONE UPDATED PANEL UPDATED ELAPSED TIME UPDATED	R
Task associated data - 002	ZONE UPDATED PANEL UPDATED MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 003	ZONE UPDATED PANEL UPDATED MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 004	ZONE UPDATED PANEL UPDATED MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Task associated data - 005	ZONE UPDATED PANEL UPDATED MAN HOURS UPDATED ELAPSED TIME UPDATED	R
Subtask 531240-941-201-001	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 531240-941-201-001	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 531240-941-201-002	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R

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Subtask 531240-941-201-001	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 531240-941-201-001	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED NOTE UPDATED REFERENCED DOCUMENTATION UPDATED REFERENCES UPDATED	R
Subtask 531240-831-202-001	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED QUANTITY UPDATED PART NUMBER DESCRIPTION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 531240-831-204-001	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED	R
Subtask 531240-831-205-001	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-203-001	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED QUANTITY UPDATED CONSUMABLE UPDATED NOTE UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED PART NUMBER DESCRIPTION UPDATED LOCATION UPDATED MANPOWER RESSOURCE UPDATED MATERIAL LIST UPDATED	R
Subtask 531240-831-206-001	SUBTASK SOLUTION ADDED	N

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Subtask 531240-831-202-002	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED QUANTITY UPDATED PART NUMBER DESCRIPTION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 531240-831-204-002	SUBTASK SOLUTION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED LOCATION UPDATED	R
Subtask 531240-831-205-002	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-203-002	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED QUANTITY UPDATED CONSUMABLE UPDATED NOTE UPDATED CONFIGURATION UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED LOCATION UPDATED MATERIAL LIST UPDATED	R
Subtask 531240-831-206-002	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-202-003	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED QUANTITY UPDATED PART NUMBER DESCRIPTION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 531240-831-204-003	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED LOCATION UPDATED	R

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Subtask 531240-831-205-003	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-203-003	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED QUANTITY UPDATED CONSUMABLE UPDATED NOTE UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED PART NUMBER DESCRIPTION UPDATED LOCATION UPDATED MATERIAL LIST UPDATED	R
Subtask 531240-831-206-003	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-202-002	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED QUANTITY UPDATED PART NUMBER DESCRIPTION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 531240-831-204-002	SUBTASK SOLUTION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED LOCATION UPDATED	R
Subtask 531240-831-205-002	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-203-002	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED QUANTITY UPDATED CONSUMABLE UPDATED NOTE UPDATED CONFIGURATION UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED LOCATION UPDATED MATERIAL LIST UPDATED	R
Subtask 531240-831-206-002	SUBTASK SOLUTION ADDED	N

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Subtask 531240-831-202-002	SUBTASK SOLUTION UPDATED LOCATION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED CONFIGURATION UPDATED FIGURE REFERENCE UPDATED NOTE UPDATED QUANTITY UPDATED PART NUMBER DESCRIPTION UPDATED MANPOWER RESSOURCE UPDATED REFERENCES UPDATED	R
Subtask 531240-831-204-002	SUBTASK SOLUTION UPDATED PANEL UPDATED ZONE UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED LOCATION UPDATED	R
Subtask 531240-831-205-002	SUBTASK SOLUTION ADDED	N
Subtask 531240-831-203-002	SUBTASK SOLUTION UPDATED ZONE UPDATED PANEL UPDATED QUANTITY UPDATED CONSUMABLE UPDATED NOTE UPDATED CONFIGURATION UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED FIGURE REFERENCE UPDATED PART NUMBER DESCRIPTION UPDATED LOCATION UPDATED MATERIAL LIST UPDATED	R
Subtask 531240-831-206-002	SUBTASK SOLUTION ADDED	N
Subtask 531240-840-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED REFERENCES UPDATED	R
Subtask 531240-840-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED REFERENCES UPDATED	R
Subtask 531240-840-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED REFERENCES UPDATED	R
Subtask 531240-840-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED REFERENCES UPDATED	R

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Subtask 531240-840-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED NOTE UPDATED REFERENCES UPDATED	R
Subtask 531240-942-201-001	SUBTASK SOLUTION UPDATED PANEL UPDATED	R
Subtask 531240-942-201-001	SUBTASK SOLUTION UPDATED PANEL UPDATED	R
Subtask 531240-942-201-002	SUBTASK SOLUTION UPDATED PANEL UPDATED	R
Subtask 531240-942-201-001	SUBTASK SOLUTION UPDATED PANEL UPDATED	R
Subtask 531240-942-201-001	SUBTASK SOLUTION UPDATED PANEL UPDATED	R
Fig. A-GBA	FIGURE DELETED FOR APPLICABLE MSN	D
Fig. A-GCAAA		
Fig. A-GCAAA Sheet 01	SHEET UPDATED	R
Fig. A-GCAAA Sheet 02	SHEET UPDATED	R
Fig. A-GCAAB		
Fig. A-GCAAB Sheet 01	SHEET UPDATED	R
Fig. A-GCAAB Sheet 02	SHEET UPDATED	R
Fig. A-GCAAC		
Fig. A-GCAAC Sheet 01	SHEET UPDATED	R
Fig. A-GCAAC Sheet 02	SHEET UPDATED	R
Appendix 01 - Manpower Gantt Chart		
Fig. A-GAAAA	FIGURE SOLUTION UPDATED	R
Fig. A-GAAAA Sheet 01	SHEET UPDATED	R
Fig. A-GAAAB	FIGURE SOLUTION UPDATED	R
Fig. A-GAAAB Sheet 01	SHEET UPDATED	R

FILING INSTRUCTIONS

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

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

HISTORY OF PREVIOUS REVISIONS

Revision No. 01 issued to:

replace SIL 51-012 with ISI 51.48.00001

add ISI 00.00.00198

add West Coast Industries (WCI) as an alternative to Fatigue Technology Inc. (FTI) for cold expansion tooling

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clarify the FTI tooling

revise kits 531240D01 and 531240D02

update the Procurement Address

update the Service Bulletin effectivity.

REVISION SEQUENCE

ORIGINAL: Mar 19/15

REVISION No. : 01 - Apr 04/16

REVISION No. : 02 - Mar 14/17

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SERVICE BULLETIN
SUMMARY

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

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 (CENTER WING BOX)

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	None				
MINOR	152104K15182				

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 embodiment of inspection Service Bulletin A320-53-1029 and accomplishment of modification Service Bulletin A320-53-1030, which required the removal of longitudinal beams, further cracks have been found on in-service aircraft. These cracks were found around the fasteners connecting the pressure panel with the flexible bracket at FR36 adjacent to the longitudinal beams, LH and RH near Y +/- 1292.

This Service Bulletin details instructions to cold expand the attachment holes under the longitudinal beam at FR36 on aircraft with no crack finding in accordance with Inspection Service Bulletin No. A320-53-1264.

The procedure as described in this Service Bulletin is to be performed if no Airbus repair and/or repair improvement has been previously performed in the same area. In case of repairs performed previously, please contact AIRBUS Repair Support department for further instructions.

Accomplishment of this Service Bulletin will cancel the requirement of additional inspections in accordance with Inspection Service Bulletin No. A320-53-1264 and thus prevent from possible expensive and time consuming repairs.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	RECOMMENDED (1)	CANCELS INSPECTION SB	YES

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EVALUATION TABLE			
POTENTIAL AD	NO	A/C OPERATION AFFECTED	NO
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	NO	VENDOR SB INVOLVED	NO
VALIDATION ON AIRCRAFT	YES	BOOKLET AVAILABLE	YES

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

NOTE: This Service Bulletin has been validated at revision No. 01 on A320 aircraft with Manufacturer Serial Number (MSN) 0111.

NOTE: A booklet including photographs taken during the validation of this Service Bulletin is available on AIRBUS|World - Maintenance and Engineering - AirN@v engineering (in the concerned SB file).

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531240D01R02	1	922.00	Bolts, pins, washers, collars
Standard tool TOOLD01	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD03	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 531240D02R02	1	849.00	Bolts, washers, collars
Standard tool TOOLD02	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD04	1	See SB	WCI tooling for cold expansion

****CONF 003**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531240D02R02	1	849.00	Bolts, washers, collars
Standard tool TOOLD02	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD04	1	See SB	WCI tooling for cold expansion

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**CONF 004

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531240D02R02	1	849.00	Bolts, washers, collars
Standard tool TOOLD02	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD04	1	See SB	WCI tooling for cold expansion

**CONF 005

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 531240D02R02	1	849.00	Bolts, washers, collars
Standard tool TOOLD02	1	See SB	FTI tooling for cold expansion
Standard tool TOOLD04	1	See SB	WCI tooling for cold expansion

EFFECTIVITY

**CONF ALL

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

03Q	06R	11S	13Y	14M	15T	16T	17M	17S	19V	23R	27V	28M
29S	31M	31V	31X	32Q	36R	38W	40N	40S	41N	41S	45O	46U
47P	48O	48P	52T	53Z	56O	59N	59Z	61W	66X	69X	73W	74T
76W	78X	79W	80X	82U	83O	83Q	85T	86P	86Z	87Q	89Q	89T
91X	95V	95W	98W	98X	AAF	AAR	AAW	AAY	ABL	ABQ	ACA	ACI
ADR	AEE	AFL	AFR	AHY	AIC	AIJ	ALK	AMC	AMU	ANA	ANR	ANZ
ART	ARU	ASL	ATR	AUA	AUH	AVA	AVJ	AWC	AWW	AXM	AZA	B2V
BAW	BEC	BEL	BER	BGF	BGH	BHP	BJN	BKP	BRS	BSX	BTN	BUC
CBJ	CCA	CCM	CEB	CEF	CES	CFG	CGH	CHB	CQH	CQN	CSA	CSC
CSN	CSZ	CTN	CTV	CYP	DAL	DAT	DCS	DKH	DLH	DNU	DQA	DRK
DTR	DWI	EAA	EDW	EIN	ELB	ETD	ETJ	EVA	EVJ	EZY	F2I	FCB
FFT	FHY	FIA	FIN	FJW	FLA	FLI	FRN	FTZ	G4I	G8E	GAF	GAP
GBB	GCA	GCR	GFA	GHT	GLG	GMI	GOW	GSW	GWI	GZQ	HDA	HFY
HKE	HKJ	HRM	HVN	HYP	I2L	I2T	IAW	IBE	IBS	IGO	IND	IRA
IRC	IRM	ISR	ISS	IZG	JAD	JAV	JBU	JBW	JSA	JST	JZR	KAC
KAY	KFR	KHO	KHV	KKK	KNE	KZR	LAA	LAN	LBT	LFO	LJB	LKE
LLC	LLM	LLP	LLX	LMJ	LMU	LUR	LWA	LZB	MAU	MEA	MGF	MJF
MJN	MLD	MMA	MON	MOV	MRJ	MSC	MSR	MXA	MYX	NIA	NKS	NLY
NMA	NMB	NVD	NVR	NWS	OAW	OBS	OHY	OLY	OMS	ONE	ORF	OTF
OZW	PAL	PGT	PIA	PIC	PTI	QAF	QQE	QSM	QTR	R1T	RBA	RBG
RCT	RFJ	RJA	RJD	ROT	RYW	RZO	SAA	SAI	SAS	SBI	SDM	SEY
SFW	SHJ	SHU	SKU	SLK	SND	SNX	SOL	SSG	SUD	SVA	SVR	SVW
SWM	SWR	SYR	TAE	TAI	TAM	TAP	TAR	TBZ	TCW	TCX	TDR	TGW
THY	TJS	TNA	TVR	U6A	UAL	UEA	UJX	UKN	UNA	USA	UZB	VAR
VIM	VIP	VIV	VJC	VKG	VLG	VOE	VOI	VRD	VRE	VVC	WGT	WHT
WOW	WRC	WZZ										

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CONCURRENT REQUIREMENTS

Accomplishment of this Service Bulletin requires the prior or simultaneous accomplishment of the following Service Bulletin(s):

Service Bulletin No. A320-53-1264

NOTE: - Service Bulletin No. A320-53-1264 FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PLATE FR35 TO FR36 (CENTER WING BOX)

REFERENCES / REPERCUSSIONS

TFU	None
OEB	None
AOT	None
SIL	None
ISI	00.00.00198 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 531240-831-848-001: Modification	
TOTAL MANHOURS	25.50
ELAPSED TIME (HOURS)	11.75

****CONF 002**

Task 531240-831-848-001: Modification	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

****CONF 003**

Task 531240-831-848-001: Modification	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

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**CONF 004

Task 531240-831-848-001: Modification	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

**CONF 005

Task 531240-831-848-001: Modification	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

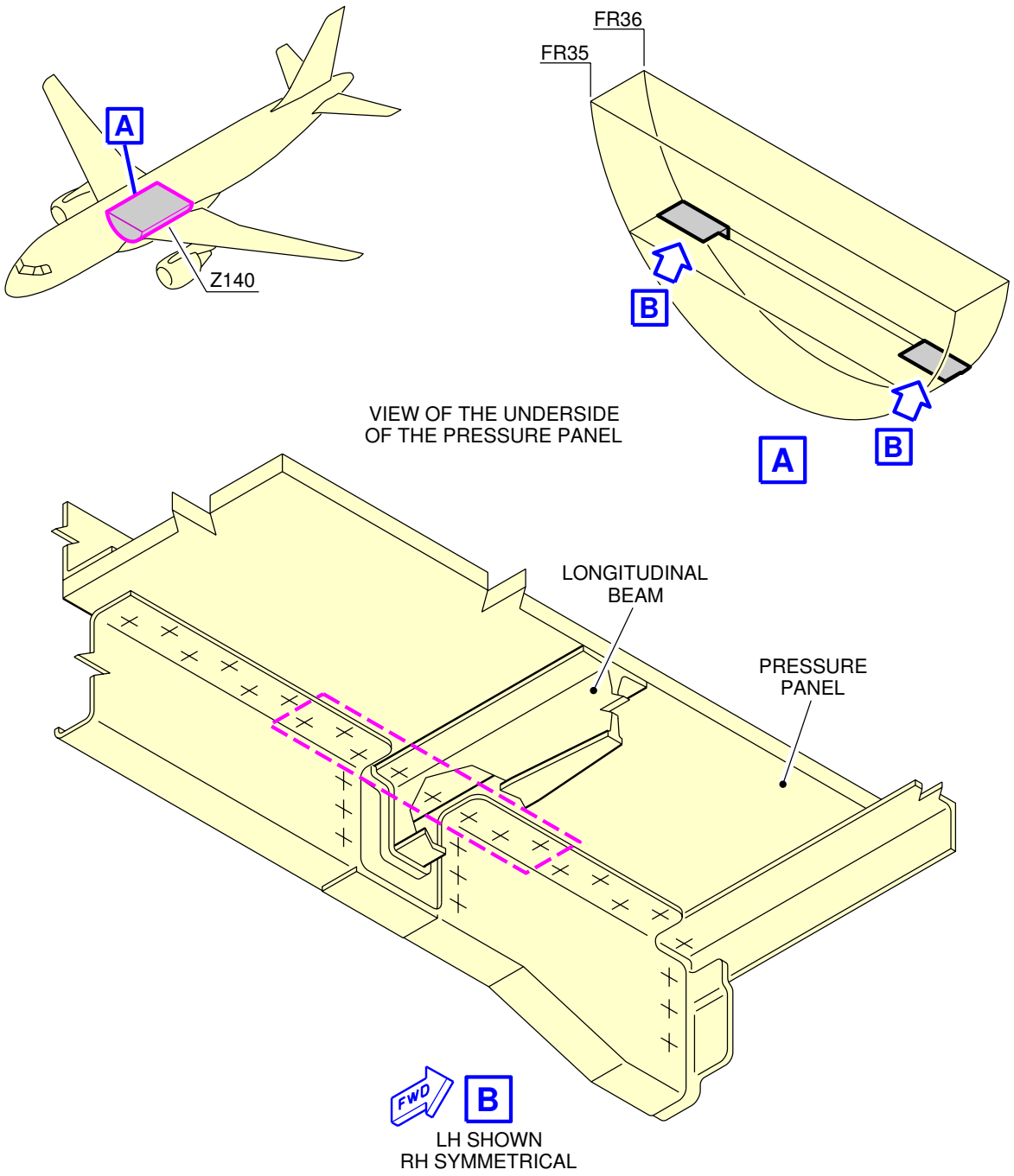
APPENDICES

**CONF ALL

Appendix 01 - Manpower Gantt Chart

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**CONF 001



NOTE:

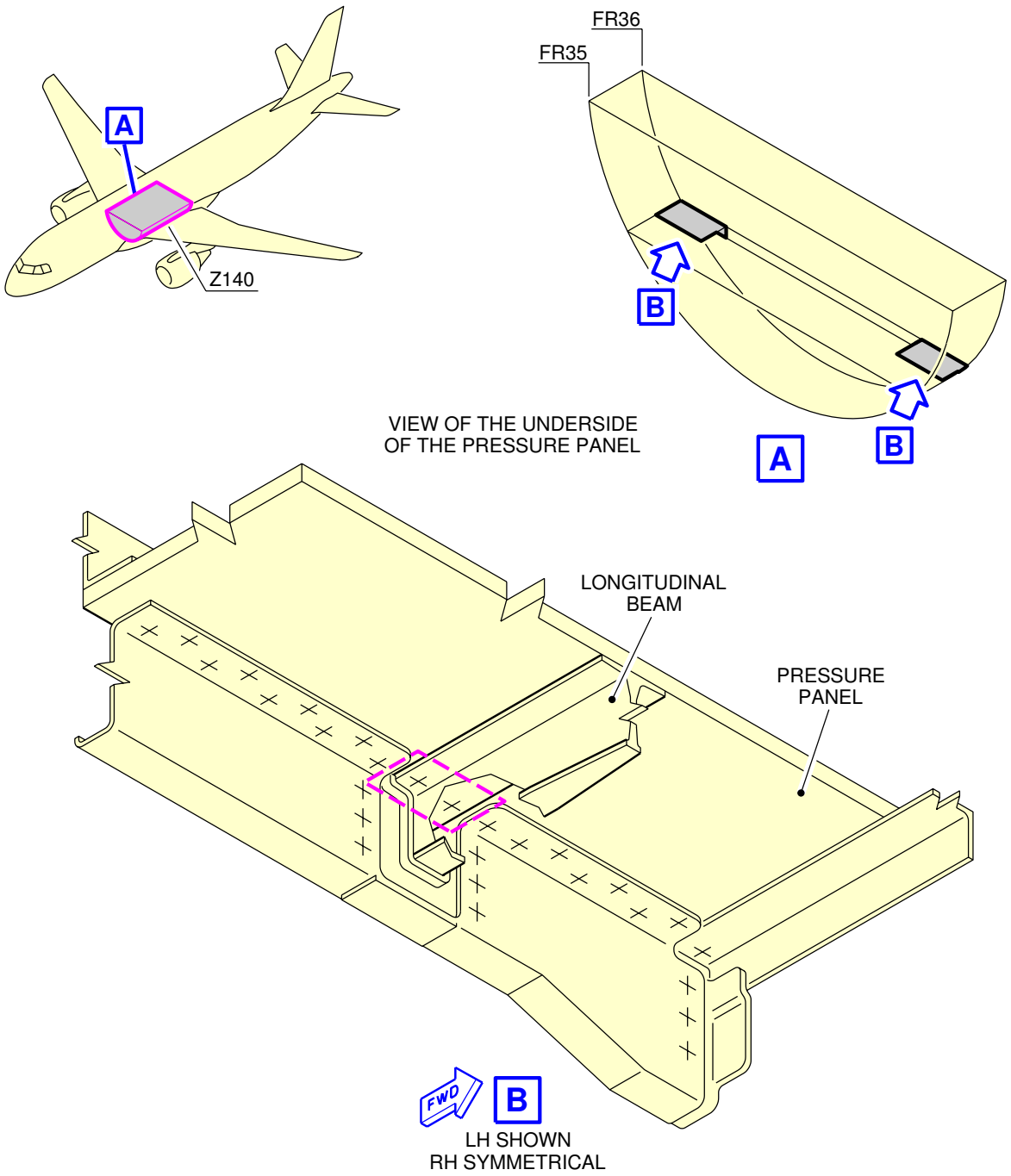
AREA TO BE MODIFIED

N_SB_531240_6_SAAA_01_02

Figure A-GSAAA - Sheet 01

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****CONF 002, 004 thru 005**



NOTE:

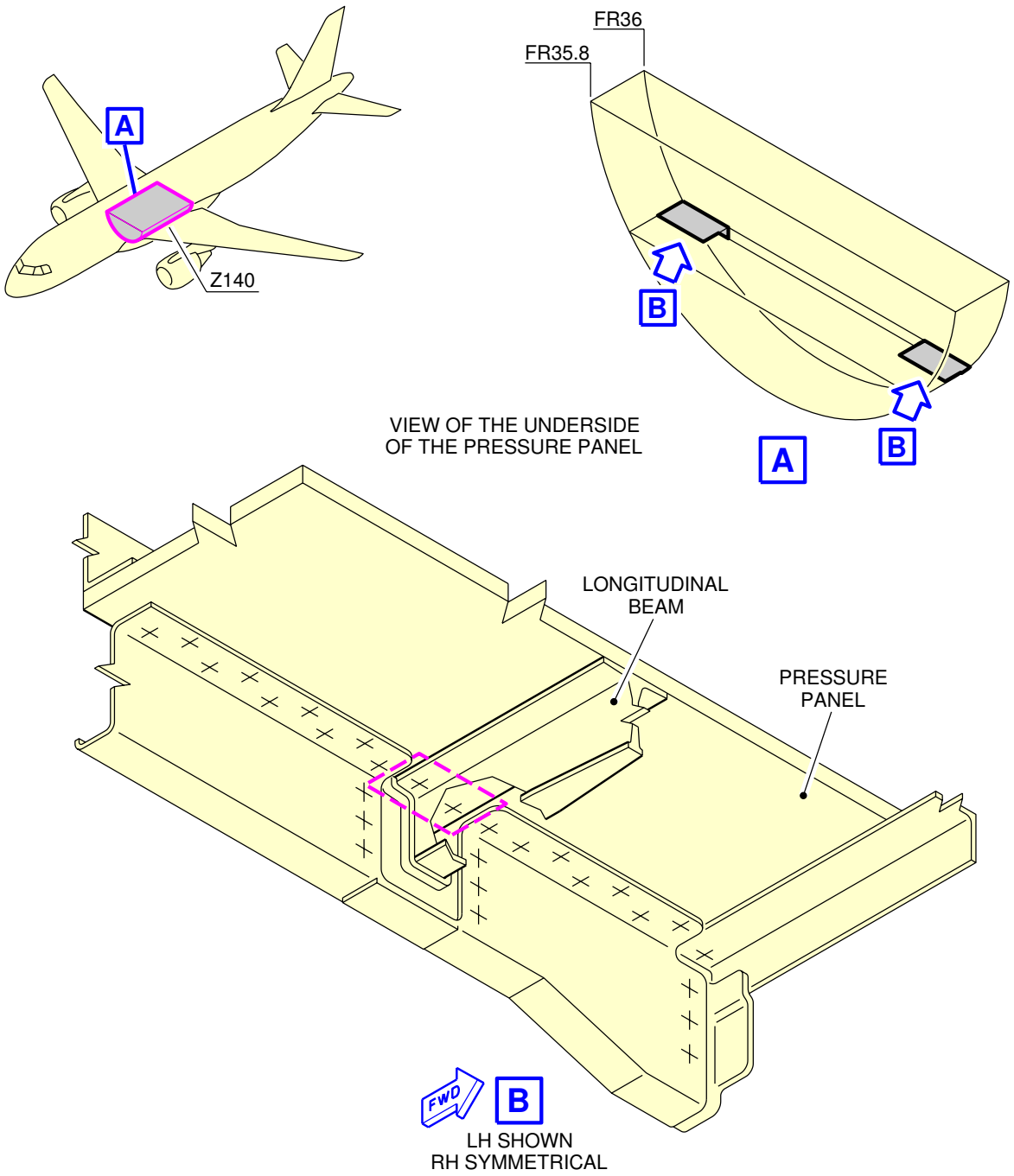
AREA TO BE MODIFIED

N_SB_531240_6_SAAB_01_02

Figure A-GSAAB - Sheet 01

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**CONF 003



NOTE:

AREA TO BE MODIFIED

N_SB_531240_6_SAAC_01_02

Figure A-GSAAC - Sheet 01

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ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 (CENTER WING BOX)

MODIFICATION No.: 152104K15182

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

This modification is applicable by Service Bulletin only.

(1) Models

318-111	318-112	318-121	318-122	319-111	319-112	319-113	319-114
319-115	319-131	319-132	319-133	320-211	320-212	320-214	320-216
320-231	320-232	320-233	321-111	321-112	321-131	321-211	321-212
321-213	321-231	321-232					

(2) Effectivity by MSN

0029 0045-0046 0049-0057 0059 0064-0073 0076-0078 0081-0087 0093-0094 0099
0104 0110-0113 0115-0118 0121-0127 0135 0137-0138 0140-0142 0148-0150
0152-0154 0157 0159-0162 0164-0166 0168-0169 0171-0172 0174-0175 0178
0181-0183 0185 0192 0194-0195 0197-0198 0200-0203 0205-0206 0208-0211 0213
0216-0220 0229-0232 0234 0237 0239 0242-0244 0248-0249 0251-0256 0259-0260
0262-0263 0265 0267-0269 0272-0273 0275-0277 0279 0281-0282 0284-0285 0287
0289-0298 0300-0303 0306-0309 0311-0312 0314 0316-0322 0324-0325 0328-0332
0339-0343 0345-0347 0350-0351 0353-0355 0357-0362 0364 0366-0368 0370-0373
0376 0378 0380-0382 0385-0388 0390 0393 0395 0398-0410 0412 0414-0418
0420-0424 0426-0432 0434-0436 0438-0439 0441-0442 0444-0445 0447-0450 0452

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0454 0456-0458 0460 0462-0466 0468 0470 0472-0477 0479-0480 0482-0491 0493
0495-0514 0516-0535 0537-0546 0548-0556 0558-0587 0589 0591-0593 0595-0600
0603-0604 0607-0614 0616-0623 0625 0627 0629-0631 0633-0662 0664-0673
0675-0706 0709 0711-0752 0754-0771 0773-0788 0790-0798 0800-0898 0900-0955
0957-0968 0970-0977 0979-1043 1045-1067 1069-1073 1075-1097 1099-1112
1114-1144 1146-1185 1187-1217 1219-1277 1279-1304 1306-1332 1334-1373
1375-1463 1465-1607 1609-1659 1661-1675 1677-1697 1699-1726 1728 1730-1767
1769-1812 1814-1821 1823-1829 1831-1918 1920-1929 1931-1938 1940-1984
1986-1990 1993-2016 2018-2024 2026-2050 2052-2057 2059-2087 2089-2110
2112-2127 2129-2217 2219-2275 2277-2423 2425-2499 2501-2721 2723-2940
2942-3037 3039-3091 3093-3109 3111-3162 3164-3243 3245-3647 3649-4329
4331-4436 4438-4442 4445

(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
03Q	0584 0620 0631 0770
06R	0527
11S	4211
13Y	0371
14M	1757
15T	0764 1494 2910 3261
16T	4024
17M	3856
17S	3333
19V	0954
23R	1730
27V	3826
28M	0055
29S	0291 0292
31M	1362
31V	0164 0293 0332 0420 0436 0565 0579 0591 0760 0855 0932 0943 0992 1048
31X	4319
32Q	1228 1283
36R	1747 1818
38W	1194
40N	0065
40S	1973
41N	3164
41S	0630
45O	3402
46U	2906 2952 2982 3275 3296 3332 3674 3734 3986 4053
47P	0619

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OPERATOR	MSN
48O	3362 3412
48P	2192
52T	1599
53Z	1468
56O	1285
59N	1589
59Z	1556
61W	0112
66X	1276
69X	0219 0300 0328
73W	0087
74T	2165
76W	0140 0157
78X	1081
79W	3751
80X	2748
82U	0279 0677 0827 0891
83O	0316
83Q	0477 0495
85T	0234
86P	0913
86Z	1706 1750 1843
87Q	0052
89Q	0427 0747
89T	3356
91X	2837
95V	3379
95W	2949 4199
98W	0434 0441 0516 0524 1093 1108 1943
98X	0551
AAF	0639 2180 2870 3136 3242 3289 4268
AAR	1174 1356 1511 2397 2459 3297 3437 3483 3496 3641 3873 4112 4142
AAW	3224 3236 3615 3657 4004
AAY	0706 0714 0716 0730 0745 1229 1255 1262 1288 1292 1318 1347 1467 1530 1540 1694 2176 2224 2265 2271 2319 2387 2398 2420 2427 2450 2556 2586 2625 2702 2709 2729 2786 2821 2876
ABL	1227 1636 1670 1734 1970 2041 2045 2110 2226 2247 2290 2422 2430 2732 2808 2840 2927 2933 2943
ABQ	3974

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OPERATOR	MSN
ACA	0059 0068 0073 0084 0122 0126 0127 0141 0149 0150 0154 0159 0174 0175 0183 0210 0231 0232 0242 0248 0253 0254 0255 0265 0277 0284 0290 0309 0324 0330 0341 0378 0403 0404 0546 0572 0634 0656 0670 0672 0682 0688 0691 0693 0695 0697 0711 0719 0721 0728 0732 0736 0740 0742 0752 0757 0769 0773 0779 0785 0800 0813 0817 0829 0831 0840 0845 1299 1562 1577 1602 1611 1623 1632 1638 1673 1691 1719 1726 1742 1748 1772 1783 1787 1811 1853 1864 1874 1940 1975 2018 2145 3051 3401 3884
ACI	2152 3547
ADR	1000 4282 4301
AEE	1428 1433 1856 1909 1996 2468 2828 3033 3066 3074 3162 3302 3316 3322 3365 3392 3423 3439 3462 3478 3484 3519 3526 3527 3709 3714 3745 3748 3753 3773 3785 3812 3820 3829 3850 3878 3990 4065 4094 4165
AFL	2106 2116 2133 2144 2330 2337 2920 3052 3063 3157 3267 3334 3373 3410 3511 3545 3574 3627 3631 3640 3644 3699 3711 3778 3786 3789 3823 3835 3923 3954 4058 4074 4099 4103 4116 4133 4148 4160
AFR	0115 0237 0239 0287 0498 0509 0521 0529 0544 0598 0600 0608 0618 0625 0637 0777 0796 0985 1020 1025 1036 1133 1151 1169 1176 1190 1201 1216 1267 1271 1344 1404 1415 1444 1449 1471 1476 1502 1505 1524 1616 1622 1640 1645 1658 1677 1699 1733 1859 1879 1894 1900 1924 1938 1949 2035 2059 2071 2081 2100 2109 2140 2317 2344 2350 2456 2582 2601 2686 2705 2716 2721 2750 2918 2938 2951 2961 2967 2972 3008 3009 3098 3372 3399 3419 3420 3441 3470 3777 3795 3814 3825 3859 3930 4063 4084 4105 4137 4139 4241 4251 4267 4295 4298 4335 4402
AHY	0331 2487 2516 2588 2685 2788 2846 2853 2865 2991 3006
AIC	0045 0046 0049 0050 0051 0056 0057 0398 0416 0423 0431 0432 0486 0490 0499 2593 2624 2629 2907 3130 3146 3212 3271 3288 3300 3305 3326 3340 3344 3367 3498 3551 3557 3573 3619 3620 3687 3752 3792 3822 3874 3918 3955 3970 4002 4009 4020 4029 4052 4078 4089 4096 4121 4138 4155 4164 4201 4212 4236 4237 4280
AIJ	0169 1132 1162 1179 1244 1259 1308 1322 1780 2048 2227 2539 2930 2964 3021 3044 3123 3149 3160 3286 3304 3312 3374 3508 3514 3667 3690 4235 4304 4411
ALK	1893 1946 2345 2584 2731 3397 3636
AMC	2186 2189 2291 2665 2768 3056 3068
AMU	0908 1758 1790 1850 1912 1926 1962 4197
ANA	0482 0501 0507 0531 0534 0549 0554 0658 0669 0685
ANR	0671 0726 0765
ANZ	2085 2090 2112 2130 2148 2153 2173 2257 2297 2445 2533 2594 2663
ART	0244 0359 0533 0566 0662 0936 0984 1823 1873 2211 2233
ARU	0573 0582 0805 1583
ASL	1140 1159 2277 2296 2335 2587 2621 2645 3252 3317
ATR	0314 0373 0393

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OPERATOR	MSN
AUA	0552 0570 0581 0768 0776 0797 0920 0935 1137 1150 1189 1385 1387 1458 1478 1504 1553 1678 1735 1931 1937 2009 2131 2174 2262 2416 2494 2547 2652
AUH	2403
AVA	1634 2328 2333 2358 2367 2377 2394 2523 2544 2552 2575 3647 3664 3691 3961 3980 3988 3992 4001 4011 4026 4046 4051 4100 4167 4200 4281 4284 4345 4381
AVJ	0368 0406
AWC	2564 2791 3830
AWW	0597
AXM	0667 0743 0872 0874 1286 2147 2162 2183 2425 2612 2633 2656 2683 2699 2760 2816 2826 2842 2881 2885 2956 2989 3000 3018 3064 3117 3140 3154 3173 3182 3194 3201 3223 3232 3277 3291 3299 3327 3338 3353 3370 3394 3404 3427 3448 3477 3486 3489 3505 3521 3536 3549 3568 3576 3582 3610 3628 3679 3701 3715 3729 3765 3776 3813 3875 3963 3997 4019 4035 4070 4079 4088 4098 4126 4147 4263 4278 4293 4302 4333 4346 4361 4367 4386 4390 4404 4426
AZA	0513 0514 0526 0532 0576 0583 0586 0593 0599 0819 0848 0940 0951 0959 1138 1168 1217 1220 1226 1448 1457 1473 1480 1489 1722 1740 1745 1770 1779 2033 2057 2074 2083 2086 2101 2127 2869 2932 2995 3076 3079 3115 3138 3161 3343 3563 3598 3609 3643 3666 3695 3732 3815 3846 3885 3906 3921 3956 3976 3978 4075 4108 4119 4143 4152 4195 4249
B2V	0185
BAW	1014 1082 1115 1118 1142 1177 1193 1197 1222 1225 1232 1236 1239 1258 1261 1279 1295 1329 1338 1380 1384 1418 1423 1424 1440 1445 1466 1482 1509 1510 1513 1529 1537 1558 1574 1590 1594 1604 1606 1613 1661 1665 1672 1687 1689 1690 1696 1708 1711 1754 1760 1771 1782 1804 1814 1829 1834 1871 1883 1892 1899 1902 1907 1910 1958 1987 2038 2040 2098 2188 2190 2194 2305 2320 2323 2324 2351 2363 2389 2429 2441 2466 2536 2653 2694 2697 2720 2799 2981 3049 3081 3089 3235 3254 3290 3301 3314 3351 3468 3499 3512 3550 3607 3649 3697 3703 3721 3726 3912 3926 4007 4039 4185 4238 4265 4306
BEC	3199
BEL	1086 1102 1160 1336 1388 1441 1493 1759 1797 1803 1838 1885 1963 2030 2114 2196 2207 2230 2260 2287 2392 2400 2700 2763 2810 2925 3255 3790 3895 4243 4275
BER	1629 1717 1769 1775 1852 1889 1961 1966 1994 2003 2005 2562 2591 2606 2627 2749 2867 2902 2968 3055 3080 3121 3178 3202 3213 3295 3328 3447 3464 3482 3502 3515 3516 3532 3540 3594 3604 3661 3700 3704 3728 3865 3945 3995 4013 4101 4128 4161 4269 4291 4316 4329 4433
BGF	3188
BGH	0142 1087 1554 2844 2863 3125 3139
BHP	3245 3422 4033 4187 4294
BJN	3617

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OPERATOR	MSN
BKP	2254 2273 2310 2362 2366 2417 2509 2531 2600 2634 2648 2660 2664 2783 3421 3424 3454 3672 3694 3759 3911
BRS	2263
BSX	0648 0650
BTN	1541 1551
BUC	0256 0276 0296 0320 0321 0353
CBJ	2557 2561 2611 2644 2733 2985 3285 3520 3548 3561 3578 3580 3638 3842 3851 3914 3958 3982 4388 4410 4412 4428 4440
CCA	0876 0921 1296 2000 2007 2015 2172 2202 2205 2237 2269 2285 2293 2298 2454 2499 2508 2525 2532 2545 2551 2559 2614 2643 2805 2819 2839 2847 2890 3195 3200 3215 3221 3226 3250 3307 3329 3337 3461 3506 3523 3601 3623 3653 3655 3665 3678 3722 3725 3766 3806 3940 3973 4022 4031 4062 4091 4131 4180 4221 4283 4317 4318 4348 4377
CCM	3325 3882 3952
CEB	2638 2790 2831 2852 2994 3048 3272 3762 3767
CEF	2801 3085
CES	0665 0754 0838 0854 0897 0909 0925 0939 1028 1030 1070 1072 1303 1312 1316 1330 1345 1357 1361 1377 1386 1532 1542 1601 1639 1906 1911 1964 1981 2022 2034 2036 2049 2056 2068 2219 2221 2235 2239 2244 2309 2315 2437 2451 2478 2493 2498 2543 2549 2693 2757 2825 2882 2895 3168 3170 3186 3197 3233 3247 3249 3262 3471 3481 3559 3593 3611 3612 3613 3639 3650 3677 3682 3692 3716 3775 3793 3797 3870 3904 3929 3937 3965 3969 4027 4037 4043 4045 4111 4144 4186 4198 4209 4220 4239 4240 4252 4297 4309 4340 4342 4355 4374 4423
CFG	0774 0809 0884 0894 0905 0957 0971 1416 1437 1607
CGH	3768 3849
CHB	4231 4262
CQH	2939 3014 3023 3747 3819 4072 4093 4168 4244 4331 4366 4373 4375
CQN	0696 0698 0704 0705 3828 3836 3876 3901 3903 3941 4140
CSA	3043 3094 3406 3436 3452 3660 3892 4258
CSC	0540 0556 0878 0915 0919 1013 2313 2348 2431 2510 2534 2597 2639 3114 3116 3124 3158 3167 3196 3210 3386 3449 3583 3591 3680 3730 3893 3962 3996 4018 4068 4288 4326 4378 4420 4424
CSN	0712 0718 0720 0722 0849 0859 0881 0895 0900 0950 0966 1035 1039 1057 1596 1614 1776 1788 1971 1974 1986 1995 2004 2008 2067 2080 2200 2203 2232 2354 2361 2371 2408 2426 2435 2484 2505 2506 2511 2519 2521 2530 2541 2546 2554 2555 2558 2574 2579 2637 2680 2689 2701 2708 2713 2714 2741 2743 2759 2767 2770 2772 2796 2809 2824 2834 2855 2861 2877 2899 2915 2936 2950 2960 2971 2986 3067 3075 3112 3144 3217 3241 3251 3258 3269 3311 3342 3459 3493 3507 3552 3566 3587 3645 3681 3764 3784 3847 3860 3867 3890 3910 3920 3934 3938 3951 3959 3981 3983 3999 4003 4017 4036 4038 4071 4172 4184 4189 4194 4205 4217 4224 4225 4230 4232 4248 4260 4266 4271 4274 4279 4290 4292 4299 4322 4325 4338 4341 4350 4362 4365 4369 4370 4387 4396 4416 4430

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OPERATOR	MSN
CSZ	2672 2684 2841 2905 2909 2935 2973 2980 3131 3132 3153 3206 3366 3383 3435 3440 3456 3528 3599 3696 3698 3756 3848 3855 3887 3898 3935 3971 4010 4028 4159 4176 4208 4214 4226 4300 4359 4407 4409 4435
CTN	0767 0833 1009 1029 1237 1252
CTV	0839 0892 1635 2598 2692 3147 3148 3861
CYP	1129
DAL	0118 0121 0125 0152 0153 0160 0171 0192 0197 0206 0208 0213 0262 0263 0272 0273 0281 0282 0297 0298 0306 0307 0318 0319 0329 0339 0340 0355 0358 0360 0367 0372 0380 0381 0387 0388 0399 0408 0410 0417 0418 0766 0778 0786 0801 0807 0818 0830 0832 0846 0903 0907 0911 0923 0962 0964 0981 0988 0996 1011 1037 1058 1062 1191 1230 1249 1324 1325 1346 1392 1414 1434 1453 1456 1483 1498 1501 1520 1535 1543 1549 1567 1570 1582 1633 1641 1646 1659 1662 1683 1685 1693 1709 1714 1738 1746 1752 1766 1774 1789 1796 1800 1810 1812 1815 1820 1824 1828 1833 1839 1875 1897 1923 1959 1976 1982 1990 2002 2013 2026 2039 2047 2082 2087 2092 2095
DAT	0466
DCS	1053 3243
DKH	2975 3027 3234 3268 3368 3485 3596 3605 3967 3984 4064 4102 4154 4276 4401 4429
DLH	0069 0070 0071 0072 0078 0083 0086 0093 0094 0104 0110 0111 0116 0162 0172 0202 0412 0458 0468 0473 0474 0484 0493 0502 0505 0518 0560 0563 0564 0567 0595 0609 0610 0616 0623 0627 0636 0641 0651 0652 0679 0689 0692 0694 0699 0700 0717 0723 0729 0738 0744 0853 0860 0875 0887 0901 1080 1161 1188 1260 1273 1337 1365 1367 3265 3339 3360 3387 3434 3592 3625 3864 3936 3987 4005 4016 4047 4054 4073 4085 4097 4120 4141 4153 4182 4191 4261 4289 4324 4332 4360 4363 4398
DNU	0113
DQA	2347 2599
DRK	2306 2346
DTR	0444 0447 2102
DWI	0561
EAA	0386
EDW	0942 0947 1026 1951 2024 2134
EIN	0926 1023 1094 1242 1394 1443 1983 2001 2191 2206 2217 2250 2256 2272 2294 2364 2374 2399 2409 2411 2432 2486 2542 2583 2635 3129 3174 3318 3345 3501 3755 3781 3857
ELB	1703 3705
ETD	0350 1947 1955 2167 3004 3050 3676 3693 3713 3902 4066 4077 4124
ETJ	0325 0428
EVA	3363 3886
EVJ	1422

