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ATA SYSTEM: 57

TITLE: WINGS - CENTER WING - REPLACE CURRENT END OF FLOOR BEAMS AND VERTICAL STRINGERS BY REINFORCED ONES

MODIFICATION No.:

164698P20635

ATA SYSTEM: 57

TITLE: WINGS - CENTER WING - REPLACE CURRENT END OF FLOOR BEAMS AND VERTICAL STRINGERS BY REINFORCED ONES

SUMMARY

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

A. MODIFICATIONS

CONF 001

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	164698P20635

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.

CONF 002

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	164698P20635

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.

CONF 003

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	164698P20635

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.

CONF 004

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	164698P20635

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.

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B. REASON

(1) History

In order to comply with the new regulations for widespread fatigue damage requirements, a modification is needed at the Center Wing Box (CWB) area, reinforcing the junction between floor beams and vertical stringers at Frame 36 front spar.

This modification only concerns A318/A319/A320 aircraft pre-MOD No. 160000P11994, A321 aircraft pre-MOD No. 160021J3446 and A319/A320 aircraft pre-MOD No. 160080J3705 (pre- Ref. SB A320-57-1193).

(2) Objective/Action

For the aircraft listed in the applicability, accomplishment of this Service Bulletin consists in:

- Replacing the forward end of the longitudinal floor beams on the CWB top skin panel by a reinforced one (with additional splices and shims installed)
- Replacing the front spar vertical stringers by an identical one and applying new holes sizes at the floor beam/stringer junction.

Prior to Service Bulletin accomplishment, specific attention must be paid to the preparation, refer to paragraph 3.B Preparation.

(3) Advantages

Accomplishment of this Service Bulletin will contribute to the structural integrity of the junction between floor beams and vertical stringers at Frame 36 front spar.

Accomplishment of this Service Bulletin cancels the requirements of Ref. SB A320-57-1178.

(4) Operational/Maintenance Consequences

None

C. GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	RECOMMENDED	COST SAVING	NO
A/C OPERATION AFFECTED	NO	VENDOR SB	NO
CANCELS INSPECTION SB	YES	ETOPS AFFECTED	NO
PAX COMFORT AFFECTED	NO	POTENTIAL AD	YES
RELIABILITY AFFECTED	NO	STRUCTURAL LIFE EXTENSION	NO
LIFE LIMIT	NO	LINE MAINTENANCE AFFECTED	NO

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

D. MAINTENANCE CONFIGURATION

CONF 001

MAINTENANCE CONFIGURATION	
FUEL TANKS OPENED	YES

CONF 002

MAINTENANCE CONFIGURATION	
FUEL TANKS OPENED	YES

CONF 003

MAINTENANCE CONFIGURATION	
FUEL TANKS OPENED	YES

CONF 004

MAINTENANCE CONFIGURATION	
FUEL TANKS OPENED	YES

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E. MATERIAL PRICE INFORMATION

CONF 001

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Tool kit 571228T01R00	1	See SB	Extractor
Part kit 571228A01R00	6	66000.00 USD	Upper fitting, shims, vertical stringer, upper splices, bush
Part kit 571228A03R01	1	50.00 USD	Hardware
TOTAL		66050.00 USD	
Components	See SB	See Note	Tape

NOTE: Price information to be obtained from the given supplier.

CONF 002

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Tool kit 571228T01R00	1	See SB	Extractor
Part kit 571228A02R00	6	66000.00 USD	Upper fitting, shims, vertical stringer, upper splices, bush
Part kit 571228A03R01	1	50.00 USD	Hardware
TOTAL		66050.00 USD	
Components	See SB	See Note	Tape

NOTE: Price information to be obtained from the given supplier.

CONF 003

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Tool kit 571228T01R00	1	See SB	Extractor
Part kit 571228A01R00	6	66000.00 USD	Upper fitting, shims, vertical stringer, upper splices, bush
Part kit 571228A03R01	1	50.00 USD	Hardware
TOTAL		66050.00 USD	
Components	See SB	See Note	Tape

NOTE: Price information to be obtained from the given supplier.

CONF 004

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Tool kit 571228T01R00	1	See SB	Extractor
Part kit 571228A01R00	6	66000.00 USD	Upper fitting, shims, vertical stringer, upper splices, bush
Part kit 571228A03R01	1	50.00 USD	Hardware
TOTAL		66050.00 USD	
Components	See SB	See Note	Tape

NOTE: Price information to be obtained from the given supplier.

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F. APPLICABILITY

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

02K 03Q 06R 10N 11K 11S 13Y 14S 15S 15T 16T 17M 17S 19R 20M 20Q 23R 25P 26L 27V 29S 31V 31X 32Q 34L 36R 36V 39N 40S 41N 41S 43S 45K 46L 46U 47P 48O 48P 49O 52L 53Z 56O 59Z 60U 66X 68M 69X 72T 76W 78X 80X 82M 82U 83O 83Q 83V 85T 86P 86Z 89Q 91X 95V 95W 96O 96U 98W 98X 99W A1L AAF AAL AAR AAV AAW AAY ABL ABQ ABY ACA ACI ADR AEE AEG AFL AFR AHY AIC AIJ ALK AMC AMU AMV ANA ANR ANZ APJ ART ARU ASA ASL ASV AUA AUH AVA AVJ AWC AWW AXM AZA B2V BAV BAW BEC BEG BEL BGF BGH BJN BKP BRS BSX BTN BUC BWJ C2C CBG CBJ CCA CCM CEB CEF CES CFG CGH CHB CLH CQH CQN CRK CSA CSC CSN CSZ CTB CTN CTV CYP DAL DCS DKH DLH DNU DQA DRK EAF EDW EIN ELB ERN ETD ETJ EVA EWE EWG EZY F2I FBS FFT FHM FHY FIA FIN FLI FOO FRN G4I G8E GAF GAP GCR GFA GJT GLG GMI GOW GSH GSW GWI GWR GZQ HDA HES HFM HFY HKE HKJ HVN I2L IAW IBE IBS IGO IND IRA IRB IRC IRM ISR IYE IZG JAD JAV JBU JBW JCC JJP JOC JSA JST JZR KAC KAY KHV KIS KKK KME KNE KZR LAA LAN LAO LBT LDM LFO LKE LLM LMJ LMU LUR LWA LYX LZB MAC MAU MEA MJF MJN MKR MLD MLH MLM MMA MMM MMO MRJ MSC MSR MXA MYX NIA NKS NMA NMB NUM NVD NWK NWS O8K OHY OLY OMS ONE ORF OTC OTF OZW PAL PGT PIA PIC PTI QAF QQE QSM QTR R1T RBG RIH RJA RJD ROT RSY RWZ RYL RZO SAA SAS SAW SBI SDM SDR SEK SEY SFJ SFW SHJ SHU SKU SLK SND SNG SOL SSG SSV SUD SVA SVR SVW SWM SWR SYR SZN T2R TAE TAI TAM TAP TAR TBZ TCI TCN TCX TDR TGW THD

THY TJS TNA TSC TTW U6A UAE UAL UEA UJX UKN UNA USA UZB VAW VIP VIV VJC VKG VLG VOE VOI VRE VVC WHT WRC WZZ

G. CONCURRENT REQUIREMENTS

None

H. NATURE OF THE WORK

CONF 001

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT	YES
EQUIPMENT	NO

CONF 002

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT	YES
EQUIPMENT	NO

CONF 003

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT	YES
EQUIPMENT	NO

CONF 004

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT	YES
EQUIPMENT	NO

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I. MANPOWER

CONF 001

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MANPOWER	
TOTAL MAN-HOURS	409.50 h
ELAPSED TIME (HOURS)	128.00 h

CONF 002

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MANPOWER	
TOTAL MAN-HOURS	409.50 h
ELAPSED TIME (HOURS)	128.00 h

CONF 003

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MANPOWER	
TOTAL MAN-HOURS	409.50 h
ELAPSED TIME (HOURS)	128.00 h

CONF 004

(1) Modification of the Structure

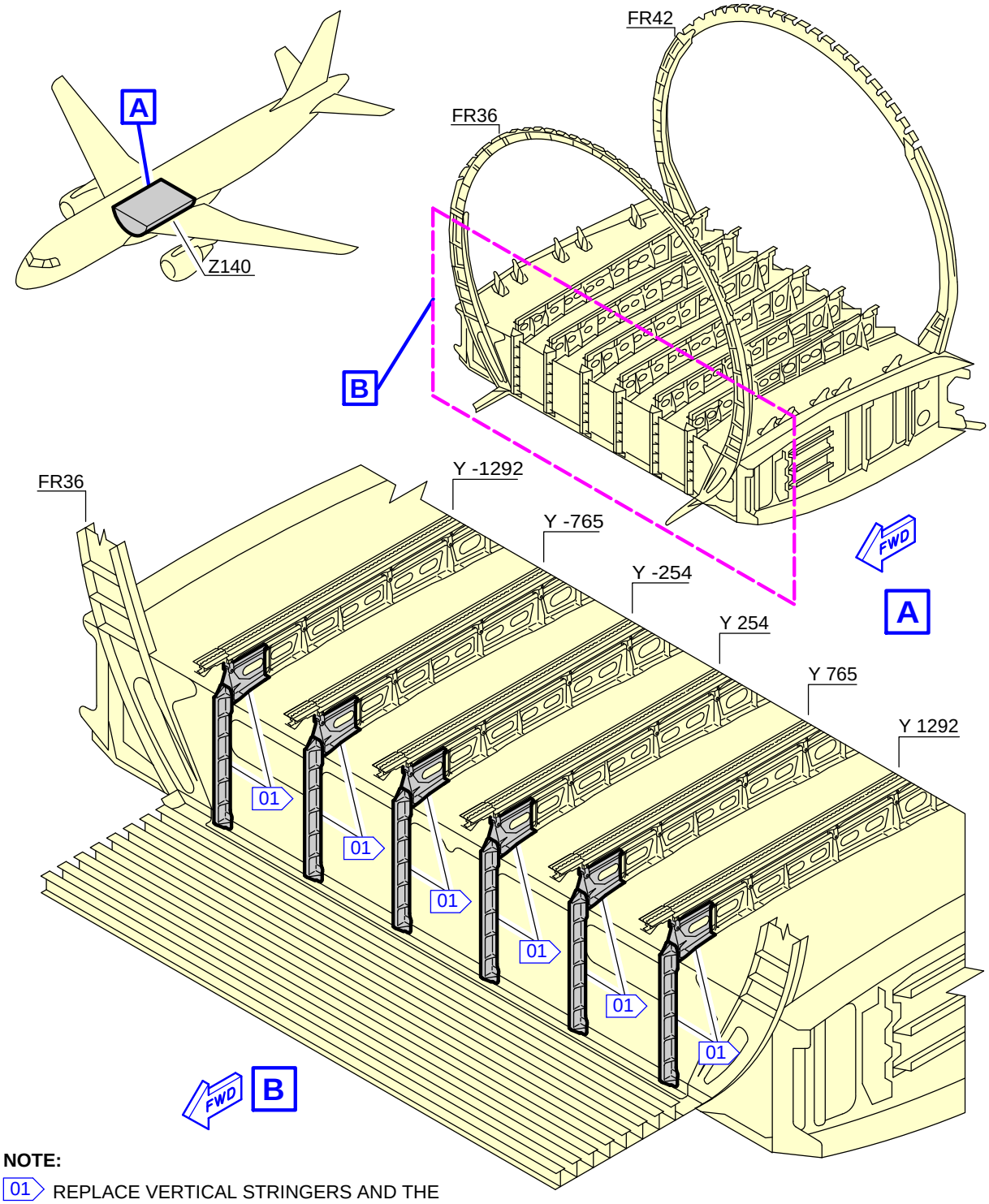
(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MANPOWER	
TOTAL MAN-HOURS	409.50 h
ELAPSED TIME (HOURS)	128.00 h

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J. GENERAL OVERVIEW

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NOTE:

01 REPLACE VERTICAL STRINGERS AND THE EXTREMITY OF FLOOR BEAMS.

ICN-A320-A-57XX1228-A-FAPE3-01KSU-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSU-A-001-01 SHEET 1/1

ATA SYSTEM: 57

TITLE: WINGS - CENTER WING - REPLACE CURRENT END OF FLOOR BEAMS AND VERTICAL STRINGERS BY REINFORCED ONES

1. PLANNING INFORMATION

A. APPLICABILITY

NOTE: This Service Bulletin is only applicable to aircraft on which:

- modification No. 21290P1547 (wings — sect. 21 — reinforcement of the front spar vertical stringers at Y+-254, Y+-765, Y+-1292 (serial solution)) is embodied for A318, A319 and A320 aircraft
- modification No. 160000P11994 (wing — center wing — introduce structure provision for sharklet project on section 21 for ST1, ST3 and ST4) is not embodied
- modification No. 160021J3446 (wings — general — certify structural provisions for sharklet installation for A321) is not embodied
- modification No. 160080J3705 (Ref. SB A320-57-1193) is not embodied.

NOTE: This modification is applicable by Service Bulletin only.

(1) Models

ON A/C 02035, 02059, 02071, 02081, 02100, 02109, 02317, 02328, 02333, 02344, 02350, 02358, 02367, 02377, 02582, 02601, 02686, 02750, 02918, 02931, 02951, 02955, 02967, 02972, 03009, 03220, 03225

318-111

ON A/C 01599, 02394, 02523, 02544, 02552, 02575, 02910, 03100, 03238, 03333, 03363, 03530, 03617, 03751, 03886, 03932, 03985, 04007, 04039, 04169, 04211, 04503, 04650, 04732, 04878

318-112

ON A/C 03030, 03062, 03214, 03371, 03390, 03469, 03509, 03585, 03602, 03606, 03642

318-122

ON A/C 00750, 00755, 00763, 00790, 00821, 00837, 00906, 00917, 00933, 00938, 00979, 00985, 00998, 01000, 01020, 01025, 01034, 01036, 01100, 01106, 01120, 01127, 01151, 01165, 01169, 01176, 01180, 01190, 01201, 01216, 01247, 01267, 01271, 01344, 01362, 01404, 01415, 01444, 01449, 01471, 01488, 01505, 01524, 01560, 01583, 01616, 01622, 01640, 01645, 01654, 01677, 01679, 01684, 01699, 01733, 01743, 01753, 01759, 01761, 01803, 01841, 01851, 01863, 01876, 01890, 01938, 02010, 02030, 02037, 02043, 02050, 02052, 02053, 02062, 02069, 02072, 02091, 02093, 02103, 02119, 02120, 02129, 02170, 02176, 02179, 02181, 02184, 02186, 02196, 02213, 02214, 02222, 02228, 02230, 02236, 02240, 02241, 02243, 02245, 02249, 02251, 02253, 02258, 02260, 02264, 02279, 02283, 02287, 02289, 02300, 02311, 02318, 02332, 02353, 02360, 02365, 02370, 02380, 02382, 02385, 02392, 02400, 02402, 02412, 02436, 02456, 02460, 02463, 02465, 02471, 02477, 02481, 02492, 02495, 02497, 02503, 02512, 02514, 02516, 02527, 02528, 02538, 02548, 02556, 02565, 02578, 02586, 02588, 02605, 02625, 02636, 02638, 02646, 02677, 02681, 02691, 02700, 02702, 02715, 02716, 02727, 02735, 02742, 02744, 02754, 02763, 02765, 02769, 02777, 02779, 02782, 02786, 02788, 02790, 02795, 02803, 02806, 02812, 02818, 02821, 02827, 02829, 02831, 02843, 02852, 02854, 02860, 02866, 02870, 02873, 02876, 02884, 02889, 02897, 02923, 02938, 02946, 02959, 02961, 03003, 03036, 03041, 03053, 03059, 03061, 03078, 03082, 03084, 03088, 03090, 03118, 03122, 03134, 03137, 03176, 03179, 03184, 03209, 03255, 03281, 03298, 03320, 03336, 03380, 03411, 03413, 03426, 03432, 03442, 03443, 03466, 03537, 03544, 03555, 03569, 03571, 03608, 03615, 03634, 03651, 03657, 03675, 03683, 03702, 03720, 03735, 03742, 03744, 03746, 03754, 03763, 03774, 03788, 03794, 03799, 03808, 03810, 03824, 03838, 03844, 03845, 03854, 03888, 03942, 03998, 04004, 04040, 04048, 04056, 04069, 04076, 04080, 04087, 04125, 04129,

04132, 04313, 04327, 04380, 04385, 04418, 04425, 04427, 04437, 04444, 04451, 04624, 04635, 04640, 04667, 04693, 04705, 04717, 04744, 04759, 04764, 04778, 04781, 04785, 04787, 04837, 04859, 04875, 04910, 05018, 05130, 05294, 05383, 05424

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ON A/C 00578, 00612, 00621, 00629, 00646, 00654, 00713, 00727, 00734, 00767, 00794, 00833, 00885, 00890, 00896, 00904, 00922, 00929, 00946, 00949, 00972, 00997, 01016, 01018, 01019, 01029, 01033, 01038, 01040, 01046, 01048, 01051, 01055, 01069, 01073, 01077, 01084, 01086, 01089, 01095, 01097, 01102, 01107, 01109, 01122, 01124, 01135, 01136, 01147, 01155, 01160, 01170, 01172, 01182, 01184, 01203, 01205, 01209, 01245, 01252, 01254, 01263, 01265, 01269, 01275, 01277, 01283, 01285, 01287, 01289, 01297, 01301, 01303, 01305, 01309, 01311, 01313, 01315, 01317, 01319, 01326, 01328, 01331, 01336, 01340, 01342, 01348, 01352, 01354, 01358, 01360, 01364, 01369, 01371, 01377, 01378, 01382, 01388, 01389, 01391, 01393, 01429, 01494, 01515, 01562, 01577, 01579, 01592, 01598, 01601, 01603, 01612, 01618, 01625, 01630, 01634, 01668, 01673, 01706, 01718, 01722, 01740, 01742, 01745, 01750, 01770, 01778, 01779, 01781, 01786, 01791, 01805, 01808, 01846, 01853, 01866, 01872, 01882, 01884, 01886, 01901, 01916, 01925, 01936, 01963, 01980, 01997, 02012, 02019, 02033, 02057, 02066, 02074, 02078, 02083, 02086, 02101, 02113, 02122, 02124, 02126, 02127, 02131, 02174, 02198, 02209, 02224, 02262, 02265, 02266, 02271, 02319, 02378, 02387, 02398, 02406, 02416, 02420, 02427, 02442, 02446, 02448, 02450, 02483, 02494, 02518, 02547, 02593, 02607, 02611, 02617, 02624, 02628, 02629, 02632, 02644, 02652, 02662, 02709, 02729, 02733, 02746, 02751, 02762, 02773, 02774, 02811, 02836, 02849, 02857, 02878, 02879, 02905, 02907, 02913, 02925, 02935, 02954, 02985, 03019, 03024, 03028, 03043, 03054, 03094, 03096, 03102, 03108, 03139, 03169, 03171, 03181, 03188, 03202, 03204, 03245, 03271, 03285, 03288, 03300, 03305, 03309, 03324, 03331, 03344, 03346, 03347, 03364, 03377, 03385, 03388, 03403, 03406, 03407, 03415, 03417, 03436, 03445, 03447, 03452, 03533, 03551, 03560, 03564, 03586, 03589, 03604, 03620, 03660, 03661, 03684, 03686, 03687, 03689, 03700, 03704, 03727, 03728, 03733, 03790, 03818, 03822, 03834, 03853, 03865, 03872, 03874, 03892, 03895, 03905, 03918, 03950, 03970, 03983, 04020, 04029, 04038, 04052, 04071, 04089, 04121, 04127, 04141, 04164, 04182, 04258, 04268, 04275, 04332, 04455, 04511, 04663, 04691, 04713, 04734, 04756, 04796, 04841, 04871, 05005, 05085, 05097, 05239, 05284, 05293, 05366, 05400

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ON A/C 00598, 00600, 00618, 00625, 00637, 00644, 00647, 00660

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ON A/C 00546, 00572, 00609, 00610, 00616, 00623, 00627, 00634, 00636, 00639, 00641, 00649, 00651, 00656, 00670, 00672, 00679, 00682, 00688, 00689, 00691, 00693-00695, 00697, 00700, 00711, 00717, 00719, 00721, 00723, 00728, 00729, 00732, 00736, 00738, 00740, 00742, 00744, 00752, 00757, 00769, 00773, 00779, 00785, 00800, 00813, 00817, 00829, 00831, 00840, 00845, 00853, 00860, 00869, 00875, 00880, 01058, 01062, 01071, 01078, 01090, 01091, 01126, 01129, 01131, 01149, 01164, 01167, 01191, 01230, 01249, 01324, 01325, 01346, 01392, 01414, 01434, 01453, 01456, 01479, 01483, 01498, 01501, 01520, 01543, 01549, 01567, 01570, 01582, 01659, 01662, 01683, 01685, 01693, 01709, 01714, 01738, 01746, 01752, 01766, 01774, 01796, 01800, 01810, 01815, 01819, 01820, 01824, 01828, 01833, 01839, 01870, 01875, 01897, 01923, 01959, 01976, 01982, 01990, 02002, 02013, 02026, 02028, 02039, 02047, 02087, 02095, 02369, 02373, 02464, 02474, 02618, 02641

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ON A/C 01002, 01157, 01485, 01541, 01551, 01556, 01795, 01908, 01999, 02237, 02269, 02285, 02293, 02298, 02306, 02346, 02440, 02487, 02499, 02507, 02508, 02519, 02525, 02532, 02541, 02545, 02546, 02550, 02551, 02554, 02555, 02557, 02558, 02561, 02581, 02592, 02672, 02675, 02684, 02693, 02706, 02748, 02757, 02801, 02805, 02819, 02825, 02837, 02839, 02841, 02847, 02890, 02921, 02949, 03046, 03065, 03073, 03085, 03133, 03168, 03186, 03226, 03243, 03250, 03260, 03356, 03467, 03513, 03518, 03542, 03632, 03647, 03691, 03826, 03828, 03856, 03903, 03957, 03994, 04024, 04200, 04204, 04222,

04228, 04254, 04287, 04336, 04353, 04470, 04679, 04768, 04822, 04956, 05023, 05040, 05057, 05079, 05088, 05119, 05193, 05273, 05277, 05380, 05412
319-115

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(3) MSN by configuration

CONF 001

MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
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MSN	CONFIGURATION
04666 04668 04670 04671 04673 04674 04675 04676 04677 04678 04680 04681 04683 04684 04685 04686 04687 04688 04689 04690 04692 04694 04696 04697 04699 04700 04701 04702 04704 04707 04708 04709 04711 04712 04714 04715 04716 04718 04720 04721 04722 04723 04724 04725 04726 04727 04729 04730 04733 04735 04736 04738 04739 04740 04741 04742 04743 04745 04747 04748 04749 04751 04752 04754 04757 04758 04762 04763 04765 04767 04769 04770 04772 04775 04776 04777 04780 04782 04784 04786 04789 04791 04793 04794 04795 04797 04798 04799 04800 04802 04803 04804 04805 04806 04807 04808 04810 04812 04813 04814 04815 04816 04817 04818 04820 04821 04823 04825 04827 04828 04829 04831 04832 04833 04835 04836 04839 04840 04844 04845 04848 04849 04851 04852 04853 04854 04855 04857 04860 04861 04862 04864 04865 04866 04867 04868 04869 04870 04872 04874 04876 04877 04879 04880 04882 04883 04884 04886 04887 04888 04889 04890 04891 04892 04894 04895 04896 04897 04899 04900 04902 04903 04904 04905 04906 04907 04908 04909 04912 04913 04914 04915 04917 04918 04919 04920 04921 04922 04924 04926 04927 04928 04929 04931 04933 04934 04936 04937 04938 04939 04941 04942 04943 04944 04946 04947 04948 04950 04951 04952 04953 04954 04955 04958 04959 04961 04963 04964 04965 04967 04969 04970 04972 04973 04974 04975 04977 04979 04980 04981 04982 04984 04985 04986 04987 04988 04989 04990 04991 04993 04996 04997 04999 05000 05001 05002 05003 05004 05006 05007 05008 05011 05012 05013 05014 05015 05016 05017 05019 05020 05021 05024 05026 05027 05029 05030 05031 05032 05033 05034 05036 05037 05039 05042 05045 05046 05047 05048 05050 05052 05053 05055 05056 05058 05060 05061 05062 05063 05064 05066 05067 05068 05069 05070 05071 05072 05073 05075 05076 05080 05081 05082 05084 05086 05089 05090 05091 05092 05093 05094 05095 05096 05100 05101 05102 05103 05104 05106 05107 05109 05110 05111 05112 05113 05114 05115 05116 05117 05120 05122 05123 05125 05128 05129 05131 05132 05134 05135 05136 05137 05138 05139 05140 05143 05144 05145 05146 05147 05149 05150 05151 05152 05153 05155 05156 05158 05159 05161 05162 05163 05165 05166 05167 05168 05170 05171 05172 05174 05175 05176 05178 05179 05181 05183 05184 05185 05187 05188 05189 05190 05191 05194 05195 05196 05198 05200 05201 05202 05203 05204 05206 05207 05209 05211 05212 05213 05214 05215 05216 05218 05220 05221 05222 05223 05224 05225 05226 05228 05229 05230 05231 05232 05234 05236 05238 05240 05243 05245 05246 05248 05249 05250 05252 05253 05258 05259 05260 05262 05263 05264 05266 05268 05270 05272 05274 05276 05278 05283 05288 05289 05290 05291 05296 05298 05299 05301 05304 05305 05308 05310 05311 05315 05316 05319 05320 05322 05324 05325 05326 05329 05331 05333 05334 05335 05337 05339 05341 05344 05347 05348 05351 05352 05353 05356 05358 05359 05360 05362 05364 05367 05369 05370 05371 05372 05373 05375 05379 05381 05384 05386 05387 05391 05393 05394 05396 05397 05398 05399 05403 05405 05407 05410 05414 05415 05416	

MSN	CONFIGURATION
05419 05420 05421 05426 05429 05431 05434 05436 05448 05449 05464 05471	

CONF 002

MSN	CONFIGURATION
00364 00385 00412 00434 00458 00468 00473 00474 00477 00484 00488 00493 00495 00498 00502 00505 00509 00513 00514 00516 00517 00518 00519 00520 00521 00522 00524 00526 00529 00532 00535 00538 00541 00544 00550 00552 00555 00560 00563 00564 00567 00570 00576 00581 00583 00586 00591 00593 00595 00597 00599 00604 00614 00620 00631 00633 00642 00652 00664 00666 00668 00675 00677 00680 00684 00687 00692 00699 00715 00725 00731 00746 00761 00765 00771 00775 00777 00781 00787 00792 00796 00802 00806 00808 00810 00811 00815 00819 00823 00827 00835 00841 00848 00852 00855 00864 00878 00887 00891 00901 00908 00915 00920 00926 00935 00940 00941 00959 00961 00963 00968 00970 00974 00983 00987 00991 00993 00995 01004 01006 01008 01012 01015 01017 01021 01023 01024 01027 01042 01045 01060 01080 01094 01133 01144 01153 01161 01174 01185 01188 01195 01199 01202 01204 01207 01214 01219 01220 01227 01233 01238 01241 01250 01260 01273 01276 01293 01299 01307 01356 01366 01399 01403 01408 01412 01417 01421 01425 01428 01431 01433 01436 01438 01442 01447 01451 01455 01458 01462 01465 01472 01476 01481 01487 01492 01496 01499 01503 01511 01517 01519 01521 01525 01531 01536 01539 01554 01572 01587 01596 01602 01607 01611 01614 01619 01623 01629 01632 01636 01638 01642 01651 01658 01666 01670 01675 01681 01690 01691 01695 01701 01704 01707 01711 01713 01716 01720 01724 01726 01734 01748 01763 01772 01776 01783 01788 01794 01798 01807 01811 01817 01836 01843 01848 01850 01859 01869 01878 01881 01887 01905 01921 01926 01928 01932 01941 01946 01950 01953 01956 01960 01966 01967 01970 01972 01974 01977 01978 01984 01988 01994 01995 02005 02021 02041 02045 02055 02060 02064 02067 02076 02080 02105 02107 02110 02115 02117 02190 02208 02211 02216 02220 02226 02234 02247 02255 02261 02267 02270 02290 02303 02305 02309 02315 02320 02323 02324 02330 02337 02342 02351 02357 02363 02381 02410 02462 02472 02476 02480 02488 02521 02530 02536 02543 02549 02553 02563 02590 02599 02610 02653 02682 02687 02707 02713 02726 02730 02736 02741 02756 02759 02767 02793 02799 02809 02823 02862 02868 02882 02895 02903 02912 02916 02919 02927 02933 02936 02957 02965 02971 02974 02996 02999 03005 03013 03015 03022 03034 03051 03067 03070 03075 03081 03098 03106 03112 03120 03126 03130 03146 03191 03198 03207 03212 03217 03222 03229 03233 03235 03241 03247 03249 03251 03254 03262 03265 03267 03274 03283 03290 03294 03297 03302 03307 03315 03322 03326 03329 03334 03339 03340 03350 03355 03360 03367 03369 03372 03382 03387 03397 03399 03401 03405 03419 03429 03434 03441 03458 03459 03462 03471 03493 03498 03504 03507 03512 03522 03523 03525 03527 03539	002

MSN	CONFIGURATION
03546 03552 03557 03566 03573 03575 03583 03584 03587 03592 03593 03600 03612 03619 03623 03625 03629 03633 03636 03637 03639 03645 03653 03655 03665 03669 03673 03678 03681 03682 03688 03708 03712 03717 03722 03725 03730 03737 03738 03740 03749 03752 03761 03764 03766 03784 03792 03796 03806 03814 03816 03820 03830 03847 03858 03862 03864 03867 03869 03878 03879 03881 03884 03893 03899 03916 03920 03924 03926 03928 03930 03934 03936 03938 03940 03944 03948 03951 03955 03960 03964 03966 03969 03973 03977 03981 03987 03989 03993 03996 04002 04005 04009 04016 04022 04025 04031 04041 04044 04045 04047 04050 04054 04058 04062 04067 04073 04074 04078 04082 04085 04091 04096 04099 04103 04107 04112 04116 04123 04131 04134 04136 04138 04142 04148 04155 04173 04180 04184 04189 04194 04198 04209 04213 04217 04221 04224 04230 04251 04266 04271 04274 04277 04280 04283 04292 04299 04311 04315 04318 04334 04338 04341 04352 04358 04360 04369 04374 04377 04382 04387 04406 04416 04420 04430 04461 04467 04472 04494 04500 04530 04534 04538 04542 04545 04560 04570 04577 04585 04590 04607 04611 04617 04626 04638 04643 04648 04654 04662 04669 04672 04682 04698 04703 04706 04710 04719 04728 04731 04737 04746 04753 04761 04771 04779 04783 04788 04792 04811 04819 04824 04826 04830 04834 04838 04843 04847 04850 04856 04863 04873 04881 04885 04893 04898 04901 04916 04923 04925 04932 04935 04940 04945 04949 04957 04960 04962 04966 04971 04976 04994 05009 05025 05028 05035 05038 05044 05049 05054 05059 05065 05074 05077 05083 05087 05099 05118 05124 05126 05133 05154 05160 05164 05169 05173 05177 05180 05186 05192 05197 05199 05205 05210 05227 05233 05235 05237 05241 05244 05247 05251 05254 05257 05265 05269 05271 05275 05279 05282 05285 05287 05292 05297 05300 05303 05306 05309 05314 05317 05321 05328 05332 05336 05340 05343 05346 05350 05354 05368 05374 05377 05382 05385 05388 05392 05402 05409 05418 05422 05427 05432 05435 05438 05444 05447 05456 05459 05462 05469 05475 05495 05500 05504 05513	

CONF 003

MSN	CONFIGURATION
00546 00572 00578 00598 00600 00609 00610 00612 00616 00618 00621 00623 00625 00627 00629 00634 00636 00637 00639 00641 00644 00646 00647 00649 00651 00654 00656 00660 00670 00672 00679 00682 00686 00688 00689 00690 00691 00693 00694 00695 00697 00700 00711 00713 00717 00719 00721 00723 00727 00728 00729 00732 00734 00736 00738 00740 00742 00744 00748 00750 00752 00755 00757 00759 00763 00767 00769 00773 00779 00783 00785 00788 00790 00794 00798 00800 00804 00813 00817 00821 00825 00829 00831 00833 00837 00840 00843 00845 00847 00850 00853 00858 00860 00862 00867 00869 00871 00873 00875 00880 00882 00885 00889 00890 00893 00896 00898 00904 00906 00910 00913 00917 00922 00924 00929 00931 00933	003

MSN	CONFIGURATION
00938 00944 00946 00948 00949 00952 00965 00972 00976 00979 00980 00985 00989 00997 00998 01000 01002 01010 01016 01018 01019 01020 01022 01025 01029 01031 01033 01034 01036 01038 01040 01043 01046 01048 01049 01051 01053 01055 01056 01058 01062 01064 01066 01069 01071 01073 01077 01078 01082 01084 01086 01088 01089 01090 01091 01092 01095 01096 01097 01100 01102 01103 01106 01107 01109 01111 01115 01116 01118 01120 01122 01124 01126 01127 01129 01131 01135 01136 01139 01140 01142 01147 01149 01151 01155 01157 01159 01160 01164 01165 01167 01169 01170 01172 01176 01178 01180 01182 01184 01190 01191 01193 01197 01201 01203 01205 01209 01211 01212 01216 01222 01223 01225 01228 01230 01232 01236 01239 01243 01245 01247 01249 01252 01254 01256 01258 01261 01263 01265 01267 01269 01271 01275 01277 01279 01281 01283 01285 01287 01289 01291 01295 01297 01301 01303 01305 01309 01311 01313 01315 01317 01319 01321 01323 01324 01325 01326 01328 01329 01331 01335 01336 01338 01340 01342 01344 01346 01348 01350 01352 01354 01358 01360 01362 01364 01369 01371 01373 01375 01377 01378 01380 01382 01384 01388 01389 01391 01392 01393 01395 01397 01401 01404 01406 01410 01414 01415 01420 01423 01426 01429 01434 01440 01444 01445 01449 01453 01456 01460 01463 01466 01468 01471 01474 01477 01479 01483 01485 01488 01490 01494 01498 01501 01505 01507 01510 01513 01515 01520 01522 01524 01527 01529 01534 01537 01541 01543 01545 01547 01549 01551 01552 01556 01558 01560 01562 01563 01565 01567 01569 01570 01573 01574 01575 01576 01577 01579 01581 01582 01583 01585 01589 01590 01592 01594 01598 01600 01601 01603 01604 01606 01612 01616 01618 01622 01625 01627 01630 01634 01640 01643 01645 01647 01649 01653 01654 01656 01659 01662 01664 01668 01671 01673 01677 01679 01683 01684 01685 01688 01693 01699 01703 01706 01709 01714 01718 01722 01731 01733 01737 01738 01740 01742 01743 01745 01746 01750 01752 01753 01758 01759 01761 01766 01770 01774 01778 01779 01781 01786 01790 01791 01795 01796 01800 01801 01803 01805 01808 01810 01815 01819 01820 01824 01826 01828 01831 01833 01837 01839 01841 01844 01846 01851 01853 01855 01863 01866 01870 01872 01875 01876 01880 01882 01884 01886 01890 01893 01897 01901 01908 01912 01916 01923 01925 01934 01936 01938 01947 01952 01955 01959 01962 01963 01971 01976 01980 01982 01986 01990 01997 01999 02000 02002 02004 02007 02008 02010 02012 02013 02015 02019 02023 02026 02028 02030 02032 02033 02037 02039 02043 02047 02050 02052 02053 02057 02062 02066 02069 02072 02074 02078 02083 02086 02087 02089 02091 02093 02095 02096 02098 02101 02103 02113 02119 02120 02122 02124 02126 02127 02129 02131 02170 02172 02174 02176 02179 02181 02184 02186 02188 02192 02194 02196 02198 02200 02202 02203 02205 02209 02213 02214 02222 02224 02228 02230 02232 02236 02237 02240 02241 02243 02245 02249 02251 02253 02258 02260 02262 02263 02264 02265 02266 02268 02269 02271 02273 02277 02279 02281 02283 02285 02287 02289 02293 02295	

MSN	CONFIGURATION
02296 02298 02300 02302 02304 02306 02308 02311 02313 02318 02319 02321 02326 02332 02335 02339 02341 02346 02348 02353 02355 02360 02362 02365 02369 02370 02371 02373 02375 02378 02379 02380 02382 02383 02385 02387 02389 02392 02396 02398 02400 02402 02406 02408 02412 02416 02418 02420 02421 02426 02427 02429 02431 02433 02435 02436 02438 02440 02442 02444 02446 02448 02450 02454 02456 02458 02460 02463 02464 02465 02466 02467 02468 02469 02470 02471 02473 02474 02477 02481 02483 02485 02487 02490 02492 02494 02495 02497 02499 02501 02503 02505 02507 02508 02510 02512 02514 02516 02518 02519 02525 02527 02528 02532 02534 02538 02541 02545 02546 02547 02548 02550 02551 02554 02555 02556 02557 02558 02559 02560 02561 02565 02567 02568 02570 02572 02574 02578 02579 02581 02585 02586 02588 02592 02593 02595 02597 02603 02605 02607 02611 02614 02615 02617 02618 02621 02622 02624 02625 02628 02629 02632 02634 02636 02638 02639 02641 02643 02644 02646 02648 02652 02657 02659 02660 02662 02664 02666 02667 02669 02672 02673 02675 02677 02679 02681 02684 02690 02691 02693 02694 02697 02698 02700 02702 02704 02706 02709 02711 02715 02716 02718 02720 02723 02727 02729 02733 02735 02742 02744 02746 02748 02751 02754 02757 02762 02763 02765 02769 02771 02773 02774 02777 02779 02780 02782 02784 02786 02788 02790 02795 02797 02801 02803 02805 02806 02811 02812 02813 02815 02818 02819 02821 02825 02827 02829 02831 02833 02836 02837 02839 02841 02843 02845 02847 02849 02850 02852 02854 02857 02858 02860 02864 02866 02870 02872 02873 02876 02878 02879 02884 02886 02887 02888 02889 02890 02892 02893 02894 02897 02898 02901 02905 02907 02913 02921 02923 02925 02929 02935 02938 02940 02942 02946 02948 02949 02954 02959 02961 02963 02969 02976 02978 02979 02981 02983 02985 02997 03003 03007 03011 03017 03019 03020 03024 03026 03028 03032 03036 03041 03043 03045 03046 03049 03053 03054 03057 03059 03061 03065 03069 03073 03077 03078 03082 03084 03085 03088 03090 03094 03096 03102 03108 03114 03116 03118 03122 03124 03128 03133 03134 03137 03139 03144 03165 03168 03169 03171 03172 03175 03176 03179 03181 03184 03186 03188 03193 03195 03200 03202 03204 03209 03226 03231 03243 03245 03248 03250 03252 03253 03255 03258 03260 03269 03271 03276 03279 03281 03285 03288 03292 03298 03300 03305 03309 03311 03317 03320 03324 03331 03336 03342 03344 03346 03347 03352 03356 03358 03364 03375 03377 03380 03385 03388 03393 03395 03403 03406 03407 03411 03413 03415 03417 03421 03424 03426 03428 03432 03436 03442 03443 03445 03447 03450 03452 03454 03463 03466 03467 03491 03500 03513 03518 03520 03533 03534 03537 03542 03544 03548 03551 03555 03560 03561 03564 03569 03571 03578 03580 03586 03588 03589 03590 03595 03604 03608 03614 03615 03620 03632 03634 03638 03647 03651 03657 03660 03661 03663 03671 03675 03680 03683 03684 03685 03686 03687 03689 03691 03694 03700 03702 03704 03705 03710 03720 03727 03728 03733 03735 03742 03744 03746 03754 03757 03759	

MSN	CONFIGURATION
03763 03768 03770 03772 03774 03779 03788 03790 03794 03799 03801 03803 03808 03810 03818 03822 03824 03826 03828 03832 03834 03836 03838 03839 03841 03842 03844 03845 03849 03851 03853 03854 03856 03860 03865 03872 03874 03876 03888 03890 03892 03895 03897 03901 03903 03905 03911 03914 03918 03942 03950 03957 03958 03962 03970 03982 03983 03994 03998 04000 04004 04018 04020 04024 04029 04036 04038 04040 04042 04048 04052 04056 04060 04069 04071 04076 04080 04087 04089 04114 04121 04125 04127 04129 04132 04141 04151 04163 04164 04166 04171 04182 04192 04200 04204 04215 04222 04227 04228 04254 04256 04258 04259 04262 04268 04275 04282 04285 04287 04301 04313 04319 04327 04332 04336 04353 04380 04385 04389 04403 04410 04418 04422 04425 04427 04428 04437 04444 04451 04452 04455 04470 04511 04522 04529 04563 04583 04598 04605 04624 04635 04640 04660 04663 04667 04679 04691 04693 04705 04713 04717 04734 04744 04756 04759 04764 04768 04773 04778 04781 04785 04787 04796 04822 04837 04841 04842 04859 04871 04875 04910 04956 04992 04995 04998 05005 05018 05023 05040 05043 05057 05079 05085 05088 05097 05105 05119 05130 05193 05208 05219 05239 05261 05273 05277 05280 05284 05286 05293 05294 05345 05366 05380 05383 05389 05400 05412 05424	

CONF 004

MSN	CONFIGURATION
01599 02035 02059 02071 02081 02100 02109 02317 02328 02333 02344 02350 02358 02367 02377 02394 02523 02544 02552 02575 02582 02601 02686 02750 02910 02918 02931 02951 02955 02967 02972 03009 03030 03062 03100 03214 03220 03225 03238 03333 03363 03371 03390 03469 03509 03530 03585 03602 03606 03617 03642 03751 03886 03932 03985 04007 04039 04169 04211 04503 04650 04732 04878	004

CONF ALL

(4) Configuration definition

CONF 001

Configuration 001

CONF 001 is only applicable to A320 aircraft.

CONF 001 retrofits following modifications: 164698P20635.

CONF 002

Configuration 002

CONF 002 is only applicable to A321 aircraft.

CONF 002 retrofits following modifications: 164698P20635.

CONF 003

Configuration 003

CONF 003 is only applicable to A319 aircraft.

CONF 003 retrofits following modifications: 164698P20635.

CONF 004

Configuration 004

CONF 004 is only applicable to A318 aircraft.

CONF 004 retrofits following modifications: 164698P20635.

CONF ALL

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

In order to comply with the new regulations for widespread fatigue damage requirements, a modification is needed at the Center Wing Box (CWB) area, reinforcing the junction between floor beams and vertical stringers at Frame 36 front spar.

This modification only concerns A318/A319/A320 aircraft pre-MOD No. 160000P11994, A321 aircraft pre-MOD No. 160021J3446 and A319/A320 aircraft pre-MOD No. 160080J3705 (pre- Ref. SB A320-57-1193).

(2) Objective/Action

For the aircraft listed in the applicability, accomplishment of this Service Bulletin consists in:

- Replacing the forward end of the longitudinal floor beams on the CWB top skin panel by a reinforced one (with additional splices and shims installed)
- Replacing the front spar vertical stringers by an identical one and applying new holes sizes at the floor beam/stringer junction.

Prior to Service Bulletin accomplishment, specific attention must be paid to the preparation, refer to paragraph 3.B Preparation.

(3) Advantages

Accomplishment of this Service Bulletin will contribute to the structural integrity of the junction between floor beams and vertical stringers at Frame 36 front spar.

Accomplishment of this Service Bulletin cancels the requirements of Ref. SB A320-57-1178.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to:

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

1 Remove the Strut Lower Attachment on Y1292 at FR36

CONF 001 003 004

2 Remove the Vertical Stringer on Y1292 at FR36

CONF 002

2 Remove the Vertical Stringer on Y1292 at FR36

CONF ALL

3 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36

CONF 001 003 004

4 Drill the New Vertical Stringer on Y1292 at FR36

CONF 002

4 Drill the New Vertical Stringer on Y1292 at FR36

CONF 001 003 004

5 Install the New Vertical Stringer on Y1292 at FR36

CONF 002

5 Install the New Vertical Stringer on Y1292 at FR36

CONF 001 003 004

6 Install the Strut Lower Attachment on Y1292 at FR36

CONF 002

6 Install the Strut Lower Attachment on Y1292 at FR36

CONF ALL

7 Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36

8 Cut out the Forward End Floor Beam on Y1292 at FR36

9 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36

CONF 001 003 004

10 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36

CONF 002

10 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36

CONF 001 003 004

11 Temporarily, Install the New Parts for Adjustment on Y1292 at FR36

CONF 002

11 Temporarily, Install the New Parts for Adjustment on Y1292 at FR36

CONF 001 003 004

12 Drill the New Parts on Y1292 at FR36

CONF 002

12 Drill the New Parts on Y1292 at FR36

CONF 001 003 004

13 Install the New Parts on Y1292 at FR36

CONF 002

13 Install the New Parts on Y1292 at FR36

CONF 001 003 004

14 Protect the Fasteners and the New Parts on Y1292 at FR36

CONF 002

14 Protect the Fasteners and the New Parts on Y1292 at FR36

CONF ALL

15 Remove the Strut Lower Attachment on Y765 at FR36

CONF 001 003 004

16 Remove the Vertical Stringer on Y765 at FR36

CONF 002

16 Remove the Vertical Stringer on Y765 at FR36

CONF ALL

17 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36

CONF 001 003 004

18 Drill the New Vertical Stringer on Y765 at FR36

CONF 002

18 Drill the New Vertical Stringer on Y765 at FR36

CONF 001 003 004

19 Install the New Vertical Stringer on Y765 at FR36

CONF 002

19 Install the New Vertical Stringer on Y765 at FR36

CONF 001 003 004

20 Install the Strut Lower Attachment on Y765 at FR36

CONF 002

20 Install the Strut Lower Attachment on Y765 at FR36

CONF ALL

21 Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36

22 Cut out the Forward End Floor Beam on Y765 at FR36

23 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36

CONF 001 003 004

24 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36

CONF 002

24 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36

CONF 001 003 004

25 Temporarily, Install the New Parts for Adjustment on Y765 at FR36

CONF 002

25 Temporarily, Install the New Parts for Adjustment on Y765 at FR36

CONF 001 003 004

26 Drill the New Parts on Y765 at FR36

CONF 002

26 Drill the New Parts on Y765 at FR36

CONF 001 003 004

27 Install the New Parts on Y765 at FR36

CONF 002

27 Install the New Parts on Y765 at FR36

CONF 001 003 004

28 Protect the Fasteners and the New Parts on Y765 at FR36

CONF 002

28 Protect the Fasteners and the New Parts on Y765 at FR36

CONF ALL

29 Remove the Strut Lower Attachment on Y254 at FR36

CONF 001 003 004

30 Remove the Vertical Stringer on Y254 at FR36

CONF 002

30 Remove the Vertical Stringer on Y254 at FR36

CONF ALL

31 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36

CONF 001 003 004

32 Drill the New Vertical Stringer on Y254 at FR36

CONF 002

32 Drill the New Vertical Stringer on Y254 at FR36

CONF 001 003 004

33 Install the New Vertical Stringer on Y254 at FR36

CONF 002

33 Install the New Vertical Stringer on Y254 at FR36

CONF 001 003 004

34 Install the Strut Lower Attachment on Y254 at FR36

CONF 002

34 Install the Strut Lower Attachment on Y254 at FR36

CONF ALL

35 Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36

36 Cut out the Forward End Floor Beam on Y254 at FR36

37 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36

CONF 001 003 004

38 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36

CONF 002

38 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36

CONF 001 003 004

39 Temporarily, Install the New Parts for Adjustment on Y254 at FR36

CONF 002

39 Temporarily, Install the New Parts for Adjustment on Y254 at FR36

CONF 001 003 004

40 Drill the New Parts on Y254 at FR36

CONF 002

40 Drill the New Parts on Y254 at FR36

CONF 001 003 004

41 Install the New Parts on Y254 at FR36

CONF 002

41 Install the New Parts on Y254 at FR36

CONF 001 003 004

42 Protect the Fasteners and the New Parts on Y254 at FR36

CONF 002

42 Protect the Fasteners and the New Parts on Y254 at FR36

CONF ALL

43 Remove the Strut Lower Attachment on Y-254 at FR36

CONF 001 003 004

44 Remove the Vertical Stringer on Y-254 at FR36

CONF 002

44 Remove the Vertical Stringer on Y-254 at FR36

CONF ALL

45 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36

CONF 001 003 004

46 Drill the New Vertical Stringer on Y-254 at FR36

CONF 002

46 Drill the New Vertical Stringer on Y-254 at FR36

CONF 001 003 004

47 Install the New Vertical Stringer on Y-254 at FR36

CONF 002

47 Install the New Vertical Stringer on Y-254 at FR36

CONF 001 003 004

48 Install the Strut Lower Attachment on Y-254 at FR36

CONF 002

48 Install the Strut Lower Attachment on Y-254 at FR36

CONF ALL

49 Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36

50 Cut out the Forward End Floor Beam on Y-254 at FR36

51 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36

CONF 001 003 004

52 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36

CONF 002

52 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36

CONF 001 003 004

53 Temporarily, Install the New Parts for Adjustment on Y-254 at FR36

CONF 002

53 Temporarily, Install the New Parts for Adjustment on Y-254 at FR36

CONF 001 003 004

54 Drill the New Parts on Y-254 at FR36

CONF 002

54 Drill the New Parts on Y-254 at FR36

CONF 001 003 004

55 Install the New Parts on Y-254 at FR36

CONF 002

55 Install the New Parts on Y-254 at FR36

CONF 001 003 004

56 Protect the Fasteners and the New Parts on Y-254 at FR36

CONF 002

56 Protect the Fasteners and the New Parts on Y-254 at FR36

CONF ALL

57 Remove the Strut Lower Attachment on Y-765 at FR36

CONF 001 003 004

58 Remove the Vertical Stringer on Y-765 at FR36

CONF 002

58 Remove the Vertical Stringer on Y-765 at FR36

CONF ALL

59 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36

CONF 001 003 004

60 Drill the New Vertical Stringer on Y-765 at FR36

CONF 002

60 Drill the New Vertical Stringer on Y-765 at FR36

CONF 001 003 004

61 Install the New Vertical Stringer on Y-765 at FR36

CONF 002

61 Install the New Vertical Stringer on Y-765 at FR36

CONF 001 003 004

62 Install the Strut Lower Attachment on Y-765 at FR36

CONF 002

62 Install the Strut Lower Attachment on Y-765 at FR36

CONF ALL

63 Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36

64 Cut out the Forward End Floor Beam on Y-765 at FR36

65 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36

CONF 001 003 004

66 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36

CONF 002

66 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36

CONF 001 003 004

67 Temporarily, Install the New Parts for Adjustment on Y-765 at FR36

CONF 002

67 Temporarily, Install the New Parts for Adjustment on Y-765 at FR36

CONF 001 003 004

68 Drill the New Parts on Y-765 at FR36

CONF 002

68 Drill the New Parts on Y-765 at FR36

CONF 001 003 004

69 Install the New Parts on Y-765 at FR36

CONF 002

69 Install the New Parts on Y-765 at FR36

CONF 001 003 004

70 Protect the Fasteners and the New Parts on Y-765 at FR36

CONF 002

70 Protect the Fasteners and the New Parts on Y-765 at FR36

CONF ALL

71 Remove the Strut Lower Attachment on Y-1292 at FR36

CONF 001 003 004

72 Remove the Vertical Stringer on Y-1292 at FR36

CONF 002

72 Remove the Vertical Stringer on Y-1292 at FR36

CONF ALL

73 Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36

CONF 001 003 004

74 Drill the New Vertical Stringer on Y-1292 at FR36

CONF 002

74 Drill the New Vertical Stringer on Y-1292 at FR36

CONF 001 003 004

75 Install the New Vertical Stringer on Y-1292 at FR36

CONF 002

75 Install the New Vertical Stringer on Y-1292 at FR36

CONF 001 003 004

76 Install the Strut Lower Attachment on Y-1292 at FR36

CONF 002

76 Install the Strut Lower Attachment on Y-1292 at FR36

CONF ALL

77 Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36

78 Cut out the Forward End Floor Beam on Y-1292 at FR36

79 Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36

CONF 001 003 004

80 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36

CONF 002

80 On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36

CONF 001 003 004

81 Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36

CONF 002

81 Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36

CONF 001 003 004

82 Drill the New Parts on Y-1292 at FR36

CONF 002

82 Drill the New Parts on Y-1292 at FR36

CONF 001 003 004

83 Install the New Parts on Y-1292 at FR36

CONF 002

83 Install the New Parts on Y-1292 at FR36

CONF 001 003 004

84 Protect the Fasteners and the New Parts on Y-1292 at FR36

CONF 002

84 Protect the Fasteners and the New Parts on Y-1292 at FR36

CONF ALL

E. COMPLIANCE

(1) Classification

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

(2) Accomplishment Timescale

This Service Bulletin has been classified Recommended. It is expected that an Airworthiness Directive (AD) published by the European Aviation Safety Agency (EASA) will be issued to change this classification to Mandatory. It is anticipated that the AD will confirm the thresholds given but reference should be made to the AD for confirmation of the mandated accomplishment timescale.

It is expected that an AD will be issued in case of Maintenance Program Publication Trigger (MPPT) extension.

The compliance timescales are as follows:

- For A318/A319/A320 aircraft: before reaching 72000 Flight Cycles (FC) or 144000 Flight Hours (FH) from aircraft first flight, but not before reaching 30000 FC or 60000 FH from aircraft first flight.
- For A321 aircraft: before reaching 66724 FC or 133448 FH from aircraft first flight, but not before reaching 34000 FC or 68000 FH from aircraft first flight.

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

G. MANPOWER

CONF 001

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.

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

PREPARATION		
Job Set-up	1.00 h	
Get Access to the Forward End Floor Beams	8.00 h	

Get Access to the Center Wing Box Interior	1.00 h	
Get Access to the Forward Center Wing Box	16.75 h	
If Installed, Remove the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Installed, Remove the Additional Center Tank No.4	2.00 h	
If Installed, Remove the Additional Center Tank No.6	2.00 h	
PROCEDURE		
Remove the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y1292 at FR36	4.25 h	
Drill the New Parts on Y1292 at FR36	7.50 h	
Install the New Parts on Y1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y1292 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Vertical Stringer on Y765 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36	0.50 h	
Drill the New Vertical Stringer on Y765 at FR36	10.00 h	
Install the New Vertical Stringer on Y765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y765 at FR36	4.25 h	
Drill the New Parts on Y765 at FR36	7.50 h	
Install the New Parts on Y765 at FR36	4.25 h	

	Protect the Fasteners and the New Parts on Y765 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y254 at FR36	0.25 h	
	Remove the Vertical Stringer on Y254 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y254 at FR36	10.00 h	
	Install the New Vertical Stringer on Y254 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y254 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y254 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y254 at FR36	4.25 h	
	Drill the New Parts on Y254 at FR36	7.50 h	
	Install the New Parts on Y254 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y254 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-254 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-254 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-254 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-254 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-254 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y-254 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y-254 at FR36	4.25 h	
	Drill the New Parts on Y-254 at FR36	7.50 h	
	Install the New Parts on Y-254 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y-254 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-765 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-765 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-765 at FR36	10.00 h	

Install the New Vertical Stringer on Y-765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y-765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-765 at FR36	4.25 h	
Drill the New Parts on Y-765 at FR36	7.50 h	
Install the New Parts on Y-765 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-765 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y-1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y-1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y-1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36	4.25 h	
Drill the New Parts on Y-1292 at FR36	7.50 h	
Install the New Parts on Y-1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-1292 at FR36	7.00 h	
PREPARATION FOR TEST		
Do the Preparation Before Forward Center Wing Box Testing	15.25 h	
Do the Preparation Before Center Wing Box Testing	1.00 h	
Do the preparation Before Cabin Testing	9.00 h	
If Removed, Install the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Removed, Install the Additional Center Tank No.4	3.00 h	
If Removed, Install the Additional Center Tank No.6	3.00 h	
TEST		
Do the Forward Center Wing Box Testing	6.00 h	

Do Center Wing Box Testing	1.00 h	
Do the Cabin Testing	6.00 h	
CLOSE-UP		
Close the Access to the Forward Center Wing Box	1.50 h	
Close-up	1.00 h	
TOTAL MAN-HOURS	409.50 h	
ELAPSED TIME (HOURS)	128.00 h	

NOTE: For an explanation of the man-hours and elapsed time, refer to the Gantt Chart given in Appendix 01 - Manpower Gantt Chart.

CONF 002

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.

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

PREPARATION		
Job Set-up	1.00 h	
Get Access to the Forward End Floor Beams	8.00 h	
Get Access to the Center Wing Box Interior	1.00 h	
Get Access to the Forward Center Wing Box	16.75 h	
If Installed, Remove the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Installed, Remove the Additional Center Tank No.4	2.00 h	
If Installed, Remove the Additional Center Tank No.6	2.00 h	
PROCEDURE		
Remove the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36	0.25 h	BENCH

Temporarily, Install the New Parts for Adjustment on Y1292 at FR36	4.25 h	
Drill the New Parts on Y1292 at FR36	7.50 h	
Install the New Parts on Y1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y1292 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Vertical Stringer on Y765 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36	0.50 h	
Drill the New Vertical Stringer on Y765 at FR36	10.00 h	
Install the New Vertical Stringer on Y765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y765 at FR36	4.25 h	
Drill the New Parts on Y765 at FR36	7.50 h	
Install the New Parts on Y765 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y765 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Vertical Stringer on Y254 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36	0.50 h	
Drill the New Vertical Stringer on Y254 at FR36	10.00 h	
Install the New Vertical Stringer on Y254 at FR36	6.25 h	
Install the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y254 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y254 at FR36	4.25 h	
Drill the New Parts on Y254 at FR36	7.50 h	
Install the New Parts on Y254 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y254 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-254 at FR36	0.25 h	

	Remove the Vertical Stringer on Y-254 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-254 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-254 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-254 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y-254 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y-254 at FR36	4.25 h	
	Drill the New Parts on Y-254 at FR36	7.50 h	
	Install the New Parts on Y-254 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y-254 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-765 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-765 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-765 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-765 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-765 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y-765 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y-765 at FR36	4.25 h	
	Drill the New Parts on Y-765 at FR36	7.50 h	
	Install the New Parts on Y-765 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y-765 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-1292 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-1292 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-1292 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-1292 at FR36	0.25 h	

Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36	4.25 h	
Drill the New Parts on Y-1292 at FR36	7.50 h	
Install the New Parts on Y-1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-1292 at FR36	7.00 h	
PREPARATION FOR TEST		
Do the Preparation Before Forward Center Wing Box Testing	15.25 h	
Do the Preparation Before Center Wing Box Testing	1.00 h	
Do the preparation Before Cabin Testing	9.00 h	
If Removed, Install the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Removed, Install the Additional Center Tank No.4	3.00 h	
If Removed, Install the Additional Center Tank No.6	3.00 h	
TEST		
Do the Forward Center Wing Box Testing	6.00 h	
Do Center Wing Box Testing	1.00 h	
Do the Cabin Testing	6.00 h	
CLOSE-UP		
Close the Access to the Forward Center Wing Box	1.50 h	
Close-up	1.00 h	
TOTAL MAN-HOURS	409.50 h	
ELAPSED TIME (HOURS)	128.00 h	

NOTE: For an explanation of the man-hours and elapsed time, refer to the Gantt Chart given in Appendix 01 - Manpower Gantt Chart.

CONF 003

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.

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

PREPARATION		
Job Set-up	1.00 h	
Get Access to the Forward End Floor Beams	8.00 h	

Get Access to the Center Wing Box Interior	1.00 h	
Get Access to the Forward Center Wing Box	16.75 h	
If Installed, Remove the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Installed, Remove the Additional Center Tank No.4	2.00 h	
If Installed, Remove the Additional Center Tank No.6	2.00 h	
PROCEDURE		
Remove the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y1292 at FR36	4.25 h	
Drill the New Parts on Y1292 at FR36	7.50 h	
Install the New Parts on Y1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y1292 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Vertical Stringer on Y765 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36	0.50 h	
Drill the New Vertical Stringer on Y765 at FR36	10.00 h	
Install the New Vertical Stringer on Y765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y765 at FR36	4.25 h	
Drill the New Parts on Y765 at FR36	7.50 h	
Install the New Parts on Y765 at FR36	4.25 h	

Protect the Fasteners and the New Parts on Y765 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Vertical Stringer on Y254 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36	0.50 h	
Drill the New Vertical Stringer on Y254 at FR36	10.00 h	
Install the New Vertical Stringer on Y254 at FR36	6.25 h	
Install the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y254 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y254 at FR36	4.25 h	
Drill the New Parts on Y254 at FR36	7.50 h	
Install the New Parts on Y254 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y254 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-254 at FR36	0.25 h	
Remove the Vertical Stringer on Y-254 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36	0.50 h	
Drill the New Vertical Stringer on Y-254 at FR36	10.00 h	
Install the New Vertical Stringer on Y-254 at FR36	6.25 h	
Install the Strut Lower Attachment on Y-254 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-254 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-254 at FR36	4.25 h	
Drill the New Parts on Y-254 at FR36	7.50 h	
Install the New Parts on Y-254 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-254 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-765 at FR36	0.25 h	
Remove the Vertical Stringer on Y-765 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36	0.50 h	
Drill the New Vertical Stringer on Y-765 at FR36	10.00 h	

Install the New Vertical Stringer on Y-765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y-765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-765 at FR36	4.25 h	
Drill the New Parts on Y-765 at FR36	7.50 h	
Install the New Parts on Y-765 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-765 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y-1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y-1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y-1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36	4.25 h	
Drill the New Parts on Y-1292 at FR36	7.50 h	
Install the New Parts on Y-1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-1292 at FR36	7.00 h	
PREPARATION FOR TEST		
Do the Preparation Before Forward Center Wing Box Testing	15.25 h	
Do the Preparation Before Center Wing Box Testing	1.00 h	
Do the preparation Before Cabin Testing	9.00 h	
If Removed, Install the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Removed, Install the Additional Center Tank No.4	3.00 h	
If Removed, Install the Additional Center Tank No.6	3.00 h	
TEST		
Do the Forward Center Wing Box Testing	6.00 h	

Do Center Wing Box Testing	1.00 h	
Do the Cabin Testing	6.00 h	
CLOSE-UP		
Close the Access to the Forward Center Wing Box	1.50 h	
Close-up	1.00 h	
TOTAL MAN-HOURS	409.50 h	
ELAPSED TIME (HOURS)	128.00 h	

NOTE: For an explanation of the man-hours and elapsed time, refer to the Gantt Chart given in Appendix 01 - Manpower Gantt Chart.

CONF 004

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.

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

PREPARATION		
Job Set-up	1.00 h	
Get Access to the Forward End Floor Beams	8.00 h	
Get Access to the Center Wing Box Interior	1.00 h	
Get Access to the Forward Center Wing Box	16.75 h	
If Installed, Remove the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Installed, Remove the Additional Center Tank No.4	2.00 h	
If Installed, Remove the Additional Center Tank No.6	2.00 h	
PROCEDURE		
Remove the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Vertical Stringer on Y1292 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36	0.50 h	
Drill the New Vertical Stringer on Y1292 at FR36	10.00 h	
Install the New Vertical Stringer on Y1292 at FR36	6.25 h	
Install the Strut Lower Attachment on Y1292 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36	0.25 h	BENCH

Temporarily, Install the New Parts for Adjustment on Y1292 at FR36	4.25 h	
Drill the New Parts on Y1292 at FR36	7.50 h	
Install the New Parts on Y1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y1292 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Vertical Stringer on Y765 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36	0.50 h	
Drill the New Vertical Stringer on Y765 at FR36	10.00 h	
Install the New Vertical Stringer on Y765 at FR36	6.25 h	
Install the Strut Lower Attachment on Y765 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y765 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y765 at FR36	4.25 h	
Drill the New Parts on Y765 at FR36	7.50 h	
Install the New Parts on Y765 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y765 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Vertical Stringer on Y254 at FR36	7.25 h	
Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36	0.50 h	
Drill the New Vertical Stringer on Y254 at FR36	10.00 h	
Install the New Vertical Stringer on Y254 at FR36	6.25 h	
Install the Strut Lower Attachment on Y254 at FR36	0.25 h	
Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y254 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y254 at FR36	4.25 h	
Drill the New Parts on Y254 at FR36	7.50 h	
Install the New Parts on Y254 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y254 at FR36	7.00 h	
Remove the Strut Lower Attachment on Y-254 at FR36	0.25 h	

	Remove the Vertical Stringer on Y-254 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-254 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-254 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-254 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y-254 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y-254 at FR36	4.25 h	
	Drill the New Parts on Y-254 at FR36	7.50 h	
	Install the New Parts on Y-254 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y-254 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-765 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-765 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-765 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-765 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-765 at FR36	0.25 h	
	Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36	2.75 h	
	Cut out the Forward End Floor Beam on Y-765 at FR36	4.25 h	
	Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36	0.25 h	
	On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36	0.25 h	BENCH
	Temporarily, Install the New Parts for Adjustment on Y-765 at FR36	4.25 h	
	Drill the New Parts on Y-765 at FR36	7.50 h	
	Install the New Parts on Y-765 at FR36	4.25 h	
	Protect the Fasteners and the New Parts on Y-765 at FR36	7.00 h	
	Remove the Strut Lower Attachment on Y-1292 at FR36	0.25 h	
	Remove the Vertical Stringer on Y-1292 at FR36	7.25 h	
	Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36	0.50 h	
	Drill the New Vertical Stringer on Y-1292 at FR36	10.00 h	
	Install the New Vertical Stringer on Y-1292 at FR36	6.25 h	
	Install the Strut Lower Attachment on Y-1292 at FR36	0.25 h	

Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36	2.75 h	
Cut out the Forward End Floor Beam on Y-1292 at FR36	4.25 h	
Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36	0.25 h	
On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36	0.25 h	BENCH
Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36	4.25 h	
Drill the New Parts on Y-1292 at FR36	7.50 h	
Install the New Parts on Y-1292 at FR36	4.25 h	
Protect the Fasteners and the New Parts on Y-1292 at FR36	7.00 h	
PREPARATION FOR TEST		
Do the Preparation Before Forward Center Wing Box Testing	15.25 h	
Do the Preparation Before Center Wing Box Testing	1.00 h	
Do the preparation Before Cabin Testing	9.00 h	
If Removed, Install the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254	1.00 h	
If Removed, Install the Additional Center Tank No.4	3.00 h	
If Removed, Install the Additional Center Tank No.6	3.00 h	
TEST		
Do the Forward Center Wing Box Testing	6.00 h	
Do Center Wing Box Testing	1.00 h	
Do the Cabin Testing	6.00 h	
CLOSE-UP		
Close the Access to the Forward Center Wing Box	1.50 h	
Close-up	1.00 h	
TOTAL MAN-HOURS	409.50 h	
ELAPSED TIME (HOURS)	128.00 h	

NOTE: For an explanation of the man-hours and elapsed time, refer to the Gantt Chart given in Appendix 01 - Manpower Gantt Chart.

CONF ALL

H. WEIGHT AND BALANCE

CONF 001

The weight and balance estimates given in this Service Bulletin are based on the Manufacturer's Empty Weight (MEW) and do not include operator's items. The definition of MEW and operator's items is given in the Weight and Balance Manual (WBM), Ref. WBM.

Manufacturer's Empty Weight	+0.459 kg	(+1.012 lb)
Effect on Balance	+7.9395 kg.m	(+57.426 lb.ft)

CONF 002

The weight and balance estimates given in this Service Bulletin are based on the Manufacturer's Empty Weight (MEW) and do not include operator's items. The definition of MEW and operator's items is given in the Weight and Balance Manual (WBM), Ref. WBM.

Manufacturer's Empty Weight	+0.459 kg	(+1.012 lb)
Effect on Balance	+9.8982 kg.m	(+71.594 lb.ft)

CONF 003

The weight and balance estimates given in this Service Bulletin are based on the Manufacturer's Empty Weight (MEW) and do not include operator's items. The definition of MEW and operator's items is given in the Weight and Balance Manual (WBM), Ref. WBM.

Manufacturer's Empty Weight	+0.459 kg	(+1.012 lb)
Effect on Balance	+7.205 kg.m	(+52.114 lb.ft)

CONF 004

The weight and balance estimates given in this Service Bulletin are based on the Manufacturer's Empty Weight (MEW) and do not include operator's items. The definition of MEW and operator's items is given in the Weight and Balance Manual (WBM), Ref. WBM.

Manufacturer's Empty Weight	+0.459 kg	(+1.012 lb)
Effect on Balance	+6.8436 kg.m	(+49.500 lb.ft)

CONF ALL

I. ELECTRICAL LOAD DATA

Not changed

J. REFERENCES

CONF 001

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
06-41-53, Page Block 001	Task 12-34-24-869-002
Task 20-21-11-911-001	Task 20-21-12-911-001
Task 20-28-00-912-802	Task 21-20-00-010-001 Task 21-20-00-410-001
Task 21-21-41-000-001 Task 21-21-41-400-001	Task 21-21-43-000-001 Task 21-21-43-400-002
Task 21-63-51-000-001 Task 21-63-51-400-001	Task 21-63-52-000-001 Task 21-63-52-400-001
Task 25-21-41-000-001 Task 25-21-41-400-001	Task 25-54-12-000-001 Task 25-54-12-400-001
Task 25-80-00-000-001 Task 25-80-00-400-001	Task 28-10-00-910-004
Task 28-11-27-000-005 Task 28-11-27-000-007 Task 28-11-27-400-005 Task 28-11-27-400-007	Task 28-25-00-650-001 Task 28-25-00-869-001
Task 32-12-00-010-001 Task 32-12-00-410-001	Task 38-10-00-614-001 Task 38-10-00-614-002

AIRCRAFT MAINTENANCE MANUAL (AMM)	
Task 38-11-41-000-001 Task 38-11-41-400-002	Task 38-41-41-000-001 Task 38-41-41-400-001
Task 38-41-42-000-001 Task 38-41-42-400-001	Task 38-41-43-000-001 Task 38-41-43-400-001
Task 38-41-44-000-001 Task 38-41-44-400-001	Task 38-42-16-000-001 Task 38-42-16-400-001
Task 38-42-42-000-001 Task 38-42-42-400-001	Task 38-42-43-000-001 Task 38-42-43-400-001
Task 38-42-51-000-001 Task 38-42-51-400-001	Task 52-30-00-860-001 Task 52-30-00-860-002
Task 53-32-12-000-002 Task 53-32-12-400-002	Task 57-17-11-000-001 Task 57-17-11-400-001

ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)	
20-33-00	20-51-20
20-55-00	

NON DESTRUCTIVE TEST MANUAL (NTM)	
51-10-01	51-10-08

PROCESS AND MATERIAL SPECIFICATION (PMS)
01-04-66

SERVICE BULLETIN (SB)	
A320-57-1178	A320-57-1193

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-27-11
51-40-00	51-42-00
51-43-00	51-44-00
51-46-12	51-47-00
51-75-12	51-78-00

WEIGHT AND BALANCE MANUAL (WBM)

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF 002

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
06-41-53, Page Block 001	Task 12-34-24-869-002

AIRCRAFT MAINTENANCE MANUAL (AMM)	
Task 20-21-11-911-001	Task 20-21-12-911-001
Task 20-28-00-912-802	Task 21-20-00-010-001 Task 21-20-00-410-001
Task 21-21-41-000-001 Task 21-21-41-400-001	Task 21-21-43-000-001 Task 21-21-43-400-002
Task 21-63-51-000-001 Task 21-63-51-400-001	Task 21-63-52-000-001 Task 21-63-52-400-001
Task 25-21-41-000-001 Task 25-21-41-400-001	Task 25-54-12-000-001 Task 25-54-12-400-001
Task 25-80-00-000-001 Task 25-80-00-400-001	Task 28-10-00-910-004
Task 28-11-27-000-005 Task 28-11-27-000-007 Task 28-11-27-400-005 Task 28-11-27-400-007	Task 28-25-00-650-001 Task 28-25-00-869-001
Task 32-12-00-010-001 Task 32-12-00-410-001	Task 38-10-00-614-001 Task 38-10-00-614-002
Task 38-11-41-000-001 Task 38-11-41-400-002	Task 38-41-41-000-001 Task 38-41-41-400-001
Task 38-41-42-000-001 Task 38-41-42-400-001	Task 38-41-43-000-001 Task 38-41-43-400-001
Task 38-41-44-000-001 Task 38-41-44-400-001	Task 38-42-16-000-001 Task 38-42-16-400-001
Task 38-42-42-000-001 Task 38-42-42-400-001	Task 38-42-43-000-001 Task 38-42-43-400-001
Task 38-42-51-000-001 Task 38-42-51-400-001	Task 52-30-00-860-001 Task 52-30-00-860-002
Task 53-32-12-000-002 Task 53-32-12-400-002	Task 57-17-11-000-001 Task 57-17-11-400-001

ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)	
20-33-00	20-51-20
20-55-00	

NON DESTRUCTIVE TEST MANUAL (NTM)	
51-10-01	51-10-08

PROCESS AND MATERIAL SPECIFICATION (PMS)
01-04-66

SERVICE BULLETIN (SB)	
A320-57-1178	A320-57-1193

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-27-11
51-40-00	51-42-00
51-43-00	51-44-00
51-46-12	51-47-00
51-75-12	51-78-00

WEIGHT AND BALANCE MANUAL (WBM)

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF 003

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
06-41-53, Page Block 001	Task 12-34-24-869-002
Task 20-21-11-911-001	Task 20-21-12-911-001
Task 20-28-00-912-802	Task 21-20-00-010-001 Task 21-20-00-410-001
Task 21-21-41-000-001 Task 21-21-41-400-001	Task 21-21-43-000-001 Task 21-21-43-400-002
Task 21-63-51-000-001 Task 21-63-51-400-001	Task 21-63-52-000-001 Task 21-63-52-400-001
Task 25-21-41-000-001 Task 25-21-41-400-001	Task 25-54-12-000-001 Task 25-54-12-400-001
Task 25-80-00-000-001 Task 25-80-00-400-001	Task 28-10-00-910-004
Task 28-11-27-000-005 Task 28-11-27-000-007 Task 28-11-27-400-005 Task 28-11-27-400-007	Task 28-25-00-650-001 Task 28-25-00-869-001
Task 32-12-00-010-001 Task 32-12-00-410-001	Task 38-10-00-614-001 Task 38-10-00-614-002
Task 38-11-41-000-001 Task 38-11-41-400-002	Task 38-41-41-000-001 Task 38-41-41-400-001
Task 38-41-42-000-001 Task 38-41-42-400-001	Task 38-41-43-000-001 Task 38-41-43-400-001
Task 38-41-44-000-001	Task 38-42-16-000-001

AIRCRAFT MAINTENANCE MANUAL (AMM)	
Task 38-41-44-400-001	Task 38-42-16-400-001
Task 38-42-42-000-001 Task 38-42-42-400-001	Task 38-42-43-000-001 Task 38-42-43-400-001
Task 38-42-51-000-001 Task 38-42-51-400-001	Task 52-30-00-860-001 Task 52-30-00-860-002
Task 53-32-12-000-002 Task 53-32-12-400-002	Task 57-17-11-000-001 Task 57-17-11-400-001

ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)	
20-33-00	20-51-20
20-55-00	

NON DESTRUCTIVE TEST MANUAL (NTM)	
51-10-01	51-10-08

PROCESS AND MATERIAL SPECIFICATION (PMS)
01-04-66

SERVICE BULLETIN (SB)	
A320-57-1178	A320-57-1193

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-27-11
51-40-00	51-42-00
51-43-00	51-44-00
51-46-12	51-47-00
51-75-12	51-78-00

WEIGHT AND BALANCE MANUAL (WBM)

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF 004

(1) Modification of the Structure

(a) Task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
06-41-53, Page Block 001	Task 12-34-24-869-002
Task 20-21-11-911-001	Task 20-21-12-911-001
Task 20-28-00-912-802	Task 21-20-00-010-001 Task 21-20-00-410-001
Task 21-21-41-000-001 Task 21-21-41-400-001	Task 21-21-43-000-001 Task 21-21-43-400-002
Task 21-63-51-000-001	Task 21-63-52-000-001

AIRCRAFT MAINTENANCE MANUAL (AMM)	
Task 21-63-51-400-001	Task 21-63-52-400-001
Task 25-21-41-000-001 Task 25-21-41-400-001	Task 25-54-12-000-001 Task 25-54-12-400-001
Task 25-80-00-000-001 Task 25-80-00-400-001	Task 28-10-00-910-004
Task 28-11-27-000-005 Task 28-11-27-000-007 Task 28-11-27-400-005 Task 28-11-27-400-007	Task 28-25-00-650-001 Task 28-25-00-869-001
Task 32-12-00-010-001 Task 32-12-00-410-001	Task 38-10-00-614-001 Task 38-10-00-614-002
Task 38-11-41-000-001 Task 38-11-41-400-002	Task 38-41-41-000-001 Task 38-41-41-400-001
Task 38-41-42-000-001 Task 38-41-42-400-001	Task 38-41-43-000-001 Task 38-41-43-400-001
Task 38-41-44-000-001 Task 38-41-44-400-001	Task 38-42-16-000-001 Task 38-42-16-400-001
Task 38-42-42-000-001 Task 38-42-42-400-001	Task 38-42-43-000-001 Task 38-42-43-400-001
Task 38-42-51-000-001 Task 38-42-51-400-001	Task 52-30-00-860-001 Task 52-30-00-860-002
Task 53-32-12-000-002 Task 53-32-12-400-002	Task 57-17-11-000-001 Task 57-17-11-400-001

ELECTRICAL STANDARD PRACTICES MANUAL (ESPM)	
20-33-00	20-51-20
20-55-00	

NON DESTRUCTIVE TEST MANUAL (NTM)	
51-10-01	51-10-08

PROCESS AND MATERIAL SPECIFICATION (PMS)
01-04-66

SERVICE BULLETIN (SB)	
A320-57-1178	A320-57-1193

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-27-11
51-40-00	51-42-00
51-43-00	51-44-00
51-46-12	51-47-00

STRUCTURAL REPAIR MANUAL (SRM)	
51-75-12	51-78-00

WEIGHT AND BALANCE MANUAL (WBM)

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF ALL

K. PUBLICATION AFFECTED

STRUCTURAL REPAIR MANUAL (SRM)

L. INDUSTRY SUPPORT INFORMATION

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

2. MATERIAL INFORMATION

A. MATERIAL APPLICABILITY

CONF 001

Material for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL	QTY	SEE NOTES
Tool kit 571228T01R00	1	
Referenced tools	See SB	
Consumables	See SB	
Part kit 571228A01R00	6	
Part kit 571228A03R01	1	
Components	See SB	
Referenced parts	See SB	

CONF 002

Material for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL	QTY	SEE NOTES
Tool kit 571228T01R00	1	
Referenced tools	See SB	
Consumables	See SB	
Part kit 571228A02R00	6	
Part kit 571228A03R01	1	
Components	See SB	
Referenced parts	See SB	

CONF 003

Material for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL	QTY	SEE NOTES
Tool kit 571228T01R00	1	
Referenced tools	See SB	
Consumables	See SB	
Part kit 571228A01R00	6	
Part kit 571228A03R01	1	
Components	See SB	
Referenced parts	See SB	

CONF 004

Material for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

MATERIAL	QTY	SEE NOTES
Tool kit 571228T01R00	1	
Referenced tools	See SB	

MATERIAL	QTY	SEE NOTES
Consumables	See SB	
Part kit 571228A01R00	6	
Part kit 571228A03R01	1	
Components	See SB	
Referenced parts	See SB	

CONF ALL

B. TOOLING

Tool kit 571228T01R00

Availability	090 d (calendar days from receipt of order)
NOTE(S)	
Procurement to be negotiated directly with AIRBUS.	