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OPERATOR	MSN
EZY	2037 2043 2050 2053 2062 2120 2170 2181 2184 2245 2289 2300 2353 2360 2370 2385 2402 2412 2463 2471 2477 2481 2492 2495 2503 2512 2514 2527 2528 2538 2565 2578 2605 2636 2646 2677 2681 2691 2715 2727 2735 2742 2744 2754 2765 2769 2777 2779 2782 2795 2803 2812 2818 2827 2829 2854 2860 2866 2873 2884 2923 2946 2959 3003 3036 3041 3053 3059 3061 3082 3084 3088 3090 3118 3122 3134 3137 3176 3184 3411 3413 3426 3432 3442 3466 3537 3544 3555 3569 3571 3608 3634 3675 3683 3702 3720 3735 3742 3746 3754 3763 3774 3788 3799 3805 3808 3810 3824 3843 3844 3845 3854 3871 3888 3909 3913 3922 3946 3953 3975 3979 3991 4006 4012 4014 4034 4040 4048 4056 4069 4076 4080 4087 4125 4129 4132 4157 4179 4196 4219 4233 4234 4250 4286 4313 4327 4380 4385 4418 4425 4427
F2I	0082 0085 0099 0138 0148 0168 0203 0220 0230 0243 0249 0251 0285 0294 0301 0317 0342 0347 0422 0449 0460 0488 0496 0497 0525 0538 0555 0653 0657 0724 0758 0787 0793 0976 1010 1018 1846 2137 3853 3872
FCB	0928 2032 2662 2875
FFT	1515 1615 1684 1781 1786 1806 1860 1980 1997 2010 2012 2019 2103 2198 2209 2236 2258 2318 2406 2448 2483 2518 2695 2806 2836 2857 3205 3389 3431 4127 4204 4253 4254 4272 4307
FHY	2524 2804 3025 3852 3891 4207
FIA	0295
FIN	0941 0961 1073 1107 1184 1185 1241 1309 1352 1364 1405 1470 1544 1588 1712 1913 1916 1978 1989 2065 2124 2146 2154 2208 2266
FJW	2281
FLA	0357
FLI	3905
FRN	0647 0660
FTZ	2268 2308 2891
G4I	1157 1795 2507
G8E	2141
GAF	1214 3897 4060
GAP	3087 3187 3273 3310 3455 3731
GBB	0053 0054 0064 0076 0077
GCA	0415
GCR	2338 2475
GFA	4030 4059 4083 4146 4158 4188 4218 4255
GHT	0438
GLG	2078 2126 3408 3467 3518 4379
GMI	0684 0970 0995 1925 3019 3407 3533 3560 3950
GOW	2118 3306 3597 3616 3798 3827 3900 3915 3972
GSW	3589 3818

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OPERATOR	MSN
GWI	0117 0135 0137 0161 0200 0201 0209 0216 0217 0218 0267 0268 0269 0346 0382 0401 0646 0654 0794 1016 1077 1084 1089 1136 1147 1155 1170 1172 1209 1277 2607 2628 2632 2813 2833 2976 3011 3128 3172 3193 3352 3358 3375 3500 3534 3839 3841 4166 4227 4256 4285
GZQ	1878
HDA	0633 0756 0784 0812 0930 0993 1024 1253 1695 1721 1984 2021 2229 2238 2428 3369 3669 4023 4247
HFY	1004
HKE	2299 2322 2717 4181 4445
HKJ	2706 3073
HRM	0642
HVN	2255 2261 2267 2303 2974 3005 3013 3022 3198 3315 3355 3600 3737 3862 3964 3966 4136 4213 4277 4311 4315
HYP	1654 1679 1753
I2L	0491 0519 0668 0734 0816 1366
I2T	1631 1682
IAW	4044 4067
IBE	0938 0998 1021 1027 1154 1516 1572 1655 1674 1681 1716 1793 1809 1836 2115 2220 2225 2242 2248 2264 2311 2365 2391 2472 2488 2736 2756 2843 2889 2897 2996 3078 3209 3320 3380 3443 3651 3744
IBS	1047 1059 1067 1099 1101 1119 1125 1198 1439 1450 1736 2104 2143 2357 2381 2563 2807
IGO	1767 1920 2108 2204 2275 2334 2359 2457 2649 2712 3264 3330 3357 3414 3453 3457 3497 3541 3618 3750 3782 3863 3943 4008 4113 4156 4216 4312 4328 4384 4399 4438
IND	0343
IRA	0303 0312 0345 0575 0857 2054
IRC	0354 0414 0480
IRM	0550
ISR	4354 4413
ISS	0737 0749
IZG	0311 0376 0395 0400 0407 0426 0430 0476 0999
JAD	2764 3246
JAV	0029 0537 2061
JBU	1123 1156 1173 1235 1240 1257 1270 1280 1302 1327 1398 1446 1452 1506 1528 1546 1557 1610 1650 1705 1739 1784 1785 1849 1861 1898 1904 1915 1917 1927 1948 2006 2020 2031 2042 2063 2075 2099 2125 2132 2136 2149 2150 2159 2160 2177 2201 2215 2231 2246 2259 2280 2284 2286 2307 2314 2336 2352 2368 2384 2386 2415 2447 2449 2461 2489 2491 2504 2520 2535 2577 2580 2640 2647 2671 2710 2725 2755 2781 2802 2814 2832 2848 2871 2880 2900 2945 2970 2977 2992 3029 3039 3072 3091 3119 3150 3190 3228 3263 3287 3348 3381 3416 3451 3479 3488 3517 3554 3572 3622 3659 3707 3724 3760 3800 3811
JBW	0445 0535
JSA	2316 2356 2423 2453 2604

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OPERATOR	MSN
JST	1195 1408 2169 2185 2197 2292 2329 2455 2515 2526 2537 2573 2608 2642 2651 2703 2766 2787 3474 3495 3668 3717 3783 3899 3916 3917 3948 4177 4178 4229 4245 4257 4303 4343 4356 4434
JZR	3919 3939 4162
KAC	0181 0182 0195 2046 3957
KAY	3046
KFR	2650
KHO	0409 0644 0937 2091 2957 2965
KHV	2084 2480
KKK	0604 0614 0675 0761 0806 0808 0823 0963 0968 0974 1008 1124 1390 1438 1451 1503 1624 1950 1953 2029 2077 2747 2753
KNE	1866 1872 1882 1942 1965 2171 2182 2199 2569 2776 3218 3238 3256 3361 3396 3425 3475 3530 3787 3802 3809 3817 3868 3889 3894 3933 4055 4061
KZR	1042 1204 3141 3614
LAA	4405
LAN	1304 1332 1351 1355 1491 1512 1526 1548 1568 1854 1858 1877 1903 2089 2096 2295 2304 2321 2572 2585 2845 2858 2864 2872 2886 2892 2894 3280 3319 3535 3556 3663 3671 3770 3772 3779 4383 4400 4439
LBT	1121 1175 1597 1744 2158 3480 3487
LFO	0659
LJB	3985
LKE	2581 2617 2746 3240
LLC	0883 0914 0967 0990 1041 1715 2987 4203
LLM	1054 1918 1956 1967 1969 1993 2413 2419 2439
LLP	0739 1007 1411 1723 2016 2342 2903 2912 3191
LLX	2529 2619
LMJ	1868
LMU	0852 0977 1561
LUR	0229
LWA	2878 2954
LZB	2540 2596 3309 3564 3780
MAU	1592 1936
MEA	1977 2055 3736 3804 3837 4296 4339
MGF	0308
MJF	4353
MJN	3723 4117
MLD	0622 0741 2849
MMA	0973 1180 1247 1791
MON	0864 0983 1015 1045 1153 1207 1320 1413 1421 1571 1605 1637 1707 1763 1794 1941 2105 2142 2234 2553 2610 2730 2793 3278 3293 3458 3522 3546 3575
MOV	2442 2446 3364 3403
MRJ	0530 1202 1300 1353
MSC	2094 2937 2966 3282 3323 3626 3840

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OPERATOR	MSN
MSR	0165 0166 0178 0194 0198 0322 0351 0366 0680 0687 0715 0725 2070 2073 2079
MXA	0252 0259 0260 0275
MYX	0888 1896
NIA	2410 2874 3183 3219 3925 4310
NKS	2433 2470 2473 2476 2485 2490 2560 2567 2590 2603 2622 2673 2679 2698 2704 2711 2723 2797 2893 2898 2929 2942 2963 2978 2983 3007 3017 3026 3165 3393 3395 4206 4264 4321 4403 4422 4431
NLY	1988 2668 3093 3415 3504 3689 3708 3749 4334 4368
NMA	1697 1732 1952 2676
NMB	3346 3586
NVD	0211 0528 0558 0709 0828 0902 1005 1626 1778 1998
NVR	2216
NWS	1219 1233 3034 3106 3120
OAW	1886
OBS	3758
OHY	0364 0385 0543 0580 0640 0661 0676 0771 0792 0810 0811 0835 0912 0916 2571 2688
OLY	0517 0666 0802 1060 1612 2396
OMS	3035 3047 3111
ONE	3001 3030 3062 3214 3216 3371 3390 3438 3469 3509 3585 3602 3606 3635 3642 4222 4287 4336
ORF	2566
OTF	1407
OZW	0429 1922
PAL	3553 3579 3652
PGT	3831 4175
PIA	2155 2212 2274 2719 2758 2789 2926 2944 3031 3060 3097
PIC	2331 2340 2517 2670 2922 3012 3621
PTI	1263 1598 1625
QAF	0927
QQE	1335 3994 4114 4170
QSM	0607 0611 0617
QTR	1487 1566 1648 1656 1773 1895 1928 1957 2097 2107 2121 2138 2161 2288 2341 3274 4110 4130 4173 4183 4382 4406 4436
R1T	1908
RBA	2135 2139 2195 3071
RBG	3152
RCT	1017 2023
RFJ	0814
RJA	2953 3428 3685 3803 3832
RJD	1618
ROT	2931 2955 3220 3225
RYW	0569
RZO	2011 2325 2390

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OPERATOR	MSN
SAA	2326 2355 2375 2379 2418 2438 2469 2501
SAI	0542 0877 1497 2027 2404 2414 2496 2502 3105 3270
SAS	1183 1383 1587 1619 1642 1675 1798 1807 1817 1848 2817 2850 2856 2883 2888 2911 2958 2990 3086 3159 3192 3227 3231 3292 3335
SBI	1071 1078 1090 1091 1126 1131 1149 1164 1167 1819 1870 2028 2064 2076 2279 2369 2373 2464 2474 2618 2623 2641 2726 3070 3446 3473 3490 3494 3866 3880 4032 4150
SDM	0649 1130 1200 1379 1488 1560 1630 1743 1761 1805 1808 1841 1851 1863 1876 1890 2093 2151 2163 2179 2241 2465 2497 2751 2879 2913 3065 3179 3794 3942 3998
SEY	1944 1945
SFW	0994
SHJ	0910
SHU	2052 2069 2072 2222 2243 3108 3281 3298 3336 3838
SKU	1400 1523 2119 2129 2214 2249 2251 2283 2378 2380 2436 2460 2548 3171 3331
SLK	2252 2568 2775 3104 3570 3821 4118 4215 4259
SND	1880 1999
SNX	0289
SOL	0302
SSG	1485 2550
SUD	3040
SVA	3932 4015 4057 4081 4090 4092 4104 4115 4122 4135 4273 4314 4337 4349 4357 4364 4376 4391 4392 4393 4394 4397 4408 4414 4419 4432 4442
SVR	0735 0775 0815 0841 0991 1012 1063 1152 1199 1484 1579 1603 1720 1751 1777 1884 1901 1905 2117 2166 2175 2187 2278 2327 2343 2349 2707 2862 2947 2998 3099 3107 3189 3385 3388 3433 3472 3834
SVW	2592 3100 3133 3542 4169
SWM	0421 0986 1293
SWR	0520 0522 0541 0545 0553 0559 0562 0574 0577 0578 0585 0596 0603 0612 0621 0635 0643 0664 0673 0681 0701 0703 0713 0727 0782 0987 1144 1762
SYR	0886 0918 1032 1076 1085 1117
TAE	0934 0946 0949 1339 1368 1500 1934 2659
TAI	1066 1334 2282 2301 2339 2434 2444 2687 2917 3042 3057 3103 3113 3248 3276 3378 3418 3510 3538 3869
TAM	1092 1096 1103 1139 1143 1158 1215 1246 1251 1376 1459 1486 1518 1575 1580 1591 1593 1595 1628 1652 1692 1801 1802 1825 1826 1827 1831 1832 1835 1837 1855 1857 1888 1891 2014 2044 2372 2393 2467 2513 2661 2734 2737 2784 2838 2859 2887 2896 2904 2924 3002 3032 3058 3156 3180 3211 3222 3229 3266 3284 3294 3313 3391 3565 3588 3595 3630 3658 3662 3710 3727 3733 3761 3816 3908 4000 4163 4171 4192 4320 4352 4358 4389 4441

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OPERATOR	MSN
TAP	0629 0750 0755 0763 0790 0821 0837 0870 0906 0917 0933 0945 0960 0979 0982 1034 1100 1106 1120 1127 1165 1181 1206 1231 1307 1399 1667 1668 1713 1718 1756 1765 1799 1816 2178 2270 2792 2822 3769 3883 4021 4095 4106 4145
TAR	0123 0124 0205 0370 0390 0402 0511 0869 0880 0958 0975 1187 1479 1700 3096 4344
TBZ	0361 0362 0405
TCW	1381 1402 1929 1954 1968
TCX	1006 1238 1250 1881 1887 1921 1972 2060
TDR	0795
TGW	2724 2728 3757 3801 4210 4421
THY	1002 2156 2164 2395 2401 2452 2522 2602 2609 2626 2631 2655 2738 2739 2823 2868 2916 2919 2928 2934 2984 2999 3010 3015 3126 3142 3185 3207 3208 3239 3257 3259 3283 3303 3308 3341 3350 3382 3405 3429 3525 3539 3558 3567 3603 3637 3654 3673 3688 3718 3719 3738 3896 3931 3949 4042
TJS	3513 3632
TNA	0731 0746 0791 0822 2376 2914 3577 3581
TVR	0424
U6A	0733
UAL	0435 0439 0442 0450 0452 0454 0456 0457 0462 0463 0464 0465 0470 0472 0475 0479 0483 0485 0487 0489 0500 0503 0504 0506 0508 0510 0512 0523 0539 0568 0571 0587 0589 0592 0613 0638 0655 0678 0683 0686 0690 0702 0748 0751 0759 0780 0783 0788 0798 0804 0820 0824 0825 0826 0834 0836 0842 0843 0847 0850 0851 0858 0862 0865 0867 0871 0873 0882 0893 0898 0944 0948 0952 0955 0965 0980 0989 1001 1022 1031 1104 1105 1128 1146 1163 1192 1211 1243 1248 1266 1272 1282 1290 1291 1321 1341 1343 1359 1363 1401 1409 1420 1426 1427 1432 1435 1460 1469 1474 1475 1477 1495 1507 1508 1514 1522 1533 1538 1545 1555 1559 1569 1573 1581 1584 1585 1586 1600 1609 1617 1620 1627 1647 1649 1653 1664 1669 1671 1680 1688 1702 1728 1731 1737 1741 1755 1821 1840 1842 1845 1847 1865 2667 2815 2901 2940 2948 2969 3020
UEA	2654 2696 2762 2774 2820 2835 3024 3706 4347
UJX	1213 1663
UKN	3260
UNA	2921 4228

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OPERATOR	MSN
USA	0066 0448 0762 0803 0844 0856 0861 0863 0866 0868 0885 0889 0890 0896 0904 0922 0924 0929 0931 0953 0972 0997 1003 1019 1033 1038 1040 1043 1046 1049 1050 1051 1052 1055 1056 1061 1064 1065 1069 1075 1079 1083 1088 1095 1097 1109 1110 1111 1112 1114 1116 1122 1134 1135 1141 1148 1166 1178 1182 1196 1203 1205 1223 1224 1234 1245 1254 1264 1265 1268 1269 1274 1275 1281 1284 1287 1289 1294 1297 1298 1301 1310 1311 1313 1314 1315 1317 1319 1323 1326 1328 1331 1340 1342 1348 1350 1354 1358 1360 1369 1371 1373 1375 1378 1382 1389 1391 1393 1395 1397 1403 1406 1410 1412 1417 1419 1425 1431 1436 1442 1447 1455 1462 1463 1465 1472 1481 1490 1492 1496 1499 1517 1519 1521 1525 1527 1531 1534 1536 1539 1547 1552 1563 1565 1576 1621 1643 1644 1651 1666 1701 1704 1710 1724 1764 1792 1844 1935 2193 2302 2312 2405 2458 2482 2570 2595 2613 2615 2630 2669 2690 3584 3629 3633 3712 3740 3796 3858 3879 3881 3924 3928 3944 3960 3977 3989 3993 4025 4041 4050 4082 4086 4107 4123 4134 4149 4202 4242
UZB	4371 4395 4417
VAR	2383 2718
VIM	0879
VIP	2421 4151
VIV	2157 2210 2443 2576 2752 2908 3743
VJC	2745 3646 3739 3791 4049 4190 4193 4415
VKG	1932 1960
VLG	1171 1208 1210 1221 1349 1372 1396 1430 1461 1550 1749 1862 1914 1933 1979 2168 2223 2388 2407 2479 2589 2620 2658 2678 2761 2785 2794 2798 2962 2988 3028 3054 3083 3095 3102 3109 3145 3151 3169 3203 3237 3321 3376 3377 3400 3444 3476 3492 3529 3833 3907
VOE	2113 2122 2240 2253 2332 2382
VOI	2657 2666 2771 2780 2979 2997 3045 3069 3077 3175 3253 3279 3450 3463 3491 3524 3543 3590 3624
VRD	2616 2674 2740 2773 2778 2800 2811 2830 2851 2993 3016 3037 3101 3135 3155 3181 3204 3230 3324 3347 3349 3359 3398 3417 3445 3460 3465 3503 3656 3670 3684 3686
VRE	0067 0081 1429 2066 2213 2228
VVC	1306 1370 1454 1564 1578 1657 1686 1725 1867 2123
WGT	1212
WHT	0548 1256 2440 2675
WOW	4270 4305
WRC	0645 0781 1869 2462 2682
WZZ	3127 3143 3166 3177 3354 3384 3409 3430 3531 3562 3741 3771 3807 3877 3927 3947 3968 4109 4174 4223 4246 4308 4323 4351 4372