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers Customer Order Fulfilment Weg beim Jaeger 150 22335 HAMBURG GERMANY Phone: +49 (0) 40 50 76 40 02 E-mail: Please contact your Single Point Of Contact (SPOC) Internet: http://spares.airbus.com
NOTE(S)		
Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.		
AIRBUS Material, Logistics and Suppliers Weg beim Jaeger 150 22335 HAMBURG GERMANY Fax: +49 40 50 76 3225 E-mail: Tool.LEASE@airbus.com Internet: http://spares.airbus.com Operators interested in the lease of standard tools should contact AIRBUS at the address given above.		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	98D57103003000	1	EXTRACTR		

CONF 001

Referenced tools for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced tasks:

Ref. AMM Task 28-10-00-910-004

Ref. AMM Task 28-11-27-000-005

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-000-007

Ref. AMM Task 28-11-27-400-007

Ref. NTM 51-10-01

Ref. NTM 51-10-08

CONF 002

Referenced tools for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced tasks:

Ref. AMM Task 28-10-00-910-004

Ref. AMM Task 28-11-27-000-005

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-000-007

Ref. AMM Task 28-11-27-400-007

Ref. NTM 51-10-01

Ref. NTM 51-10-08

CONF 003

Referenced tools for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced tasks:

Ref. AMM Task 28-10-00-910-004

Ref. AMM Task 28-11-27-000-005

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-000-007

Ref. AMM Task 28-11-27-400-007

Ref. NTM 51-10-01

Ref. NTM 51-10-08

CONF 004

Referenced tools for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the tools listed in the subsequent referenced tasks:

Ref. AMM Task 28-10-00-910-004

Ref. AMM Task 28-11-27-000-005

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-000-007

Ref. AMM Task 28-11-27-400-007

Ref. NTM 51-10-01

Ref. NTM 51-10-08

CONF ALL

C. CONSUMABLES

CONF 001

Consumables for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	05EML7	Epoxy Adhesive - - - Legacy 3		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF 002

Consumables for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	05EML7	Epoxy Adhesive - - - Legacy 3		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF 003

Consumables for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	05EML7	Epoxy Adhesive - - - Legacy 3		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF 004

Consumables for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	05EML7	Epoxy Adhesive - - - Legacy 3		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF ALL

D. LIST OF NEW PARTS

CONF 001 003 004

Part kit 571228A01R00

Cost	11000.00 USD
Availability	240 d (calendar days from receipt of order)
NOTE(S)	
The sales terms (costs and availability) are estimated in relation to economic conditions. The latest valid price and lead time for ordering purposes shall be obtained through the AIRBUS Spares portal or through a request for quotation to airbus.kit@airbus.com.	
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.	

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: airbus.kit@airbus.com Internet: http://spares.airbus.com
NOTE(S)		
Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
5	D0041005820000	1	STRINGER		
6	D5713006420000	1	BUSHING		
10	ASNA2528-3	34	NUT		
12	ASNA2529-3	40	NUT		
13	ASNA2536-3	16	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	10	NUT		
16	EN6115K4-8	2	BOLT		
17	EN6115K5X15	4	BOLT		
18	EN6115V3-6	40	BOLT		
19	EN6115V3X4	2	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	26	BOLT		
22	EN6115V3X8	2	BOLT		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
30	MS24665-153	1	PIN		
	ASNA2050DCJ3215	20	RIVET		
	ASNA2050DXJ4020	20	RIVET		

NOTE(S)

Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.

CONF 002

Part kit 571228A02R00

Cost	11000.00 USD
Availability	240 d (calendar days from receipt of order)

NOTE(S)

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

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.

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: airbus.kit@airbus.com Internet: http://spares.airbus.com

NOTE(S)

Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
5	D0041005820000	1	STRINGER		
6	D5713006420000	1	BUSHING		
10	ASNA2528-3	30	NUT		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
11	ASNA2528-4	2	NUT		
12	ASNA2529-3	40	NUT		
13	ASNA2536-3	16	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	10	NUT		
16	EN6115K4-8	2	BOLT		
17	EN6115K5X15	4	BOLT		
18	EN6115V3-6	40	BOLT		
20	EN6115V3X5	18	BOLT		
21	EN6115V3X6	26	BOLT		
22	EN6115V3X8	2	BOLT		
23	EN6115V4X5	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	4	BOLT		
29	MS24665-136	1	PIN		
30	MS24665-153	1	PIN		
	ASNA2050DCJ3215	20	RIVET		
	ASNA2050DXJ4020	20	RIVET		

NOTE(S)

Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.

CONF ALL

Part kit 571228A03R01

Cost	50.00 USD
Availability	270 d (calendar days from receipt of order)

NOTE(S)

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

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.

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY Phone: +49 40 743 51660 E-mail: airbus.kit@airbus.com Internet: http://spares.airbus.com

NOTE(S)

Customers with aircraft shown in the applicability of this Service Bulletin should send a purchase order to AIRBUS at the address given above and quote the number of this Service Bulletin.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
67	MS21042-3	8	NUT		
71	NAS1726-3E	26	NUT		
114	ABS5800D028A	1	SEAL		
118	NSA8206-014	1	ORING		

NOTE(S)

Refer to the AIRBUS Ref. SM if you find part numbers of hardware components which you cannot identify. The SM will give you the correct part number to part number relationship.

CONF 001

Components for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers Standard Parts Customer Order Fulfilment Phone: +49 (0) 40 50 76 40 02 E-mail: Please contact your Single Point Of Contact (SPOC) Internet: http://spares.airbus.com or via SPEC2000

NOTE(S)

For standard hardware the purchase order must be addressed to AIRBUS at the address given above. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	ABS1133C025 (D4296)	10 (m)	TAPE		(1)
	ABS1133D025 (D4296)	10 (m)	TAPE		(1)

NOTE(S)

(1): The components listed above are not an AIRBUS Kit, the required parts must be ordered as necessary through the given channel.

CONF 002

Components for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers Standard Parts Customer Order Fulfilment Phone: +49 (0) 40 50 76 40 02 E-mail: Please contact your Single Point Of Contact (SPOC) Internet: http://spares.airbus.com or via SPEC2000

NOTE(S)

For standard hardware the purchase order must be addressed to AIRBUS at the address given above. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	ABS1133C025 (D4296)	10 (m)	TAPE		(1)
	ABS1133D025 (D4296)	10 (m)	TAPE		(1)
NOTE(S)					
(1): The components listed above are not an AIRBUS Kit, the required parts must be ordered as necessary through the given channel.					

CONF 003

Components for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers Standard Parts Customer Order Fulfilment Phone: +49 (0) 40 50 76 40 02 E-mail: Please contact your Single Point Of Contact (SPOC) Internet: http://spares.airbus.com or via SPEC2000
NOTE(S)		
For standard hardware the purchase order must be addressed to AIRBUS at the address given above. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference.		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	ABS1133C025 (D4296)	10 (m)	TAPE		(1)
	ABS1133D025 (D4296)	10 (m)	TAPE		(1)
NOTE(S)					
(1): The components listed above are not an AIRBUS Kit, the required parts must be ordered as necessary through the given channel.					

CONF 004

Components for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

Procurement address	D4296	AIRBUS Material, Logistics and Suppliers Standard Parts Customer Order Fulfilment Phone: +49 (0) 40 50 76 40 02 E-mail: Please contact your Single Point Of Contact (SPOC) Internet: http://spares.airbus.com or via SPEC2000
NOTE(S)		
For standard hardware the purchase order must be addressed to AIRBUS at the address given above. Quote the number of this Service Bulletin, the MSN and, if applicable the Retrofit Information Letter (RIL) reference.		

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	ABS1133C025 (D4296)	10 (m)	TAPE		(1)
	ABS1133D025 (D4296)	10 (m)	TAPE		(1)
NOTE(S)					
(1): The components listed above are not an AIRBUS Kit, the required parts must be ordered as necessary through the given channel.					

CONF 001

Referenced parts for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM Task 21-21-43-400-002

Ref. AMM Task 38-11-41-400-002

Ref. AMM Task 38-41-41-400-001

Ref. AMM Task 38-41-42-400-001

Ref. AMM Task 38-42-16-400-001

Ref. AMM Task 38-42-42-400-001

Ref. AMM Task 38-42-43-400-001

Ref. AMM Task 21-63-51-400-001

Ref. AMM Task 21-63-52-400-001

Ref. AMM Task 57-17-11-400-001

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-400-007

CONF 002

Referenced parts for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM Task 21-21-43-400-002

Ref. AMM Task 38-11-41-400-002

Ref. AMM Task 38-41-41-400-001

Ref. AMM Task 38-41-42-400-001

Ref. AMM Task 38-42-16-400-001

Ref. AMM Task 38-42-42-400-001

Ref. AMM Task 38-42-43-400-001

Ref. AMM Task 21-63-51-400-001

Ref. AMM Task 21-63-52-400-001

Ref. AMM Task 57-17-11-400-001

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-400-007

CONF 003

Referenced parts for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM Task 21-21-43-400-002

Ref. AMM Task 38-11-41-400-002

Ref. AMM Task 38-41-41-400-001

Ref. AMM Task 38-41-42-400-001

Ref. AMM Task 38-42-16-400-001

Ref. AMM Task 38-42-42-400-001

Ref. AMM Task 38-42-43-400-001

Ref. AMM Task 21-63-51-400-001

Ref. AMM Task 21-63-52-400-001

Ref. AMM Task 57-17-11-400-001

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-400-007

CONF 004

Referenced parts for task set A320-A-57-XX-1228-01000-93AA-A Modification of the Structure

NOTE: To accomplish this Service Bulletin it is necessary to use the expendable parts listed in the subsequent referenced tasks:

Ref. AMM Task 21-21-43-400-002

Ref. AMM Task 38-11-41-400-002

Ref. AMM Task 38-41-41-400-001

Ref. AMM Task 38-41-42-400-001

Ref. AMM Task 38-42-16-400-001

Ref. AMM Task 38-42-42-400-001

Ref. AMM Task 38-42-43-400-001

Ref. AMM Task 21-63-51-400-001

Ref. AMM Task 21-63-52-400-001

Ref. AMM Task 57-17-11-400-001

Ref. AMM Task 28-11-27-400-005

Ref. AMM Task 28-11-27-400-007

CONF ALL

E. LIST OF EXISTING PARTS

No parts

3. ACCOMPLISHMENT INSTRUCTIONS

Task set A320-A-57-XX-1228-01000-93AA-A
Modification of the Structure

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

WARNING: THIS PROCEDURE USES A FUEL SYSTEM ITEM THAT IS IN A CATEGORY KNOWN AS A CRITICAL DESIGN CONFIGURATION CONTROL LIMITATION (CDCCL). CDCCL IDENTIFIES AN ITEM THAT CAN BE THE SOURCE OF A POSSIBLE FUEL TANK IGNITION. YOU MUST KEEP ALL CDCCL ITEMS IN THE APPROVED CONFIGURATION. DAMAGE, WEAR OR CHANGES TO A CDCCL ITEM CAN CAUSE A POSSIBLE TANK EXPLOSION.

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 Ref. ESPM 20-55-00.

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

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

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

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

NOTE: This Service Bulletin contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.
For any deviations to the instructions, including RC paragraph contained herein, contact AIRBUS for further instructions and approval.

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

A. TASK SET ASSOCIATED INFORMATION

CONF 001

Maintenance Configuration

Fuel tanks opened

CONF 002

Maintenance Configuration

Fuel tanks opened

CONF 003

Maintenance Configuration

Fuel tanks opened

CONF 004

Maintenance Configuration

Fuel tanks opened

Task Manpower

CONF 001

TOTAL MAN-HOURS 409.50 h

CONF 002

TOTAL MAN-HOURS 409.50 h

CONF 003

TOTAL MAN-HOURS 409.50 h

CONF 004

TOTAL MAN-HOURS 409.50 h

CONF 001

ELAPSED TIME (HOURS) 128.00 h

CONF 002

ELAPSED TIME (HOURS) 128.00 h

CONF 003

ELAPSED TIME (HOURS) 128.00 h

CONF 004

ELAPSED TIME (HOURS) 128.00 h

CONF ALL

B. PREPARATION

(1) Task A320-A-57-XX-1228-01001-540A-A - Job Set-up

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	2
Elapsed Time	0.50 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 12-34-24-869-002 Task 28-10-00-910-004 Task 28-25-00-650-001 Task 28-25-00-869-001 Task 32-12-00-010-001 Task 52-30-00-860-001

Procedure

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

NOTE: This Service Bulletin is based on the aircraft configuration as known by AIRBUS (first aircraft delivery configuration and modified by the reported incorporation of AIRBUS Service Bulletins).
Prior to Service Bulletin accomplishment, specific attention must be paid to structural damage which may exist and to repairs which were performed on the area defined, refer to Ref. Fig. Work Area, because they may be affected by the Service Bulletin. If any repairs were performed and prevent accomplishment of this Service Bulletin, contact AIRBUS Customer Services Repair Engineering Support department for instructions on how to proceed. AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before accomplishment of the Service Bulletin.
If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RDAS issued by AIRBUS, AIRBUS Customer Services Repair, Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

(a) Make sure that the aircraft is electrically grounded, refer to Ref. AMM Task 12-34-24-869-002.

(b) Open the Main Landing Gear (MLG) doors, refer to Ref. AMM Task 32-12-00-010-001.

(c) Open the FWD cargo door (Door 825), refer to Ref. AMM Task 52-30-00-860-001.

(d) Put an access platform in position at the Zone 825.

(e) Defuel the center tank, refer to Ref. AMM Task 28-25-00-650-001.
or
Transfer the fuel into a different tank, refer to Ref. AMM Task 28-25-00-869-001.

(f) Purge and vent the center fuel tank, refer to Ref. AMM Task 28-10-00-910-004.

(g) Safety precautions.

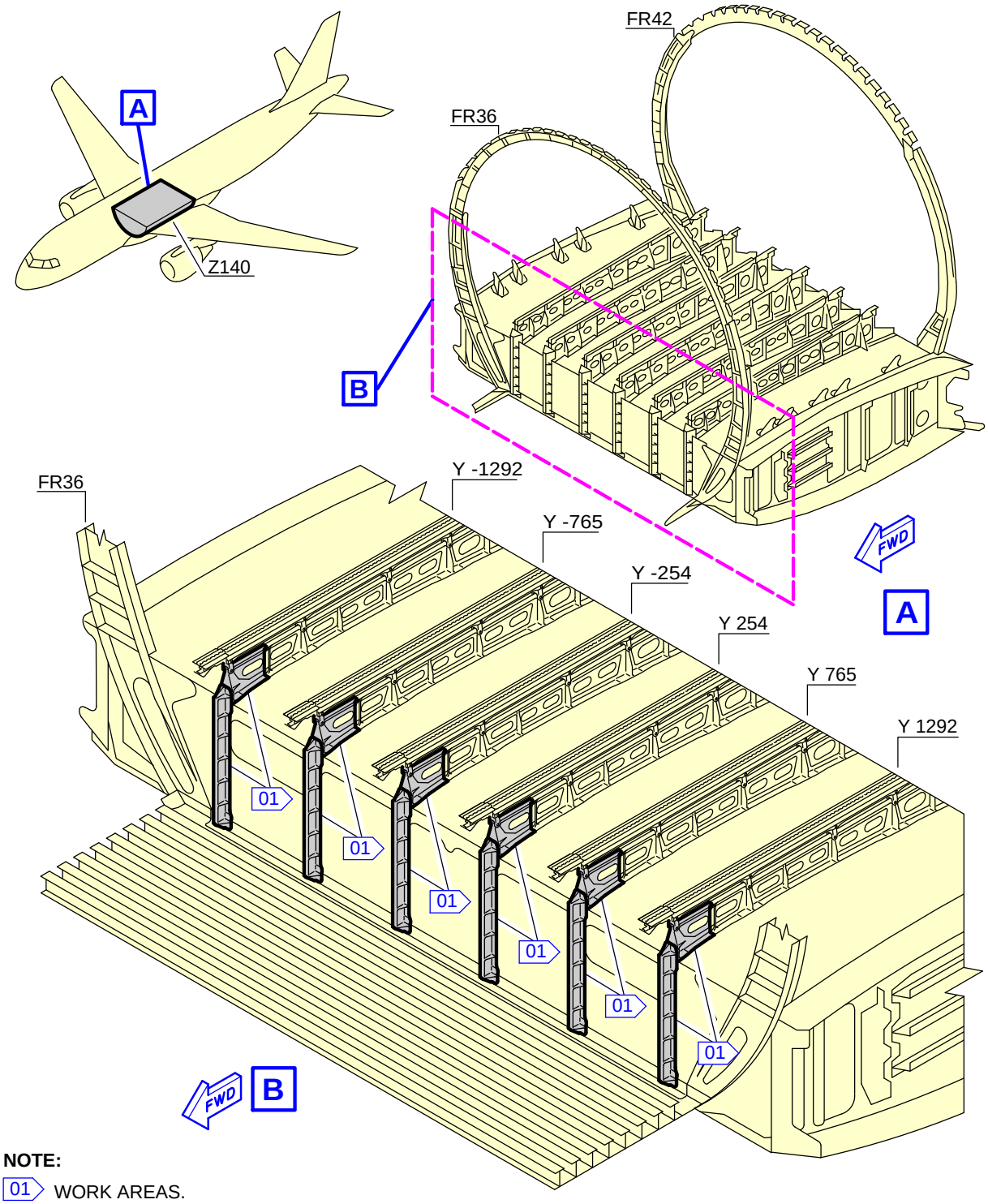
1 Put warning notices in position to tell persons not to pressurize the potable water system.

2 In the cockpit, make sure that:

- On the panel (Electrical Panel 400VU), the landing gear control-lever FIN 6GA is in the “down” position.
- On the panel (Electrical Panel 110VU), the “GRAVITY GEAR EXTN” handle is folded into the center console.

3 Put the safety barrier(s) in position to prevent access to the range(s) of travel of the applicable MLG door(s).

CONF ALL



NOTE:

01 WORK AREAS.

ICN-A320-A-57XX1228-A-FAPE3-01RSD-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01RSD-A-001-01 SHEET 1/1

(2) Task A320-A-57-XX-1228-01001-520A-A - Get Access to the Forward End Floor Beams

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	From Frame 35 to Frame 42

Manpower/Resources/Skills

Man-hours	8.00 h
Minimum Number of person	2
Elapsed Time	4.00 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 25-21-41-000-001 Task 53-32-12-000-002
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

4 Tag all the parts you must remove and retain to make the subsequent installation easier.

5 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the passenger seats between Frame 35 and Frame 42 for access, refer to Ref. AMM Task 25-21-41-000-001.

(c) Remove the floor panels between Frame 35 and Frame 42 for access, refer to Ref. AMM Task 53-32-12-000-002.

(d) Remove the hydraulic system clamps between Y–1292 and outboard for access, refer to Ref. Fig. Removal of the Bridge Brackets and the Hydraulic Clamps between the FR36 and FR38.

1 Remove the hydraulic system clamps at Frame 36.

1	HYDRAULIC CLAMP	Item (95)	Retain
2	BOLT	Item (96)	Retain
2	WASHER	Item (97)	Retain

2 Remove the hydraulic system clamps at Frame 37.

1	HYDRAULIC CLAMP	Item (95)	Retain

2	BOLT	Item (96)	Retain
2	WASHER	Item (97)	Retain

3 Protect the hydraulic line between Frame 36 and Frame 37 on the horizontal bulkhead without disconnection.

NOTE: Push the hydraulic line aside as necessary during the modification.

(e) Remove the bridge brackets for access, refer to Ref. Fig. Removal of the Bridge Brackets and the Hydraulic Clamps between the FR36 and FR38.

1 Remove the potable water distribution system clamps.

a Disconnect the potable water distribution system clamps from the bridge bracket at Frame 36.

1	SCREW	Item (70)	Retain
1	WASHER FLAT	Item (69)	Retain
1	CLAMP	Item (74)	Retain
1	DISTANCE PIECE	Item (75)	Retain
1	NUT SELF LOCKING	Item (71)	Discard

b Disconnect the potable water distribution system clamps from the bridge bracket at Frame 37.

1	SCREW	Item (70)	Retain
1	WASHER FLAT	Item (69)	Retain
1	CLAMP	Item (74)	Retain
1	DISTANCE PIECE	Item (75)	Retain
1	NUT SELF LOCKING	Item (71)	Discard

c Protect the potable water distribution system between Frame 35 and Frame 37 on the horizontal bulkhead without disconnection.

NOTE: Push the potable water distribution system aside as necessary during the modification.

2 Remove the toilet vacuum system clamps.

a Disconnect the toilet vacuum system clamps from the bridge bracket at Frame 36.

2	SCREW	Item (78)	Retain
2	WASHER FLAT	Item (79)	Retain
1	CLAMP	Item (76)	Retain
2	NUT SELF LOCKING	Item (71)	Discard

b Disconnect the toilet vacuum system clamps from the bridge bracket at Frame 37.

2	SCREW	Item (78)	Retain
2	WASHER FLAT	Item (79)	Retain

1	CLAMP	Item (76)	Retain
2	SPACER	Item (80)	Retain
2	NUT SELF LOCKING	Item (71)	Discard

c Protect the toilet vacuum system between Frame 35 and Frame 37 on the horizontal bulkhead without disconnection.

NOTE: Push the toilet vacuum system aside as necessary during the modification.

3 Remove the air pressure system clamps.

a Disconnect the air pressure system clamps from the bridge bracket at Frame 36.

1	SCREW	Item (82)	Retain
1	WASHER FLAT	Item (83)	Retain
1	CLAMP	Item (81)	Retain
1	NUT SELF LOCKING	Item (71)	Discard

b Disconnect the air pressure system clamps from the bridge bracket at Frame 37.

1	SCREW	Item (82)	Retain
1	WASHER FLAT	Item (83)	Retain
1	CLAMP	Item (81)	Retain
1	NUT SELF LOCKING	Item (71)	Discard

c Protect the air pressure system between Frame 35 and Frame 37 on the horizontal bulkhead without disconnection.

NOTE: The air pressure system can be pushed aside as necessary during the modification.

4 Remove the bridge brackets between Y–1292 and Y–765.

a Remove the bridge bracket at Frame 36.

1	BRIDGE BRACKET	Item (63)	Retain
2	SCREW	Item (64)	Retain
3	WASHER	Item (65)	Retain
4	WASHER HOLDING	Item (66)	Retain
2	NUT SELF LOCKING	Item (67)	Discard

b Remove the bridge bracket at Frame 37.

1	BRIDGE BRACKET	Item (63)	Retain
2	SCREW	Item (64)	Retain
3	WASHER	Item (65)	Retain
4	WASHER HOLDING	Item (66)	Retain

2	NUT SELF LOCKING	Item (67)	Discard

5 Remove the bridge brackets between Y 765 and Y 1292.

a Remove the bridge bracket at Frame 36.

1	BRIDGE BRACKET	Item (63)	Retain
2	SCREW	Item (64)	Retain
3	WASHER	Item (65)	Retain
4	WASHER HOLDING	Item (66)	Retain
2	NUT SELF LOCKING	Item (67)	Discard

b Remove the bridge bracket at Frame 37.

1	BRIDGE BRACKET	Item (63)	Retain
2	SCREW	Item (64)	Retain
3	WASHER	Item (65)	Retain
4	WASHER HOLDING	Item (66)	Retain
2	NUT SELF LOCKING	Item (67)	Discard

6 Remove the bridge brackets between Y 254 and Y 765.

a Remove the bridge bracket at Frame 36.

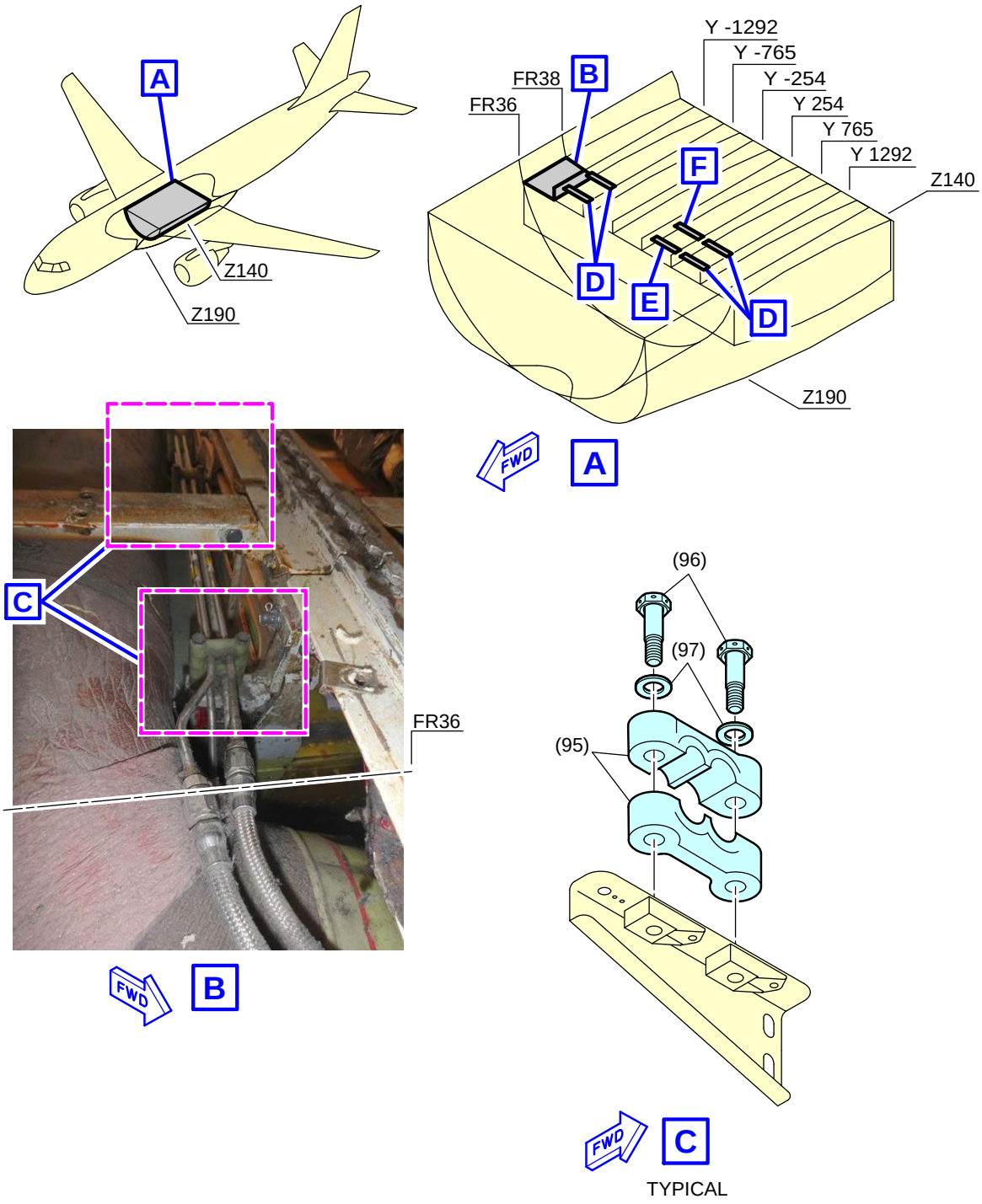
1	BRIDGE BRACKET	Item (68)	Retain
4	SCREW	Item (70)	Retain
4	WASHER FLAT	Item (69)	Retain
2	PLATE	Item (72)	Retain
2	PLATE	Item (73)	Retain
4	NUT SELF LOCKING	Item (71)	Discard

b Remove the bridge bracket at Frame 37.

1	BRIDGE BRACKET	Item (68)	Retain
4	SCREW	Item (70)	Retain
4	WASHER FLAT	Item (69)	Retain
2	PLATE	Item (72)	Retain
2	PLATE	Item (73)	Retain
4	NUT SELF LOCKING	Item (71)	Discard

(f) If necessary, remove the electrical bundle clamps and push the bundles aside without disconnection for access to the work area.