(4) Configuration by MSN

MSN	CONFIGURATION
0029 0072 0085 0086 0087 0094	001 002

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MSN	CONFIGURATION
0045 0046 0049 0050 0051 0052 0053 0054 0055 0056 0057 0059 0064 0065 0066 0067 0068 0069 0070 0071 0073 0076 0077 0078 0081 0082 0083 0084 0093 0099 0104 0110 0111 0112 0113 0115 0116 0117 0118 0121 0122 0123 0124 0125 0126 0127 0135 0137 0138 0140 0141 0142 0148 0149 0150 0152 0153 0154 0157 0159 0160 0161 0162 0164 0165 0166 0168 0169 0171 0172 0174 0175 0178 0181 0182 0183 0185 0192 0194 0195 0197 0198 0200 0201 0202 0203 0205 0206 0208 0209 0210 0211 0213 0216 0217 0218 0219 0220 0229 0230 0231 0232 0234 0237 0239 0242 0243 0244 0248 0249 0251 0252 0253 0254 0255 0256 0259 0260 0262 0263 0265 0267 0268 0269 0272 0273 0275 0276 0277 0279 0281 0282 0284 0285 0287 0289 0290 0291 0292 0293 0294 0295 0296 0297 0298 0300 0301 0302 0303 0306 0307 0308 0309 0311 0312 0314 0316 0317 0318 0319 0320 0321 0322 0324 0325 0328 0329 0330 0331 0332 0339 0340 0341 0342 0343 0345 0346 0347 0350 0351 0353 0354 0355 0357 0358 0359 0360 0361 0362 0366 0367 0368 0370 0371 0372 0373 0376 0378 0380 0381 0382 0386 0387 0388 0390 0393 0395 0398 0399 0400 0401 0402 0403 0404 0405 0406 0407 0408 0409 0410 0414 0415 0416 0417 0418 0420 0421 0422 0423 0424 0426 0427 0428 0429 0430 0431 0432 0435 0436 0438 0439 0441 0442 0444 0445 0447 0448 0449 0450 0452 0454 0456 0457 0460 0462 0463 0464 0465 0466 0470 0472 0475 0476 0479 0480 0482 0483 0485 0486 0487 0489 0490 0491 0496 0497 0499 0500 0501 0503 0504 0506 0507 0508 0510 0511 0512 0523 0525 0527 0528 0530 0531 0533 0534 0537 0539 0540 0542 0543 0545 0548 0549 0551 0553 0554 0556 0558 0559 0561 0562 0565 0566 0568 0569 0571 0573 0574 0575 0577 0579 0580 0582 0584 0585 0587 0589 0592 0596 0603 0607 0611 0613 0617 0619 0622 0630 0635 0638 0640 0643 0645 0648 0650 0653 0655 0657 0658 0659 0661 0662 0665 0667 0669 0671 0673 0676 0678 0681 0683 0685 0696 0698 0701 0702 0703 0704 0705 0706 0709 0712 0714 0716 0718 0720 0722 0724 0726 0730 0733 0735 0737 0739 0741 0743 0745 0747 0749 0751 0754 0756 0758 0760 0762 0764 0766 0768 0770 0774 0776 0778 0780 0782 0784 0786 0791 0793 0795 0797 0801 0803 0805 0807 0809 0812 0814 0816 0818 0820 0822 0824 0826 0828 0830 0832 0834 0836 0838 0839 0842 0844 0846 0849 0851 0854 0856 0857 0859 0861 0863 0865 0866 0868 0870 0872 0874 0876 0877 0879 0881 0883 0884 0886 0888 0892 0894 0895 0897 0900 0902 0903 0905 0907 0909 0911 0912 0914 0916 0918 0919 0921 0923 0925 0927 0928 0930 0932 0934 0936 0937 0939 0942 0943 0945 0947 0950 0951 0953 0955 0957 0958 0960 0962 0964 0966 0967 0971 0973 0975 0977 0981 0982 0984 0986 0988 0990 0992 0994 0996 0999 1001 1003 1005 1007 1009 1011 1013 1014 1026 1028 1030 1032 1035 1037 1039 1041 1047 1050 1052 1054 1057 1059 1061 1063 1065 1067 1070 1072 1075 1076	002

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MSN	CONFIGURATION
1079 1081 1083 1085 1087 1093 1099 1101 1104 1105 1108 1110 1112 1114 1117 1119 1121 1123 1125 1128 1130 1132 1134 1137 1138 1141 1143 1146 1148 1150 1152 1156 1158 1162 1163 1166 1168 1171 1173 1175 1177 1179 1181 1183 1187 1189 1192 1194 1196 1198 1200 1206 1208 1210 1213 1215 1217 1221 1224 1226 1229 1231 1234 1235 1237 1240 1242 1244 1246 1248 1251 1253 1255 1257 1259 1262 1264 1266 1268 1270 1272 1274 1280 1282 1284 1286 1288 1290 1292 1294 1296 1298 1300 1302 1304 1306 1308 1310 1312 1314 1316 1318 1320 1322 1327 1330 1332 1334 1337 1339 1341 1343 1345 1347 1349 1351 1353 1355 1357 1359 1361 1363 1365 1367 1368 1370 1372 1376 1379 1381 1383 1385 1387 1390 1394 1396 1398 1400 1402 1405 1407 1409 1411 1413 1416 1418 1419 1422 1424 1427 1430 1432 1435 1437 1439 1441 1443 1446 1448 1450 1452 1454 1457 1459 1461 1467 1469 1470 1473 1475 1478 1480 1482 1484 1486 1489 1491 1493 1495 1497 1500 1502 1504 1506 1508 1509 1512 1514 1516 1518 1523 1526 1528 1530 1532 1533 1535 1538 1540 1542 1544 1546 1548 1550 1553 1555 1557 1559 1561 1564 1566 1568 1571 1578 1580 1584 1586 1588 1591 1593 1595 1597 1605 1609 1610 1613 1615 1617 1620 1621 1624 1626 1628 1631 1633 1635 1637 1639 1641 1644 1646 1648 1650 1652 1655 1657 1661 1663 1665 1667 1669 1672 1674 1678 1680 1682 1686 1687 1689 1692 1694 1696 1697 1700 1702 1705 1708 1710 1712 1715 1717 1719 1721 1723 1725 1728 1730 1732 1735 1736 1739 1741 1744 1747 1749 1751 1754 1755 1757 1760 1762 1764 1767 1769 1771 1773 1775 1777 1780 1782 1784 1785 1787 1789 1792 1793 1797 1799 1802 1804 1806 1809 1812 1814 1816 1818 1821 1823 1825 1827 1829 1832 1834 1835 1838 1840 1842 1845 1847 1849 1852 1854 1856 1857 1858 1860 1861 1862 1864 1865 1867 1868 1871 1873 1874 1877 1879 1883 1885 1888 1889 1891 1892 1894 1895 1896 1898 1899 1900 1902 1903 1904 1906 1907 1909 1910 1911 1913 1914 1915 1917 1918 1920 1922 1924 1927 1929 1931 1933 1935 1937 1940 1942 1944 1945 1948 1949 1951 1954 1957 1958 1961 1964 1965 1968 1969 1973 1975 1979 1981 1983 1987 1989 1993 1996 1998 2001 2003 2006 2009 2011 2014 2016 2018 2020 2022 2024 2027 2029 2031 2034 2036 2038 2040 2042 2044 2046 2048 2049 2054 2056 2061 2063 2065 2068 2070 2073 2075 2077 2079 2082 2084 2085 2090 2092 2094 2097 2099 2102 2104 2106 2108 2112 2114 2116 2118 2121 2123 2125 2130 2132 2133 2134 2135 2136 2137 2138 2139 2140 2141 2142 2143 2144 2145 2146 2147 2148 2149 2150 2151 2152 2153 2154 2155 2156 2157 2158 2159 2160 2161 2162 2163 2164 2165 2166 2167 2168 2169 2171 2173 2175 2177 2178 2180 2182 2183 2185 2187 2189 2191 2193 2195 2197 2199 2201 2204 2206 2207 2210 2212 2215 2217 2219 2221 2223 2225 2227 2229 2231 2233 2235 2238 2239 2242 2244 2246 2248 2250 2252 2254 2256 2257 2259 2272 2274 2275 2278 2280 2282 2284 2286 2288 2291 2292 2294 2297 2299 2301 2307 2310 2312	002

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MSN	CONFIGURATION
2314 2316 2322 2325 2327 2329 2331 2334 2336 2338 2340 2343 2345 2347 2349 2352 2354 2356 2359 2361 2364 2366 2368 2372 2374 2376 2384 2386 2388 2390 2391 2393 2395 2397 2399 2401 2403 2405 2407 2409 2411 2413 2415 2417 2419 2422 2423 2425 2428 2430 2432 2434 2437 2439 2441 2443 2445 2447 2449 2451 2453 2455 2457 2459 2461 2475 2478 2479 2482 2484 2486 2489 2491 2493 2496 2498 2502 2504 2506 2509 2511 2513 2515 2517 2520 2522 2524 2526 2529 2531 2533 2535 2537 2539 2540 2542 2562 2564 2566 2569 2571 2573 2576 2577 2580 2583 2584 2587 2589 2591 2594 2596 2598 2600 2602 2604 2606 2608 2609 2612 2613 2616 2619 2620 2623 2626 2627 2630 2633 2635 2637 2640 2642 2645 2647 2649 2651 2654 2656 2658 2661 2663 2665 2668 2670 2671 2674 2676 2678 2680 2683 2685 2688 2689 2692 2695 2696 2699 2701 2703 2705 2708 2710 2712 2714 2717 2719 2721 2724 2725 2728 2731 2732 2734 2737 2740 2743 2745 2747 2749 2752 2753 2755 2758 2760 2761 2764 2766 2768 2770 2772 2775 2776 2778 2781 2783 2785 2787 2789 2791 2792 2794 2796 2798 2800 2802 2804 2807 2808 2810 2814 2816 2817 2820 2822 2824 2826 2828 2830 2832 2834 2835 2838 2840 2842 2844 2846 2848 2851 2853 2855 2856 2859 2861 2863 2865 2867 2869 2871 2874 2875 2877 2880 2881 2883 2885 2896 2899 2900 2902 2904 2906 2908 2909 2911 2914 2915 2917 2920 2922 2924 2926 2928 2930 2932 2934 2937 2939 2943 2944 2945 2947 2950 2952 2953 2956 2958 2960 2962 2964 2966 2968 2970 2973 2975 2977 2980 2982 2984 2986 2987 2988 2989 2990 2991 2992 2993 2994 2995 2998 3000 3002 3004 3006 3008 3010 3012 3014 3016 3018 3021 3023 3025 3027 3029 3031 3033 3035 3037 3039 3040 3042 3044 3047 3048 3050 3052 3055 3056 3058 3060 3063 3064 3066 3068 3071 3072 3074 3076 3079 3080 3083 3086 3087 3089 3091 3093 3095 3097 3099 3101 3103 3105 3107 3109 3111 3113 3115 3117 3119 3121 3123 3125 3127 3129 3131 3132 3135 3136 3138 3140 3141 3143 3145 3147 3148 3149 3150 3151 3152 3153 3154 3155 3156 3157 3158 3159 3160 3161 3162 3164 3166 3167 3170 3173 3174 3177 3178 3180 3182 3183 3185 3187 3189 3190 3192 3194 3196 3197 3199 3201 3203 3205 3206 3208 3210 3211 3213 3215 3218 3219 3221 3223 3224 3227 3228 3230 3232 3234 3236 3237 3239 3240 3242 3246 3256 3257 3259 3261 3263 3264 3266 3268 3270 3272 3273 3275 3277 3278 3280 3282 3284 3286 3287 3289 3291 3293 3295 3296 3299 3301 3303 3304 3306 3308 3310 3312 3313 3314 3316 3318 3319 3321 3323 3325 3327 3328 3330 3332 3335 3337 3338 3341 3343 3345 3348 3349 3351 3353 3354 3357 3359 3361 3362 3365 3366 3368 3370 3373 3374 3376 3378 3379 3381 3383 3384 3386 3389 3391 3392 3394 3396 3398 3400 3402 3404 3408 3409 3410 3412 3414 3416 3418 3420 3422 3423 3425 3427 3430 3431 3433 3435 3437 3439 3440 3444 3446 3448 3449 3451 3453 3455 3456 3457 3460 3461 3464 3465 3468 3470 3472 3473 3474 3475 3476 3477 3478 3479 3480 3481 3482	002

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MSN	CONFIGURATION
3483 3484 3485 3486 3487 3488 3489 3490 3492 3494 3495 3496 3497 3499 3501 3502 3503 3505 3506 3508 3510 3511 3514 3515 3516 3517 3519 3521 3524 3526 3528 3529 3531 3532 3535 3536 3538 3540 3541 3543 3545 3547 3549 3550 3553 3554 3556 3558 3559 3562 3563 3565 3567 3568 3570 3572 3574 3576 3577 3579 3581 3582 3591 3594 3596 3597 3598 3599 3601 3603 3605 3607 3609 3610 3611 3613 3616 3618 3621 3622 3624 3626 3627 3628 3630 3631 3640 3641 3643 3644 3646 3649 3650 3652 3654 3656 3658 3659 3662 3664 3666 3667 3668 3670 3672 3674 3676 3677 3679 3690 3692 3693 3695 3696 3697 3698 3699 3701 3703 3706 3707 3709 3711 3713 3714 3715 3716 3718 3719 3721 3723 3724 3726 3729 3731 3732 3734 3736 3739 3741 3743 3745 3747 3748 3750 3753 3755 3756 3758 3760 3762 3765 3767 3769 3771 3773 3775 3776 3777 3778 3780 3781 3782 3783 3785 3786 3787 3789 3791 3793 3795 3797 3798 3800 3802 3804 3805 3807 3809 3811 3812 3813 3815 3817 3819 3821 3823 3825 3827 3829 3831 3833 3835 3837 3840 3843 3846 3848 3850 3852 3855 3857 3859 3861 3863 3866 3868 3870 3871 3873 3875 3877 3880 3882 3883 3885 3887 3889 3891 3894 3896 3898 3900 3902 3904 3906 3907 3908 3909 3910 3912 3913 3915 3917 3919 3921 3922 3923 3925 3927 3929 3931 3933 3935 3937 3939 3941 3943 3945 3946 3947 3949 3952 3953 3954 3956 3959 3961 3963 3965 3967 3968 3971 3972 3974 3975 3976 3978 3979 3980 3984 3986 3988 3990 3991 3992 3995 3997 3999 4001 4003 4006 4008 4010 4011 4012 4013 4014 4015 4017 4019 4021 4023 4026 4027 4028 4030 4032 4033 4034 4035 4037 4043 4046 4049 4051 4053 4055 4057 4059 4061 4063 4064 4065 4066 4068 4070 4072 4075 4077 4079 4081 4083 4084 4086 4088 4090 4092 4093 4094 4095 4097 4098 4100 4101 4102 4104 4105 4106 4108 4109 4110 4111 4113 4115 4117 4118 4119 4120 4122 4124 4126 4128 4130 4133 4135 4137 4139 4140 4143 4144 4145 4146 4147 4149 4150 4152 4153 4154 4156 4157 4158 4159 4160 4161 4162 4165 4167 4168 4170 4172 4174 4175 4176 4177 4178 4179 4181 4183 4185 4186 4187 4188 4190 4191 4193 4195 4196 4197 4199 4201 4202 4203 4205 4206 4207 4208 4210 4212 4214 4216 4218 4219 4220 4223 4225 4226 4229 4231 4232 4233 4234 4235 4236 4237 4238 4239 4240 4241 4242 4243 4244 4245 4246 4247 4248 4249 4250 4252 4253 4255 4257 4260 4261 4263 4264 4265 4267 4269 4270 4272 4273 4276 4278 4279 4281 4284 4286 4288 4289 4290 4291 4293 4294 4295 4296 4297 4298 4300 4302 4303 4304 4305 4306 4307 4308 4309 4310 4312 4314 4316 4317 4320 4321 4322 4323 4324 4325 4326 4328 4329 4331 4333 4335 4337 4339 4340 4342 4343 4344 4345 4346 4347 4348 4349 4350 4351 4354 4355 4356 4357 4359 4361 4362 4363 4364 4365 4366 4367 4368 4370 4371 4372 4373 4375 4376 4378 4379 4381 4383 4384 4386 4388 4390 4391 4392 4393 4394 4395 4396 4397 4398 4399 4400 4401 4402 4404 4405 4407 4408 4409 4411 4412 4413 4414 4415 4417 4419 4421 4423 4424	002

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MSN	CONFIGURATION
4426 4429 4431 4432 4433 4434 4435 4436 4438 4439 4440 4441 4442 4445	002

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MSN	CONFIGURATION
0364 0385 0412 0434 0458 0468 0473 0474 0477 0484 0488 0493 0495 0498 0502 0505 0509 0513 0514 0516 0517 0518 0519 0520 0521 0522 0524 0526 0529 0532 0535 0538 0541 0544 0550 0552 0555 0560 0563 0564 0567 0570 0576 0581 0583 0586 0591 0593 0595 0597 0599 0604 0614 0620 0631 0633 0642 0652 0664 0666 0668 0675 0677 0680 0684 0687 0692 0699 0715 0725 0731 0746 0761 0765 0771 0775 0777 0781 0787 0792 0796 0802 0806 0808 0810 0811 0815 0819 0823 0827 0835 0841 0848 0852 0855 0864 0878 0887 0891 0901 0908 0915 0920 0926 0935 0940 0941 0954 0959 0961 0963 0968 0970 0974 0983 0987 0991 0993 0995 1004 1006 1008 1012 1015 1017 1021 1023 1024 1027 1042 1045 1060 1080 1094 1133 1144 1153 1161 1174 1185 1188 1195 1199 1202 1204 1207 1214 1219 1220 1227 1233 1238 1241 1250 1260 1273 1276 1293 1299 1307 1356 1366 1399 1403 1408 1412 1417 1421 1425 1428 1431 1433 1436 1438 1442 1447 1451 1455 1458 1462 1465 1472 1476 1481 1487 1492 1496 1499 1503 1511 1517 1519 1521 1525 1531 1536 1539 1554 1572 1587 1596 1602 1607 1611 1614 1619 1623 1629 1632 1636 1638 1642 1651 1658 1666 1670 1675 1681 1690 1691 1695 1701 1704 1707 1711 1713 1716 1720 1724 1726 1734 1748 1763 1772 1776 1783 1788 1794 1798 1807 1811 1817 1836 1843 1848 1850 1859 1869 1878 1881 1887 1905 1921 1926 1928 1932 1941 1946 1950 1953 1956 1960 1966 1967 1970 1972 1974 1977 1978 1984 1988 1994 1995 2005 2021 2041 2045 2055 2060 2064 2067 2076 2080 2105 2107 2110 2115 2117 2190 2208 2211 2216 2220 2226 2234 2247 2255 2261 2267 2270 2290 2303 2305 2309 2315 2320 2323 2324 2330 2337 2342 2351 2357 2363 2381 2410 2462 2472 2476 2480 2488 2521 2530 2536 2543 2549 2553 2563 2590 2599 2610 2653 2682 2687 2707 2713 2726 2730 2736 2741 2756 2759 2767 2793 2799 2809 2823 2862 2868 2882 2895 2903 2912 2916 2919 2927 2933 2936 2957 2965 2971 2974 2996 2999 3005 3013 3015 3022 3034 3051 3067 3070 3075 3081 3098 3106 3112 3120 3126 3130 3146 3191 3198 3207 3212 3217 3222 3229 3233 3235 3241 3247 3249 3251 3254 3262 3265 3267 3274 3283 3290 3294 3297 3302 3307 3315 3322 3326 3329 3334 3339 3340 3350 3355 3360 3367 3369 3372 3382 3387 3397 3399 3401 3405 3419 3429 3434 3441 3458 3459 3462 3471 3493 3498 3504 3507 3512 3522 3523 3525 3527 3539 3546 3552 3557 3566 3573 3575 3583 3584 3587 3592 3593 3600 3612 3619 3623 3625 3629 3633 3636 3637 3639 3645 3653 3655 3665 3669 3673 3678 3681 3682 3688 3708 3712 3717 3722 3725 3730 3737 3738 3740 3749 3752 3761 3764 3766 3784 3792 3796 3806 3814 3816 3820 3830 3847 3858 3862 3864 3867 3869 3878 3879 3881 3884 3893 3899 3916 3920 3924 3926 3928 3930 3934 3936 3938 3940 3944 3948 3951 3955 3960 3964 3966 3969 3973 3977 3981 3987 3989 3993 3996 4002 4005 4009 4016 4022 4025 4031 4041 4044 4045 4047 4050 4054 4058 4062 4067 4073 4074 4078 4082 4085 4091 4096 4099 4103 4107 4112 4116 4123	003

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MSN	CONFIGURATION
4131 4134 4136 4138 4142 4148 4155 4173 4180 4184 4189 4194 4198 4209 4213 4217 4221 4224 4230 4251 4266 4271 4274 4277 4280 4283 4292 4299 4311 4315 4318 4334 4338 4341 4352 4358 4360 4369 4374 4377 4382 4387 4406 4416 4420 4430	003

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MSN	CONFIGURATION
0546 0572 0578 0598 0600 0608 0609 0610 0612 0616 0618 0621 0623 0625 0627 0629 0634 0636 0637 0639 0641 0644 0646 0647 0649 0651 0654 0656 0660 0670 0672 0679 0682 0686 0688 0689 0690 0691 0693 0694 0695 0697 0700 0711 0713 0717 0719 0721 0723 0727 0728 0729 0732 0734 0736 0738 0740 0742 0744 0748 0750 0752 0755 0757 0759 0763 0767 0769 0773 0779 0783 0785 0788 0790 0794 0798 0800 0804 0813 0817 0821 0825 0829 0831 0833 0837 0840 0843 0845 0847 0850 0853 0858 0860 0862 0867 0869 0871 0873 0875 0880 0882 0885 0889 0890 0893 0896 0898 0904 0906 0910 0913 0917 0922 0924 0929 0931 0933 0938 0944 0946 0948 0949 0952 0965 0972 0976 0979 0980 0985 0989 0997 0998 1000 1002 1010 1016 1018 1019 1020 1022 1025 1029 1031 1033 1034 1036 1038 1040 1043 1046 1048 1049 1051 1053 1055 1056 1058 1062 1064 1066 1069 1071 1073 1077 1078 1082 1084 1086 1088 1089 1090 1091 1092 1095 1096 1097 1100 1102 1103 1106 1107 1109 1111 1115 1116 1118 1120 1122 1124 1126 1127 1129 1131 1135 1136 1139 1140 1142 1147 1149 1151 1154 1155 1157 1159 1160 1164 1165 1167 1169 1170 1172 1176 1178 1180 1182 1184 1190 1191 1193 1197 1201 1203 1205 1209 1211 1212 1216 1222 1223 1225 1228 1230 1232 1236 1239 1243 1245 1247 1249 1252 1254 1256 1258 1261 1263 1265 1267 1269 1271 1275 1277 1279 1281 1283 1285 1287 1289 1291 1295 1297 1301 1303 1309 1311 1313 1315 1317 1319 1321 1323 1324 1325 1326 1328 1329 1331 1335 1336 1338 1340 1342 1344 1346 1348 1350 1352 1354 1358 1360 1362 1364 1369 1371 1373 1375 1377 1378 1380 1382 1384 1386 1388 1389 1391 1392 1393 1395 1397 1401 1404 1406 1410 1414 1415 1420 1423 1426 1429 1434 1440 1444 1445 1449 1453 1456 1460 1463 1466 1468 1471 1474 1477 1479 1483 1485 1488 1490 1494 1498 1501 1505 1507 1510 1513 1515 1520 1522 1524 1527 1529 1534 1537 1541 1543 1545 1547 1549 1551 1552 1556 1558 1560 1562 1563 1565 1567 1569 1570 1573 1574 1575 1576 1577 1579 1581 1582 1583 1585 1589 1590 1592 1594 1598 1600 1601 1603 1604 1606 1612 1616 1618 1622 1625 1627 1630 1634 1640 1643 1645 1647 1649 1653 1654 1656 1659 1662 1664 1668 1671 1673 1677 1679 1683 1684 1685 1688 1693 1699 1703 1706 1709 1714 1718 1722 1731 1733 1737 1738 1740 1742 1743 1745 1746 1750 1752 1753 1756 1758 1759 1761 1765 1766 1770 1774 1778 1779 1781 1786 1790 1791 1795 1796 1800 1801 1803 1805 1808 1810 1815 1819 1820 1824 1826 1828 1831 1833 1837 1839 1841 1844 1846 1851 1853 1855 1863 1866 1870 1872 1875 1876 1880 1882 1884 1886 1890 1893 1897 1901 1908 1912 1916 1923 1925 1934 1936 1938 1943 1947 1952 1955 1959 1962 1963 1971 1976 1980 1982 1986 1990 1997 1999 2000 2002 2004 2007 2008 2010 2012 2013 2015 2019 2023 2026 2028 2030 2032 2033 2037 2039 2043 2047 2050 2052 2053 2057 2062 2066 2069 2072 2074 2078 2083 2086 2087 2089 2091 2093 2095 2096 2098 2101 2103 2113 2119 2120 2122 2124 2126 2127	004

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MSN	CONFIGURATION
2129 2131 2170 2172 2174 2176 2179 2181 2184 2186 2188 2192 2194 2196 2198 2200 2202 2203 2205 2209 2213 2214 2222 2224 2228 2230 2232 2236 2237 2240 2241 2243 2245 2249 2251 2253 2258 2260 2262 2263 2264 2265 2266 2268 2269 2271 2273 2277 2279 2281 2283 2285 2287 2289 2293 2295 2296 2298 2300 2302 2304 2306 2308 2311 2313 2318 2319 2321 2326 2332 2335 2339 2341 2346 2348 2353 2355 2360 2362 2365 2369 2370 2371 2373 2375 2378 2379 2380 2382 2383 2385 2387 2389 2392 2396 2398 2400 2402 2404 2406 2408 2412 2414 2416 2418 2420 2421 2426 2427 2429 2431 2433 2435 2436 2438 2440 2442 2444 2446 2448 2450 2452 2454 2456 2458 2460 2463 2464 2465 2466 2467 2468 2469 2470 2471 2473 2474 2477 2481 2483 2485 2487 2490 2492 2494 2495 2497 2499 2501 2503 2505 2507 2508 2510 2512 2514 2516 2518 2519 2525 2527 2528 2532 2534 2538 2541 2545 2546 2547 2548 2550 2551 2554 2555 2556 2557 2558 2559 2560 2561 2565 2567 2568 2570 2572 2574 2578 2579 2581 2585 2586 2588 2592 2593 2595 2597 2603 2605 2607 2611 2614 2615 2617 2618 2621 2622 2624 2625 2628 2629 2631 2632 2634 2636 2638 2639 2641 2643 2644 2646 2648 2650 2652 2655 2657 2659 2660 2662 2664 2666 2667 2669 2672 2673 2675 2677 2679 2681 2684 2690 2691 2693 2694 2697 2698 2700 2702 2704 2706 2709 2711 2715 2716 2718 2720 2723 2727 2729 2733 2735 2738 2739 2742 2744 2746 2748 2751 2754 2757 2762 2763 2765 2769 2771 2773 2774 2777 2779 2780 2782 2784 2786 2788 2790 2795 2797 2801 2803 2805 2806 2811 2812 2813 2815 2818 2819 2821 2825 2827 2829 2831 2833 2836 2837 2839 2841 2843 2845 2847 2849 2850 2852 2854 2857 2858 2860 2864 2866 2870 2872 2873 2876 2878 2879 2884 2886 2887 2888 2889 2890 2891 2892 2893 2894 2897 2898 2901 2905 2907 2913 2921 2923 2925 2929 2935 2938 2940 2942 2946 2948 2949 2954 2959 2961 2963 2969 2976 2978 2979 2981 2983 2985 2997 3003 3007 3011 3017 3019 3020 3024 3026 3028 3032 3036 3041 3043 3045 3046 3049 3053 3054 3057 3059 3061 3065 3069 3073 3077 3078 3082 3084 3085 3088 3090 3094 3096 3102 3104 3108 3114 3116 3118 3122 3124 3128 3133 3134 3137 3139 3142 3144 3165 3168 3169 3171 3172 3175 3176 3179 3181 3184 3186 3188 3193 3195 3200 3202 3204 3209 3226 3231 3243 3245 3248 3250 3252 3253 3255 3258 3260 3269 3271 3276 3279 3281 3285 3288 3292 3298 3300 3305 3309 3311 3317 3320 3324 3331 3336 3342 3344 3346 3347 3352 3356 3358 3364 3375 3377 3380 3385 3388 3393 3395 3403 3406 3407 3411 3413 3415 3417 3421 3424 3426 3428 3432 3436 3442 3443 3445 3447 3450 3452 3454 3463 3466 3467 3491 3500 3513 3518 3520 3533 3534 3537 3542 3544 3548 3551 3555 3560 3561 3564 3569 3571 3578 3580 3586 3588 3589 3590 3595 3604 3608 3614 3615 3620 3632 3634 3638 3647 3651 3657 3660 3661 3663 3671 3675 3680 3683 3684 3685 3686 3687 3689 3691 3694 3700 3702 3704 3705 3710 3720 3727 3728 3733 3735 3742 3744 3746 3754 3757	004

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MSN	CONFIGURATION
3759 3763 3768 3770 3772 3774 3779 3788 3790 3794 3799 3801 3803 3808 3810 3818 3822 3824 3826 3828 3832 3834 3836 3838 3839 3841 3842 3844 3845 3849 3851 3853 3854 3856 3860 3865 3872 3874 3876 3888 3890 3892 3895 3897 3901 3903 3905 3911 3914 3918 3942 3950 3957 3958 3962 3970 3982 3983 3994 3998 4000 4004 4018 4020 4024 4029 4036 4038 4040 4042 4048 4052 4056 4060 4069 4071 4076 4080 4087 4089 4114 4121 4125 4127 4129 4132 4141 4151 4163 4164 4166 4171 4182 4192 4200 4204 4215 4222 4227 4228 4254 4256 4258 4259 4262 4268 4275 4282 4285 4287 4301 4313 4319 4327 4332 4336 4353 4380 4385 4389 4403 4410 4418 4422 4425 4427 4428	004
1599 2035 2059 2071 2081 2100 2109 2317 2328 2333 2344 2350 2358 2367 2377 2394 2523 2544 2552 2575 2582 2601 2686 2750 2910 2918 2931 2951 2955 2967 2972 3001 3009 3030 3062 3100 3214 3216 3220 3225 3238 3333 3363 3371 3390 3438 3469 3509 3530 3585 3602 3606 3617 3635 3642 3751 3886 3932 3985 4007 4039 4169 4211	005

(5) Configuration definition

**CONF 001
Config. 001 is valid for all A320 aircraft given in the effectivity of this Service Bulletin without Service Bulletin No. A320-53-1029 accomplished, or repaired as per Inspection Service Bulletin No. A320-53-1030 or Modification No. 21202K1432 is embodied.

**CONF 002
Config 002 is valid for all A320 aircraft given in the effectivity of this Service Bulletin with Service Bulletin No. A320-53-1029 accomplished or Modification No. 21202K1432 is embodied and where Modification No. 151574K15052 is not embodied.

**CONF 003
Config. 003 is valid for all A321 aircraft given in the effectivity of this Service Bulletin with Modification No. 21202K1432 is embodied and where Modification No. 151574K15052 is not embodied.

**CONF 004
Config 004 is valid for all the A319 aircraft given in the effectivity of this Service Bulletin with Modification No. 21202K1432 is embodied and where Modification No. 151574K15052 is not embodied.

**CONF 005
Config 005 is valid for all A318 aircraft given in the effectivity of this Service Bulletin with Modification No. 21202K1432 is embodied and where Modification No. 151574K15052 is not embodied.

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(6) Material Effectivity

**CONF 001

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531240D01R02	1	
Standard tool TOOLD01	1	
Standard tool TOOLD03	1	
Consumable CMLD01	1	

**CONF 002 thru 005

MATERIAL	QTY PER A/C	SEE NOTES
Kit 531240D02R02	1	
Standard tool TOOLD02	1	
Standard tool TOOLD04	1	
Consumable CMLD01	1	

**CONF ALL

B. CONCURRENT REQUIREMENTS

Accomplishment of this Service Bulletin requires the prior or simultaneous accomplishment of the following Service Bulletin(s):

Service Bulletin No. A320-53-1264

NOTE: - Service Bulletin No. A320-53-1264 FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PLATE FR35 TO FR36 (CENTER WING BOX)

C. REASON

(1) History

During embodiment of inspection Service Bulletin A320-53-1029 and accomplishment of modification Service Bulletin A320-53-1030, which required the removal of longitudinal beams, further cracks have been found on in-service aircraft. These cracks were found around the fasteners connecting the pressure panel with the flexible bracket at FR36 adjacent to the longitudinal beams, LH and RH near Y +/- 1292.

(2) Objective/Action

This Service Bulletin details instructions to cold expand the attachment holes under the longitudinal beam at FR36 on aircraft with no crack finding in accordance with Inspection Service Bulletin No. A320-53-1264.

The procedure as described in this Service Bulletin is to be performed if no Airbus repair and/or repair improvement has been previously performed in the same area. In case of repairs performed previously, please contact AIRBUS Repair Support department for further instructions.

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(3) Advantages

Accomplishment of this Service Bulletin will cancel the requirement of additional inspections in accordance with Inspection Service Bulletin No. A320-53-1264 and thus prevent from possible expensive and time consuming repairs.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

****CONF 001**

Task 531240-831-848-001: Modification

(1) Remove the Fasteners in the Pressure Panel at FR36

(2) Prepare the Structure to Install the New Fasteners at FR36 LH

(3) Prepare the Structure to Install the New Fasteners at FR36 RH

(4) Install the New Fasteners in the Pressure Panel at FR36 LH

(5) Install the New Fasteners in the Pressure Panel at FR36 RH

****CONF 002**

Task 531240-831-848-001: Modification

(1) Remove the Fasteners in the Pressure Panel at FR36

(2) Prepare the Structure to Install the New Fasteners at FR36 LH

(3) Prepare the Structure to Install the New Fasteners at FR36 RH

(4) Install the New Fasteners in the Pressure Panel at FR36 LH

(5) Install the New Fasteners in the Pressure Panel at FR36 RH

****CONF 003**

Task 531240-831-848-001: Modification

(1) Remove the fasteners in the pressure panel at FR36

(2) Prepare the Structure to Install the New Fasteners at FR36 LH

(3) Prepare the Structure to Install the New Fasteners at FR36 RH

(4) Install the New Fasteners in the Pressure Panel at FR36 LH

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(5) Install the New Fasteners in the Pressure Panel at FR36 RH

**CONF 004

Task 531240-831-848-001: Modification

(1) Remove the Fasteners in the Pressure Panel at FR36

(2) Prepare the Structure to Install the New Fasteners at FR36 LH

(3) Prepare the Structure to Install the New Fasteners at FR36 RH

(4) Install the New Fasteners in the Pressure Panel at FR36 LH

(5) Install the New Fasteners in the Pressure Panel at FR36 RH

**CONF 005

Task 531240-831-848-001: Modification

(1) Remove the Fasteners in the Pressure Panel at FR36

(2) Prepare the Structure to Install the New Fasteners at FR36 LH

(3) Prepare the Structure to Install the New Fasteners at FR36 RH

(4) Install the New Fasteners in the Pressure Panel at FR36 LH

(5) Install the New Fasteners in the Pressure Panel at FR36 RH

**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.

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.

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G. MANPOWER

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

**CONF 001

Task 531240-831-848-001: Modification	
On Aircraft	
Remove the Fasteners in the Pressure Panel at FR36	0.00
Prepare the Structure to Install the New Fasteners at FR36 LH	1.00
Prepare the Structure to Install the New Fasteners at FR36 RH	1.00
Install the New Fasteners in the Pressure Panel at FR36 LH	1.00
Install the New Fasteners in the Pressure Panel at FR36 RH	1.00
Tests	6.00
Close-Up	15.50
TOTAL MANHOURS	25.50
ELAPSED TIME (HOURS)	11.75

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

NOTE: The removal of fasteners is done in Service Bulletin No. A320-53-1264 (CENTER FUSELAGE -INSPECTION OF ATTACHMENT HOLES ON THE PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF 002

Task 531240-831-848-001: Modification	
On Aircraft	
Remove the Fasteners in the Pressure Panel at FR36	0.00
Prepare the Structure to Install the New Fasteners at FR36 LH	0.50
Prepare the Structure to Install the New Fasteners at FR36 RH	0.50
Install the New Fasteners in the Pressure Panel at FR36 LH	0.50
Install the New Fasteners in the Pressure Panel at FR36 RH	0.50
Tests	6.00
Close-Up	15.50
TOTAL MANHOURS	23.50

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Task 531240-831-848-001: Modification	
ELAPSED TIME (HOURS)	11.25

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

NOTE: The removal of fasteners is done in Service Bulletin No. A320-53-1264 (CENTER FUSELAGE -INSPECTION OF ATTACHMENT HOLES ON THE PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

****CONF 003**

Task 531240-831-848-001: Modification	
On Aircraft	
Remove the fasteners in the pressure panel at FR36	0.00
Prepare the Structure to Install the New Fasteners at FR36 LH	0.50
Prepare the Structure to Install the New Fasteners at FR36 RH	0.50
Install the New Fasteners in the Pressure Panel at FR36 LH	0.50
Install the New Fasteners in the Pressure Panel at FR36 RH	0.50
Tests	6.00
Close-Up	15.50
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

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

NOTE: The removal of fasteners is done in Service Bulletin No. A320-53-1264 (CENTER FUSELAGE -INSPECTION OF ATTACHMENT HOLES ON THE PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

****CONF 004**

Task 531240-831-848-001: Modification	
On Aircraft	
Remove the Fasteners in the Pressure Panel at FR36	0.00
Prepare the Structure to Install the New Fasteners at FR36 LH	0.50
Prepare the Structure to Install the New Fasteners at FR36 RH	0.50
Install the New Fasteners in the Pressure Panel at FR36 LH	0.50
Install the New Fasteners in the Pressure Panel at FR36 RH	0.50
Tests	6.00
Close-Up	15.50

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Task 531240-831-848-001: Modification	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

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

NOTE: The removal of fasteners is done in Service Bulletin No. A320-53-1264 (CENTER FUSELAGE -INSPECTION OF ATTACHMENT HOLES ON THE PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF 005

Task 531240-831-848-001: Modification	
On Aircraft	
Remove the Fasteners in the Pressure Panel at FR36	0.00
Prepare the Structure to Install the New Fasteners at FR36 LH	0.50
Prepare the Structure to Install the New Fasteners at FR36 RH	0.50
Install the New Fasteners in the Pressure Panel at FR36 LH	0.50
Install the New Fasteners in the Pressure Panel at FR36 RH	0.50
Tests	6.00
Close-Up	15.50
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

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

NOTE: The removal of fasteners is done in Service Bulletin No. A320-53-1264 (CENTER FUSELAGE -INSPECTION OF ATTACHMENT HOLES ON THE PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF ALL

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

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J. REFERENCES

**CONF 001

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 25-54-12 36-22-18 38-13-00	06-31-53 21-20-00 25-80-00 38-11-41 53-35-13	06-41-53 21-21-43 36-22-00 38-12-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A320-53-1264		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-22-00 51-44-00 51-75-12	51-24-00 51-47-00	51-42-00 51-48-00

**CONF 002

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 25-54-12 36-22-18 38-13-00	06-31-53 21-20-00 25-80-00 38-11-41 53-35-13	06-41-53 21-21-43 36-22-00 38-12-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A320-53-1264		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-22-00 51-44-00 51-75-12	51-24-00 51-47-00	51-42-00 51-48-00

**CONF 003

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 25-54-12 36-22-18 38-13-00	06-31-53 21-20-00 25-80-00 38-11-41 52-30-00	06-41-53 21-21-43 36-22-00 38-12-00 53-35-13
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A320-53-1264		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-22-00 51-44-00 51-75-12	51-24-00 51-47-00	51-42-00 51-48-00

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**CONF 004

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 25-54-12 36-22-18 38-13-00	06-31-53 21-20-00 25-80-00 38-11-41 53-35-13	06-41-53 21-21-43 36-22-00 38-12-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A320-53-1264		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-22-00 51-44-00 51-75-12	51-24-00 51-47-00	51-42-00 51-48-00

**CONF 005

Aircraft Maintenance Manual (AMM)	06-20-00 20-21-11 25-54-12 36-22-18 38-13-00	06-31-53 21-20-00 25-80-00 38-11-41 53-35-13	06-41-53 21-21-43 36-22-00 38-12-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A320-53-1264		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-22-00 51-44-00 51-75-12	51-24-00 51-47-00	51-42-00 51-48-00

**CONF ALL

K. PUBLICATION AFFECTED

Aircraft Maintenance Manual (AMM)	53-31-00

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

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2. MATERIAL INFORMATION

****CONF ALL**

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

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

Kit 531240D01R02 Kit 531240D02R02	AIRBUS Material, Logistics and Suppliers ATP II B Hein-Sass-Weg 24 D-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 51660

(2) Price and Availability

Kit 531240D01R02	
Cost	922.00 USD
Availability	90 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 AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

Kit 531240D02R02	
Cost	849.00 USD
Availability	200 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 AirbusSpares portal or through a request for quotation to airbus.kit@airbus.com.

B. INDUSTRY SUPPORT INFORMATION

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

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C. LIST OF COMPONENTS

Kit 531240D01R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	D5337239120000	4	WASHER				
2	NSA5330-6	6	COLLAR				
3	ASNA2538-3A	4	NUT				
4	ASNA2538-3	6	NUT				
5	EN6115K3-4	6	BOLT				
6	EN6115K3A8	4	BOLT				
7	DAN5-6-7Y	6	PIN				

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

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	D5337239120000	4	WASHER				
3	ASNA2538-3A	4	NUT				
6	EN6115K3A8	4	BOLT				

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.

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 - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Corrosion Preventive Compound	12ADB1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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(2) Components

None

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the FTI tool kits should contact:

Standard tool TOOLD01 Standard tool TOOLD02	Fatigue Technology Inc 401 Andover Park East SEATTLE WA 98188-7605 USA Internet: www.fatiguetech.com Phone: (206) 2462010 Fax: (206) 2449886

Operators interested in obtaining WCI tool kits should contact:

Standard tool TOOLD03 Standard tool TOOLD04	West Coast Industries Inc. 14900 Whitman Ave. N SEATTLE, Washington 98133 USA Tel: (206) 3657513 Fax: (206) 3657483 Email: info@coldwork.com Europe, Middle East, Africa, India and Russia: customer@capaero.com / +33 5 61 92 04 91 (France)

(b) Price and Availability

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

or

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

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(2) Tools

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-1	Durable tooling	1	(1)
	EK-A320531240-1	Expendable tooling	1	(2)
	FTIA320531240-1	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-1

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-1

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-1

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
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD03

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-3	Durable tooling	1	(1)
	EK-A320531240-3	Expendable tooling	1	(2)
	WCIA320531240-3	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-3

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-3

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-3

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.

Standard tool TOOLD04

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 531240-831-848-001 - 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: Discarded parts must be managed at the operator's discretion.

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: Partial embodiment of this Service Bulletin to only one side is possible if a crack is found on one side only.