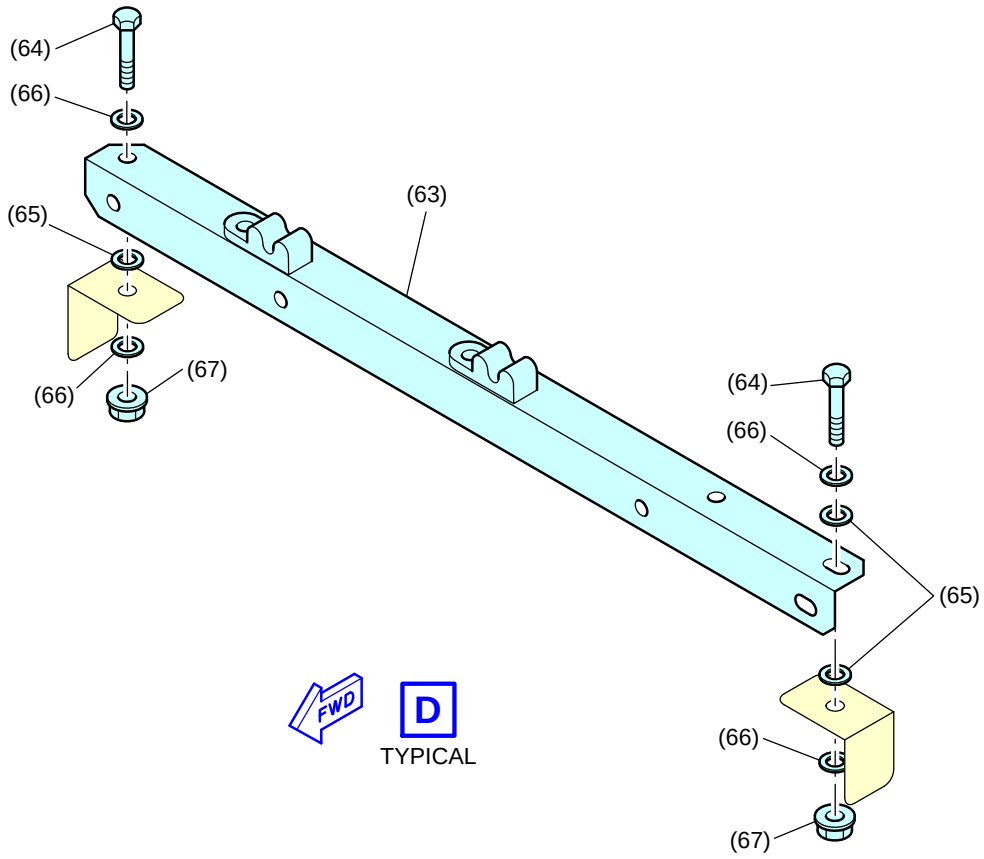
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO5-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO5-A-002-01 SHEET 1/4

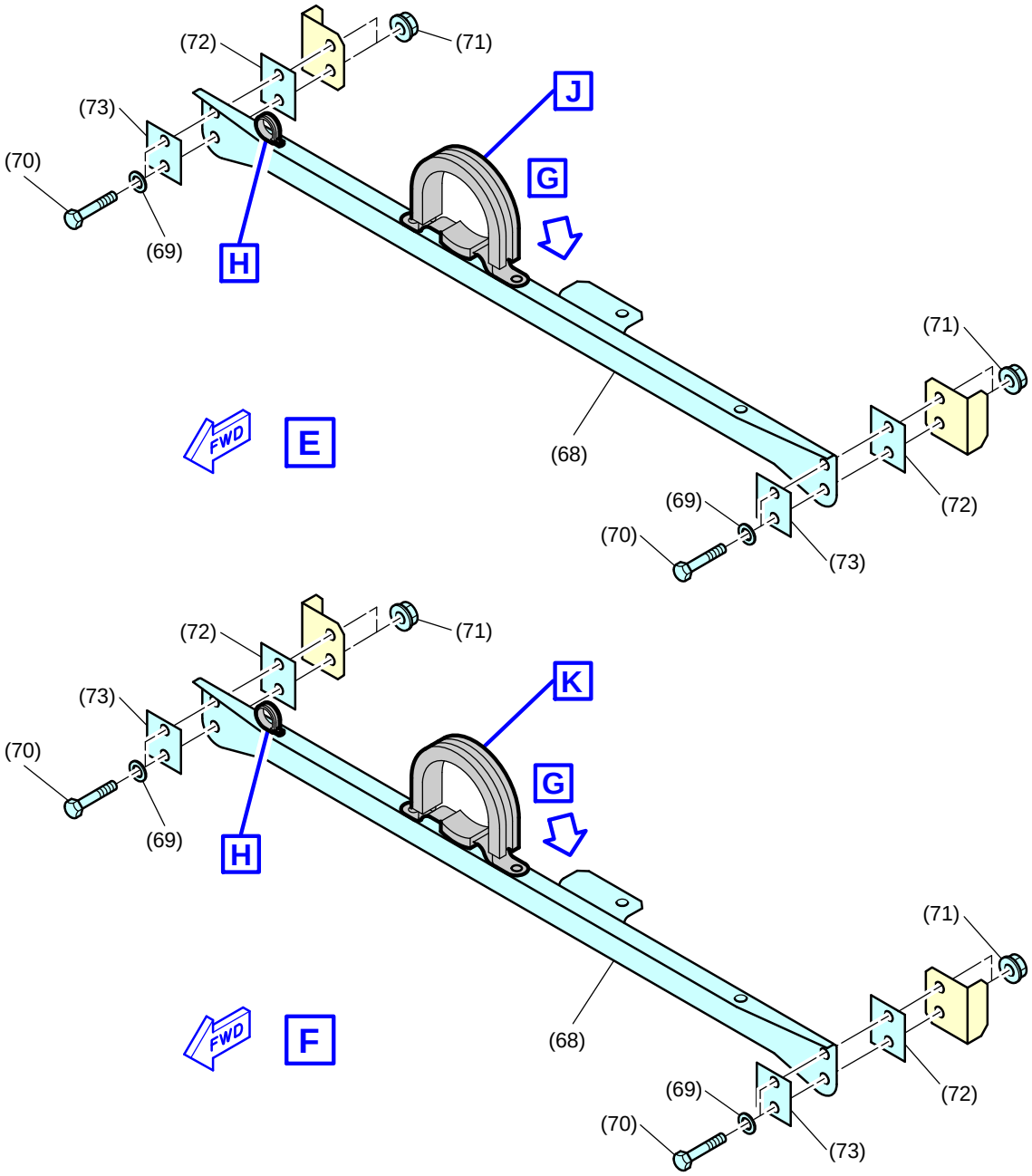
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO6-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO6-A-002-01 SHEET 2/4

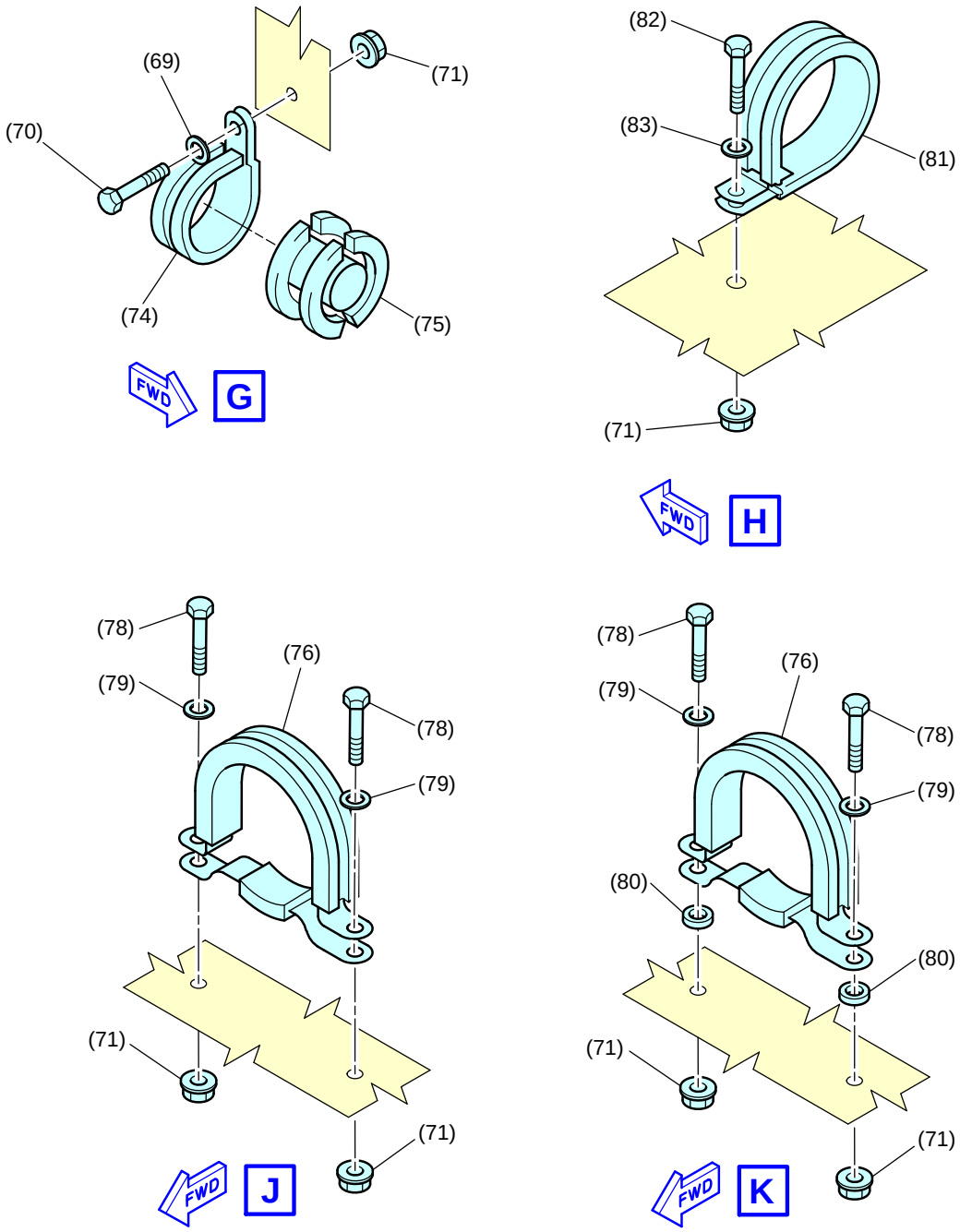
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO7-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO7-A-002-01 SHEET 3/4

CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO8-A-002-01 SHEET 4/4

(3) Task A320-A-57-XX-1228-02001-520A-A - Get Access to the Center Wing Box Interior

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
147	
148	

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	2
Elapsed Time	0.50 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 57-17-11-000-001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the access covers (Panel 147AZ and Panel 148AZ) for access, refer to Ref. AMM Task 57-17-11-000-001.

(4) Task A320-A-57-XX-1228-03001-520A-A - Get Access to the Forward Center Wing Box

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Work location	From Frame 34 to Frame 36

Manpower/Resources/Skills

Man-hours	16.75 h

Minimum Number of person	2
Elapsed Time	9.00 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 21-20-00-010-001 Task 21-21-41-000-001 Task 21-21-43-000-001 Task 21-63-51-000-001 Task 21-63-52-000-001 Task 25-54-12-000-001 Task 25-80-00-000-001 Task 38-11-41-000-001 Task 38-41-41-000-001 Task 38-41-42-000-001 Task 38-41-43-000-001 Task 38-41-44-000-001 Task 38-42-16-000-001 Task 38-42-42-000-001 Task 38-42-43-000-001 Task 38-42-51-000-001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the FWD cargo compartment partition panels (Panel 131PW, Panel 131NW and Panel 132PW) at Frame 34 or Frame 35.5 for access, refer to Ref. AMM Task 25-54-12-000-001.

(c) Remove the FWD cargo compartment partition beams at Frame 34 or Frame 35.5 for access, refer to Ref. Fig. Removal of the Partition Beams at FR34 or FR35.5.

1 Remove the left FWD cargo compartment partition beam.

1	PARTITION BEAM ASSY	Item (101)	Retain
3	BOLT	Item (102)	Retain

3	WASHER	Item (103)	Retain
1	RING	Item (104)	Retain
3	NUT	Item (71)	Discard

2 Remove the right FWD cargo compartment partition beam.

1	PARTITION BEAM ASSY	Item (101)	Retain
3	BOLT	Item (102)	Retain
3	WASHER	Item (103)	Retain
1	RING	Item (104)	Retain
3	NUT	Item (71)	Discard

(d) Remove the LH and RH recirculation filters (FIN 4012HM and FIN 4013HM) for access, refer to Ref. AMM Task 21-21-41-000-001.

(e) Remove the mixer unit for access, refer to Ref. AMM Task 21-21-43-000-001.

(f) Remove the potable water tank (FIN 3000MM) for access, refer to Ref. AMM Task 38-11-41-000-001.

(g) Remove the air conditioning distribution ducts for access, refer to Ref. AMM Task 21-20-00-010-001.

(h) Remove check valve (FIN 4205MM) for access, refer to Ref. AMM Task 38-41-41-000-001.

(i) Remove the air filter (FIN 4210MM) for access, refer to Ref. AMM Task 38-41-42-000-001.

(j) Remove the pressure reducing valve (FIN 4200MM) for access, refer to Ref. AMM Task 38-41-43-000-001.

(k) Remove the shuttle valve (FIN 4215MM) for access, refer to Ref. AMM Task 38-41-44-000-001.

(l) If installed, remove the pressure switch (FIN 10MD) for access, refer to Ref. AMM Task 38-42-16-000-001.

(m) If installed, remove the air filter (FIN 4212MM) for access, refer to Ref. AMM Task 38-42-42-000-001.

(n) If installed, remove the check valve (FIN 4206MM) for access, refer to Ref. AMM Task 38-42-43-000-001.

(o) Remove the trim air valves (FIN 11HK, FIN 12HK and FIN 13HK) for access, refer to Ref. AMM Task 21-63-51-000-001.

(p) Remove the pressure regulating valve (FIN 14HK) for access, refer to Ref. AMM Task 21-63-52-000-001.

(q) Remove the insulated hot air collector between Frame 35 and Frame 36, refer to Ref. Fig. Removal of the Hot Air Collector at FR36.

1 Disconnect the insulated hot air collector from the control tube.

1	O-RING	Item (118)	Discard
1	ADAPTER	Item (119)	Retain

2 Disconnect the connector from the pressure switch (FIN 26HK).

1	CONNECTOR	Item (120)	Retain

3 Disconnect the insulated hot air collector from the flange.

1	CLAMP	Item (115)	Retain
1	SEAL	Item (114)	Discard

4 Remove the hot air collector.

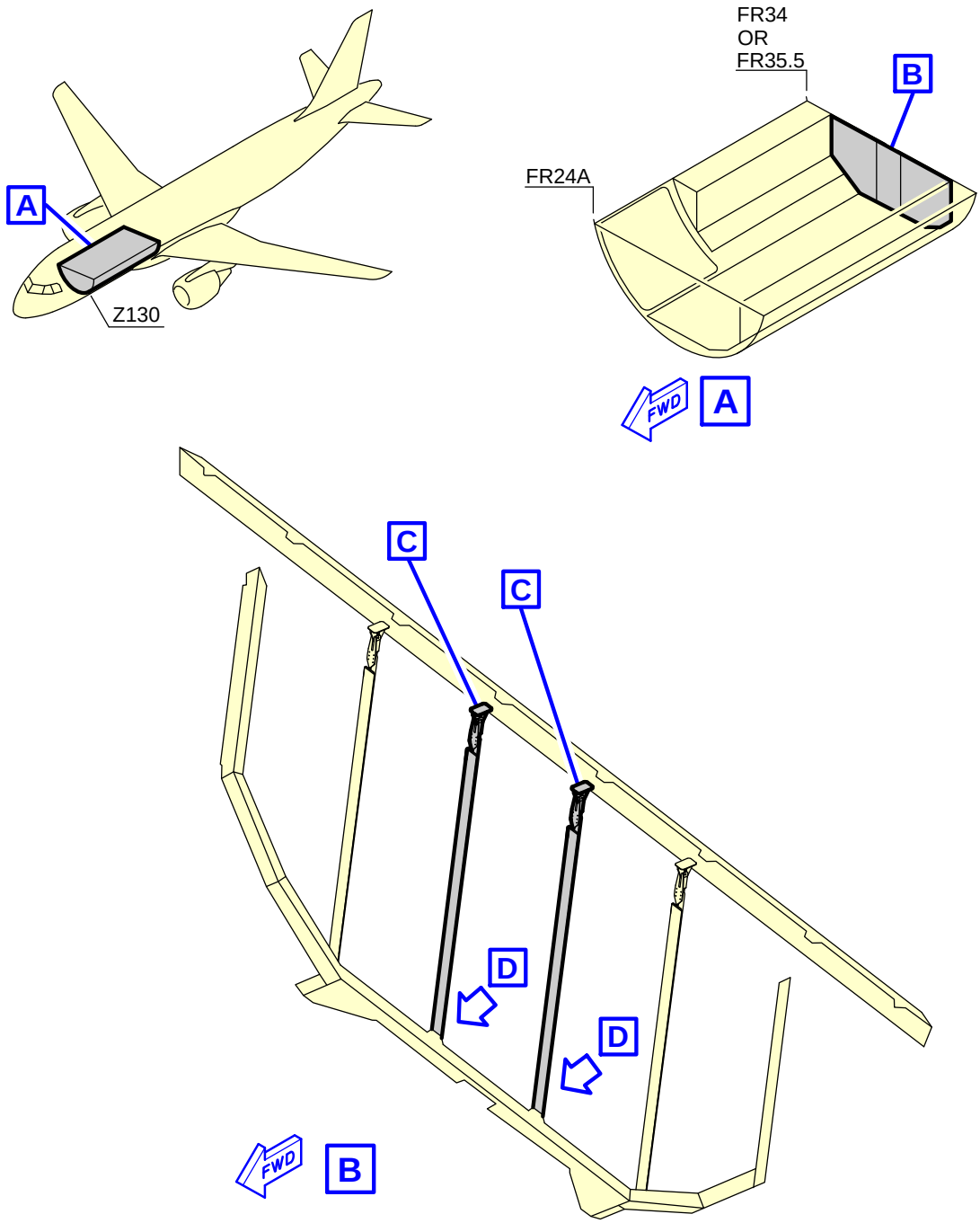
1	HOT AIR COLLECTOR	Item (110)	Retain

(r) If installed, remove the compressor (FIN 8MD) for access, refer to Ref. AMM Task 38-42-51-000-001.

(s) Remove for access the electrical wiring between Frame 35 and Frame 36 on horizontal bulkhead without disconnection, push aside and protect.

(t) Remove the insulation blankets around the work areas between Frame 35 and Frame 36 for access, refer to Ref. AMM Task 25-80-00-000-001.

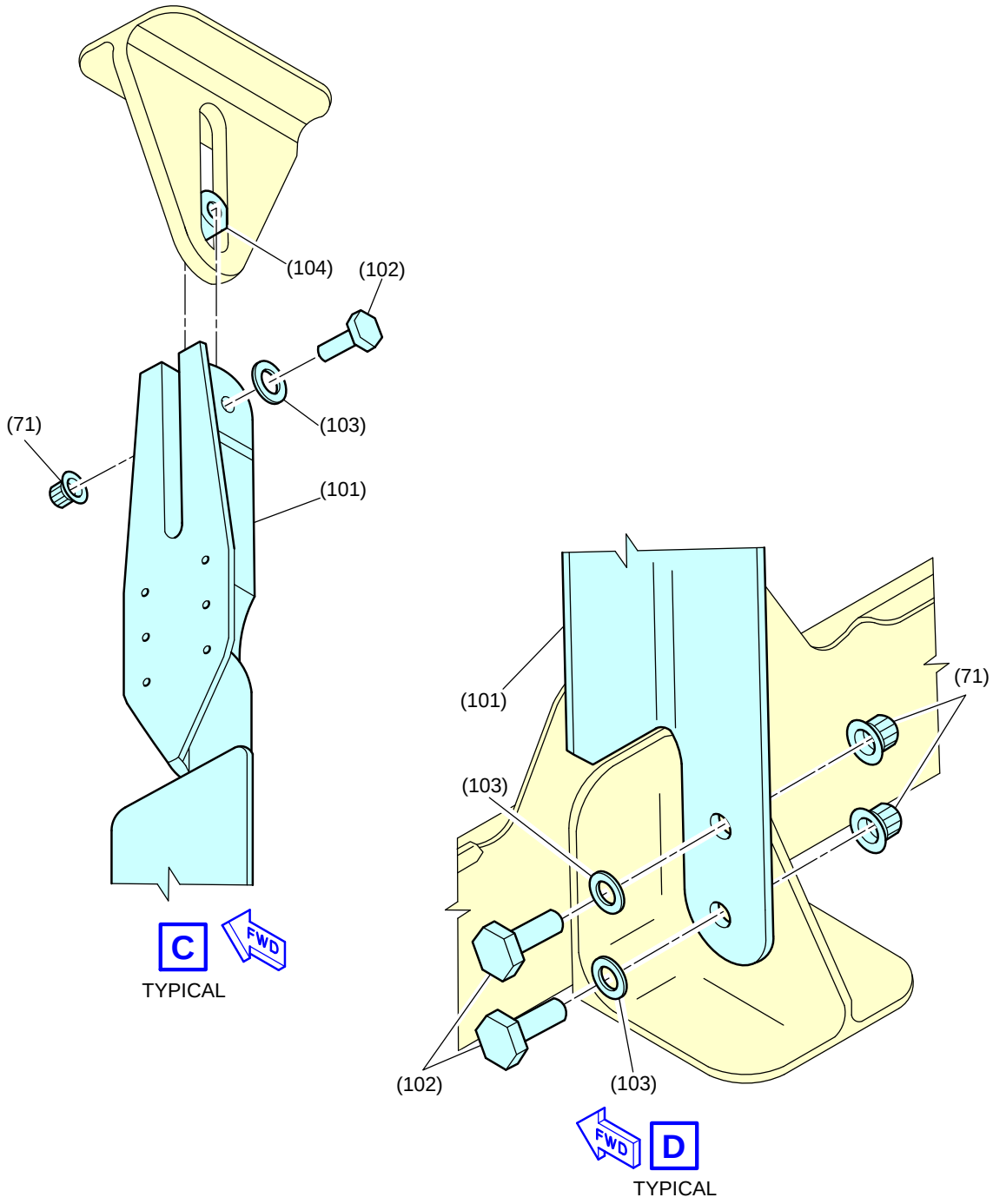
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO3-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO3-A-003-01 SHEET 1/2

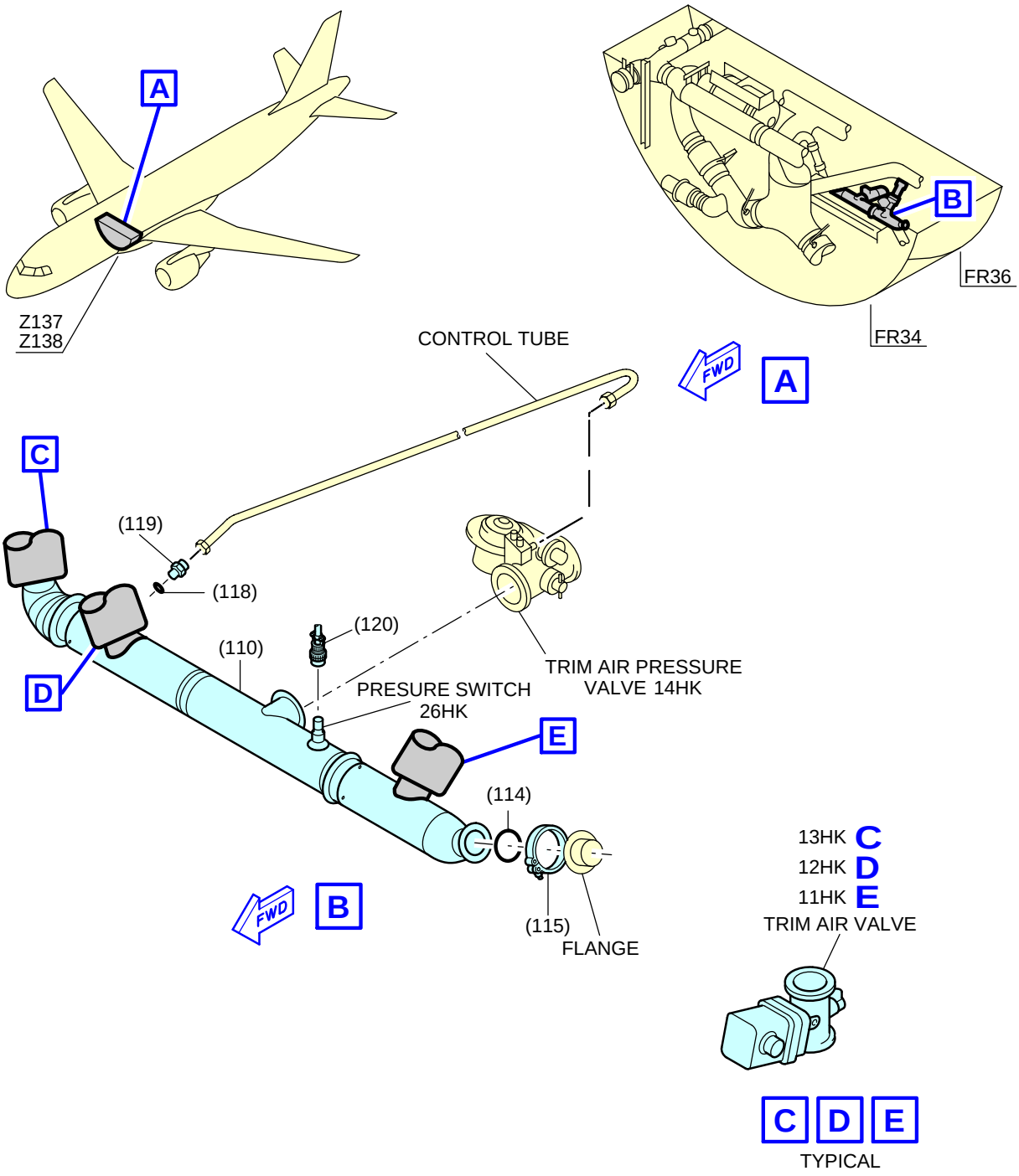
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO4-A-002-01 SHEET 2/2

CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO2-A-004-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO2-A-004-01 SHEET 1/1

(5) Task A320-A-57-XX-1228-22001-520A-A - If Installed, Remove the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	From Frame 35 to Frame 37

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	1
Elapsed Time	1.00 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

4 Tag all the parts you must remove and retain to make the subsequent installation easier.

5 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) If installed, remove the bridge bracket for access, refer to Ref. Fig. Depending of the Aircraft Configuration, Removal of the Bridge of the Inerting System between FR36 and FR38 and between Y254 and Y-254.

1 Disconnect the inerting system clamp at Frame 36 between Y254 and Y–254.

2	BOLT	Item (91)	Retain
2	WASHER	Item (87)	Retain
1	CLAMP	Item (93)	Retain

2 Disconnect the bonding lead at Frame 36 between Y254 and Y–254.

1	BOLT	Item (92)	Retain
1	WASHER	Item (87)	Retain

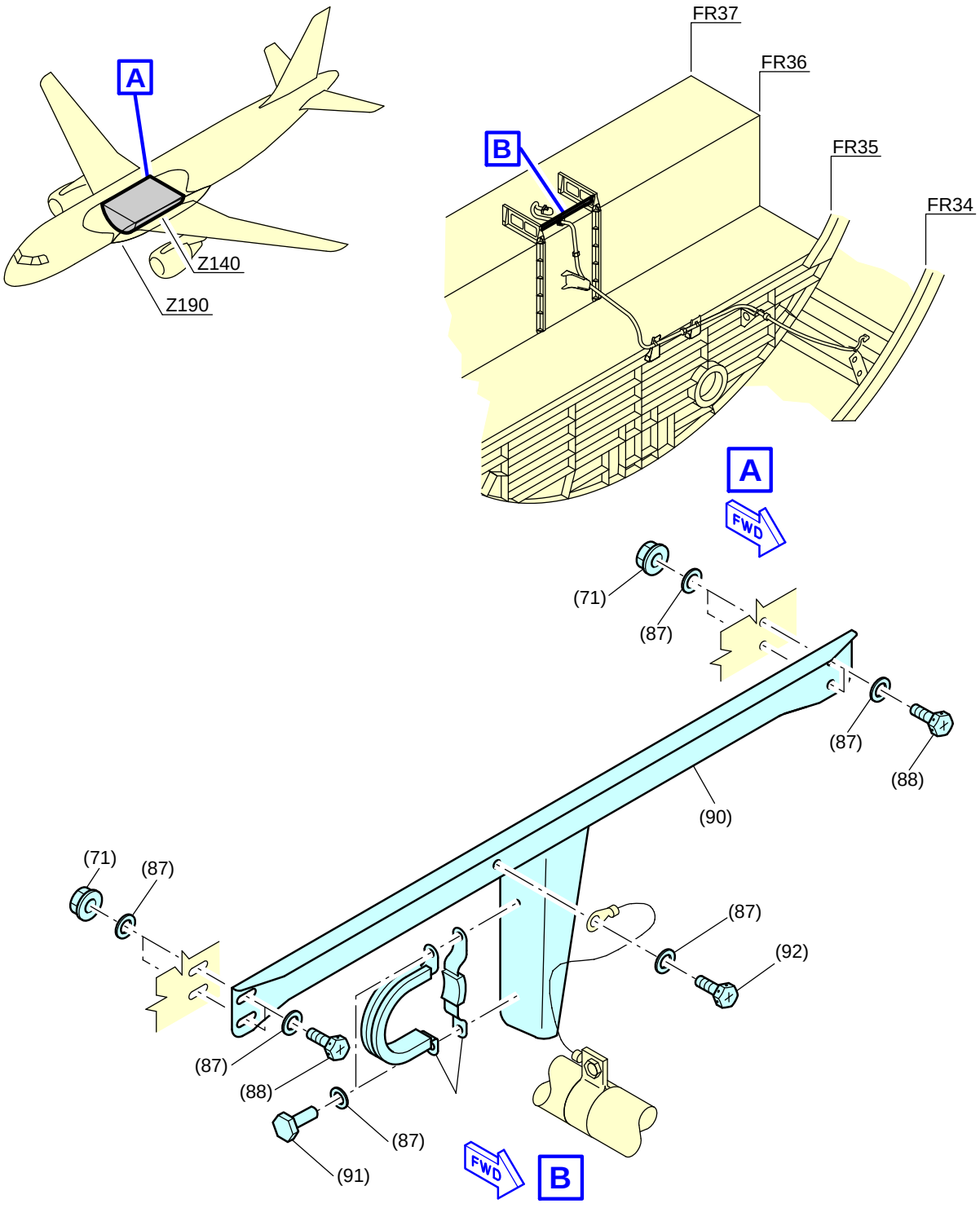
3 Protect the inerting system between Frame 35 and between Frame 37 on the horizontal bulkhead without disconnection.

NOTE: Push the inerting system aside as necessary during the modification.

4 Remove the bridge bracket at Frame 36.

1	BRIDGE BRACKET	Item (90)	Retain
4	SCREW	Item (88)	Retain
8	WASHER	Item (87)	Retain
4	NUT SELF LOCKING	Item (71)	Discard

CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KO1-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KO1-A-003-01 SHEET 1/1
Depending of the Aircraft Configuration, Removal of the Bridge of the Inerting System between FR36 and FR38 and between Y254 and Y-254

(6) Task A320-A-57-XX-1228-23001-520A-A - If Installed, Remove the Additional Center Tank No.4

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
130	

Manpower/Resources/Skills

Man-hours	2.00 h
Minimum Number of person	2
Elapsed Time	1.00 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 28-11-27-000-005

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

(b) If installed, remove the Additional Center Tank No.4 (ACT4) for access, refer to Ref. AMM Task 28-11-27-000-005.

(7) Task A320-A-57-XX-1228-24001-520A-A - If Installed, Remove the Additional Center Tank No.6

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
130	

Manpower/Resources/Skills

Man-hours	2.00 h
Minimum Number of person	2
Elapsed Time	1.00 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 28-11-27-000-007

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

(b) If installed, remove the Additional Center Tank No.6 (ACT6) for access, refer to Ref. AMM Task 28-11-27-000-007.

C. PROCEDURE

(1) Task A320-A-57-XX-1228-04001-520A-A - Remove the Strut Lower Attachment on Y1292 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

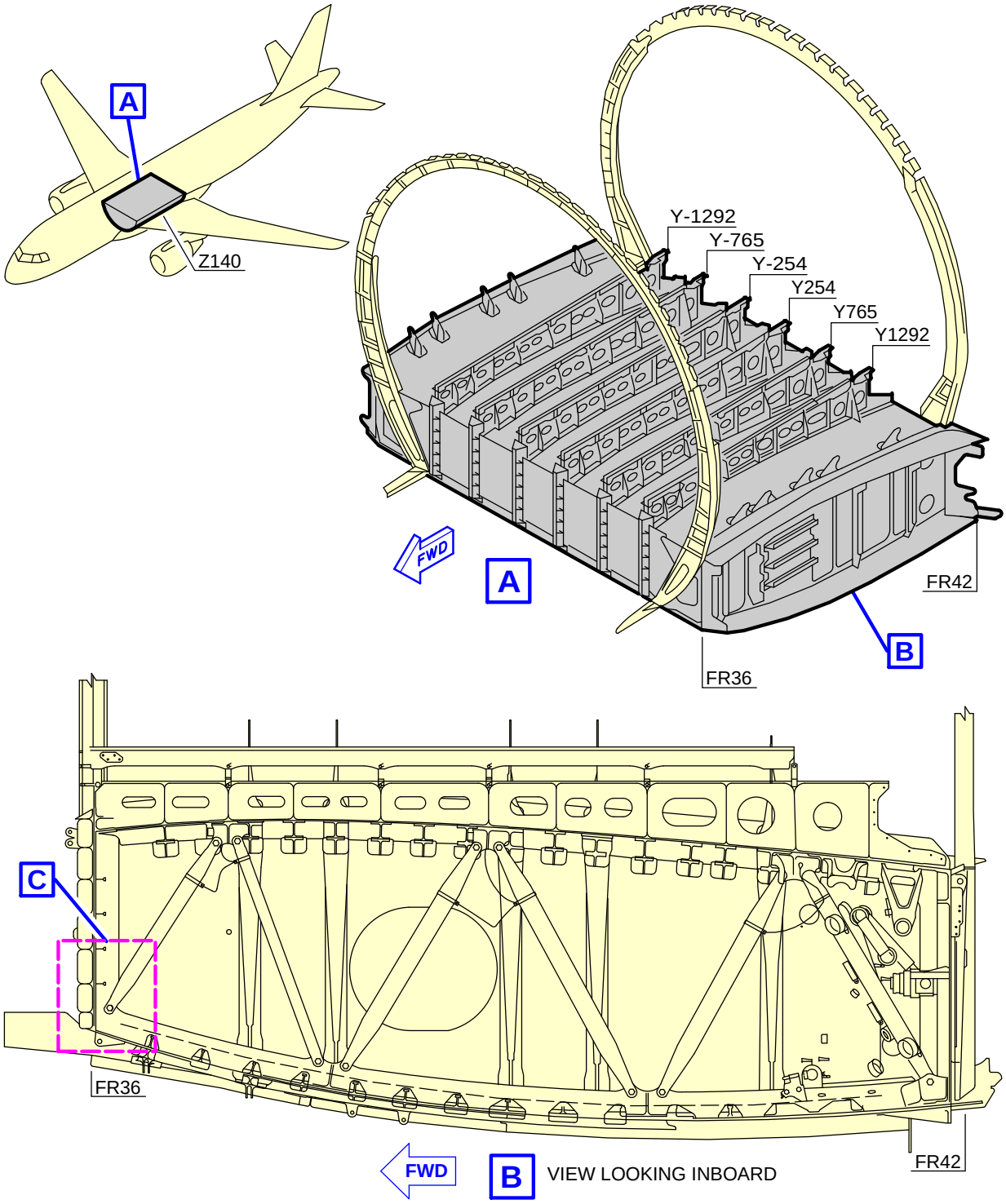
(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain
1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

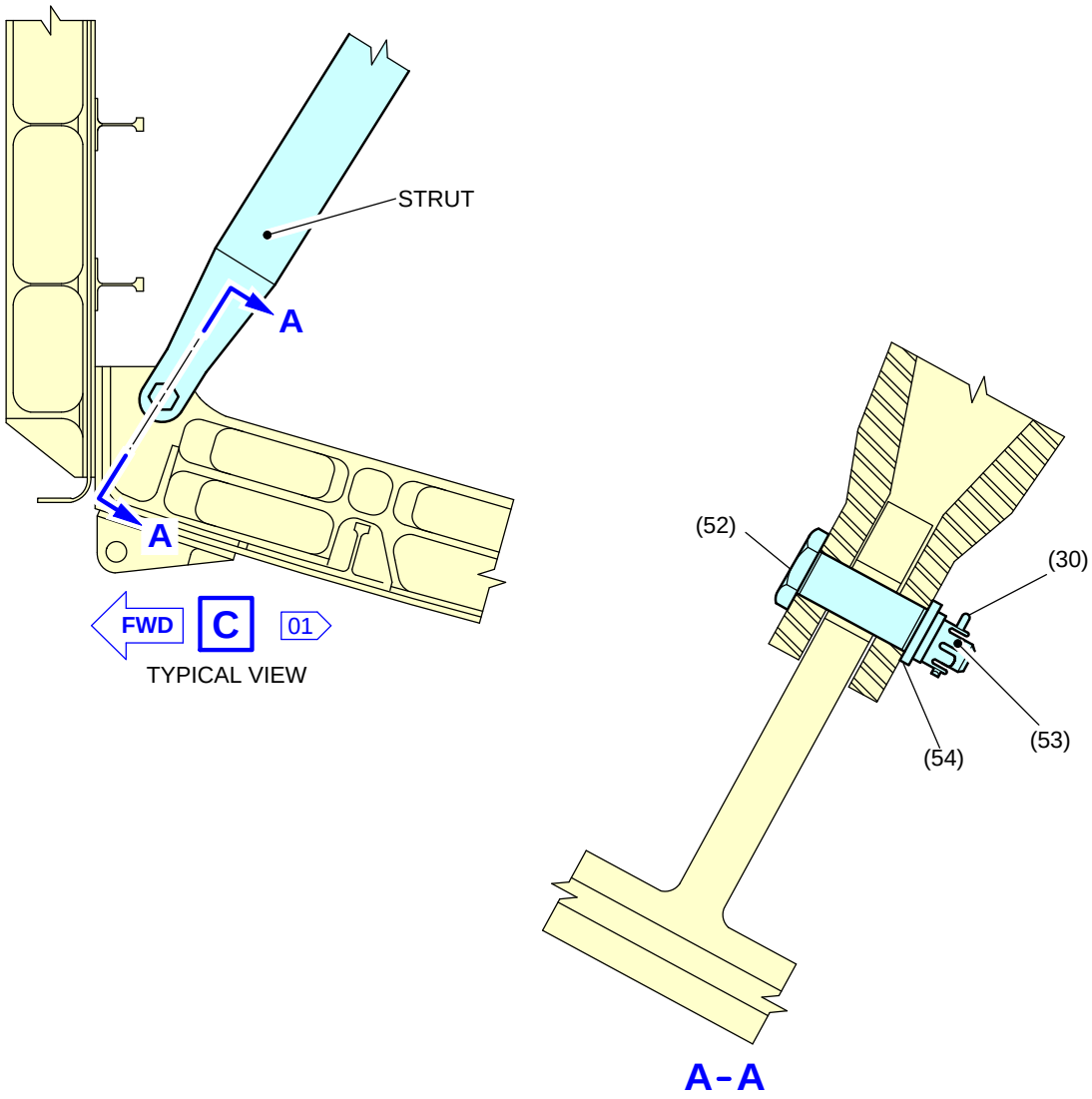
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(2) Task A320-A-57-XX-1228-05001-520A-A - Remove the Vertical Stringer on Y1292 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