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Task Associated Data

****CONF 001**

Zone	
190 240 241 242 800	
Access	
Door	831 841
Panel	191BB 192FB 241DF 241HF 242DF 242HF
Manpower	
TOTAL MANHOURS	25.50
ELAPSED TIME (HOURS)	11.75

****CONF 002**

Zone	
190 240 241 242 800	
Access	
Door	831 841
Panel	191BB 192FB 241DF 241HF 242DF 242HF
Manpower	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

****CONF 003**

Zone	
190 240 241 242 800	
Access	
Door	831 841
Panel	191BB 192FB 241DF 241HF 242DF 242HF
Manpower	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

****CONF 004**

Zone	
190 240 241 242 800	
Access	
Door	831 841
Panel	191BB 192FB 241DF 241HF 242DF 242HF
Manpower	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

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**CONF 005

Zone	
190 240 241 242 800	
Access	
Door	831 841
Panel	191BB 192FB 241DF 241HF 242DF 242HF
Manpower	
TOTAL MANHOURS	23.50
ELAPSED TIME (HOURS)	11.25

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 531240-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-22-00 51-24-00 51-42-00 51-44-00 51-47-00 51-48-00 51-75-12

(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

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

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

(d) For the identification of access panels, refer to 06-41-53, Page Block 001.

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

(f) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

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(g) Obtain corrosion prevention data in accordance with SRM 51-22-00.

(h) Remove and install fasteners in accordance with SRM 51-42-00.

(i) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

(k) Apply sealant in accordance with SRM 51-24-00.

(l) Obtain fastener edge and margin data in accordance with SRM 51-47-00.

(m) Cold expand the fastener holes in accordance with SRM 51-48-00.

(n) When you remove fasteners you must be careful that you do not damage the holes in the structure.

(o) 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.

(2) Subtask 531240-839-201-001 - 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 002**

(1) Subtask 531240-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-22-00 51-24-00 51-42-00 51-44-00 51-47-00 51-48-00 51-75-12

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(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

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

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

(d) For the identification of access panels, refer to 06-41-53, Page Block 001.

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

(f) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(g) Obtain corrosion prevention data in accordance with SRM 51-22-00.

(h) Remove and install fasteners in accordance with SRM 51-42-00.

(i) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

(k) Apply sealant in accordance with SRM 51-24-00.

(l) Obtain fastener edge and margin data in accordance with SRM 51-47-00.

(m) Cold expand the fastener holes in accordance with SRM 51-48-00.

(n) When you remove fasteners you must be careful that you do not damage the holes in the structure.

(o) 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.

(2) Subtask 531240-839-201-001 - 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 003**

(1) Subtask 531240-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-22-00 51-24-00 51-42-00 51-44-00 51-47-00 51-48-00 51-75-12

(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

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

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

(d) For the identification of access panels, refer to 06-41-53, Page Block 001.

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

(f) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(g) Obtain corrosion prevention data in accordance with SRM 51-22-00.

(h) Remove and install fasteners in accordance with SRM 51-42-00.

(i) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

(k) Apply sealant in accordance with SRM 51-24-00.

(l) Obtain fastener edge and margin data in accordance with SRM 51-47-00.

(m) Cold expand the fastener holes in accordance with SRM 51-48-00.

(n) When you remove fasteners you must be careful that you do not damage the holes in the structure.

(o) 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.

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(2) Subtask 531240-839-201-001 - 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 004**

(1) Subtask 531240-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-22-00 51-24-00 51-42-00 51-44-00 51-47-00 51-48-00 51-75-12

(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

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

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

(d) For the identification of access panels, refer to 06-41-53, Page Block 001.

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

(f) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(g) Obtain corrosion prevention data in accordance with SRM 51-22-00.

(h) Remove and install fasteners in accordance with SRM 51-42-00.

(i) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

(k) Apply sealant in accordance with SRM 51-24-00.

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(l) Obtain fastener edge and margin data in accordance with SRM 51-47-00.

(m) Cold expand the fastener holes in accordance with SRM 51-48-00.

(n) When you remove fasteners you must be careful that you do not damage the holes in the structure.

(o) 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.

(2) Subtask 531240-839-201-001 - 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 005**

(1) Subtask 531240-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-22-00 51-24-00 51-42-00 51-44-00 51-47-00 51-48-00 51-75-12

(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

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

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

(d) For the identification of access panels, refer to 06-41-53, Page Block 001.

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

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(f) To torque tighten the standard threaded fasteners, refer to AMM Task 20-21-11-911-001.

(g) Obtain corrosion prevention data in accordance with SRM 51-22-00.

(h) Remove and install fasteners in accordance with SRM 51-42-00.

(i) Obtain fastener hole diameters and drill data in accordance with SRM 51-44-00.

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

(k) Apply sealant in accordance with SRM 51-24-00.

(l) Obtain fastener edge and margin data in accordance with SRM 51-47-00.

(m) Cold expand the fastener holes in accordance with SRM 51-48-00.

(n) When you remove fasteners you must be careful that you do not damage the holes in the structure.

(o) 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.

(2) Subtask 531240-839-201-001 - 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 531240-941-201-001 - Job Set-up

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Service Bulletin (SB)	A320-53-1264

(a) The job set-up procedure is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

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**CONF 002

(1) Subtask 531240-941-201-001 - Job Set-up

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Service Bulletin (SB)	A320-53-1264

(a) The job set-up procedure is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF 003

(1) Subtask 531240-941-201-002 - Job Set-up

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Service Bulletin (SB)	A320-53-1264

(a) The job set-up procedure is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF 004

(1) Subtask 531240-941-201-001 - Job Set-up

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Service Bulletin (SB)	A320-53-1264

(a) The job set-up procedure is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

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**CONF 005

(1) **Subtask 531240-941-201-001 - Job Set-up**

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Service Bulletin (SB)	A320-53-1264

(a) The job set-up procedure is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

**CONF ALL

C. **PROCEDURE**

**CONF 001

(1) **Subtask 531240-831-202-001 - Remove the Fasteners in the Pressure Panel at FR36**

Manpower Resources	
Manhours	0.00
Minimum number of person	2
Subtask elapsed time	0.00
Skills	AIRFRAME

References	
Service Bulletin (SB)	A320-53-1264

(a) The removal of the fasteners is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

(2) **Subtask 531240-831-204-001 - Prepare the Structure to Install the New Fasteners at FR36 LH**

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

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Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-1	Durable tooling	1	(1)
	EK-A320531240-1	Expendable tooling	1	(2)
	FTIA320531240-1	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-1

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-1

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-1

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 TOOLD03

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-3	Durable tooling	1	(1)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EK-A320531240-3	Expendable tooling	1	(2)
	WCIA320531240-3	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-3

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-3

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-3

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 51-75-12
Fig. A-GCAAA Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 LH, refer to Fig. A-GCAAA Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-1 Durable tooling 1

or

Refer to WCI tool list No.

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DK-A320531240-3 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-1 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-3 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.

FTIA320531240-1 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-3 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAA Sheet 01.

Refer to FTI tool list No.

DK-A320531240-1 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-3 Durable tooling 1

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7 Deburr and clean the fastener holes with:

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

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(3) Subtask 531240-831-205-001 - Prepare the Structure to Install the New Fasteners at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-1	Durable tooling	1	(1)
	EK-A320531240-1	Expendable tooling	1	(2)
	FTIA320531240-1	Capital tooling	1	(3)

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NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-1

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-1

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-1

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 TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-3	Durable tooling	1	(1)
	EK-A320531240-3	Expendable tooling	1	(2)
	WCIA320531240-3	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-3

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-3

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-3

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)	

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References	
Structural Repair Manual (SRM)	51-48-00 51-75-12
Fig. A-GCAAA Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 RH, refer to Fig. A-GCAAA Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-1 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-3 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-1 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-3 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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FTIA320531240-1 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-3 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAA Sheet 01.

Refer to FTI tool list No.

DK-A320531240-1 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-3 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(4) Subtask 531240-831-203-001 - Install the New Fasteners in the Pressure Panel at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

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Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D01R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
2	NSA5330-6	3	COLLAR	
3	ASNA2538-3A	2	NUT	
4	ASNA2538-3	3	NUT	
5	EN6115K3-4	3	BOLT	
6	EN6115K3A8	2	BOLT	
7	DAN5-6-7Y	3	PIN	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAA Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

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(a) In the pressure panel at FR36 LH, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the reworked washers , Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 LH, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1
3	Pin, Hi-Lok	DAN5-6-7Y	Item 7
3	Collar	NSA5330-6	Item 2
3	Bolt	EN6115K3-4	Item 5
3	Nut	ASNA2538-3	Item 4

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

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Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

(5) Subtask 531240-831-206-001 - Install the New Fasteners in the Pressure Panel at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D01R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
2	NSA5330-6	3	COLLAR	
3	ASNA2538-3A	2	NUT	
4	ASNA2538-3	3	NUT	
5	EN6115K3-4	3	BOLT	
6	EN6115K3A8	2	BOLT	
7	DAN5-6-7Y	3	PIN	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAA Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 RH, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 RH, refer to Fig. A-GCAAA Sheet 01, View B, Fig. A-GCAAA Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

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3	Pin, Hi-Lok	DAN5-6-7Y	Item 7
3	Collar	NSA5330-6	Item 2
3	Bolt	EN6115K3-4	Item 5
3	Nut	ASNA2538-3	Item 4

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

and

Corrosion Preventive Compound	12ADB1	As required

**CONF 002

(1) Subtask 531240-831-202-002 - Remove the Fasteners in the Pressure Panel at FR36

Manpower Resources	
Manhours	0.00
Minimum number of person	2
Subtask elapsed time	0.00
Skills	AIRFRAME

References	
Service Bulletin (SB)	A320-53-1264

(a) The removal of the fasteners is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

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(2) Subtask 531240-831-204-002 - Prepare the Structure to Install the New Fasteners at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

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DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 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.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

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DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General 08BAA9 As required

and

Textile - Lint Free Cotton 14SBA1 As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys 10ABC1 As required

(3) Subtask 531240-831-205-002 - Prepare the Structure to Install the New Fasteners at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 Expendable tooling 1

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

Refer to FTI tool list No.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(4) Subtask 531240-831-203-002 - Install the New Fasteners in the Pressure Panel at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

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Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2 Washer D5337239120000 Item 1

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(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the reworked washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

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(5) Subtask 531240-831-206-002 - Install the New Fasteners in the Pressure Panel at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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NOTE: 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.

(a) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

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Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

**CONF 003

(1) Subtask 531240-831-202-003 - Remove the fasteners in the pressure panel at FR36

Manpower Resources	
Manhours	0.00
Minimum number of person	2
Subtask elapsed time	0.00
Skills	AIRFRAME

References	
Service Bulletin (SB)	A320-53-1264

(a) The removal of the fasteners is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

(2) Subtask 531240-831-204-003 - Prepare the Structure to Install the New Fasteners at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35.8 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 51-75-12
Fig. A-GCAAC Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 LH, refer to Fig. A-GCAAC Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

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EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 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.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAC Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

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(3) Subtask 531240-831-205-003 - Prepare the Structure to Install the New Fasteners at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35.8 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 51-75-12
Fig. A-GCAAC Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 RH, refer to Fig. A-GCAAC Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

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DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 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.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAC Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

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DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General 08BAA9 As required

and

Textile - Lint Free Cotton 14SBA1 As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys 10ABC1 As required

(4) Subtask 531240-831-203-003 - Install the New Fasteners in the Pressure Panel at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35.8 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAC Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 LH, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 LH, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6

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2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

(5) Subtask 531240-831-206-003 - Install the New Fasteners in the Pressure Panel at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35.8 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAC Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 RH, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, View C and View D.

(c) Remove the washers.

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(d) Apply protective treatment to the washers , Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 RH, refer to Fig. A-GCAAC Sheet 01, View B, Fig. A-GCAAC Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

and

Corrosion Preventive Compound	12ADB1	As required

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**CONF 004

(1) Subtask 531240-831-202-002 - Remove the Fasteners in the Pressure Panel at FR36

Manpower Resources	
Manhours	0.00
Minimum number of person	2
Subtask elapsed time	0.00
Skills	AIRFRAME

References	
Service Bulletin (SB)	A320-53-1264

(a) The removal of the fasteners is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

(2) Subtask 531240-831-204-002 - Prepare the Structure to Install the New Fasteners at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 Expendable tooling 1

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

Refer to FTI tool list No.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(3) Subtask 531240-831-205-002 - Prepare the Structure to Install the New Fasteners at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

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Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD04

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

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DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 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.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

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7 Deburr and clean the fastener holes with:

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

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(4) Subtask 531240-831-203-002 - Install the New Fasteners in the Pressure Panel at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the reworked washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3

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2	Washer	D5337239120000	Item 1
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

(5) Subtask 531240-831-206-002 - Install the New Fasteners in the Pressure Panel at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

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(e) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

and

Corrosion Preventive Compound	12ADB1	As required

**CONF 005

(1) Subtask 531240-831-202-002 - Remove the Fasteners in the Pressure Panel at FR36

Manpower Resources	
Manhours	0.00
Minimum number of person	2
Subtask elapsed time	0.00
Skills	AIRFRAME

References	
Service Bulletin (SB)	A320-53-1264

(a) The removal of the fasteners is done in Service Bulletin No. A320-53-1264 (FUSELAGE - CENTER FUSELAGE - INSPECTION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35 - FR36 (CENTER WING BOX).

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(2) Subtask 531240-831-204-002 - Prepare the Structure to Install the New Fasteners at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

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DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 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.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

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DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General 08BAA9 As required

and

Textile - Lint Free Cotton 14SBA1 As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys 10ABC1 As required

(3) Subtask 531240-831-205-002 - Prepare the Structure to Install the New Fasteners at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
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	
	Surface Pretreatment - Light Alloys	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-2	Durable tooling	1	(1)

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ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EK-A320531240-2	Expendable tooling	1	(2)
	FTIA320531240-2	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-2

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-2

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

NOTE (3): Capital Tooling: Ref. FTI-A320-53-1240-2

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 TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DK-A320531240-4	Durable tooling	1	(1)
	EK-A320531240-4	Expendable tooling	1	(2)
	WCIA320531240-4	Capital tooling	1	(3)

NOTE (1): Durable Tooling: Ref. DK-A320-53-1240-4

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

NOTE (2): Expendable Tooling: Ref. EK-A320-53-1240-4

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

NOTE (3): Capital Tooling: Ref. WCI-A320-53-1240-4

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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 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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

(a) At FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B and in accordance with SRM 51-48-00, do the cold expansion of the fastener holes.

1 Oversize the holes to the start diameter in accordance with SRM 51-48-00.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

2 Clean the drilled areas 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.

EK-A320531240-2 Expendable tooling 1

or

Refer to WCI tool list No.

EK-A320531240-4 Expendable tooling 1

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

Refer to FTI tool list No.

FTIA320531240-2 Capital tooling 1

or

Refer to WCI tool list No.

WCIA320531240-4 Capital tooling 1

5 Remove the sleeves.

6 Ream the holes to the final hole diameter in accordance with SRM 51-48-00 and Fig. A-GCAAB Sheet 01.

Refer to FTI tool list No.

DK-A320531240-2 Durable tooling 1

or

Refer to WCI tool list No.

DK-A320531240-4 Durable tooling 1

7 Deburr and clean the fastener holes with:

Non Aqueous Cleaner - General	08BAA9	As required

and

Textile - Lint Free Cotton	14SBA1	As required

8 Renew the protective finish of the holes in accordance with SRM 51-75-12 with:

Surface Pretreatment - Light Alloys	10ABC1	As required

(4) Subtask 531240-831-203-002 - Install the New Fasteners in the Pressure Panel at FR36 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	241	Access	Panel 241DF, Panel 241HF
		Work location	from Frame 35 LH to Frame 36 LH
	190	Access	Panel 191BB
	800	Access	Door 831

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Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

NOTE: 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.

(a) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2 Washer D5337239120000 Item 1

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(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the reworked washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 LH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

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(5) Subtask 531240-831-206-002 - Install the New Fasteners in the Pressure Panel at FR36 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	242	Access	Panel 242DF, Panel 242HF
		Work location	from Frame 35 RH to Frame 36 RH
	190	Access	Panel 192FB
	800	Access	Door 841

Manpower Resources	
Manhours	0.50
Minimum number of person	2
Subtask elapsed time	0.25
Skills	AIRFRAME

Material necessary to do the job

Kit 531240D02R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	D5337239120000	2	WASHER	
3	ASNA2538-3A	2	NUT	
6	EN6115K3A8	2	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Corrosion Preventive Compound	12ADB1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-21-11-911-001
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-42-00 51-75-12
Fig. A-GCAAB Installation of the Fasteners on the Pressure Panel between FR35 and FR36	Sheet 01 Sheet 02

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NOTE: 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.

(a) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, temporarily install:

2	Washer	D5337239120000	Item 1

(b) Make sure that the washers, Item 1, are installed flat and not on the radius, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D, and if necessary rework the washers, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, View C and View D.

(c) Remove the washers.

(d) Apply protective treatment to the washers, Item 1, use:

Wash Primer - Structure	04CMA2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(e) In the pressure panel at FR36 RH, refer to Fig. A-GCAAB Sheet 01, View B, Fig. A-GCAAB Sheet 02, Views C and D, and in accordance with SRM 51-42-00, wet install:

2	Bolt	EN6115K3A8	Item 6
2	Collar	ASNA2538-3A	Item 3
2	Washer	D5337239120000	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Torque tighten fasteners, refer to AMM Task 20-21-11-911-001.

(g) To the fasteners, apply in accordance with SRM 51-75-12:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

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Top Coat Polyurethane - Grey Internal Structure	04JME4	As required
and		
Corrosion Preventive Compound	12ADB1	As required

**CONF ALL

D. TEST

**CONF 001

(1) Subtask 531240-840-201-001 - Preparation for Test

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 21-21-43-400-002 Task 25-54-12-400-001 Task 25-80-00-400-001 Task 36-22-18-400-001 Task 38-11-41-400-002

(a) Install the potable water tank, refer to AMM Task 38-11-41-400-002.

(b) Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.

(c) Install the overheating sensing elements, refer to AMM Task 36-22-18-400-001.

(d) If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001.

(e) If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002.

(f) Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

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(2) Subtask 531240-710-201-001 - Operational Test

Manpower Resources	
Skills	AIRFRAME CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-710-050 Task 36-22-00-710-001 38-12-00, Page Block 501 Task 38-13-00-710-001

(a) Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001.

(b) Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.

(c) Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.

(d) Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

****CONF 002**

(1) Subtask 531240-840-201-001 - Preparation for Test

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 21-21-43-400-002 Task 25-54-12-400-001 Task 25-80-00-400-001 Task 36-22-18-400-001 Task 38-11-41-400-002

(a) Install the potable water tank, refer to AMM Task 38-11-41-400-002.

(b) Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.

(c) Install the overheating sensing elements, refer to AMM Task 36-22-18-400-001.

(d) If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001.

(e) If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002.

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(f) Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

(2) Subtask 531240-710-201-001 - Operational Test

Manpower Resources	
Skills	AIRFRAME CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-710-050 Task 36-22-00-710-001 38-12-00, Page Block 501 Task 38-13-00-710-001

(a) Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001.

(b) Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.

(c) Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.

(d) Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

****CONF 003**

(1) Subtask 531240-840-201-001 - Preparation for Test

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 21-21-43-400-002 Task 25-54-12-400-001 Task 25-80-00-400-001 Task 36-22-18-400-001 Task 38-11-41-400-002

(a) Install the potable water tank, refer to AMM Task 38-11-41-400-002.

(b) Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.

(c) Install the overheating sensing elements, refer to AMM Task 36-22-18-400-001.

(d) If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001.

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(e) If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002.

(f) Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

(2) Subtask 531240-710-201-001 - Operational Test

Manpower Resources	
Skills	AIRFRAME CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-710-050 Task 36-22-00-710-001 38-12-00, Page Block 501 Task 38-13-00-710-001

(a) Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001.

(b) Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.

(c) Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.

(d) Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

**CONF 004

(1) Subtask 531240-840-201-001 - Preparation for Test

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 21-21-43-400-002 Task 25-54-12-400-001 Task 25-80-00-400-001 Task 36-22-18-400-001 Task 38-11-41-400-002

(a) Install the potable water tank, refer to AMM Task 38-11-41-400-002.

(b) Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.

(c) Install the overheating sensing elements, refer to AMM Task 36-22-18-400-001.

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(d) If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001.

(e) If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002.

(f) Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

(2) Subtask 531240-710-201-001 - Operational Test

Manpower Resources	
Skills	AIRFRAME CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-710-050 Task 36-22-00-710-001 38-12-00, Page Block 501 Task 38-13-00-710-001

(a) Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001.

(b) Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.

(c) Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.

(d) Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

****CONF 005**

(1) Subtask 531240-840-201-001 - Preparation for Test

Manpower Resources	
Skills	AIRFRAME NON SPECIFIC CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-410-001 Task 21-21-43-400-002 Task 25-54-12-400-001 Task 25-80-00-400-001 Task 36-22-18-400-001 Task 38-11-41-400-002

(a) Install the potable water tank, refer to AMM Task 38-11-41-400-002.

(b) Install the heat and sound insulation between FR35 and FR36 that was removed for access, refer to AMM Task 25-80-00-400-001.

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(c) Install the overheating sensing elements, refer to AMM Task 36-22-18-400-001.

(d) If removed before, install the air conditioning ducts, refer to AMM Task 21-20-00-410-001.

(e) If removed before, install the mixer unit, refer to AMM Task 21-21-43-400-002.

(f) Install the forward cargo-compartment partition, refer to AMM Task 25-54-12-400-001.

(2) Subtask 531240-710-201-001 - Operational Test

Manpower Resources	
Skills	AIRFRAME CABIN

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-710-050 Task 36-22-00-710-001 38-12-00, Page Block 501 Task 38-13-00-710-001

(a) Do an operational test of the water quantity indicating system if the potable water system was removed, refer to AMM Task 38-13-00-710-001.

(b) Do an operational test of the water distribution system if the potable water system was removed, refer to AMM 38-12-00, Page Block 501.

(c) Do an operational test of the overheat detection system, refer to AMM Task 36-22-00-710-001.

(d) Do the leak test of the air conditioning distribution ducts, refer to AMM Task 21-20-00-710-050.

****CONF ALL**

E. CLOSE-UP

****CONF 001**

(1) Subtask 531240-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	240	Access	Panel 241DF, Panel 241HF, Panel 242DF, Panel 242HF
		Work location	from Frame 35 to Frame 42
	190	Access	Panel 191BB, Panel 192FB

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Manpower Resources	
Skills	NON SPECIFIC AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 25-80-00-400-001 Task 53-35-13-400-002

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

(b) If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.

(d) Remove the access platform.

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

**CONF 002

(1) Subtask 531240-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	240	Access	Panel 241DF, Panel 241HF, Panel 242DF, Panel 242HF
		Work location	from Frame 35 to Frame 42
	190	Access	Panel 191BB, Panel 192FB

Manpower Resources	
Skills	NON SPECIFIC AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 25-80-00-400-001 Task 53-35-13-400-002

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

(b) If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.

(d) Remove the access platform.

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

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**CONF 003

(1) Subtask 531240-942-201-002 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	240	Access	Panel 241DF, Panel 241HF, Panel 242DF, Panel 242HF
		Work location	from Frame 35 to Frame 42
	190	Access	Panel 191BB, Panel 192FB

Manpower Resources	
Skills	NON SPECIFIC AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 25-80-00-400-001 Task 52-30-00-860-002 Task 53-35-13-400-002

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

(b) If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.

(d) Close the FWD cargo compartment door 825, refer to AMM Task 52-30-00-860-002.

(e) Remove the access platform.

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

**CONF 004

(1) Subtask 531240-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	240	Access	Panel 241DF, Panel 241HF, Panel 242DF, Panel 242HF
		Work location	from Frame 35 to Frame 42
	190	Access	Panel 191BB, Panel 192FB

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Manpower Resources	
Skills	NON SPECIFIC AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 25-80-00-400-001 Task 53-35-13-400-002

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

(b) If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.

(d) Remove the access platform.

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

**CONF 005

(1) Subtask 531240-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	240	Access	Panel 241DF, Panel 241HF, Panel 242DF, Panel 242HF
		Work location	from Frame 35 to Frame 42
	190	Access	Panel 191BB, Panel 192FB

Manpower Resources	
Skills	NON SPECIFIC AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 25-80-00-400-001 Task 53-35-13-400-002

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

(b) If necessary, install the insulation blankets, refer to AMM Task 25-80-00-400-001.

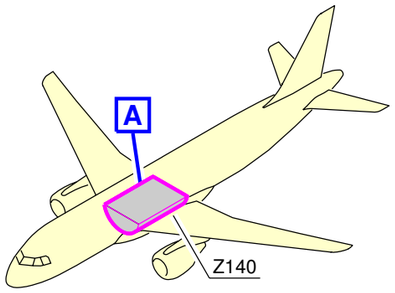
(c) Install the access panels 191BB and 192FB, refer to AMM Task 53-35-13-400-002.

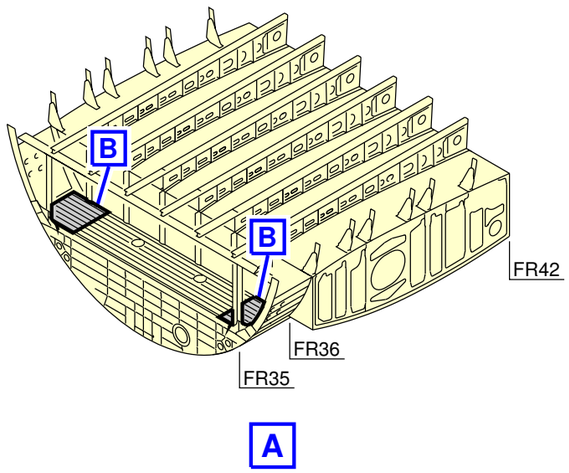
(d) Remove the access platform.

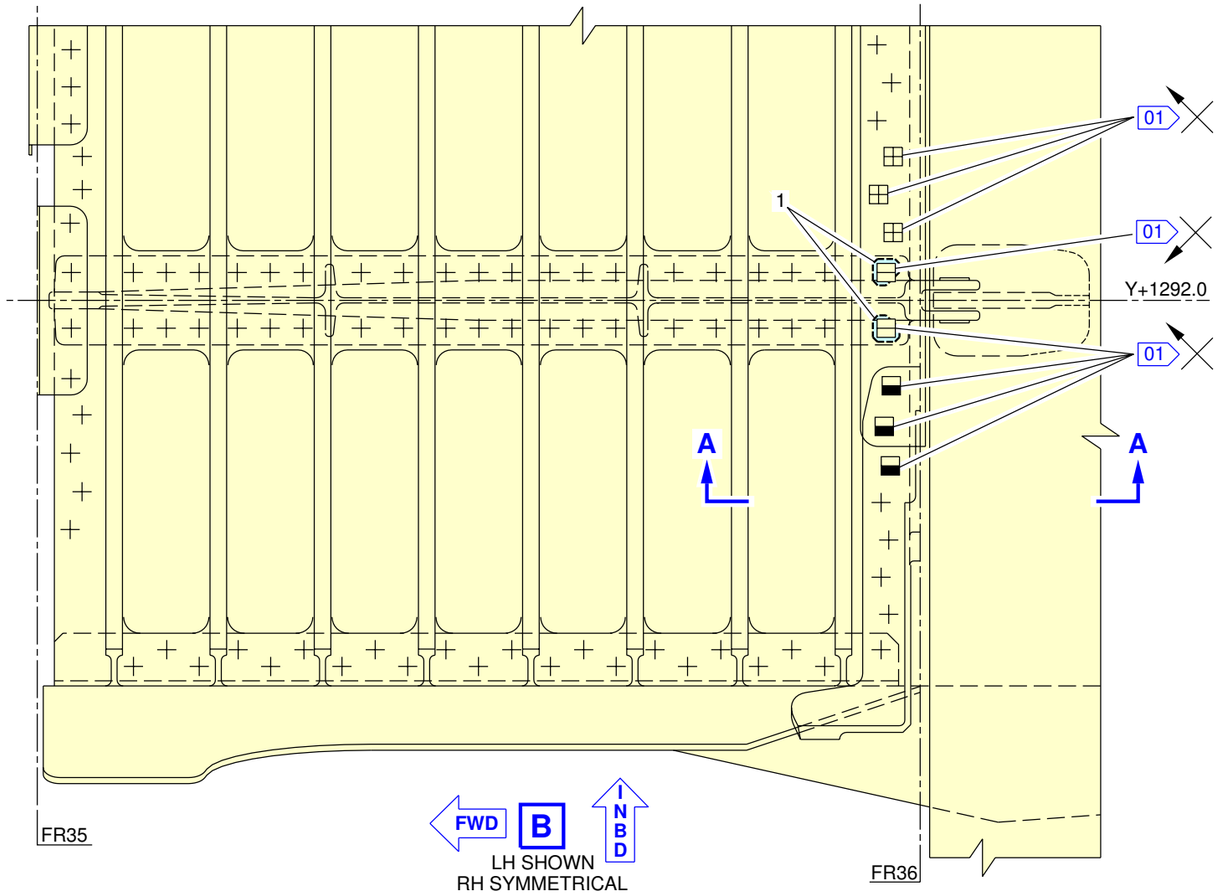
(e) Put the aircraft back to its initial configuration.

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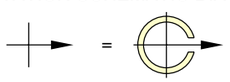
**CONF 001







EXPANSION SLEEVE INSTALLATION.
ORIENTATION SCHEMATIC DIAGRAM



NOTE:

01 TYPICAL DIRECTION OF SLEEVE GAP FOR COLD EXPANSION.

02 4% COLD WORKING.

03 FASTENER HEAD FAR SIDE.

04 FASTENER HEAD NEAR SIDE.

EXISTING FASTENERS

FASTENER TABLE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
					MIN	MAX	MIN	MAX		
⬓	2	NSA5330–6	COLLAR	6–1–N	4.88 mm (0.1921 in)	4.93 mm (0.1941 in)	5.452 mm (0.2146 in)	5.487 mm (0.2160 in)	2ND OVERSIZE INTERFERENCE FIT	02 03
	7	DAN5–6–7Y	HI–LOK							
⊟	3	ASNA2538–3A	COLLAR	6–1–N	4.88 mm (0.1921 in)	4.93 mm (0.1941 in)	5.452 mm (0.2146 in)	5.487 mm (0.2160 in)	2ND OVERSIZE INTERFERENCE FIT	02 04
	6	EN6115K3A8	BOLT							
⊞	4	ASNA2538–3	NUT	4–4–N	4.29 mm (0.1690 in)	4.34 mm (0.1710 in)	4.723 mm (0.1859 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	02 03
	5	EN6115K3–4	BOLT							

N_SB_531240_6_CAAA_01_05

Figure A-GCAAA - Sheet 01
Installation of the Fasteners on the Pressure Panel between FR35 and FR36

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**CONF 001

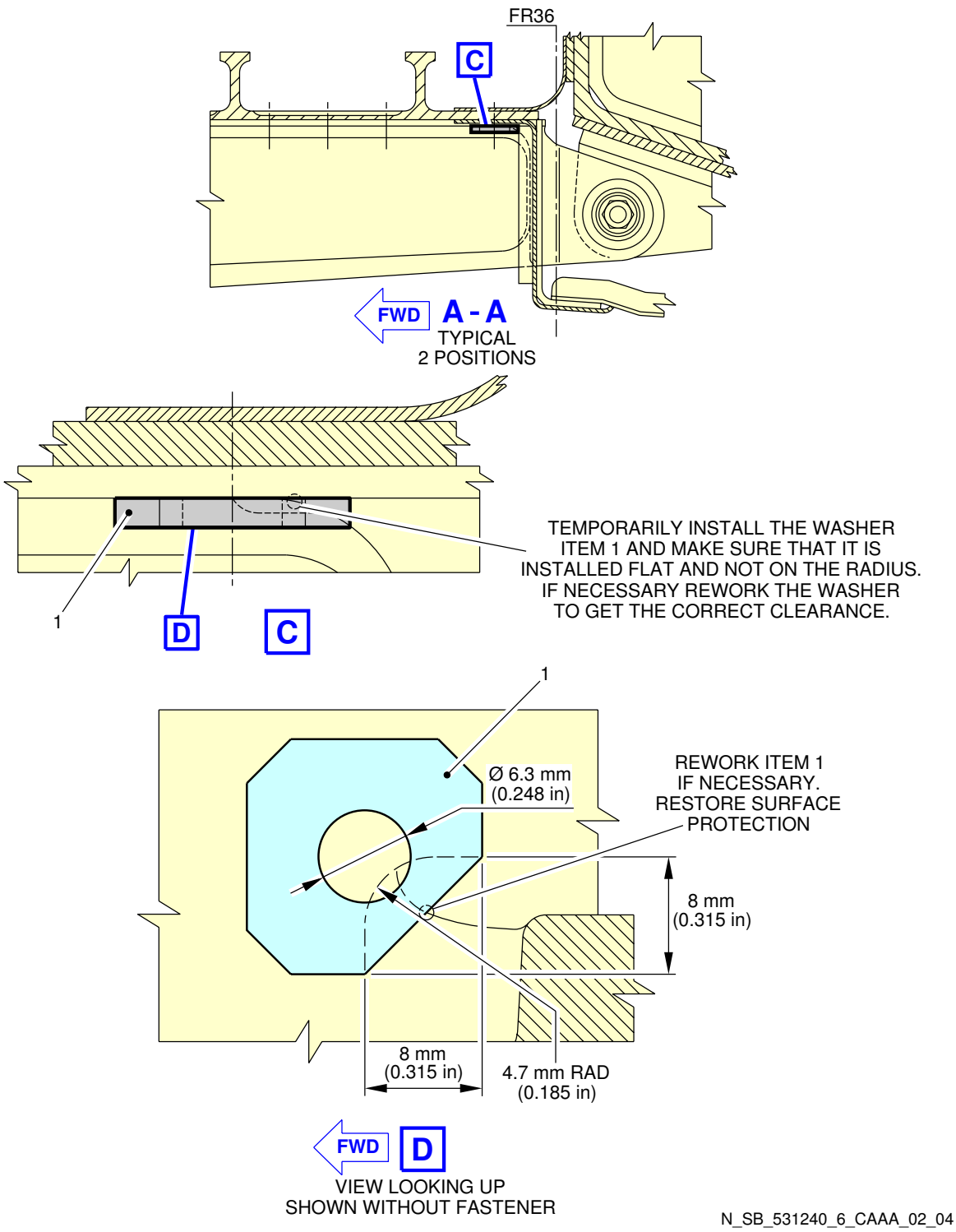
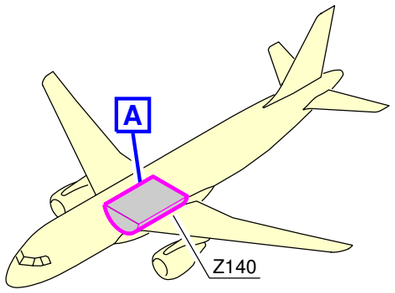
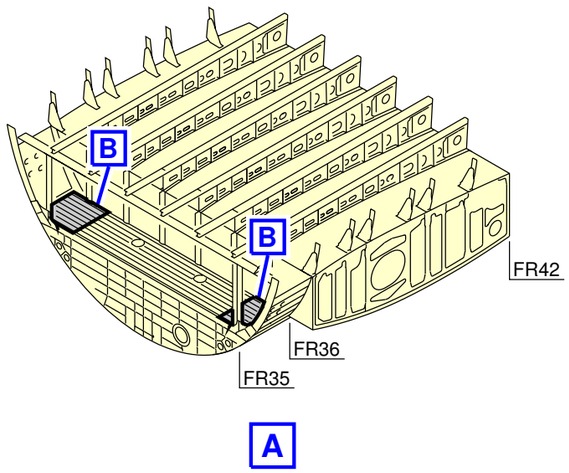


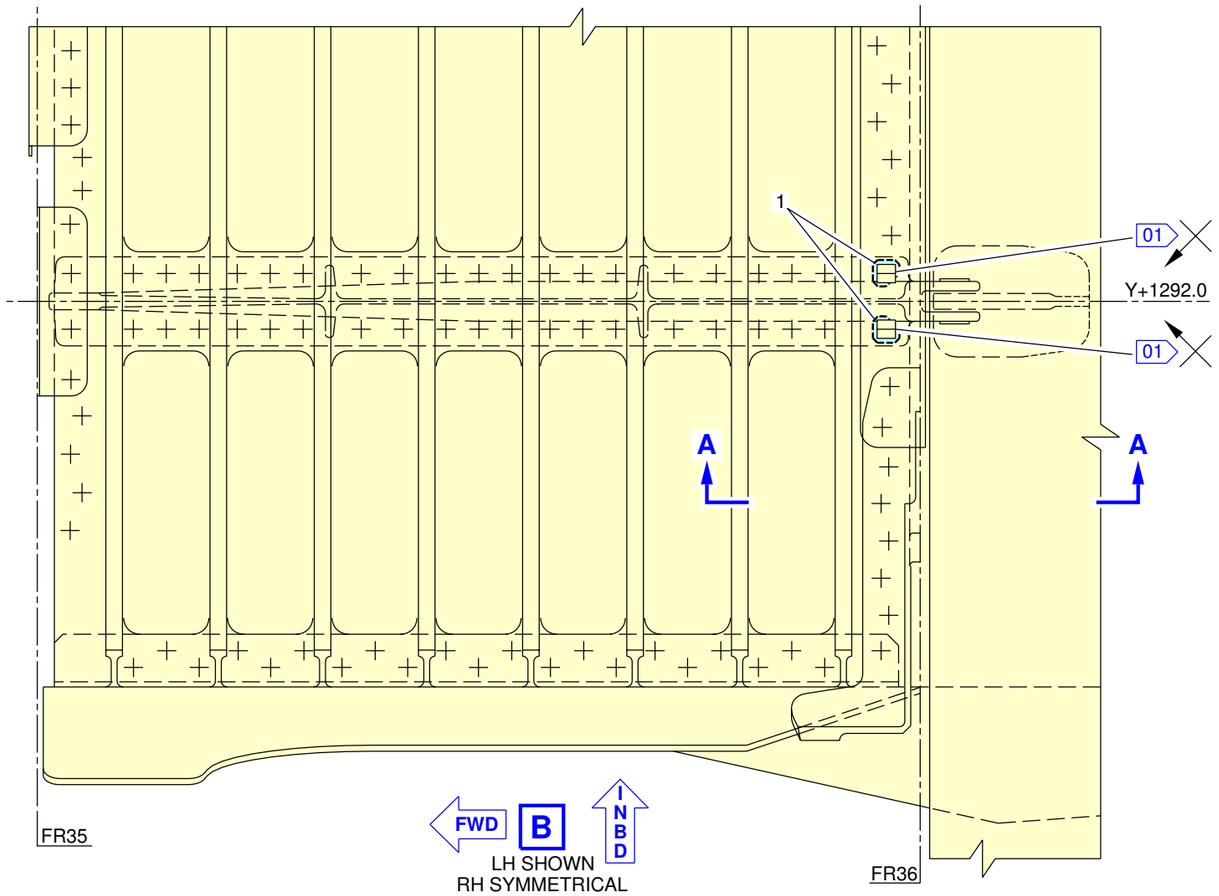
Figure A-GCAAA - Sheet 02
Installation of the Fasteners on the Pressure Panel between FR35 and FR36

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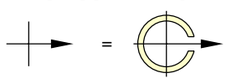
**CONF 002, 004 thru 005







EXPANSION SLEEVE INSTALLATION.
ORIENTATION SCHEMATIC DIAGRAM



NOTE:

01 TYPICAL DIRECTION OF SLEEVE GAP FOR COLD EXPANSION.

02 4% COLD WORKING.