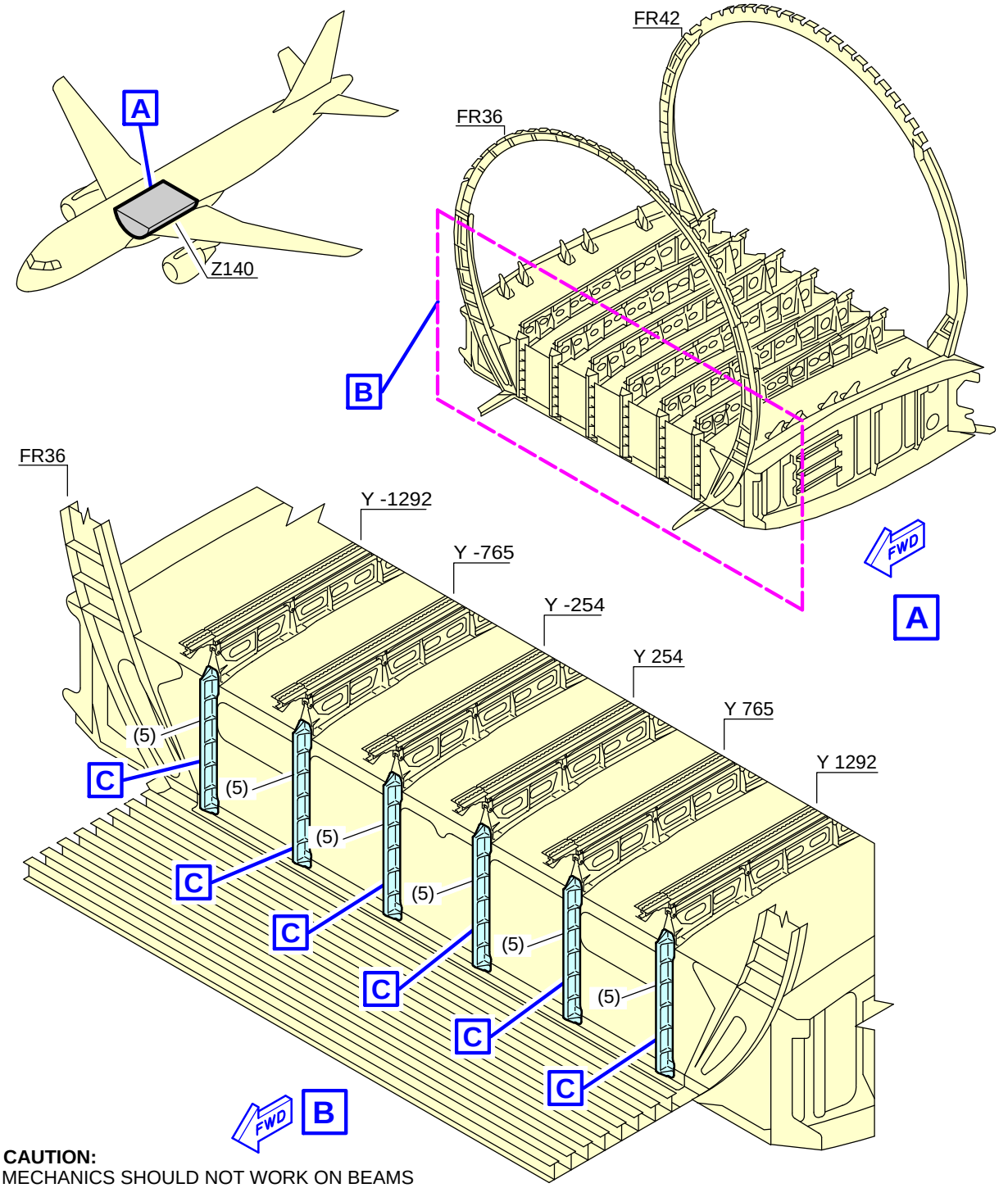
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-01ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

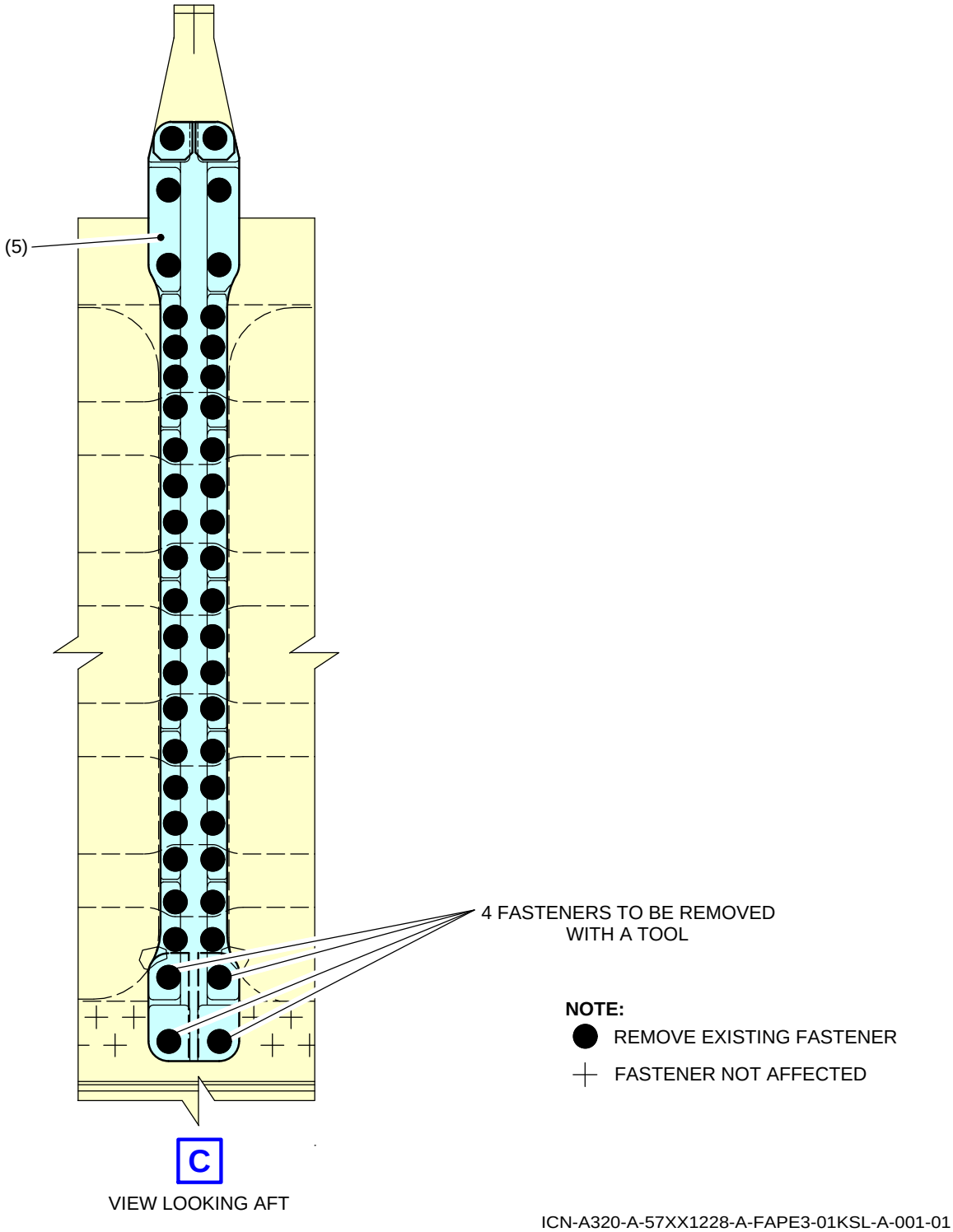


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

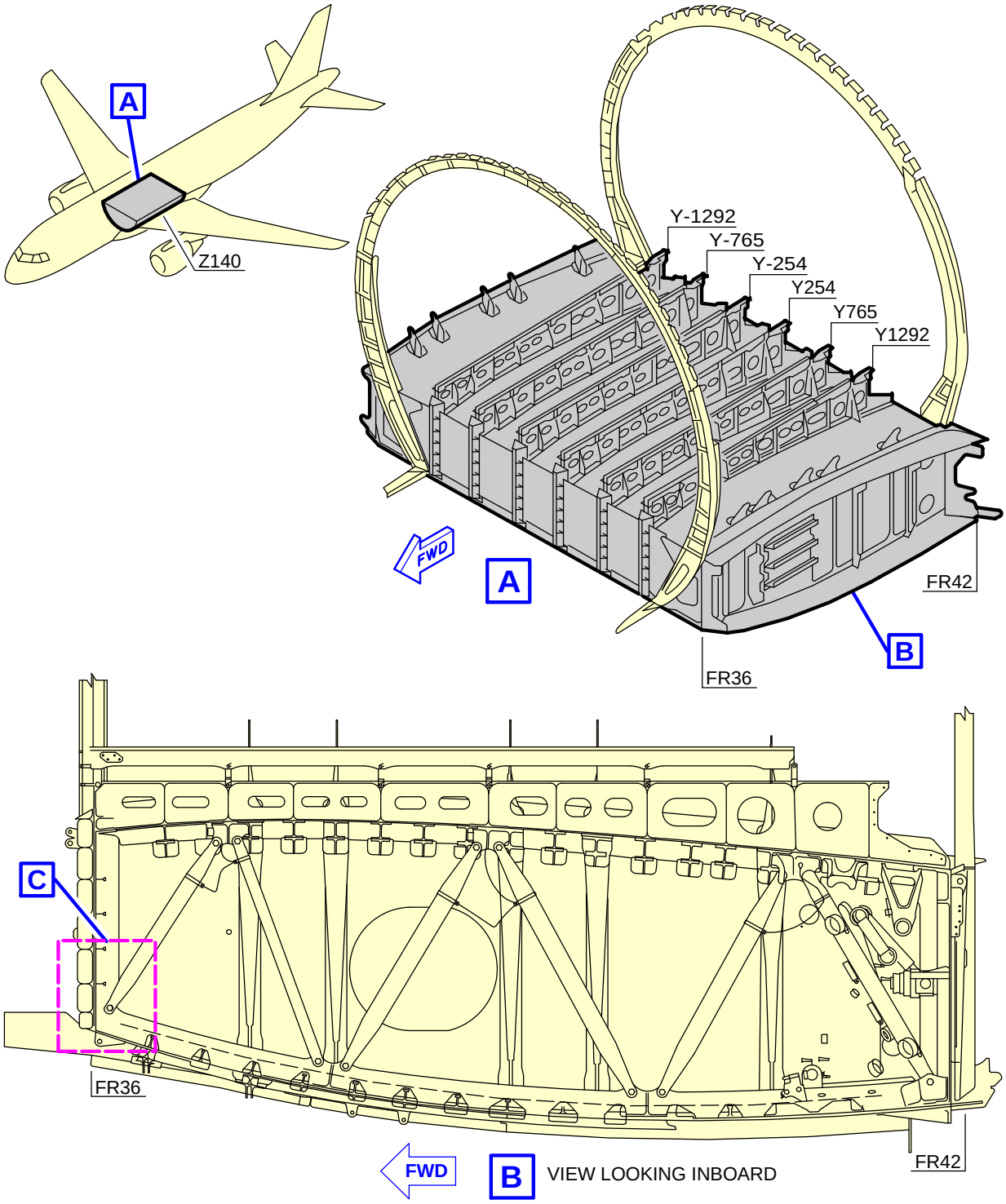
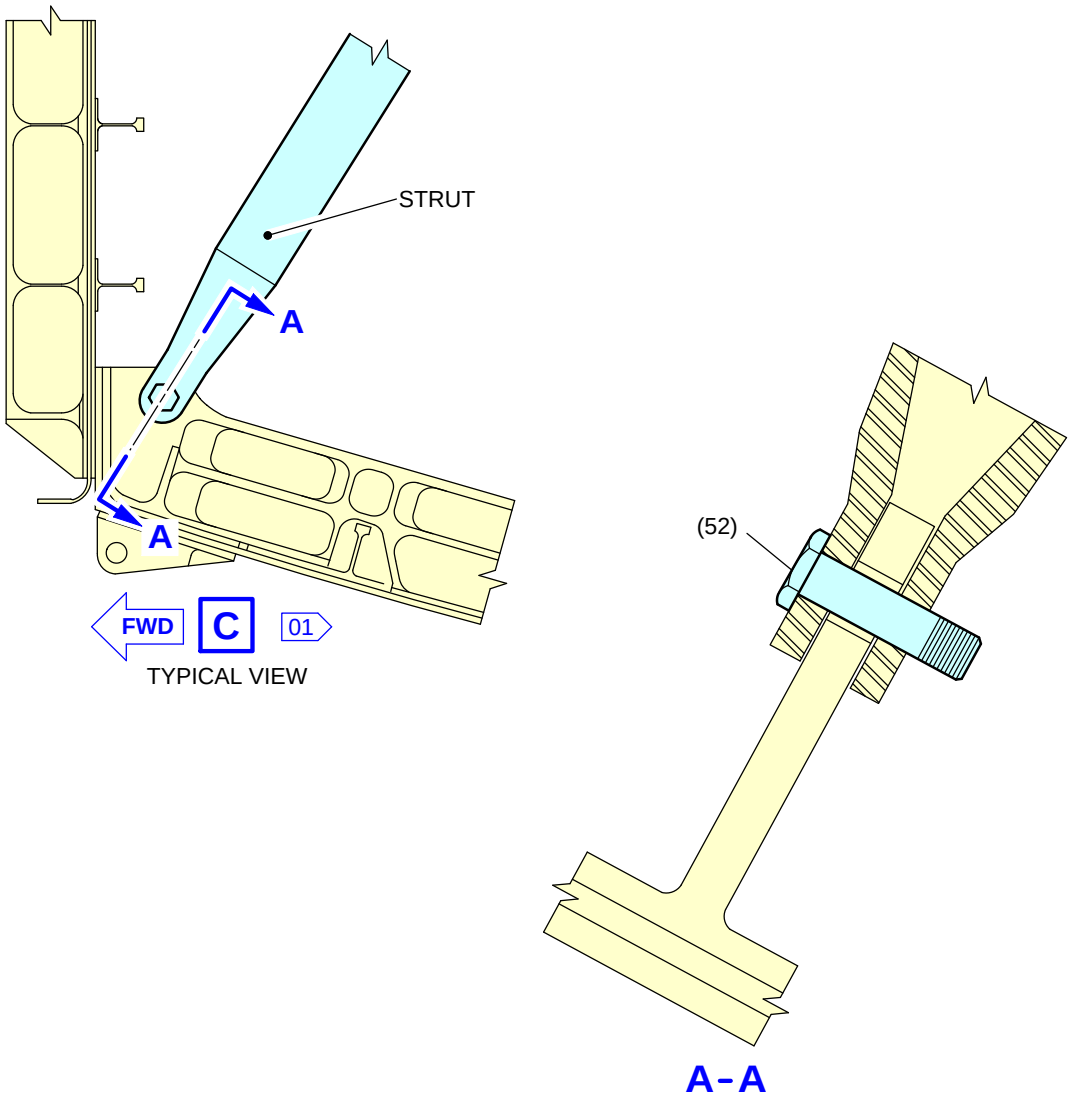


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(2) Task A320-A-57-XX-1228-05002-520A-A - Remove the Vertical Stringer on Y1292 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

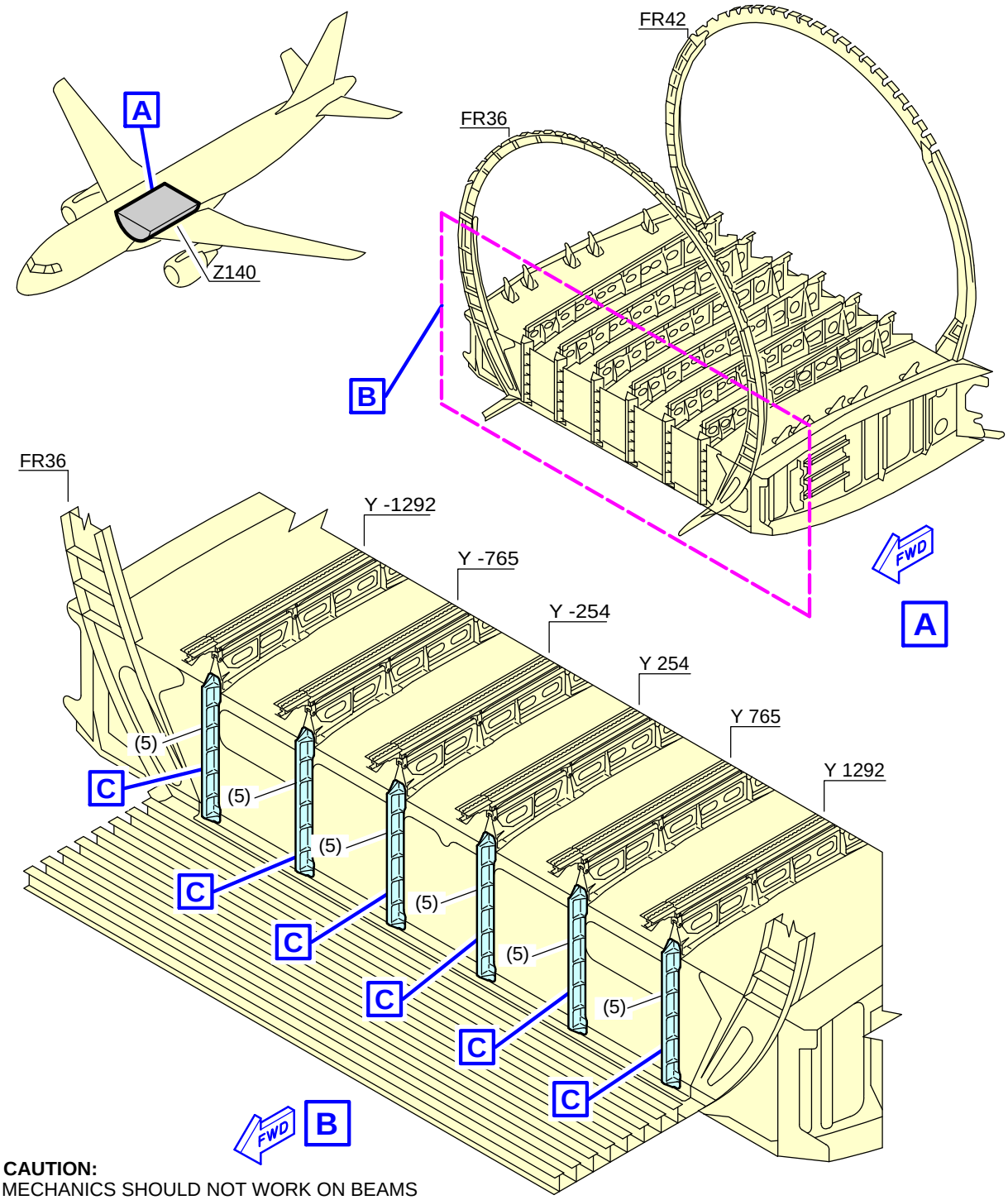
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-01ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

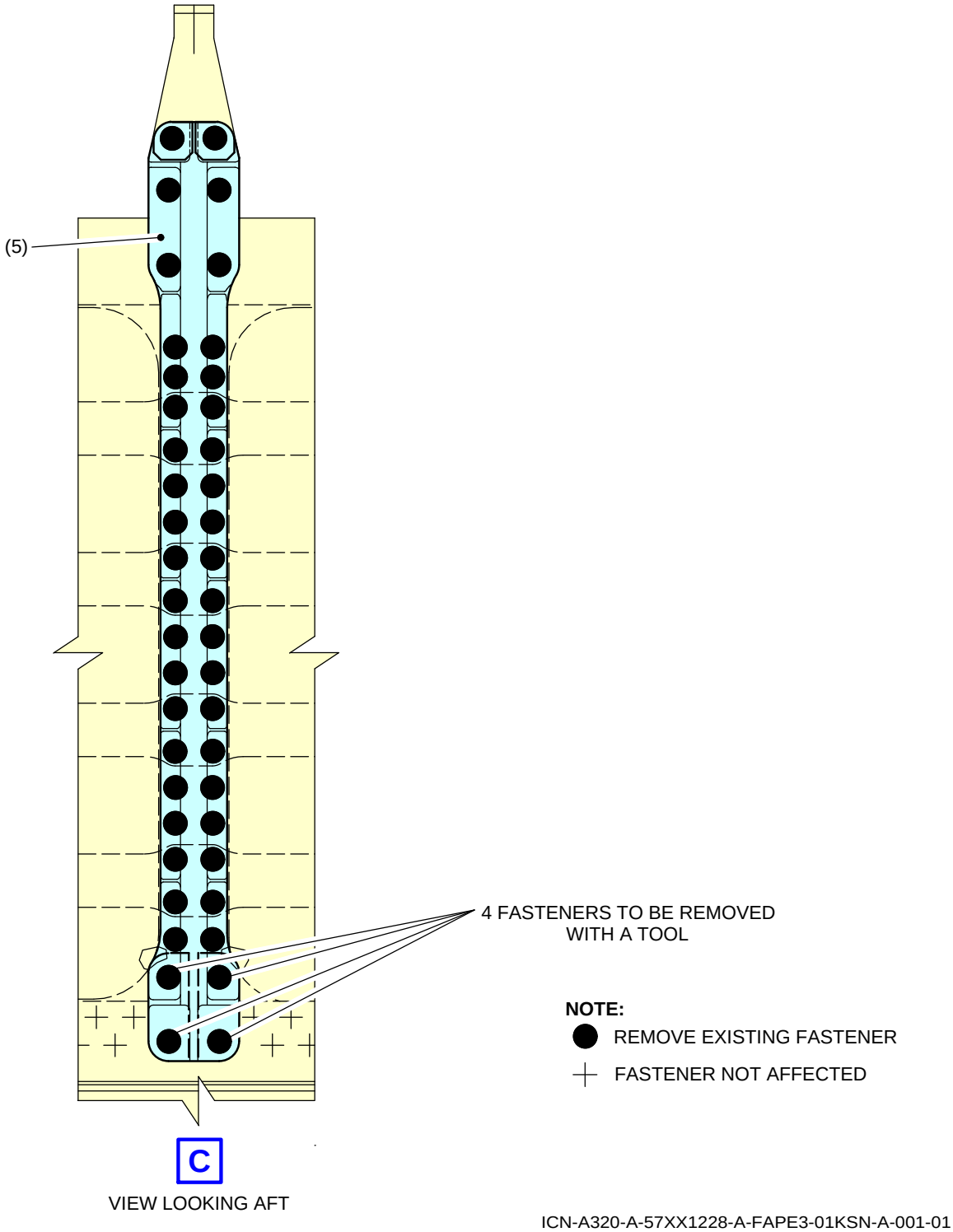
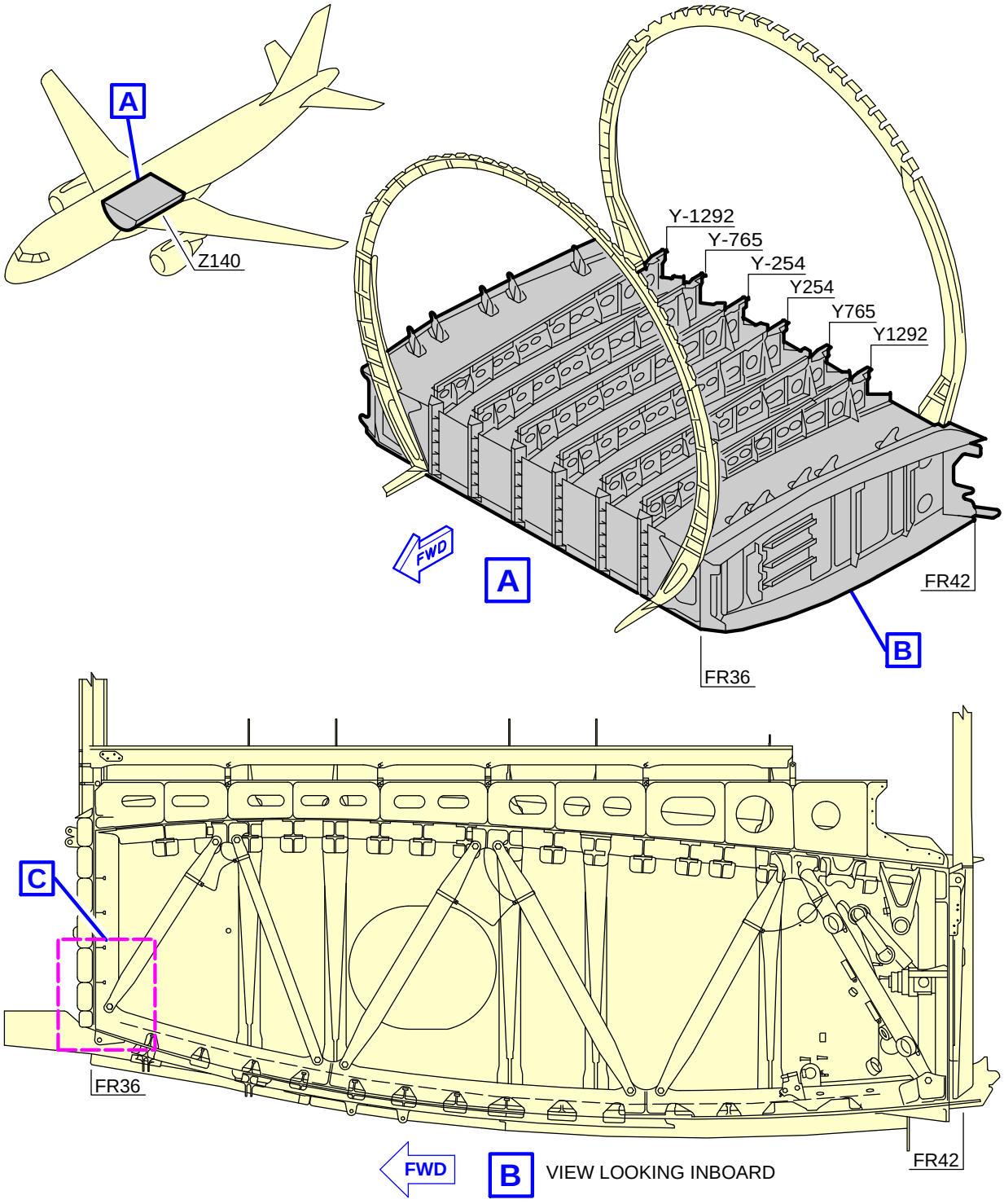


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

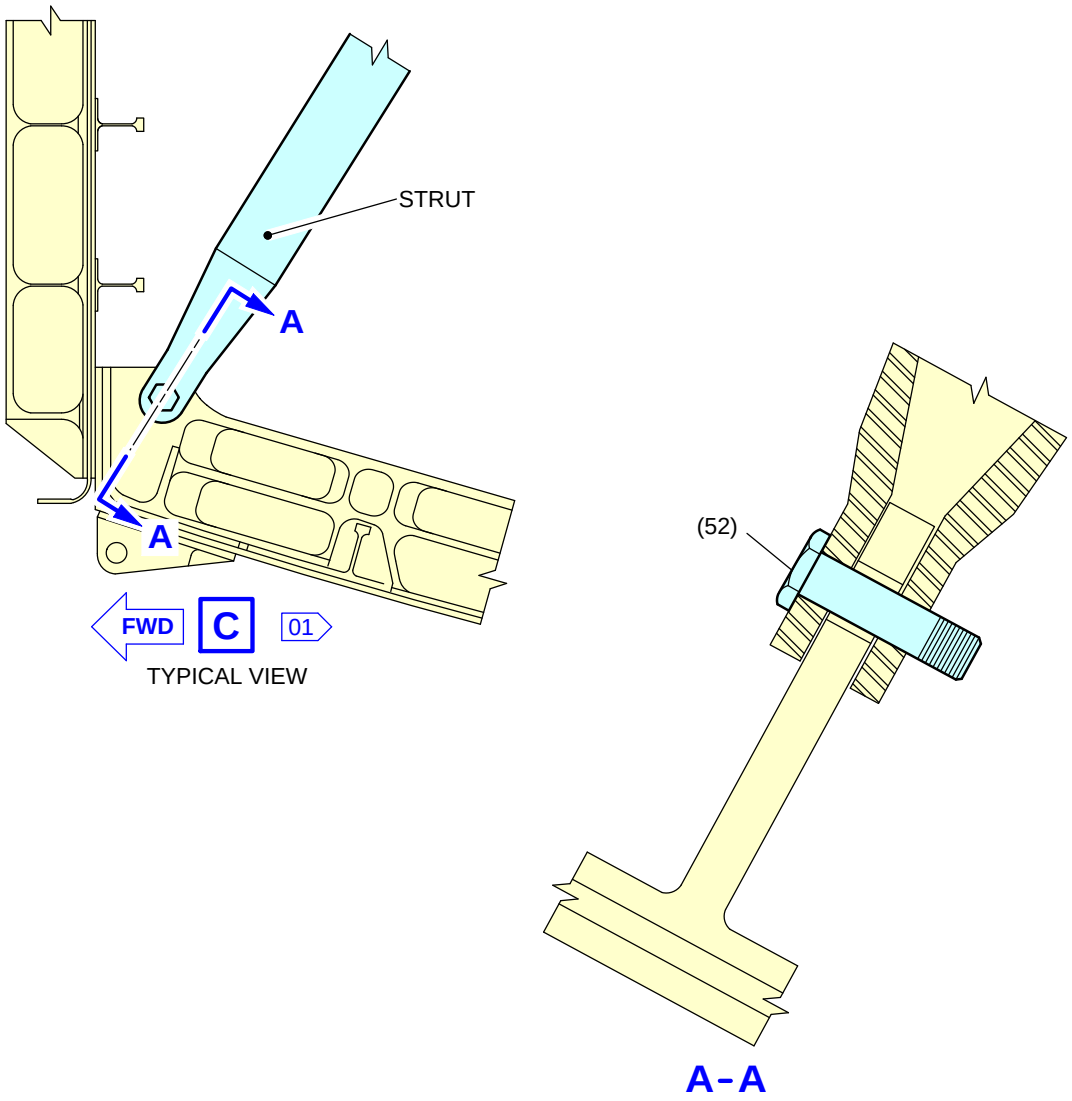
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(3) Task A320-A-57-XX-1228-01001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-01ZZZ-900Z-A.

CONF 001 003 004

(4) Task A320-A-57-XX-1228-01001-900A-A - Drill the New Vertical Stringer on Y1292 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

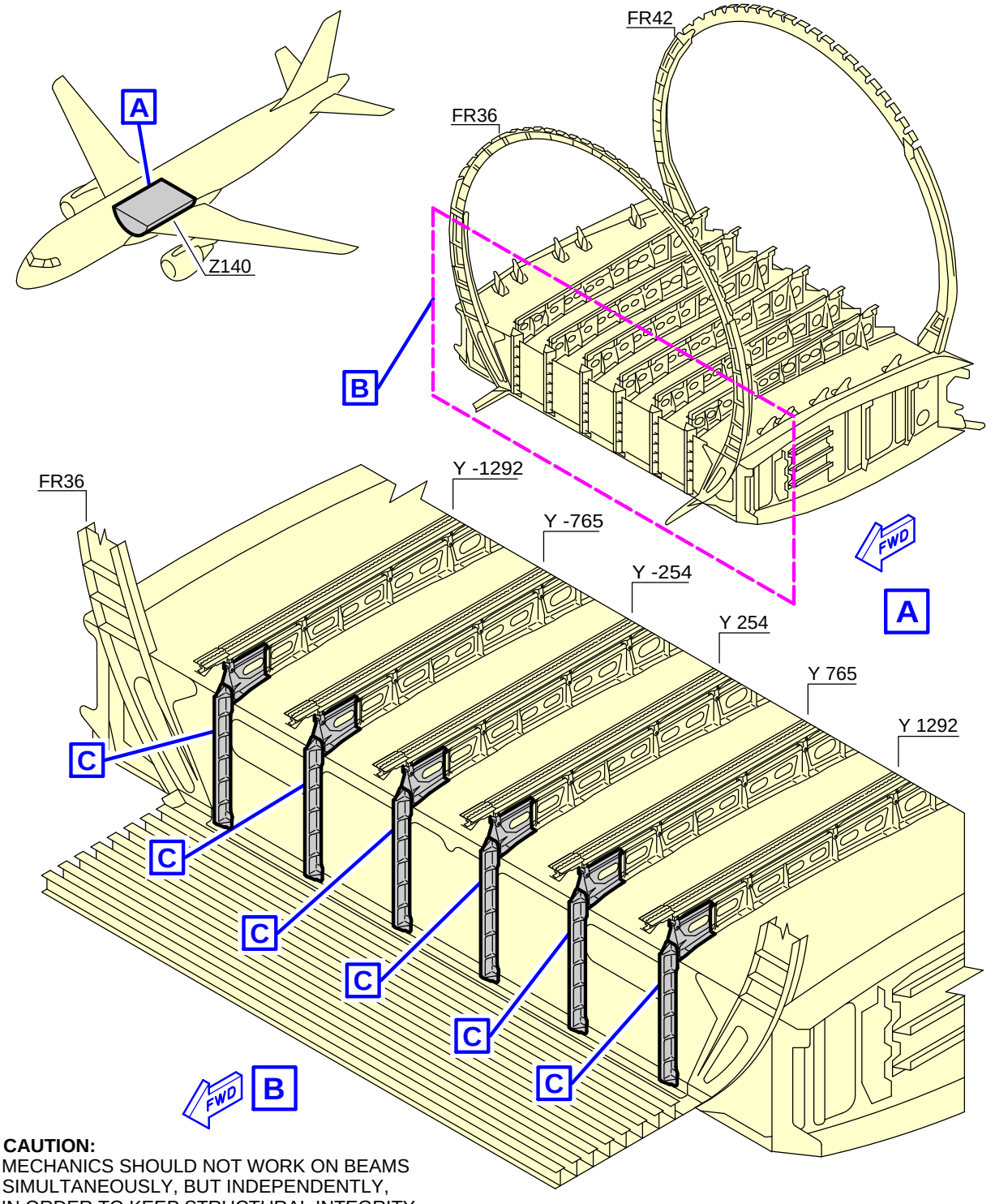
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 001 003 004

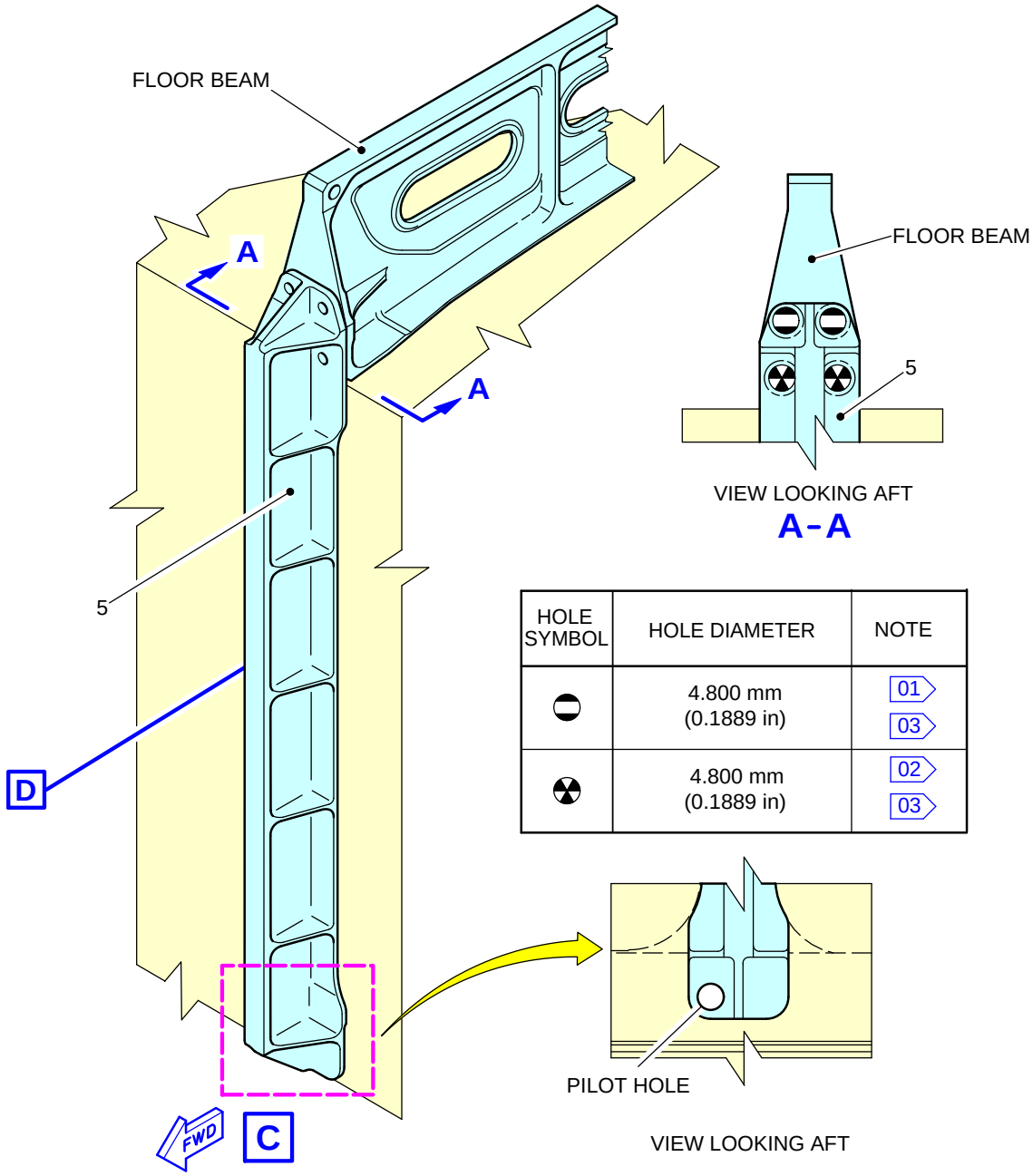


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

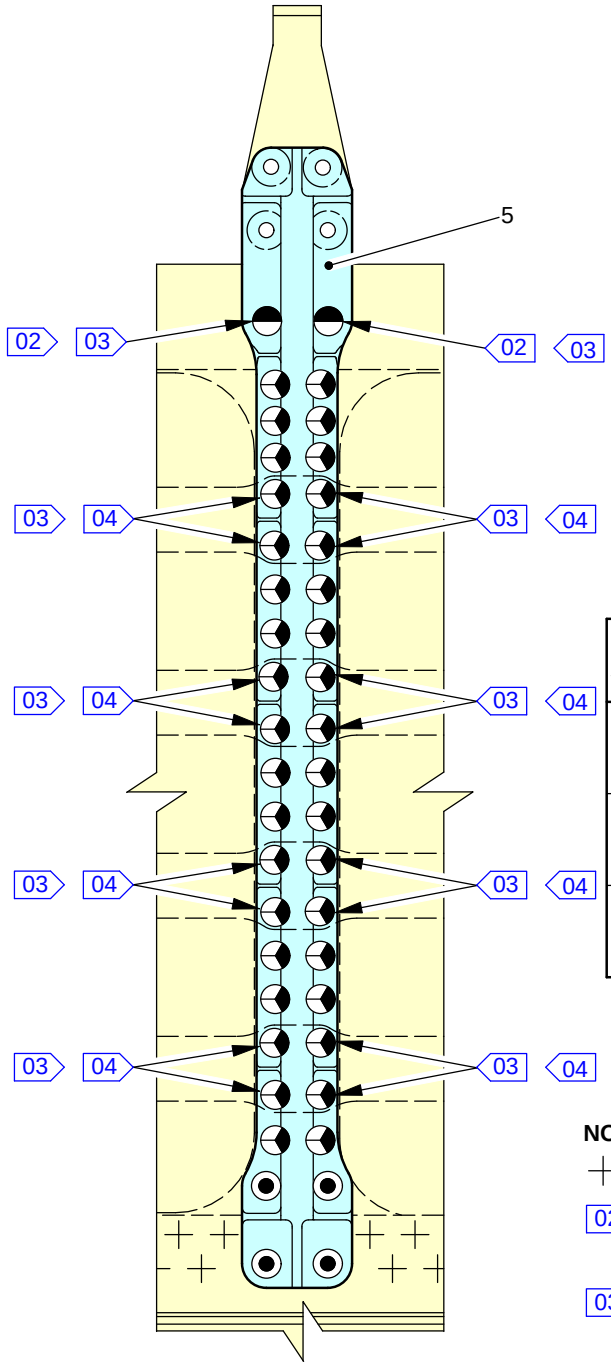
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

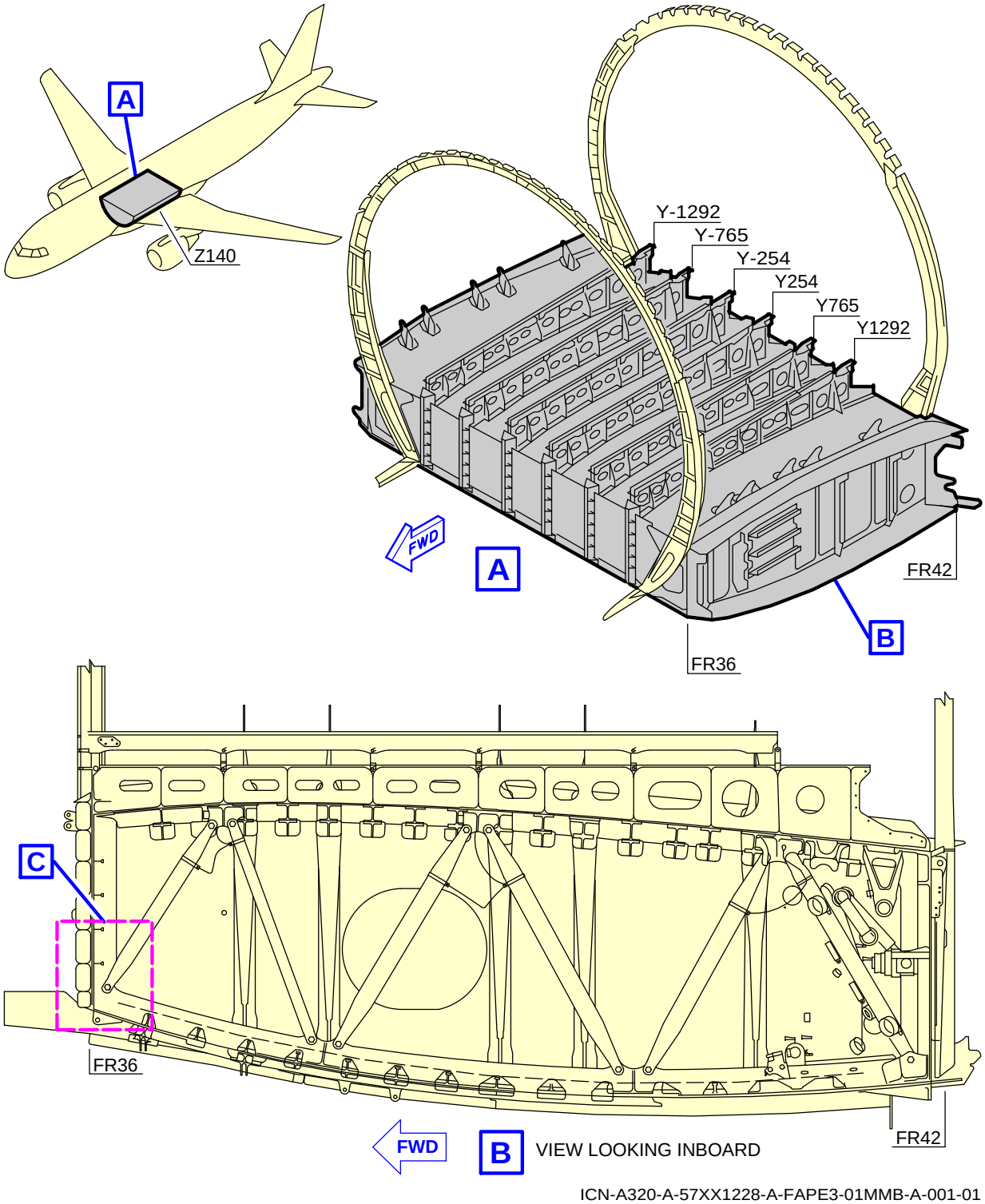
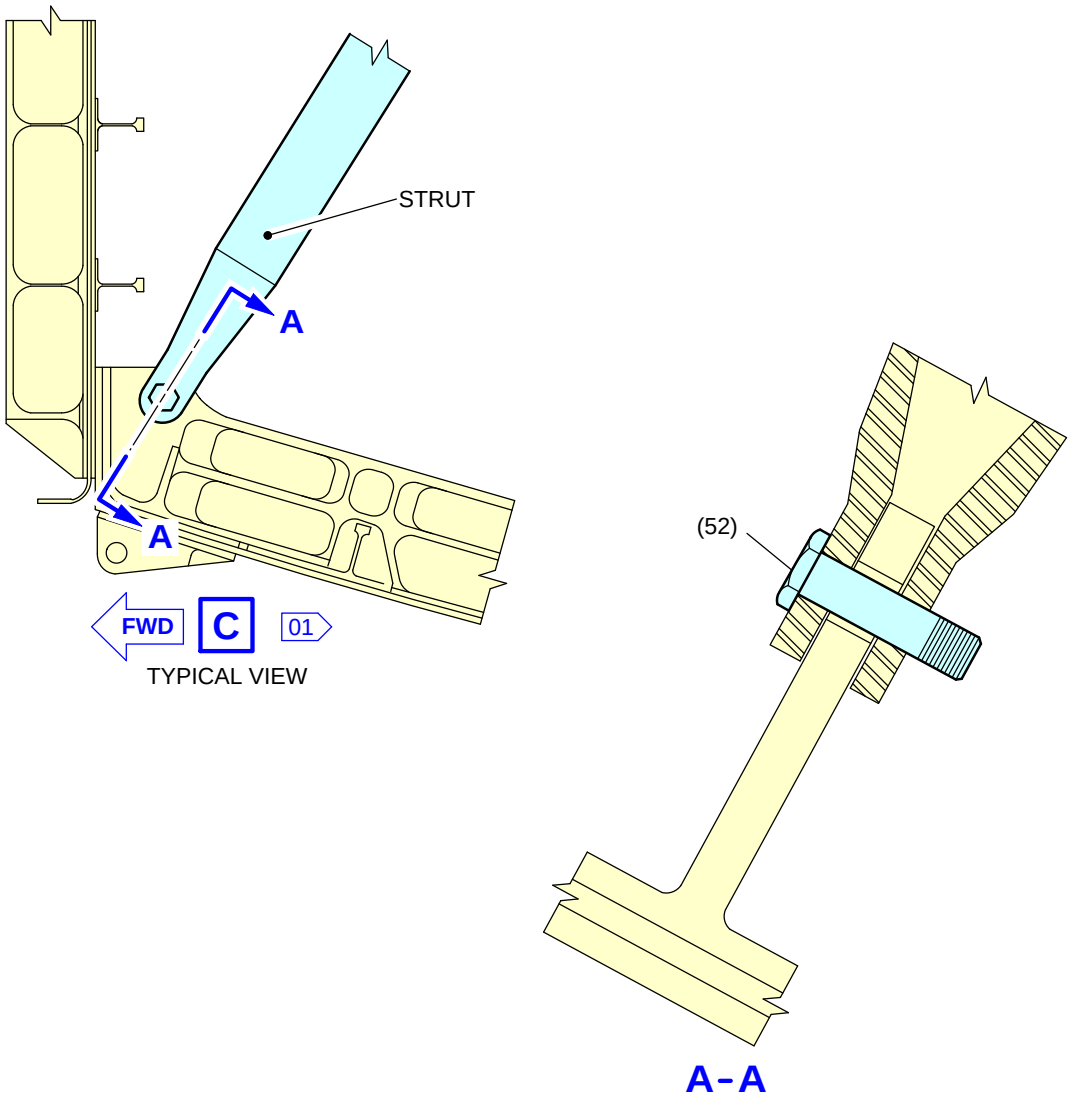


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(4) Task A320-A-57-XX-1228-01002-900A-A - Drill the New Vertical Stringer on Y1292 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

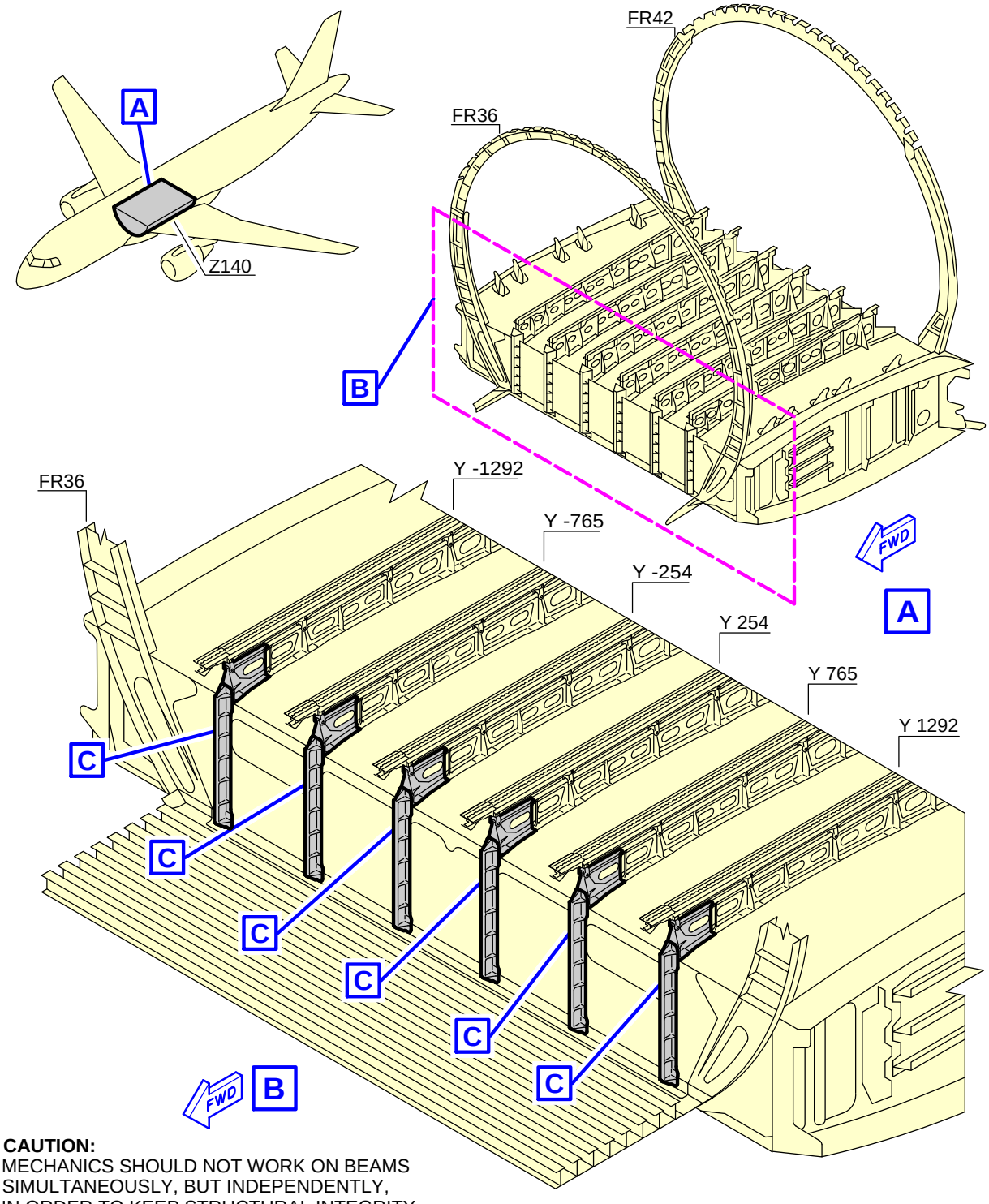
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

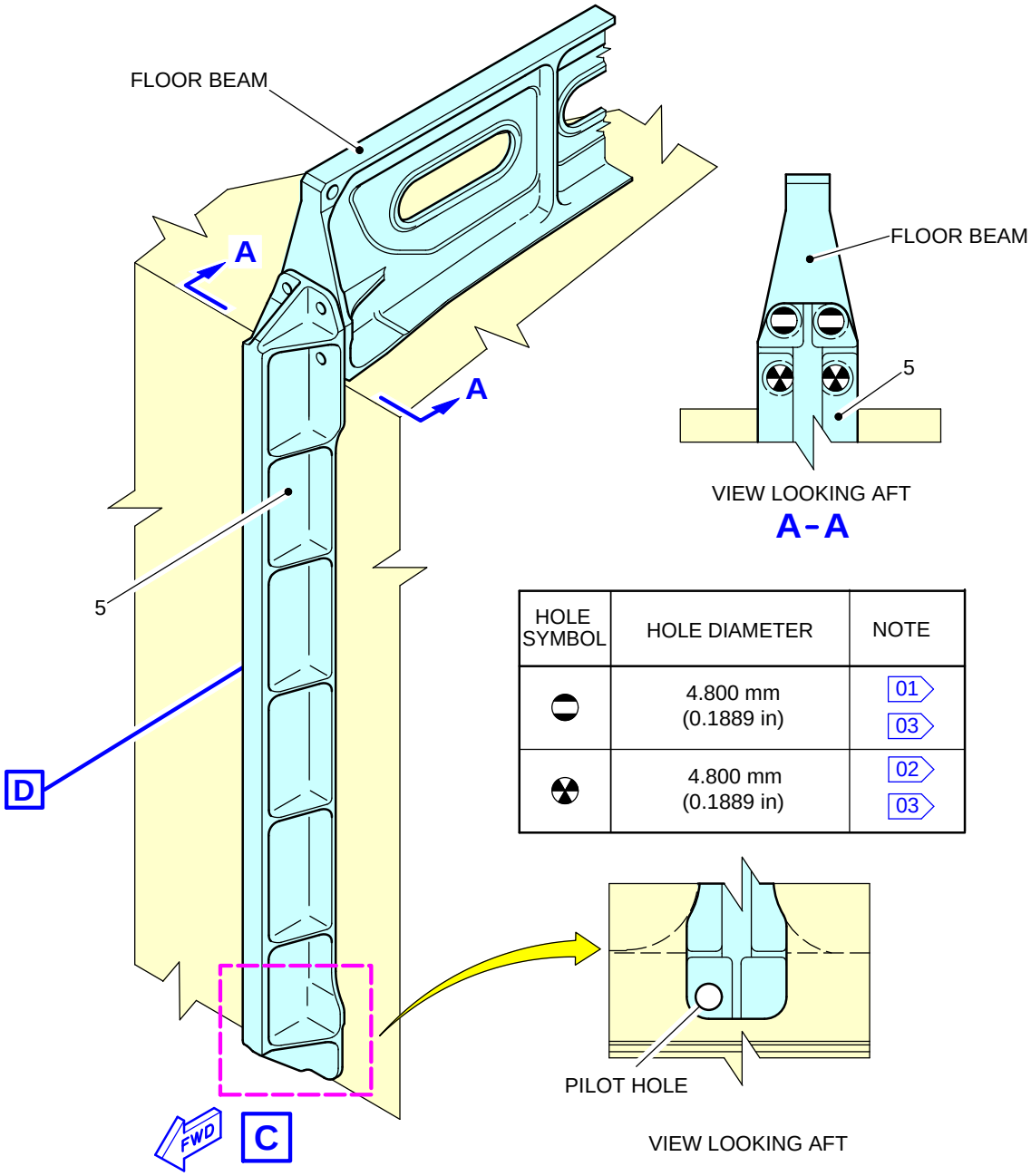


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

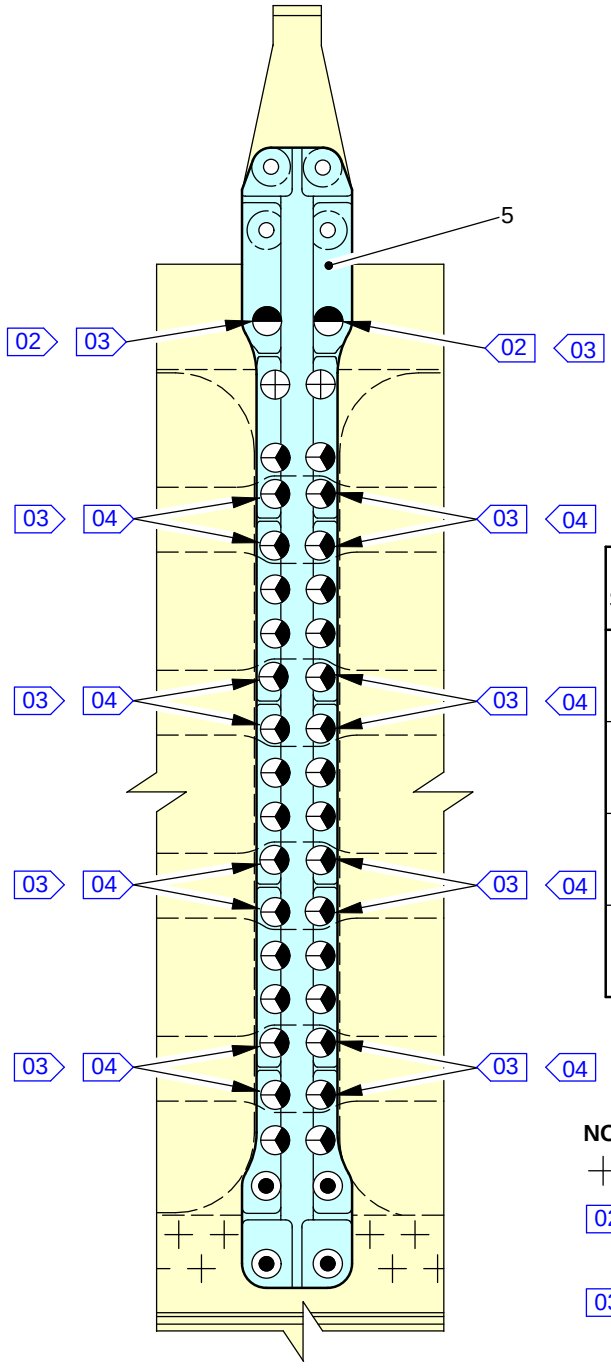
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

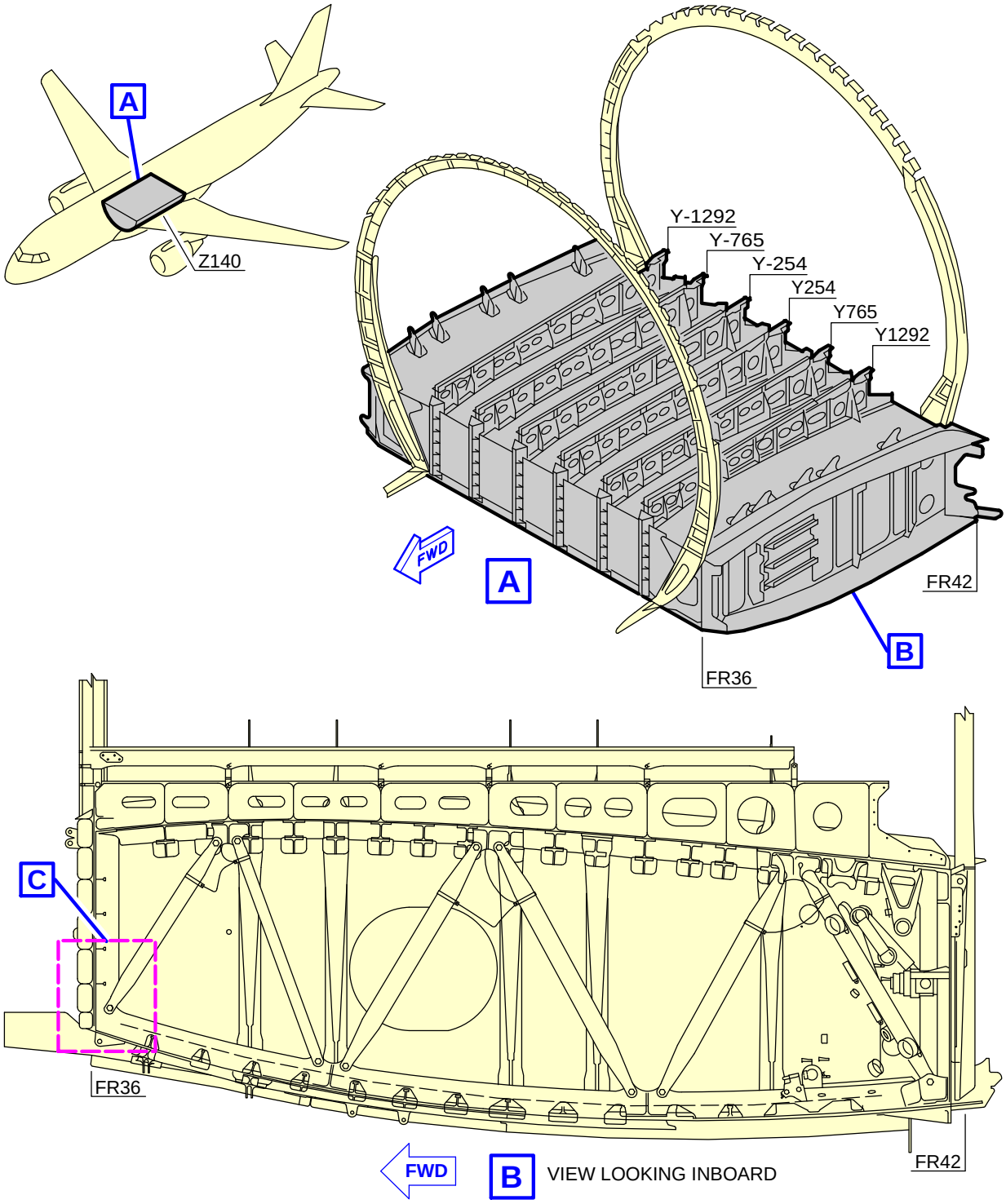
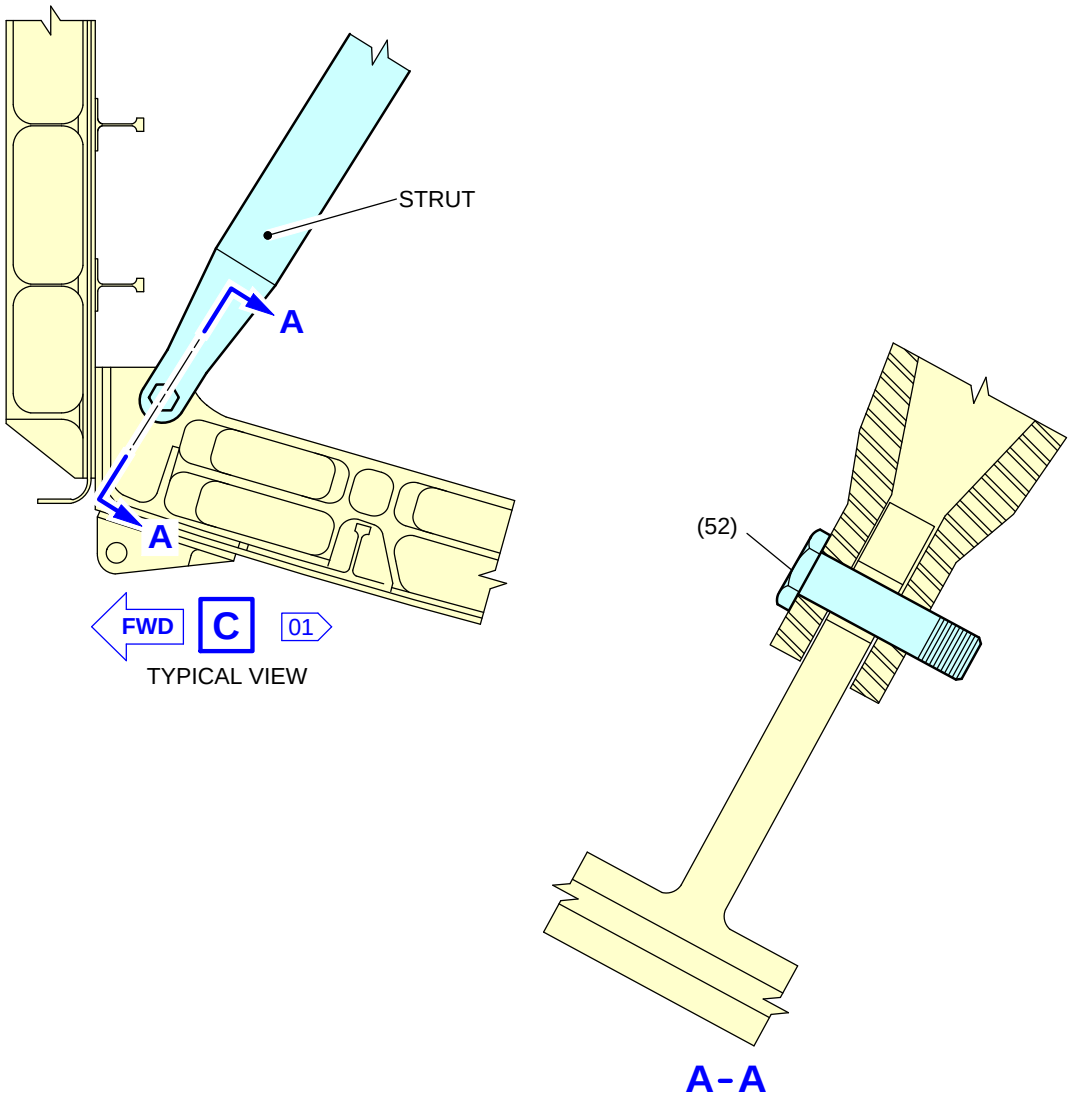


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(5) Task A320-A-57-XX-1228-01001-720A-A - Install the New Vertical Stringer on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001

Manuals/Drawings	References/Sheets
	06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

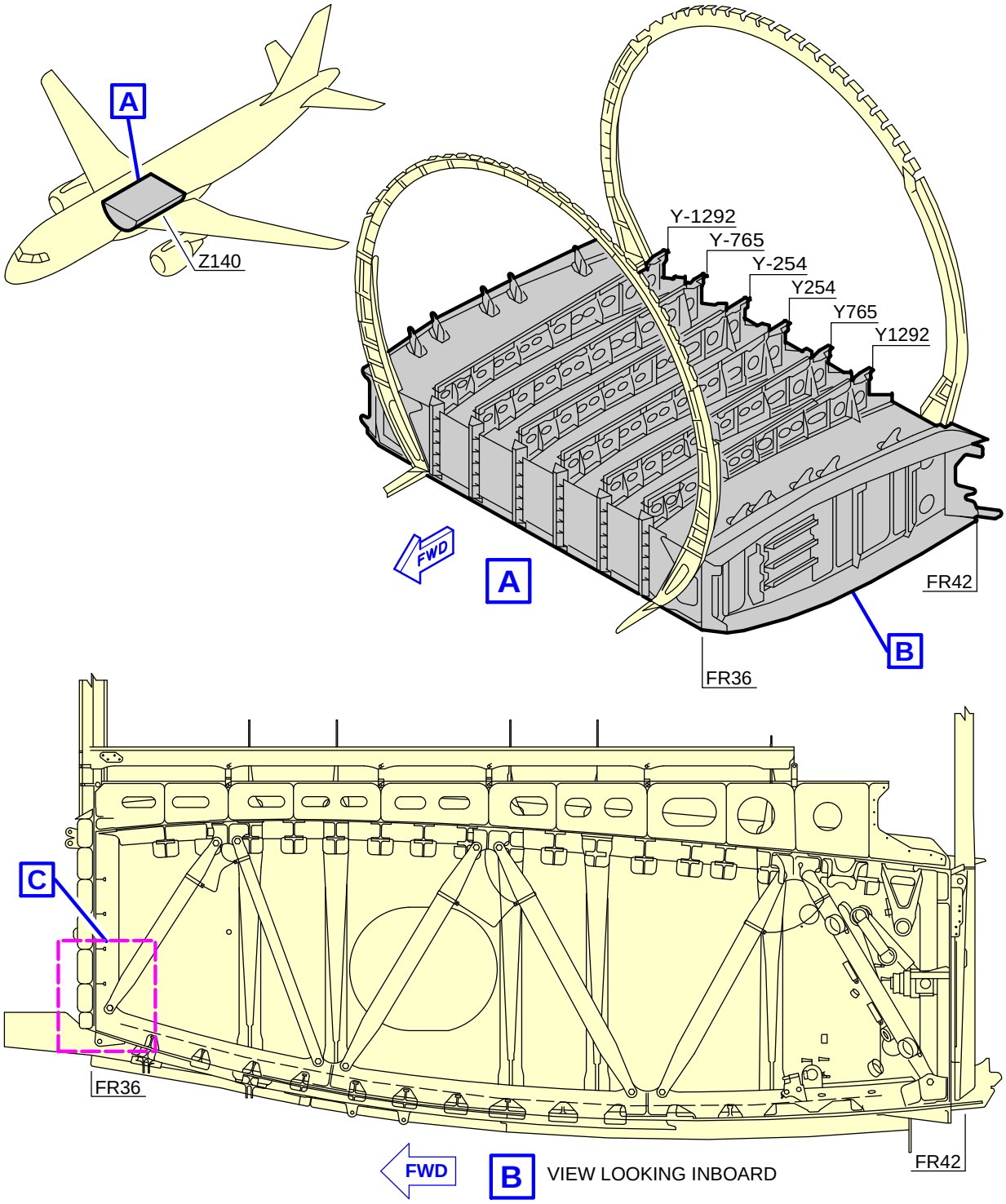
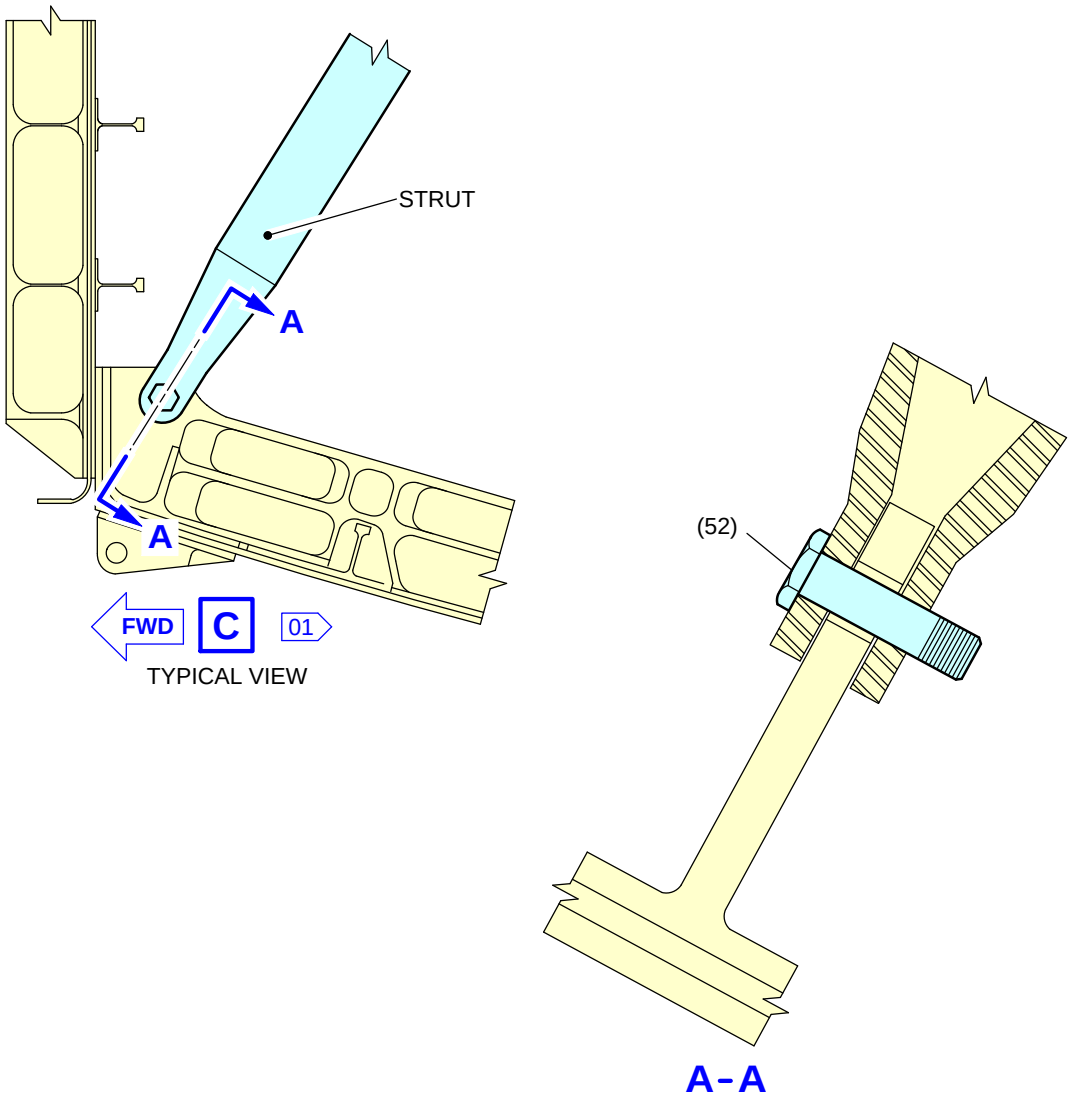


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



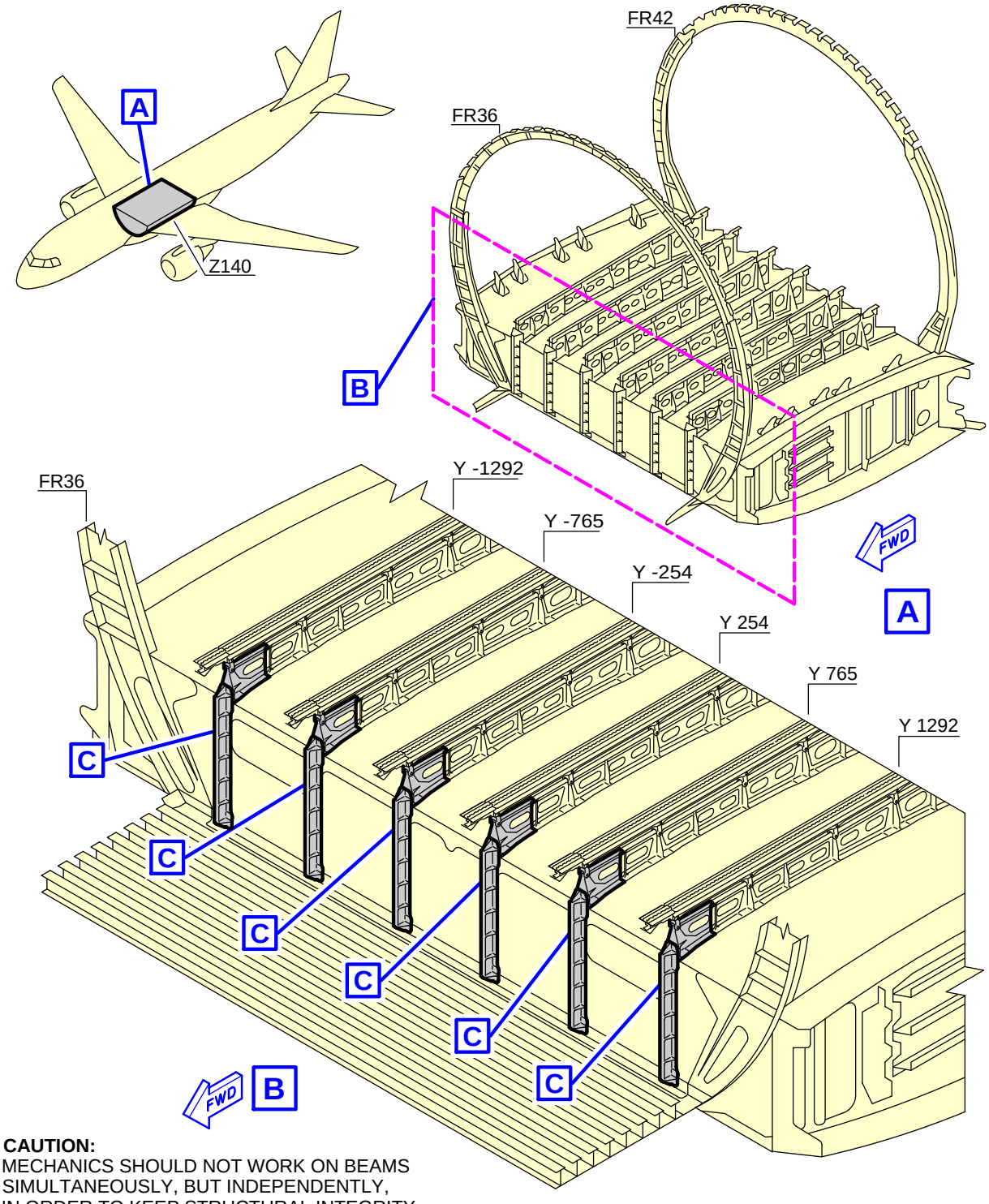
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