03 FASTENER HEAD NEAR SIDE.

EXISTING FASTENERS

FASTENER TABLE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
					MIN	MAX	MIN	MAX		
⊟	3	ASNA2538–3A	COLLAR	6–1–N	4.88 mm (0.1921 in)	4.93 mm (0.1941 in)	5.452 mm (0.2146 in)	5.487 mm (0.2160 in)	2ND OVERSIZE INTERFERENCE FIT	02 03
	6	EN6115K3A8	BOLT							

N_SB_531240_6_CAAB_01_04

Figure A-GCAAB - Sheet 01
Installation of the Fasteners on the Pressure Panel between FR35 and FR36

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**CONF 002, 004 thru 005

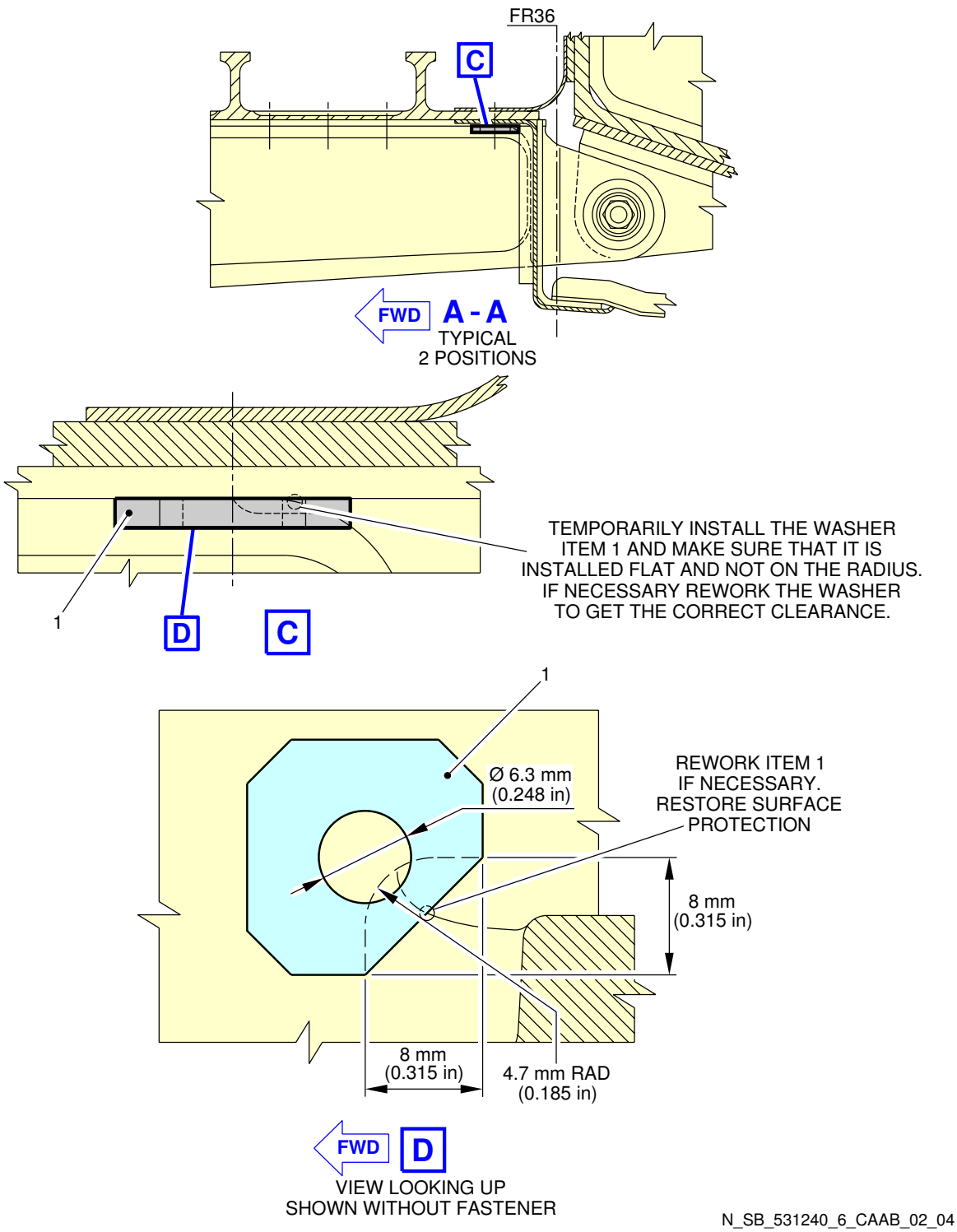
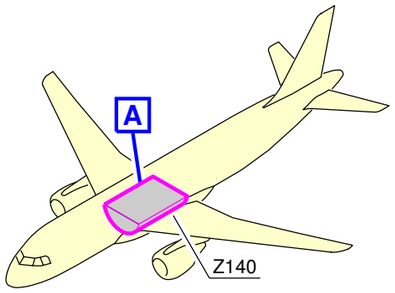
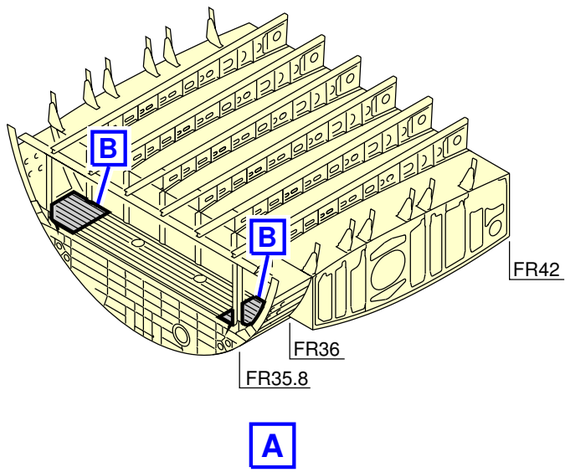


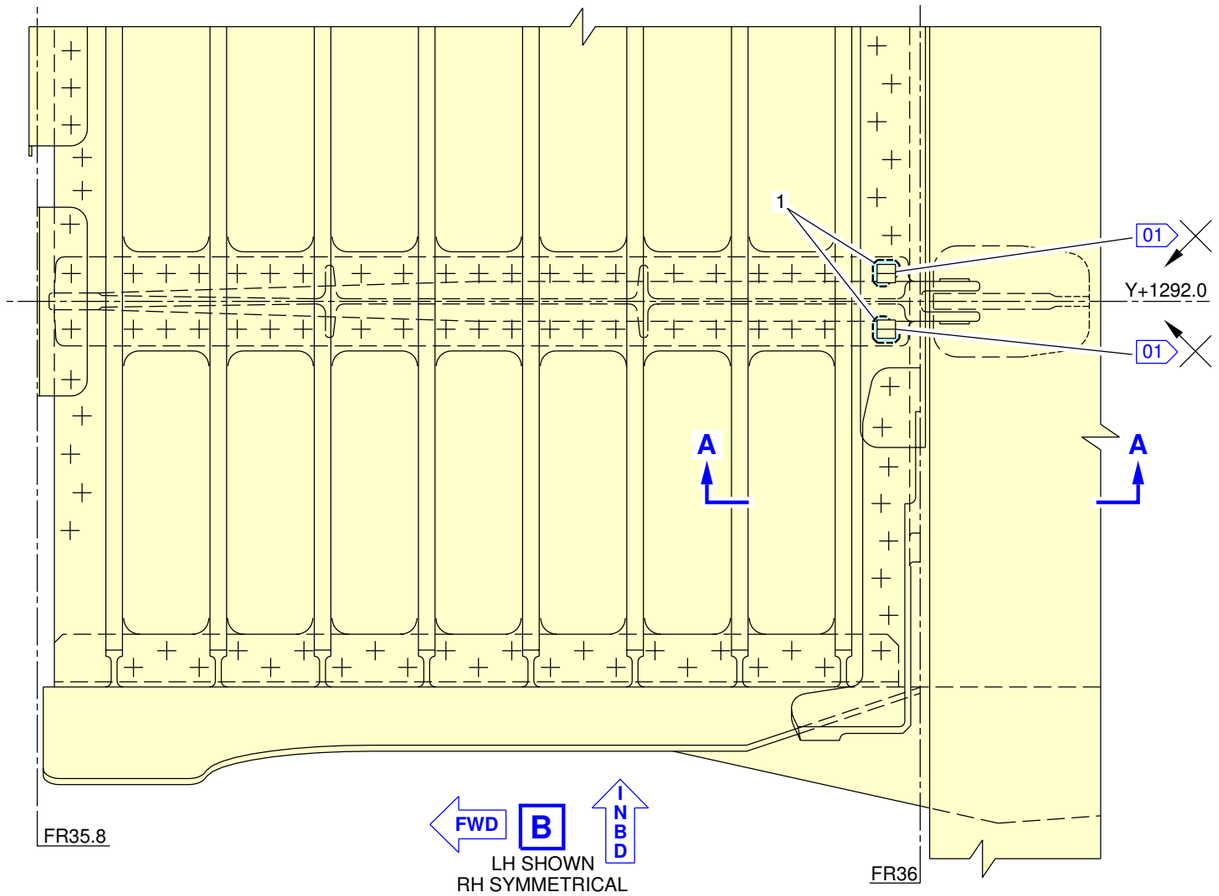
Figure A-GCAAB - Sheet 02
Installation of the Fasteners on the Pressure Panel between FR35 and FR36

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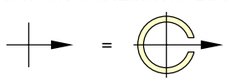
**CONF 003







EXPANSION SLEEVE INSTALLATION.
ORIENTATION SCHEMATIC DIAGRAM



NOTE:

01 TYPICAL DIRECTION OF SLEEVE GAP FOR COLD EXPANSION.

02 4% COLD WORKING.

03 FASTENER HEAD NEAR SIDE.

EXISTING FASTENERS

FASTENER TABLE

HOLE SYMBOL	ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
					MIN	MAX	MIN	MAX		
⊟	3	ASNA2538–3A	COLLAR	6–1–N	4.88 mm (0.1921 in)	4.93 mm (0.1941 in)	5.452 mm (0.2146 in)	5.487 mm (0.2160 in)	2ND OVERSIZE INTERFERENCE FIT	02 03
	6	EN6115K3A8	BOLT							

N_SB_531240_6_CAAC_01_04

Figure A-GCAAC - Sheet 01
Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36

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**CONF 003

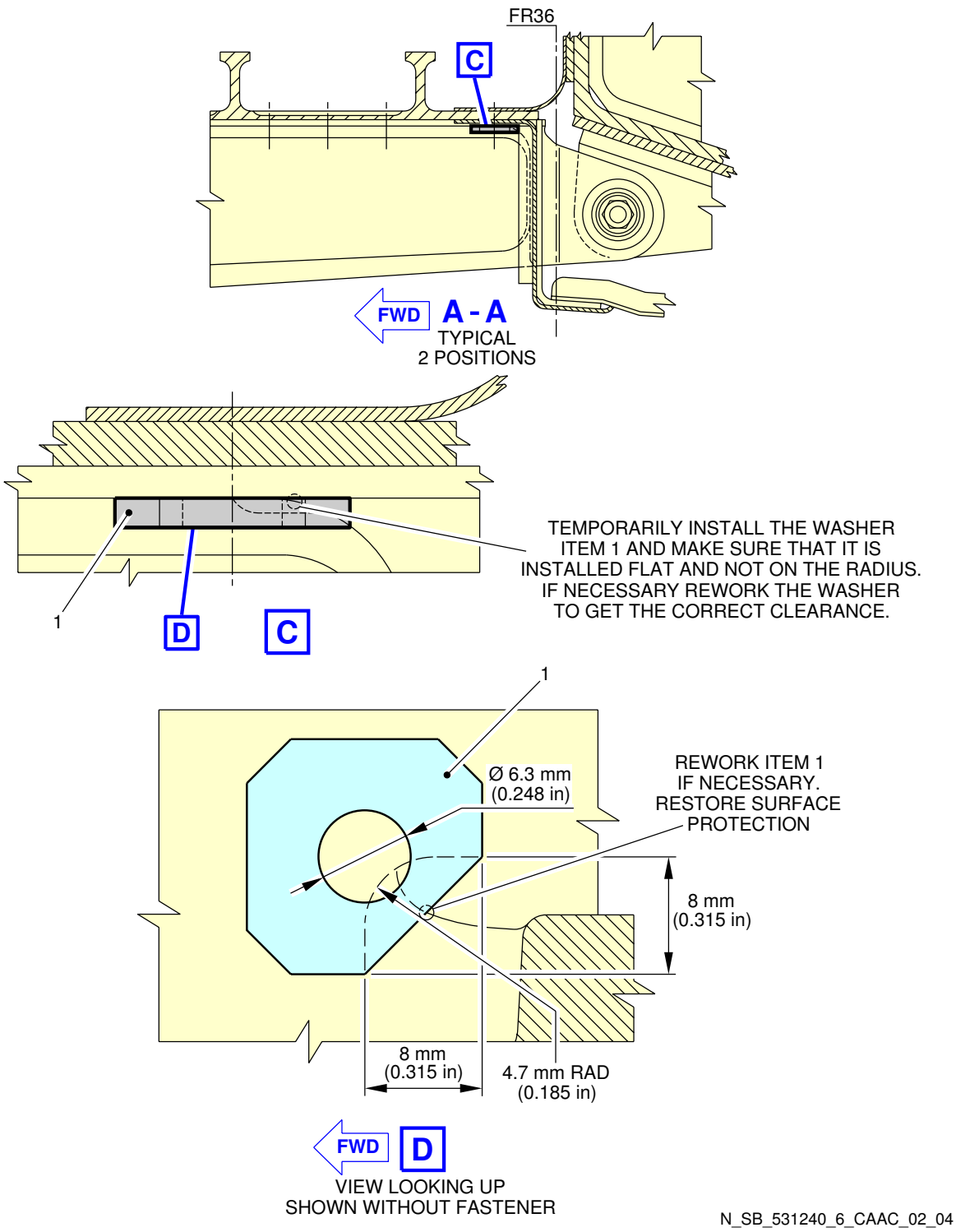


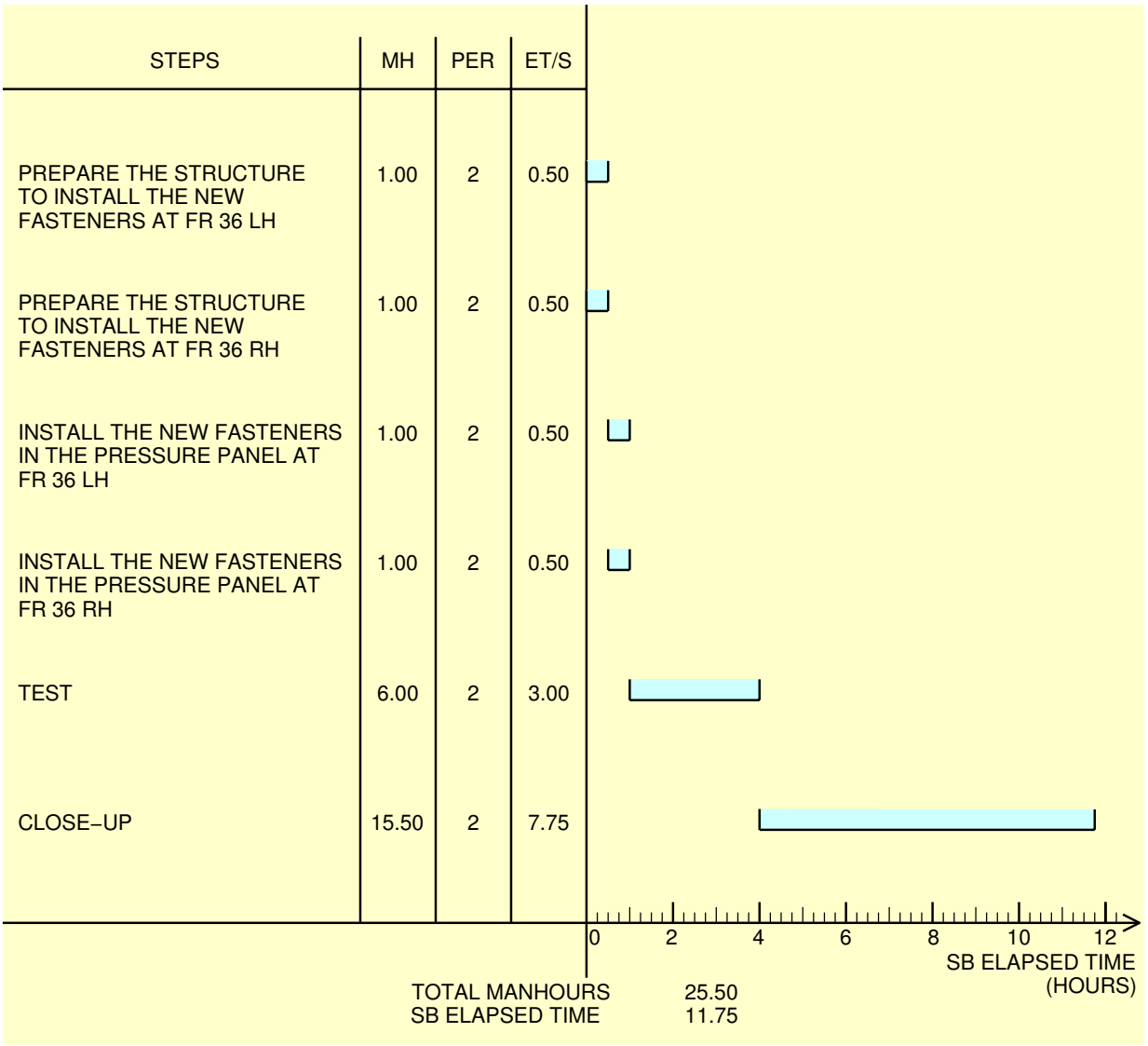
Figure A-GCAAC - Sheet 02
Installation of the Fasteners on the Pressure Panel between FR35.8 and FR36

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**CONF 001

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–53–1240 01 02

STEPS	MH	PER	ET/S
PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR 36 LH	1.00	2	0.50
PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR 36 RH	1.00	2	0.50
INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR 36 LH	1.00	2	0.50
INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR 36 RH	1.00	2	0.50
TEST	6.00	2	3.00
CLOSE–UP	15.50	2	7.75



TOTAL MANHOURS 25.50
SB ELAPSED TIME 11.75

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

N_SB_531240_6_AAAA_01_01

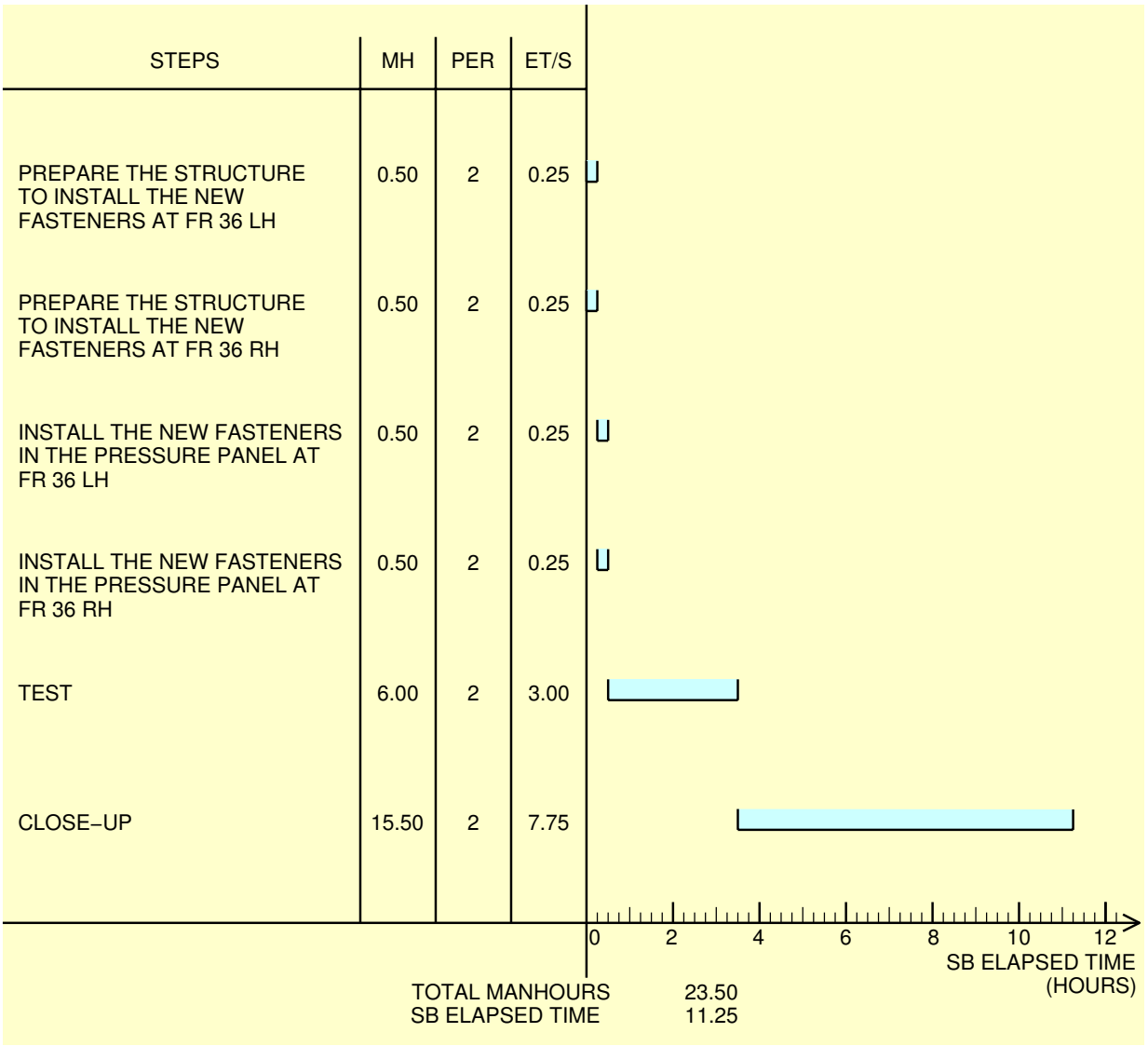
Figure A-GAAAA - Sheet 01
Manpower Gantt Chart

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**CONF 002 thru 005

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320–53–1240 01 02

STEPS	MH	PER	ET/S
PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR 36 LH	0.50	2	0.25
PREPARE THE STRUCTURE TO INSTALL THE NEW FASTENERS AT FR 36 RH	0.50	2	0.25
INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR 36 LH	0.50	2	0.25
INSTALL THE NEW FASTENERS IN THE PRESSURE PANEL AT FR 36 RH	0.50	2	0.25
TEST	6.00	2	3.00
CLOSE–UP	15.50	2	7.75
TOTAL MANHOURS	23.50		
SB ELAPSED TIME	11.25		



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

N_SB_531240_6_AAAB_01_01

Figure A-GAAAB - Sheet 01
Manpower Gantt Chart

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TITLE: FUSELAGE - CENTER FUSELAGE - COLD EXPANSION OF ATTACHMENT HOLES ON PRESSURE PANEL FR35-FR36 (CENTER WING BOX)

MODIFICATION No.: 152104K15182

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
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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

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