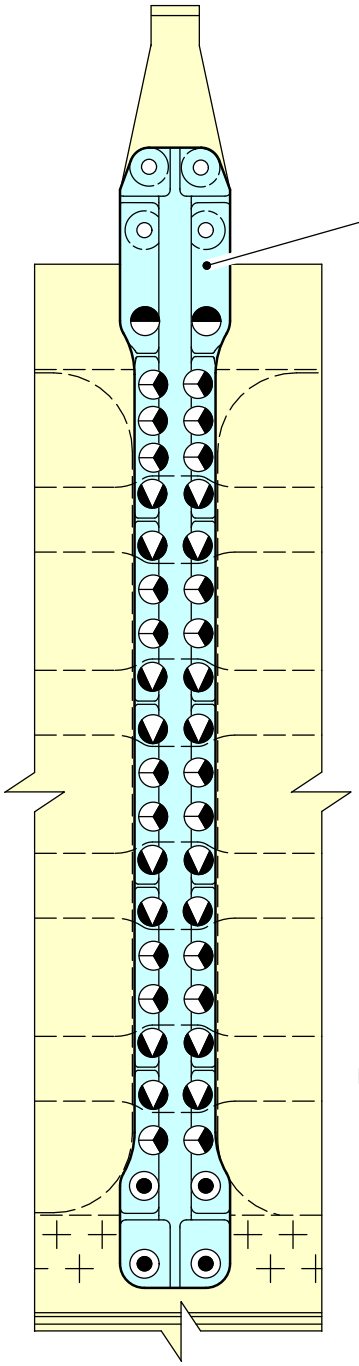


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(5) Task A320-A-57-XX-1228-01002-720A-A - Install the New Vertical Stringer on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1 AXLE Item (52) Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

	Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
	Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

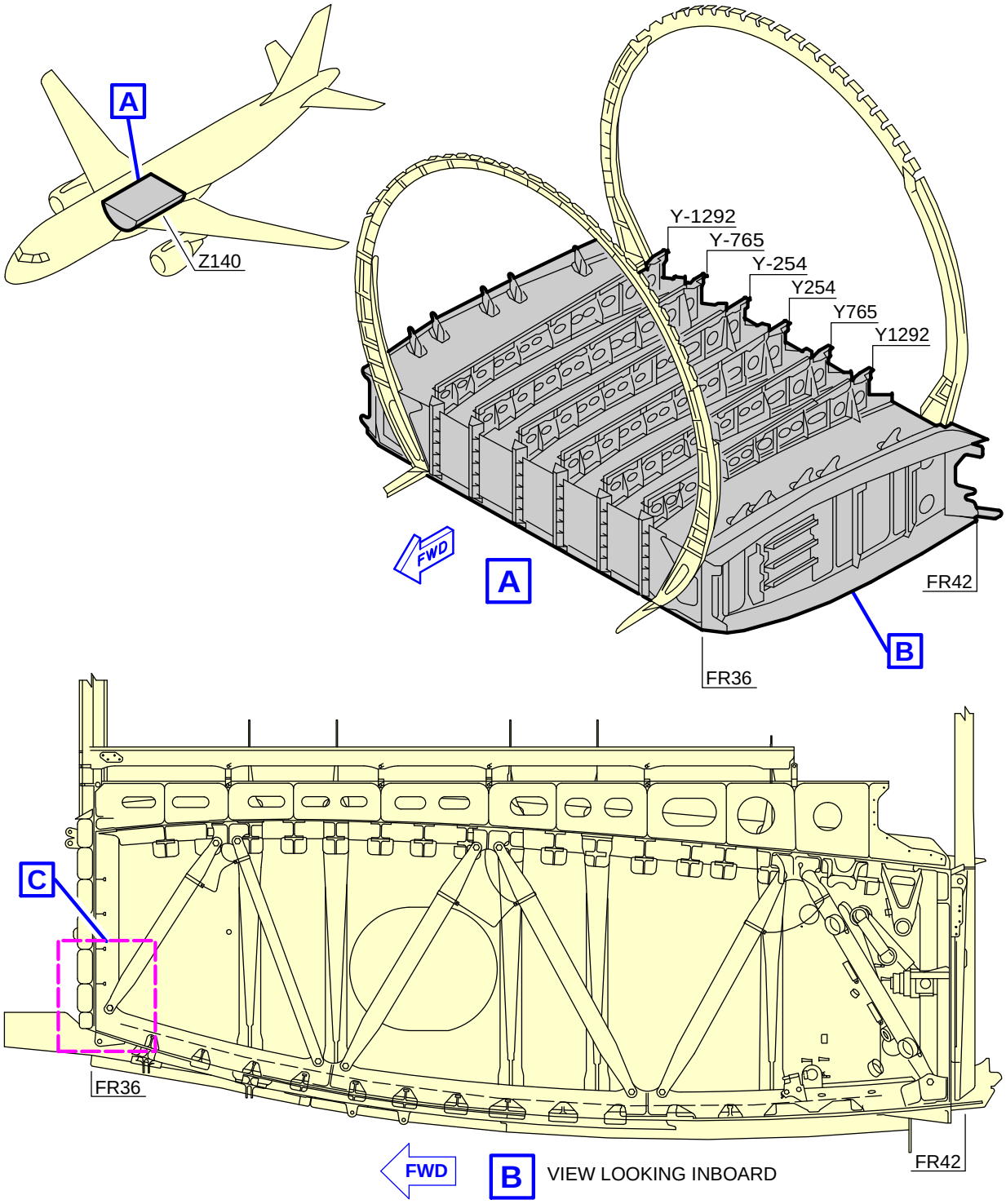
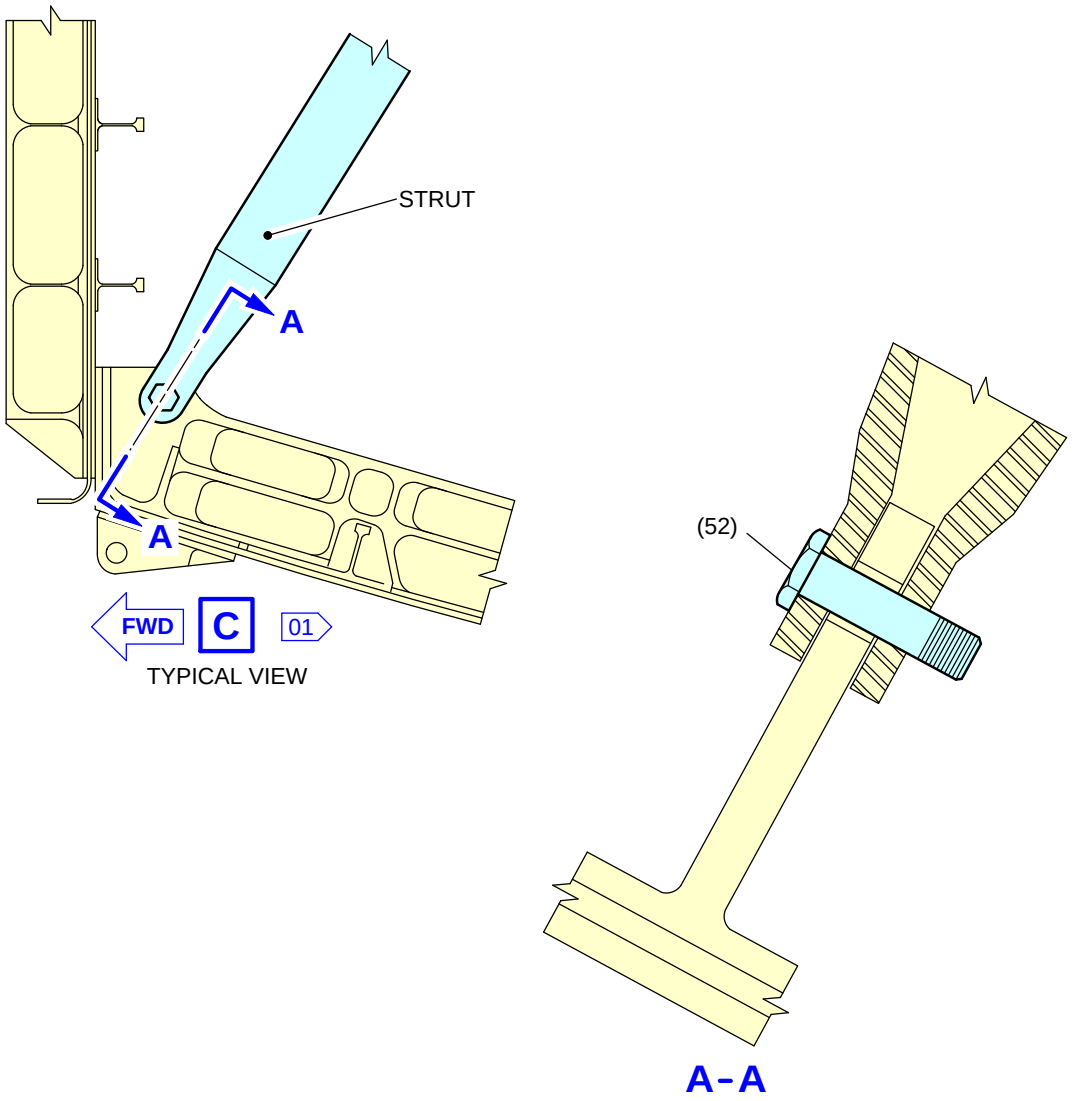


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



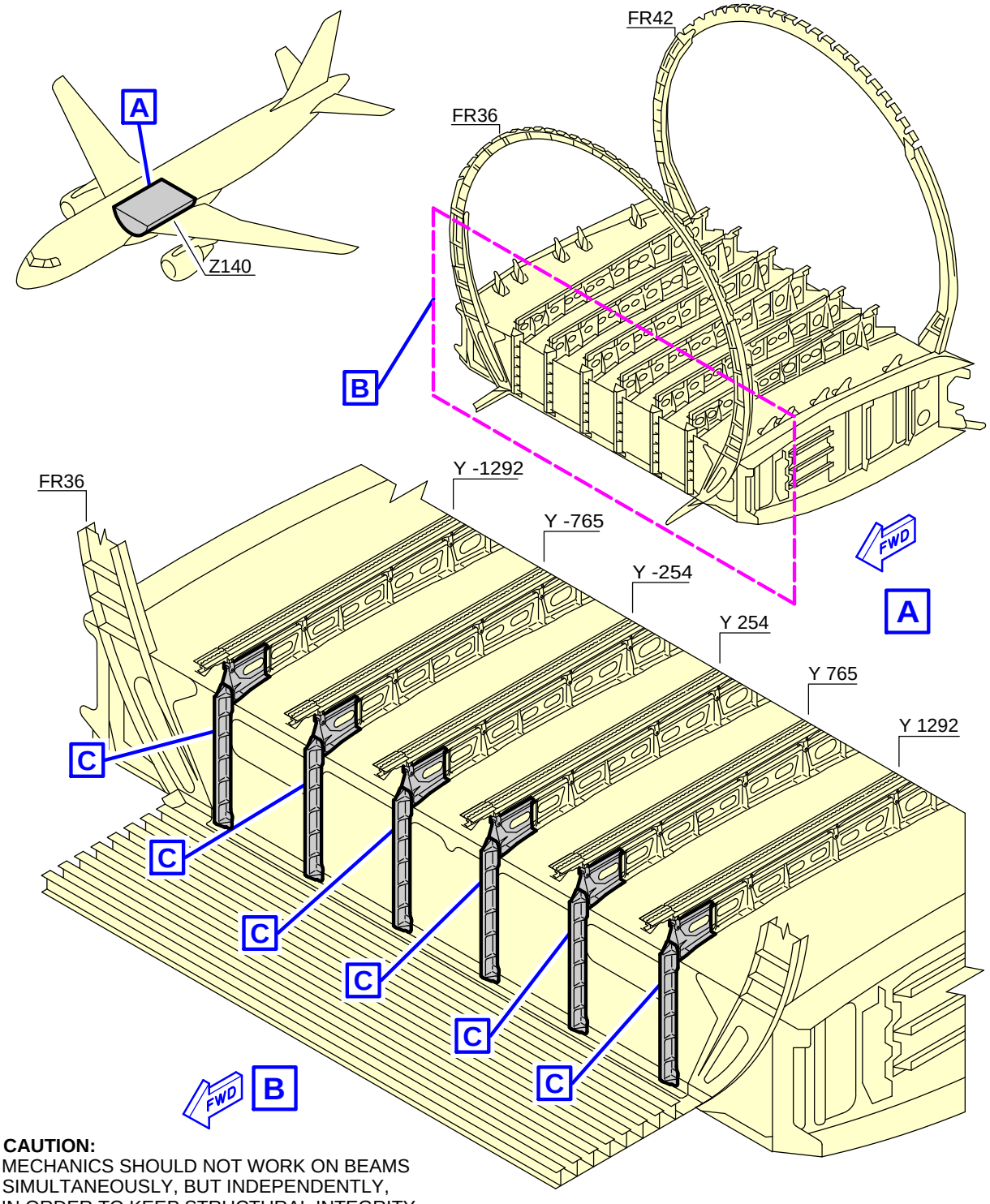
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

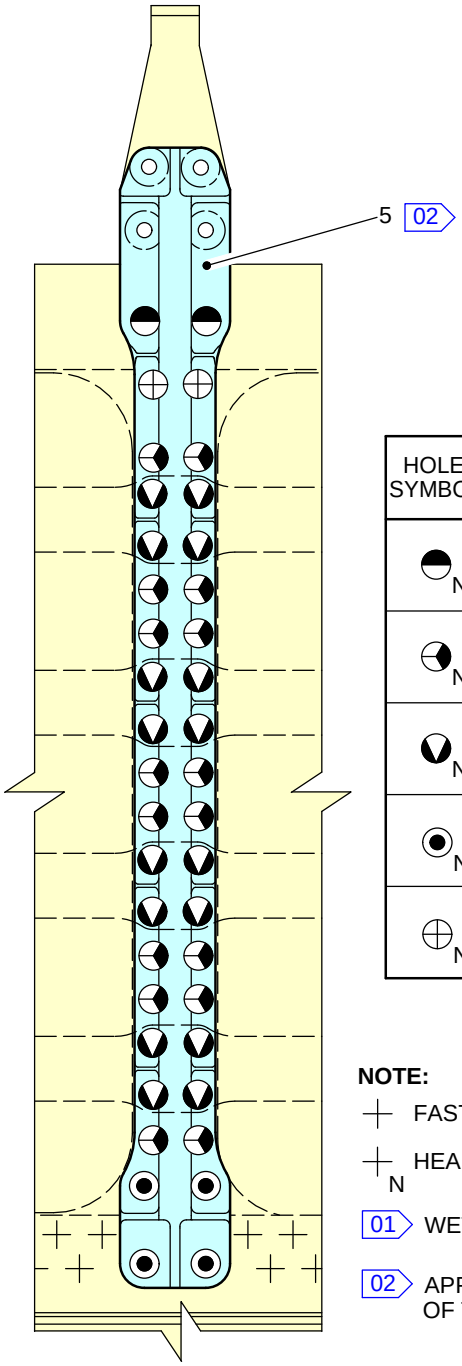


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(6) Task A320-A-57-XX-1228-11001-720A-A - Install the Strut Lower Attachment on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

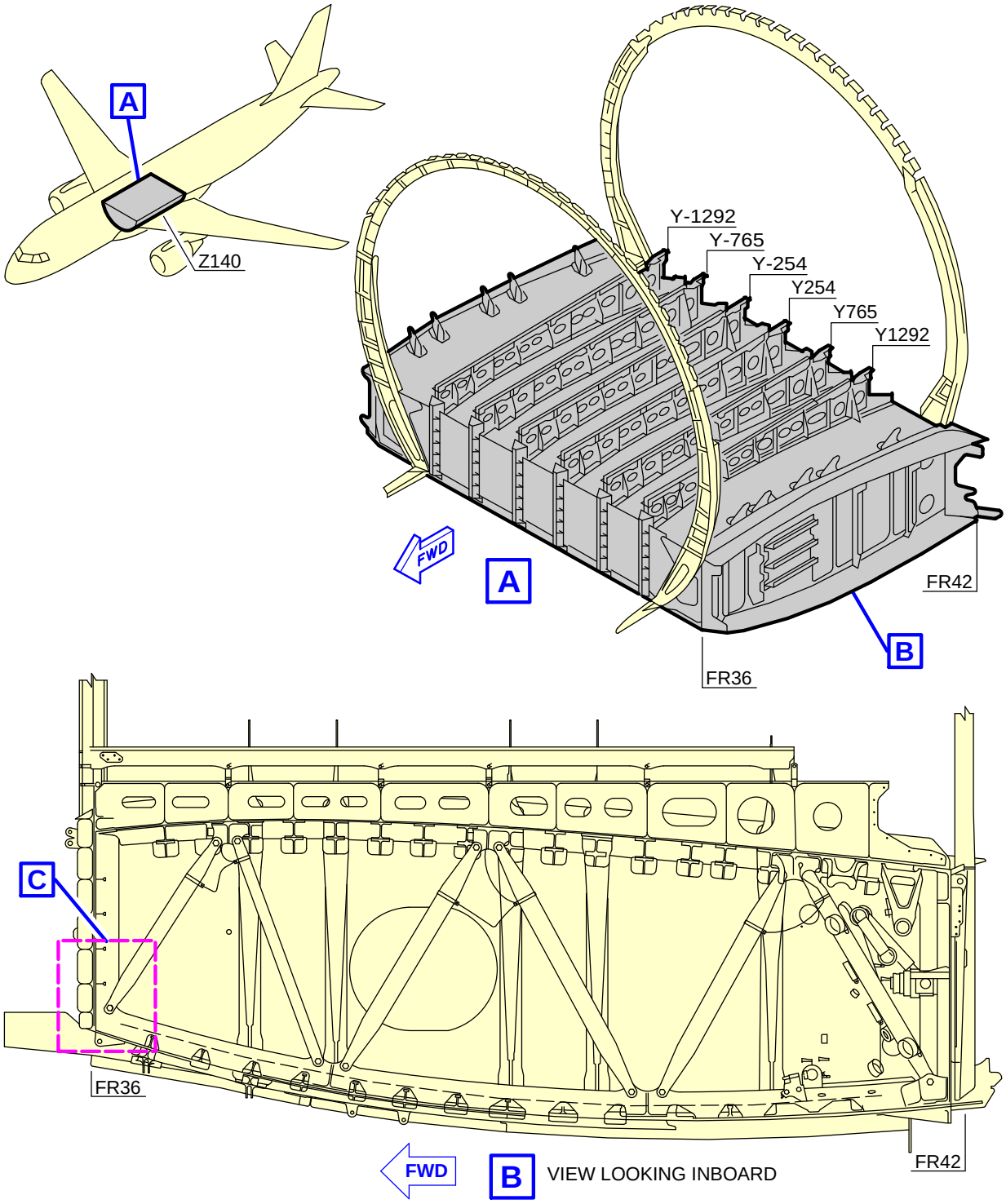
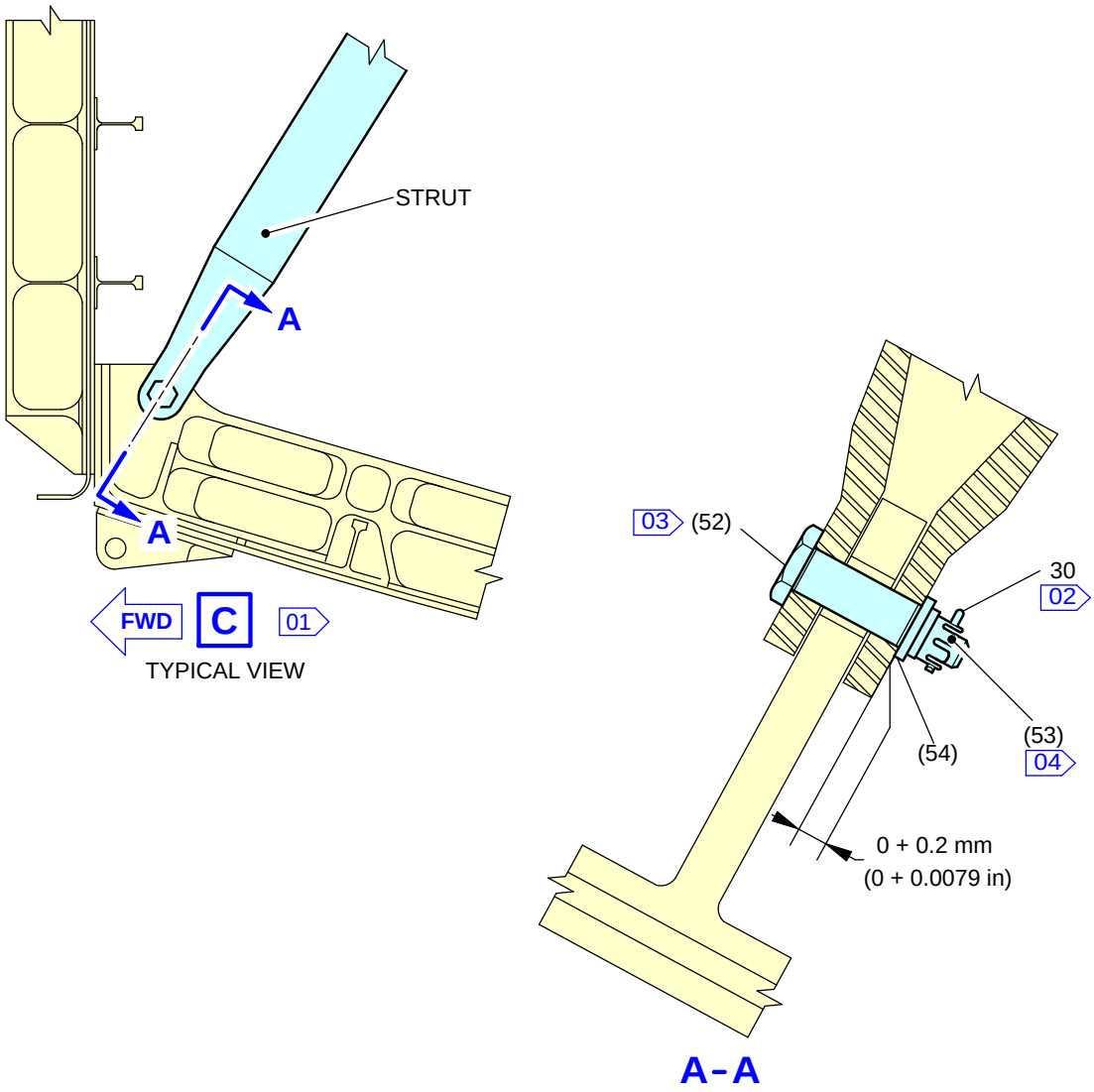


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(6) Task A320-A-57-XX-1228-11002-720A-A - Install the Strut Lower Attachment on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 002

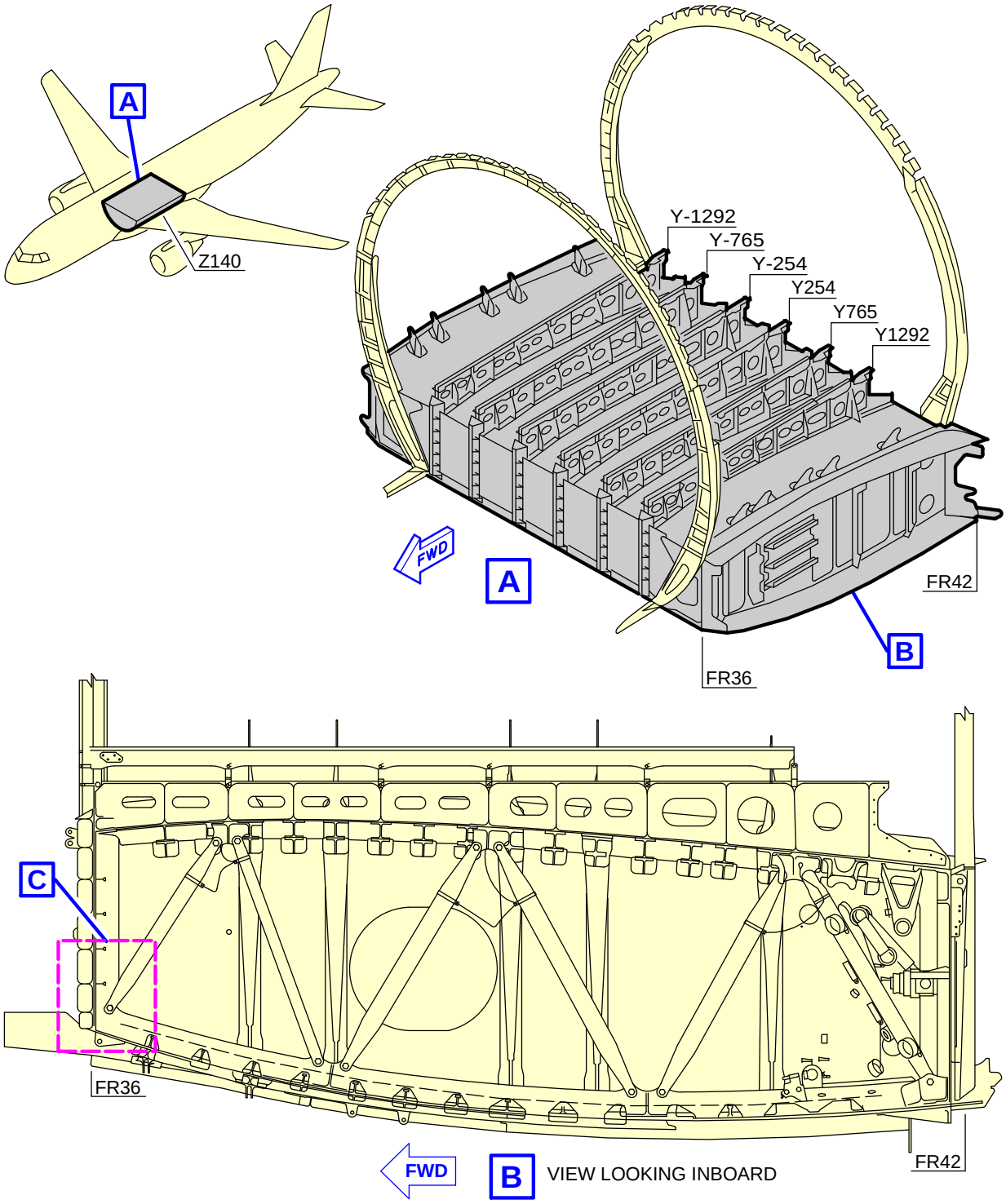
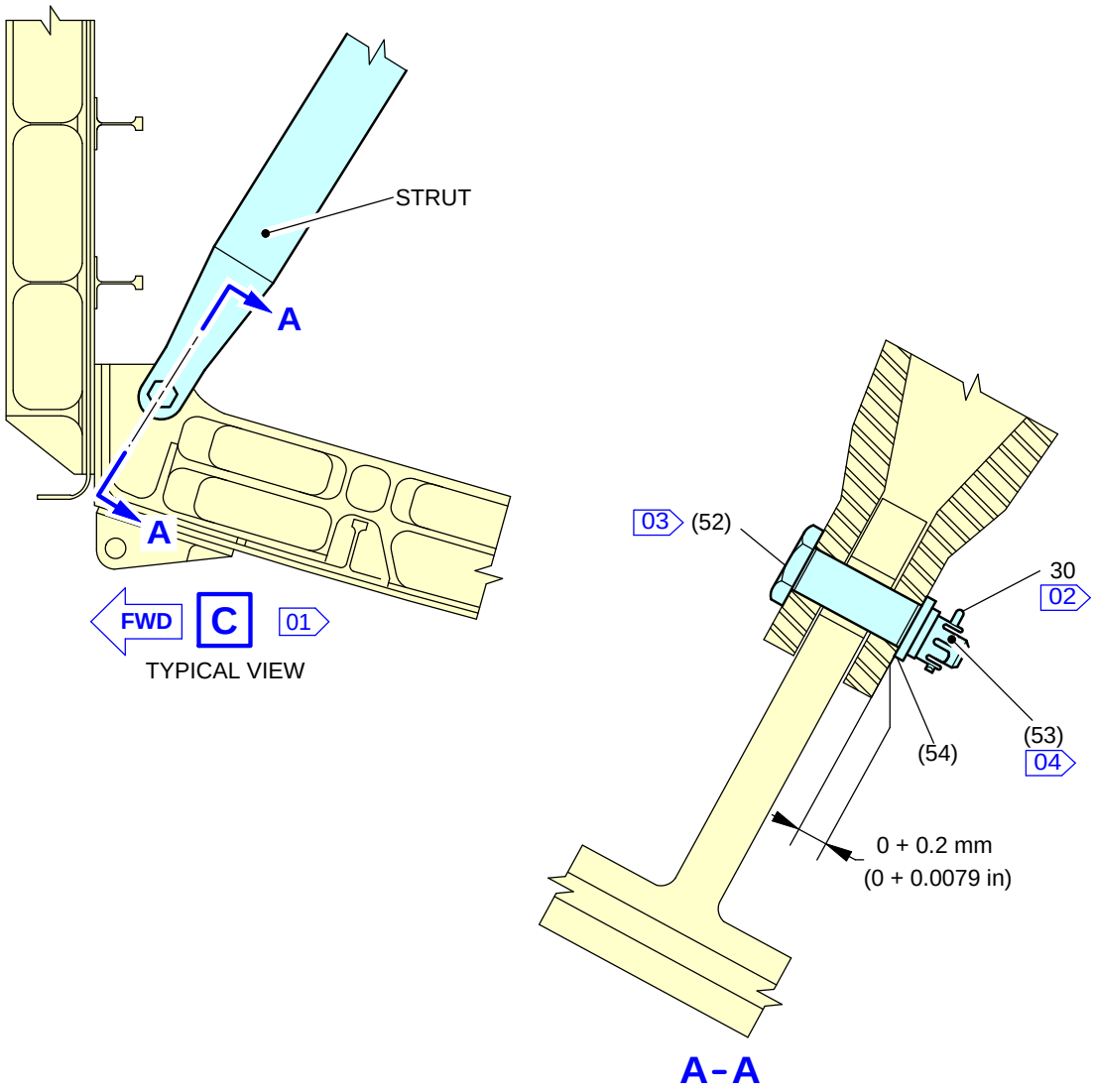


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(7) Task A320-A-57-XX-1228-06001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

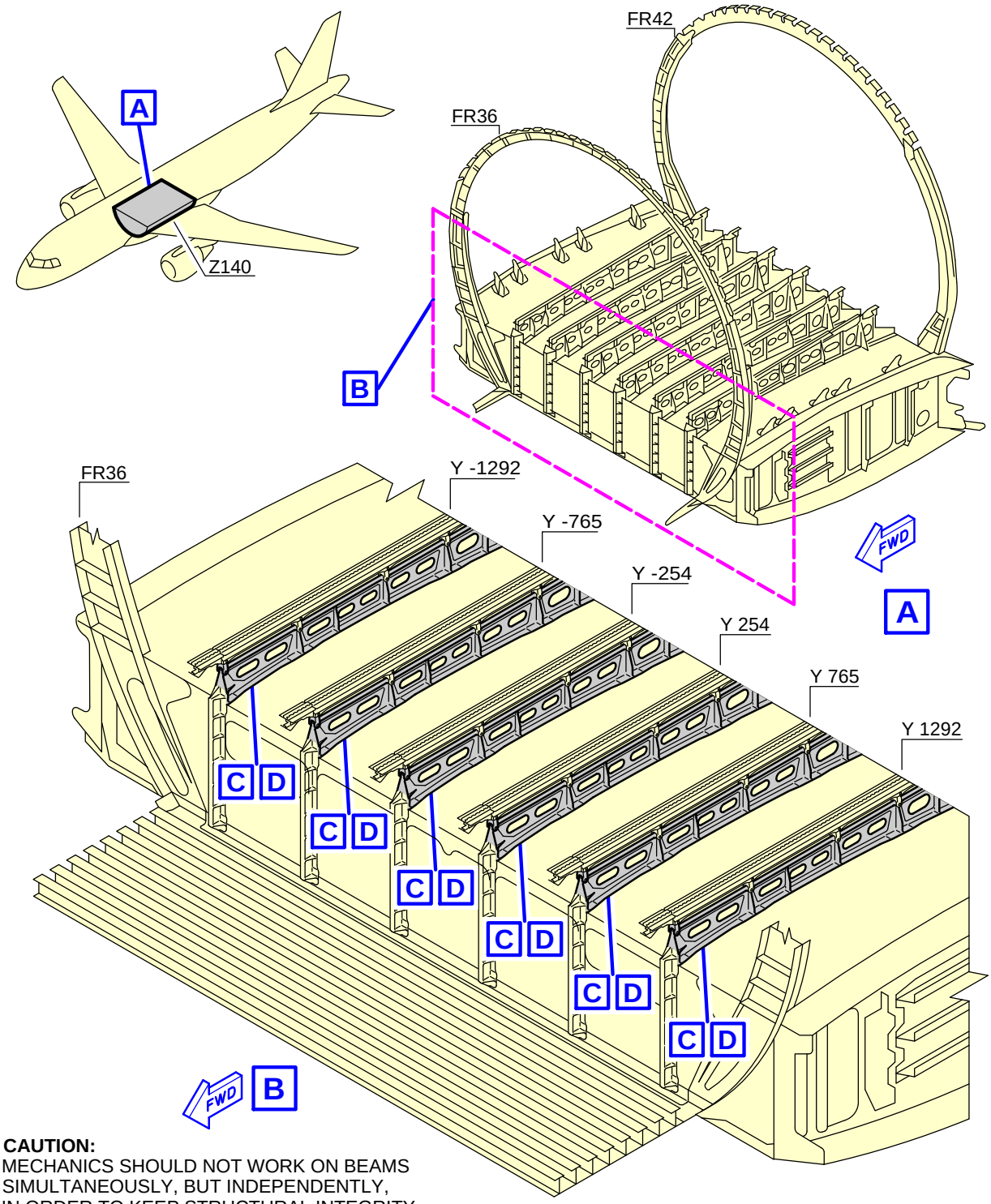
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-03ZZZ-720Z-A.

CONF ALL

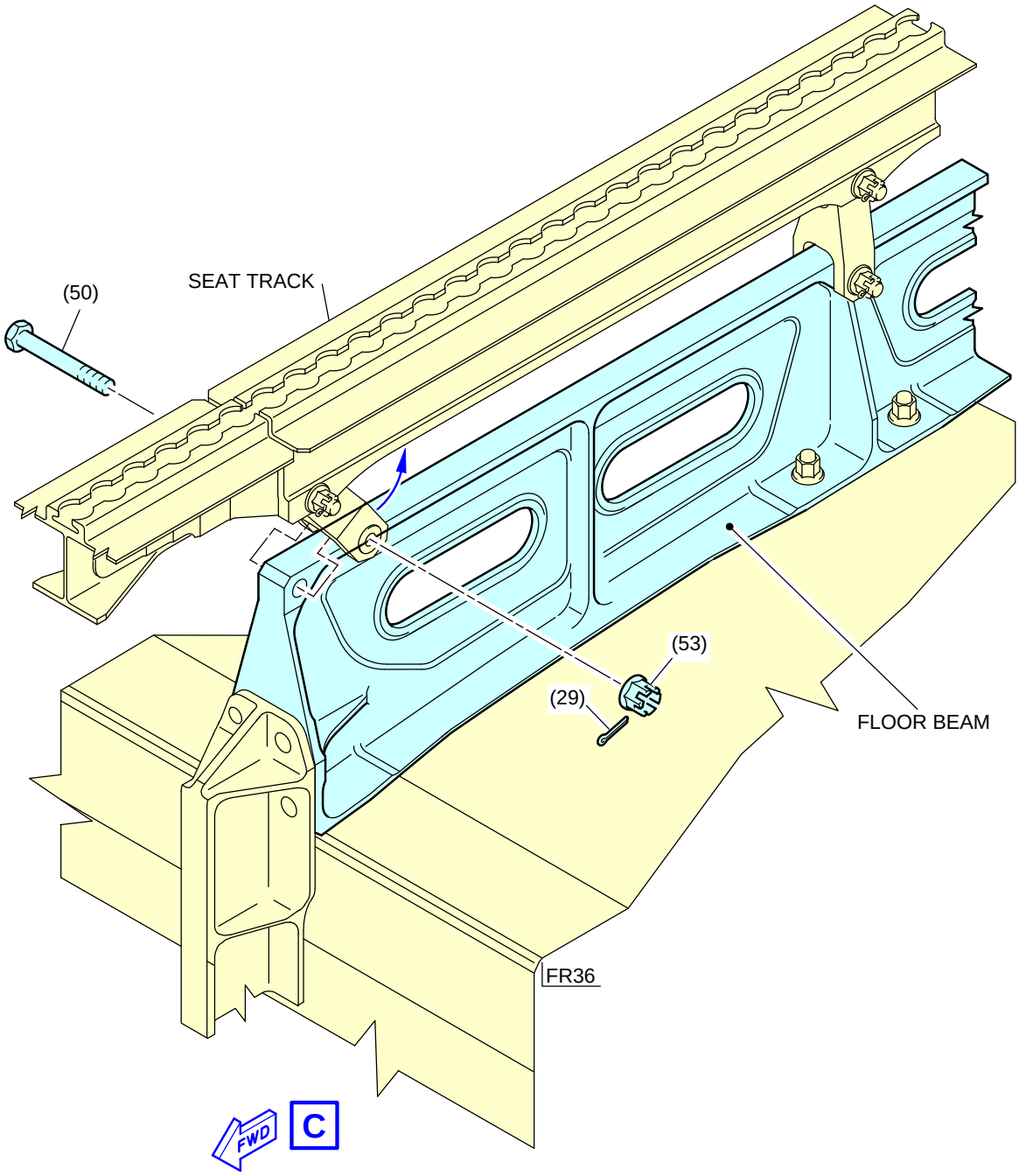


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

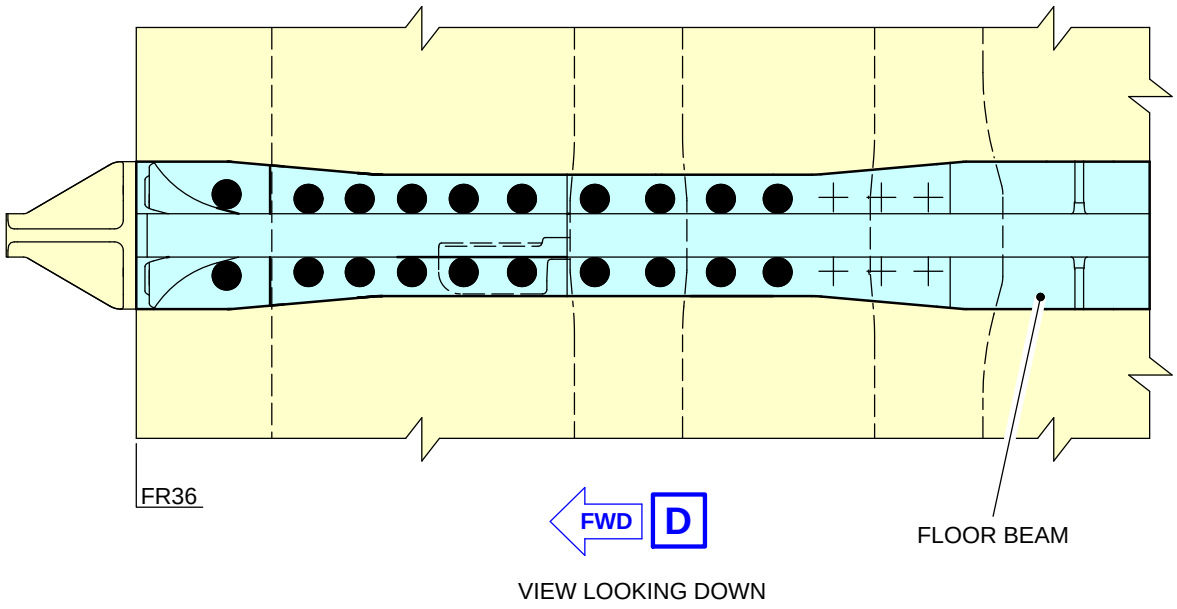
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(8) Task A320-A-57-XX-1228-01001-650A-A - Cut out the Forward End Floor Beam on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

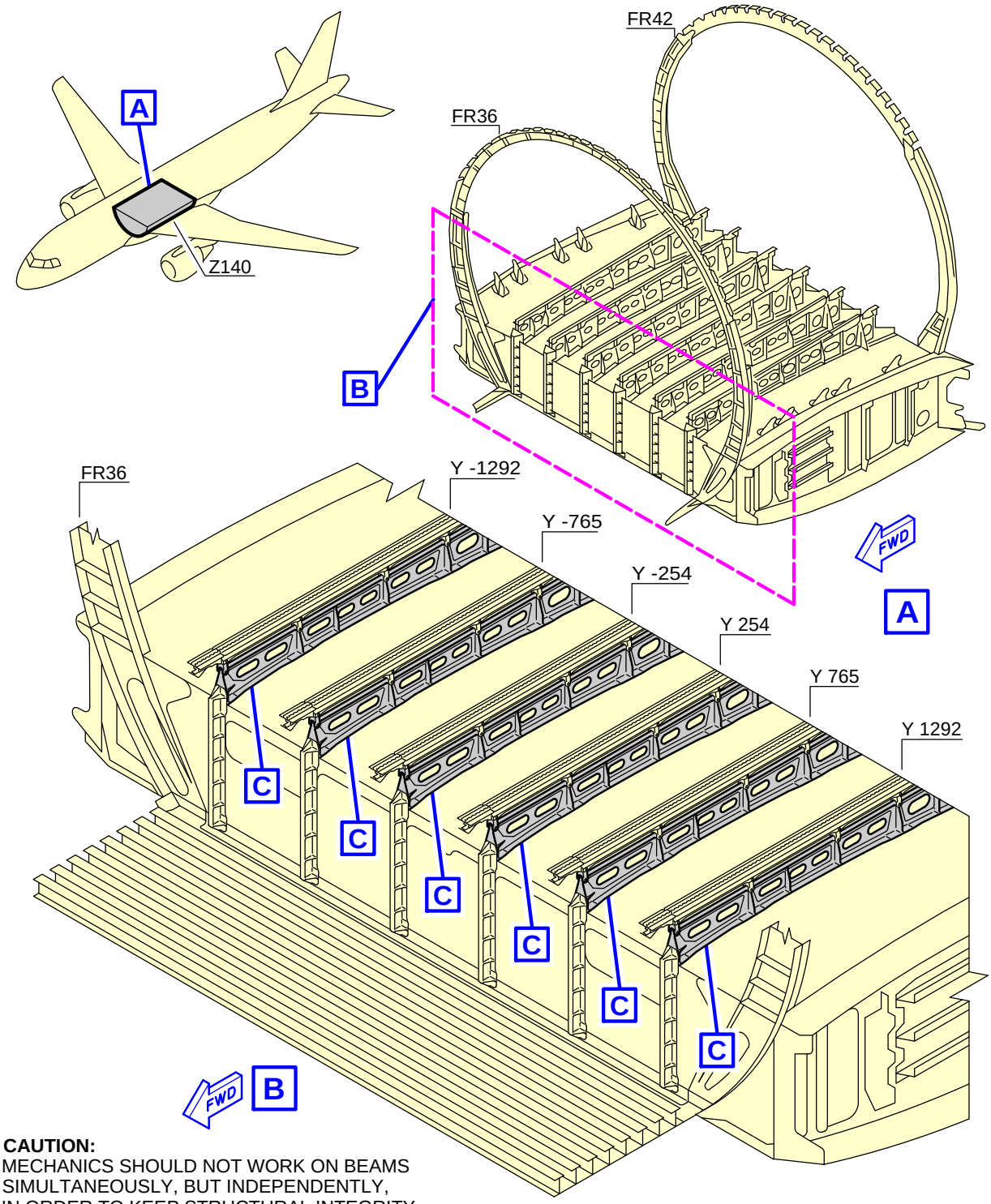
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

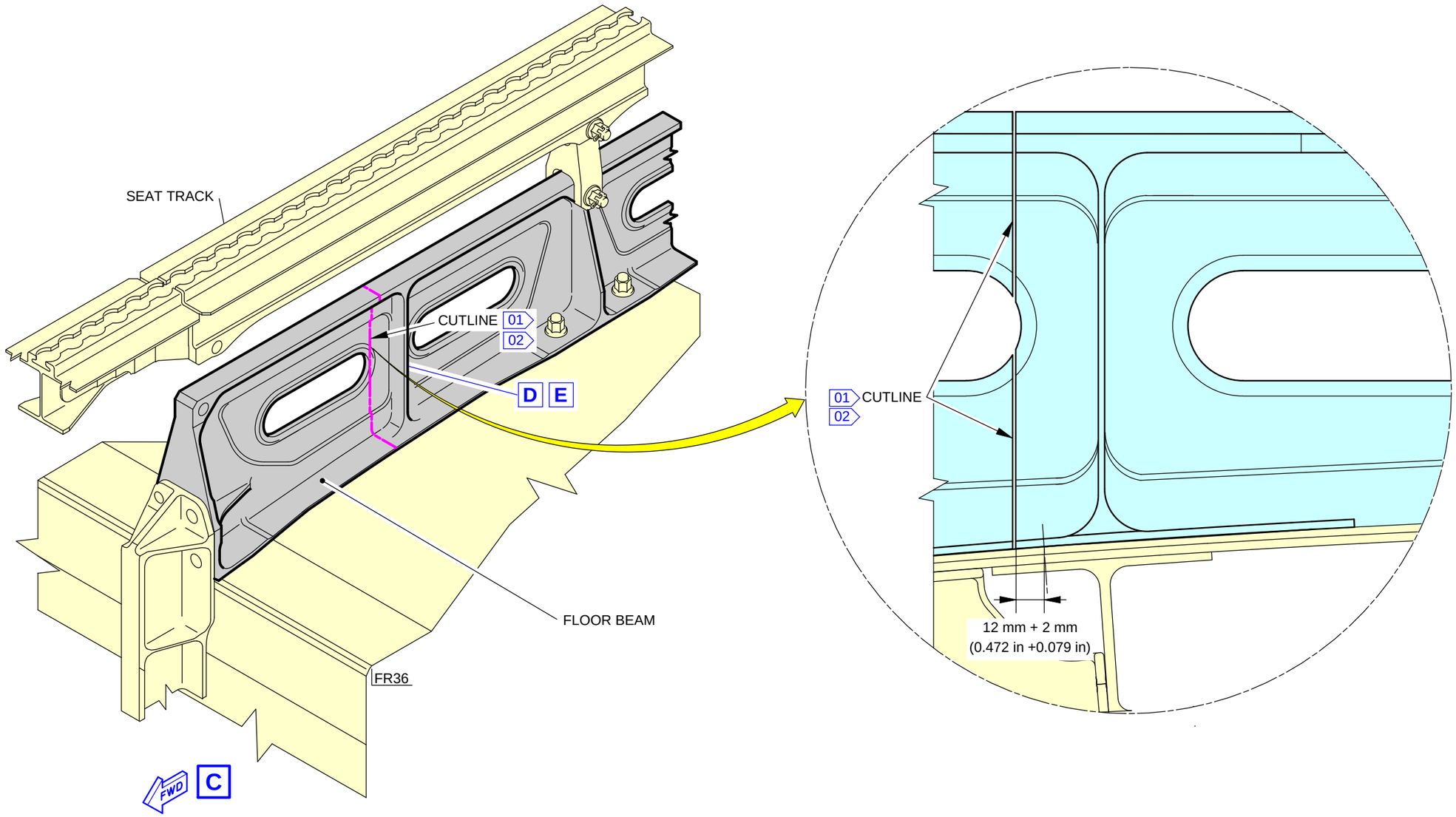


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

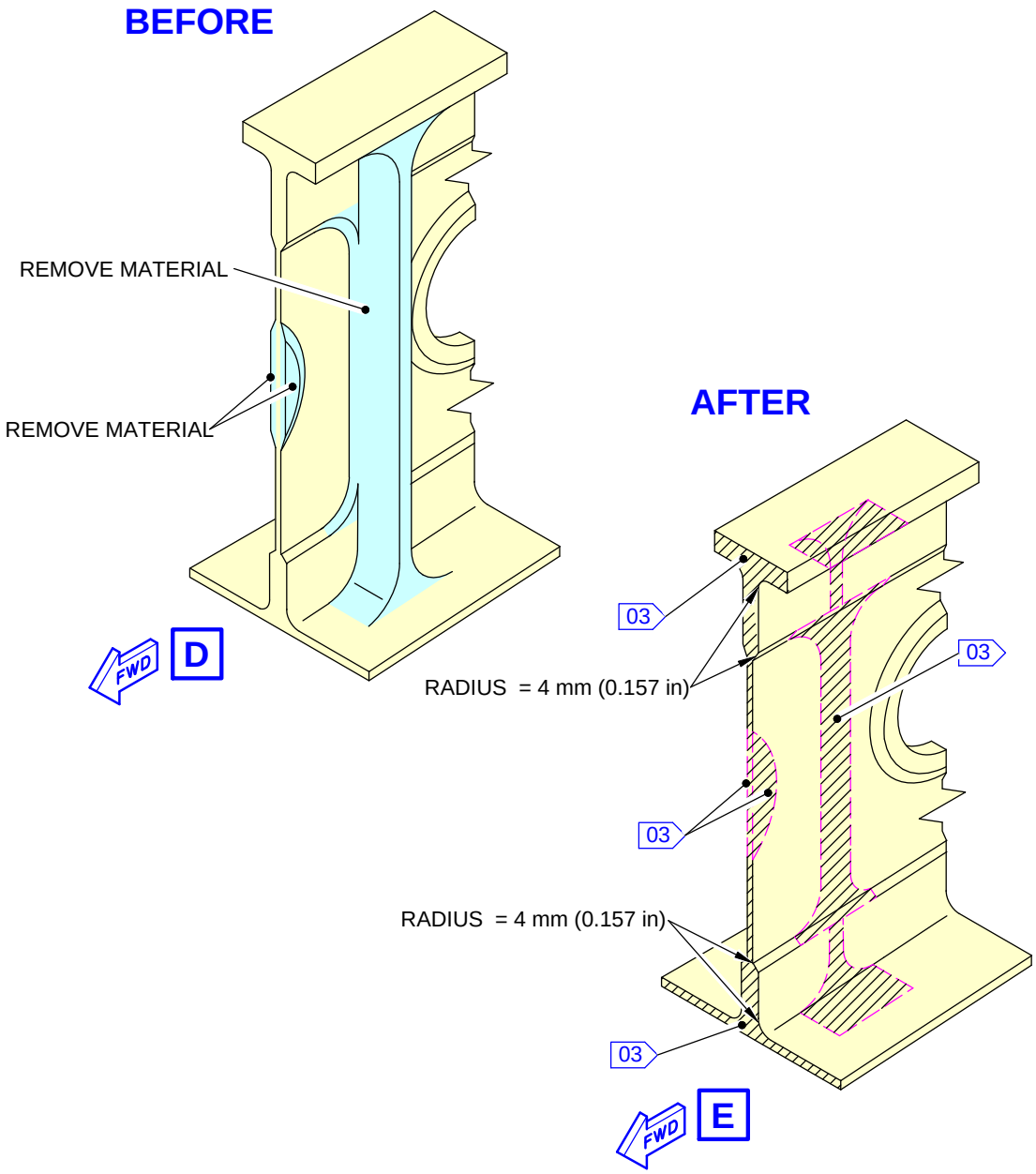
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(9) Task A320-A-57-XX-1228-02001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-02ZZZ-720Z-C.

CONF 001 003 004

(10) Task A320-A-57-XX-1228-02001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

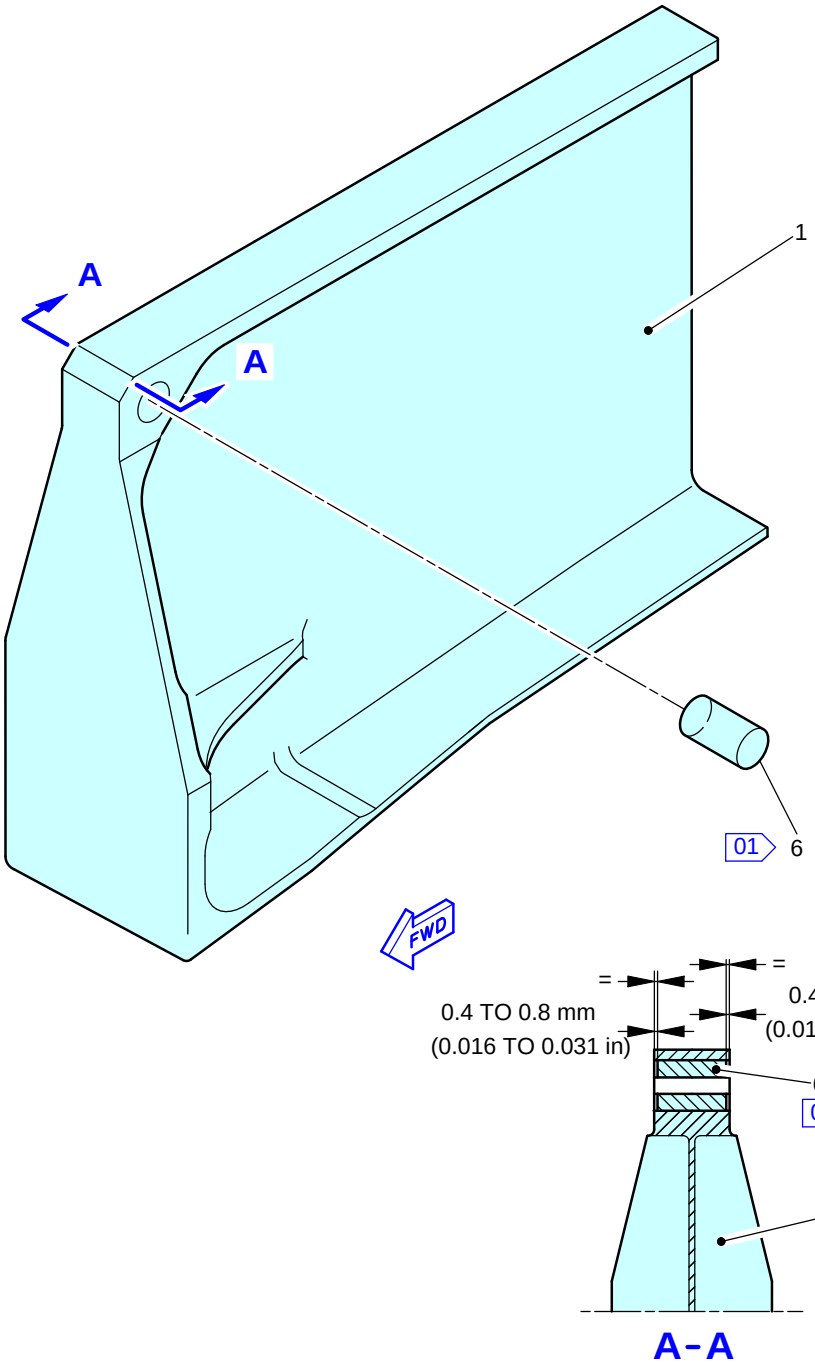
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(10) Task A320-A-57-XX-1228-02002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y1292 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

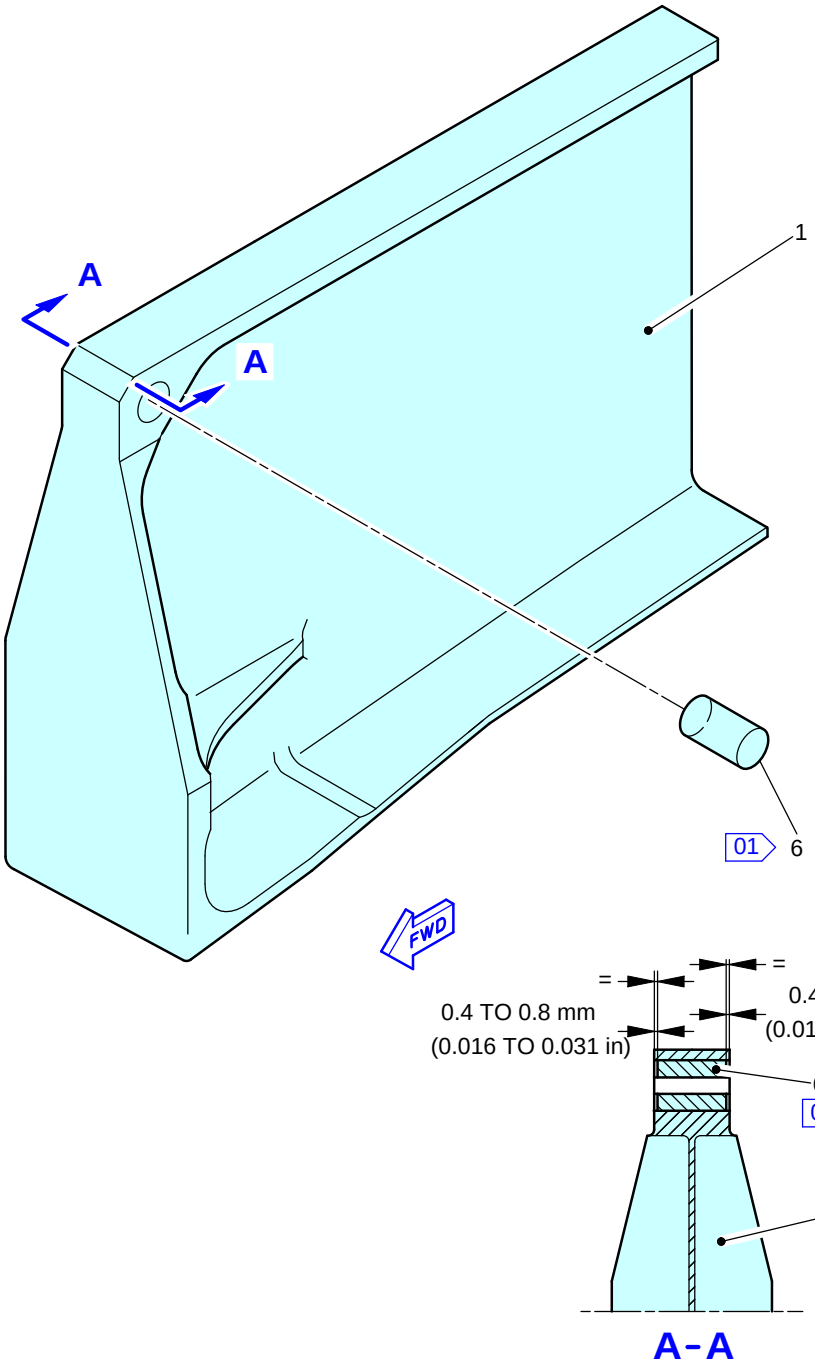
2 Install:

1	BUSHING	D5713006420000	Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(11) Task A320-A-57-XX-1228-01001-270A-A - Temporarily, Install the New Parts for Adjustment on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

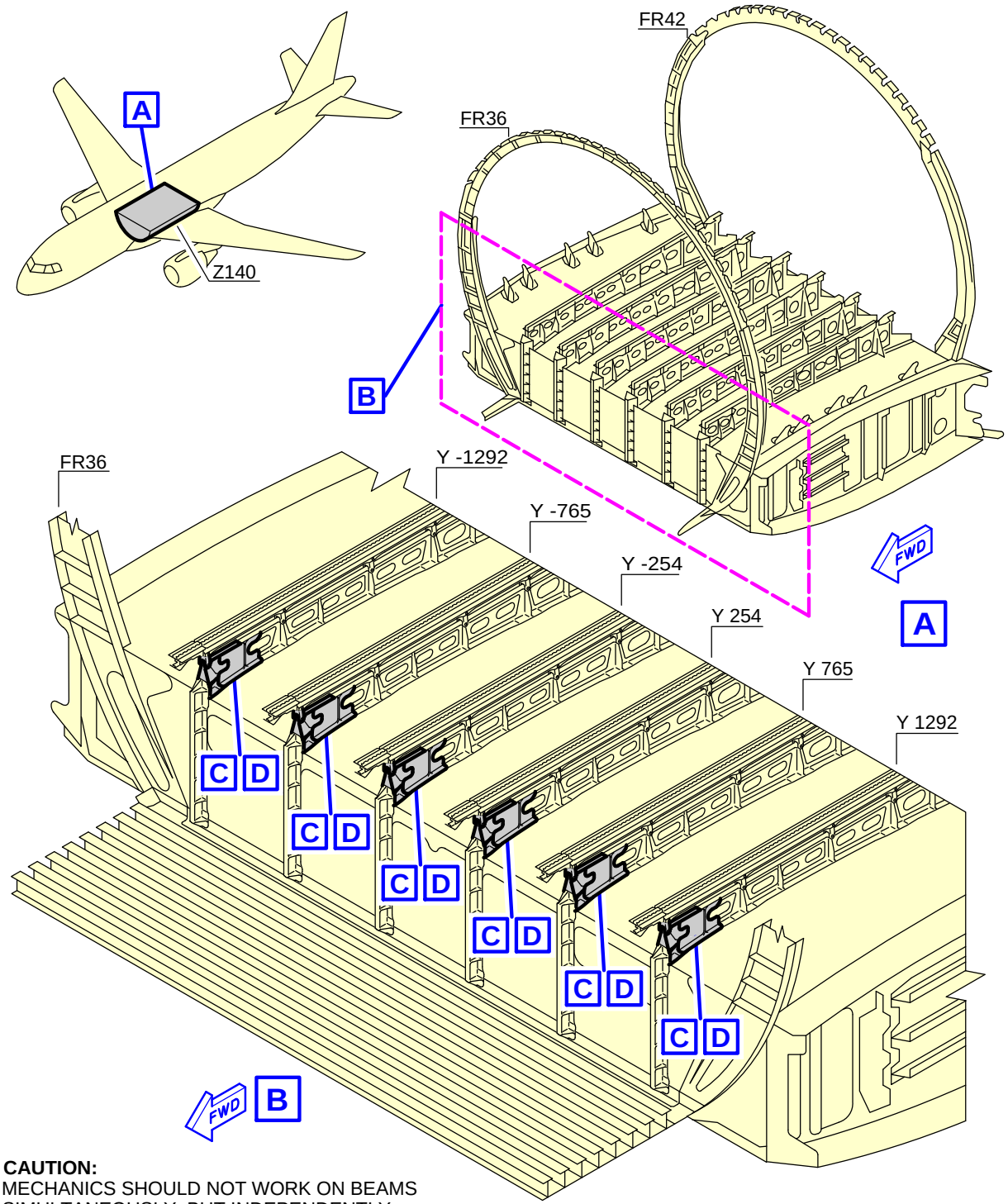
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

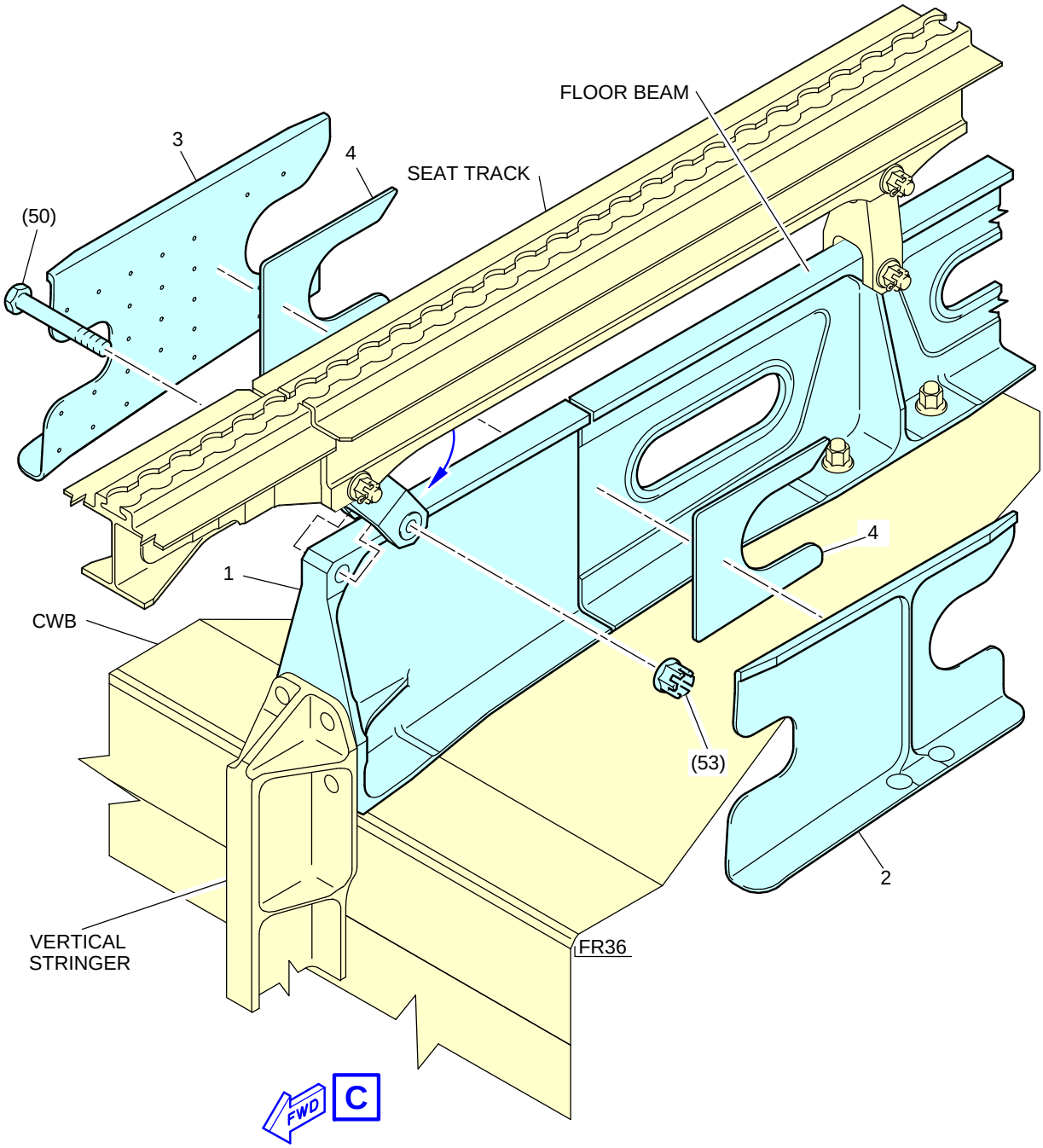


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

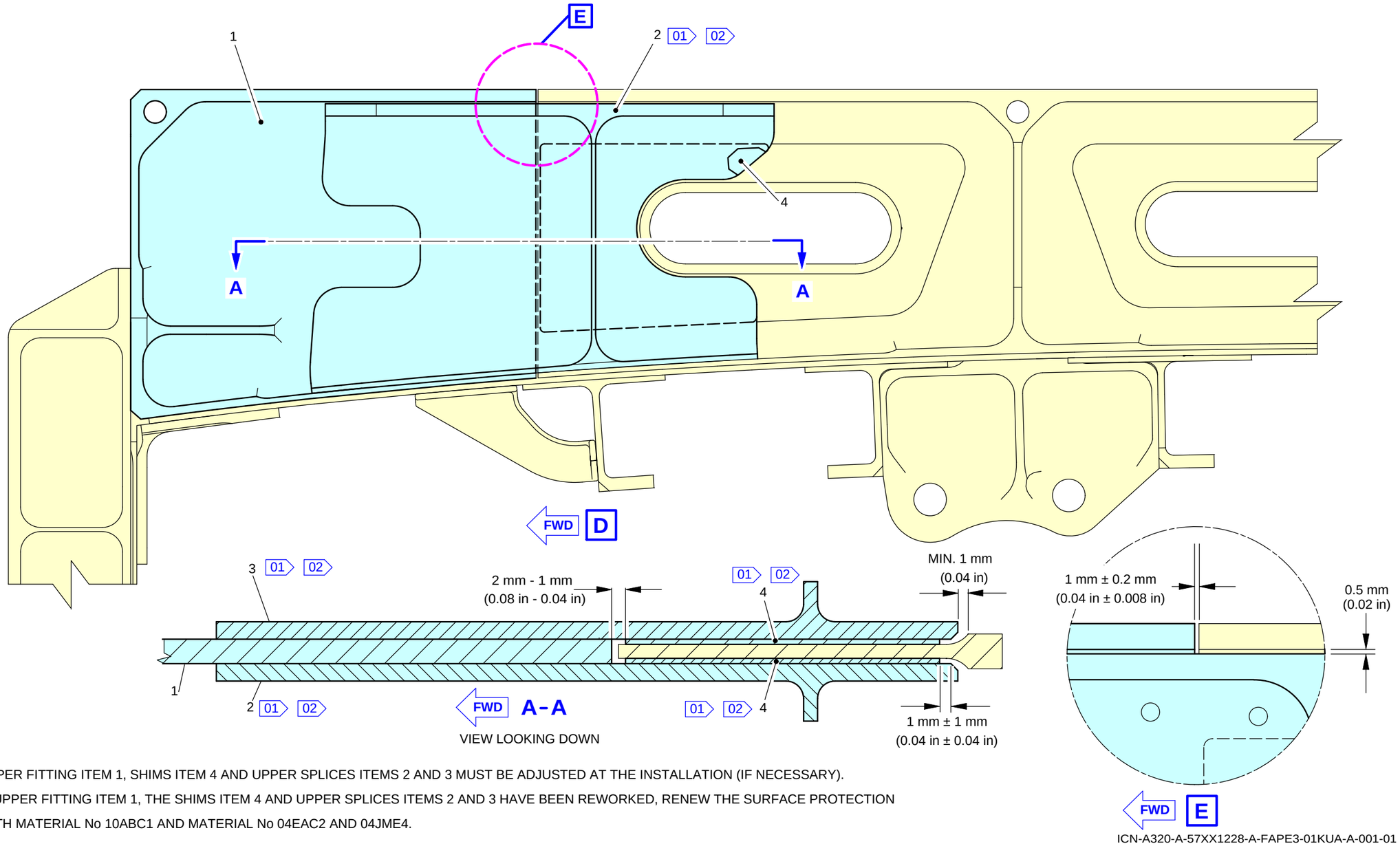
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(11) Task A320-A-57-XX-1228-01002-270A-A - Temporarily, Install the New Parts for Adjustment on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

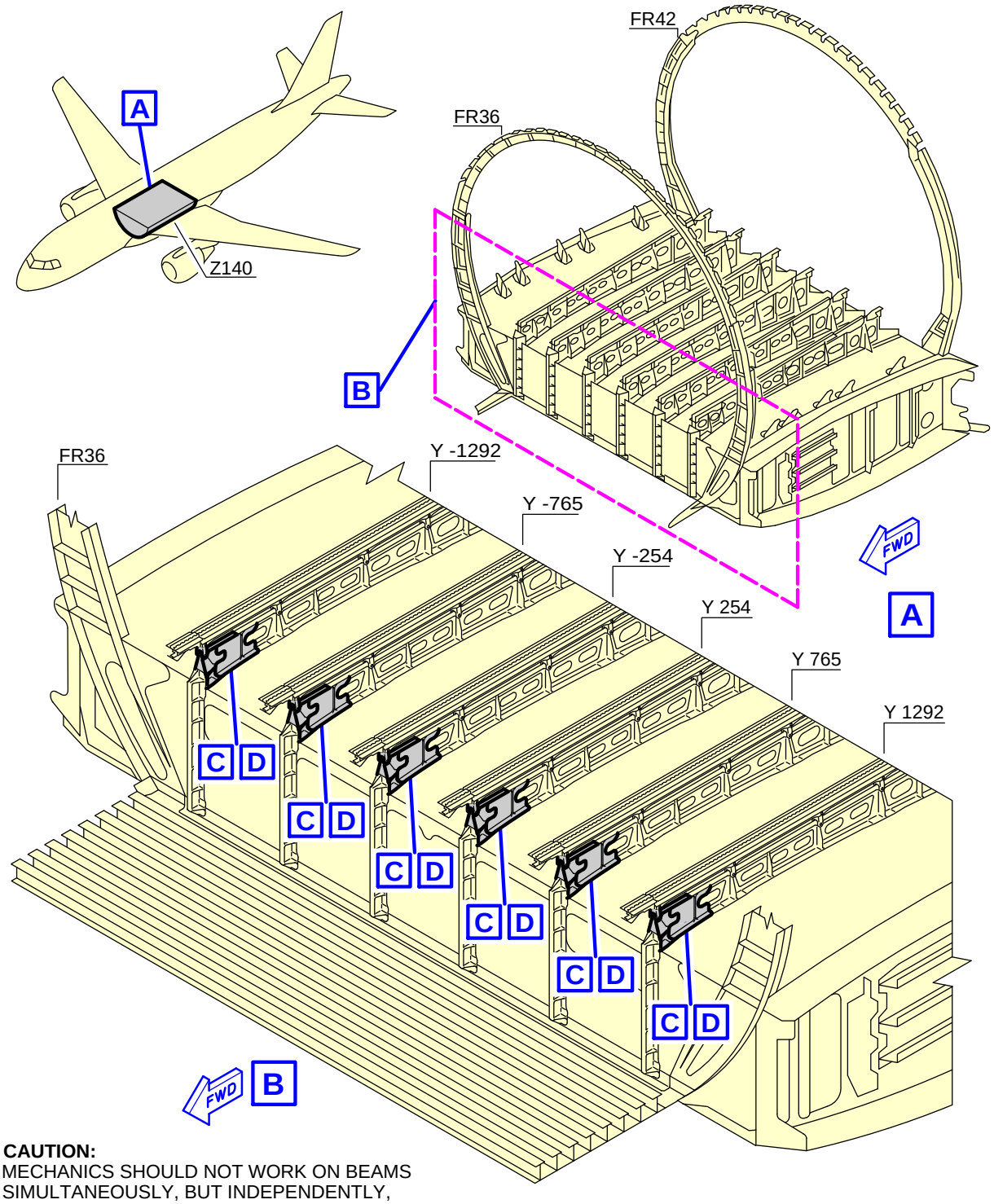
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

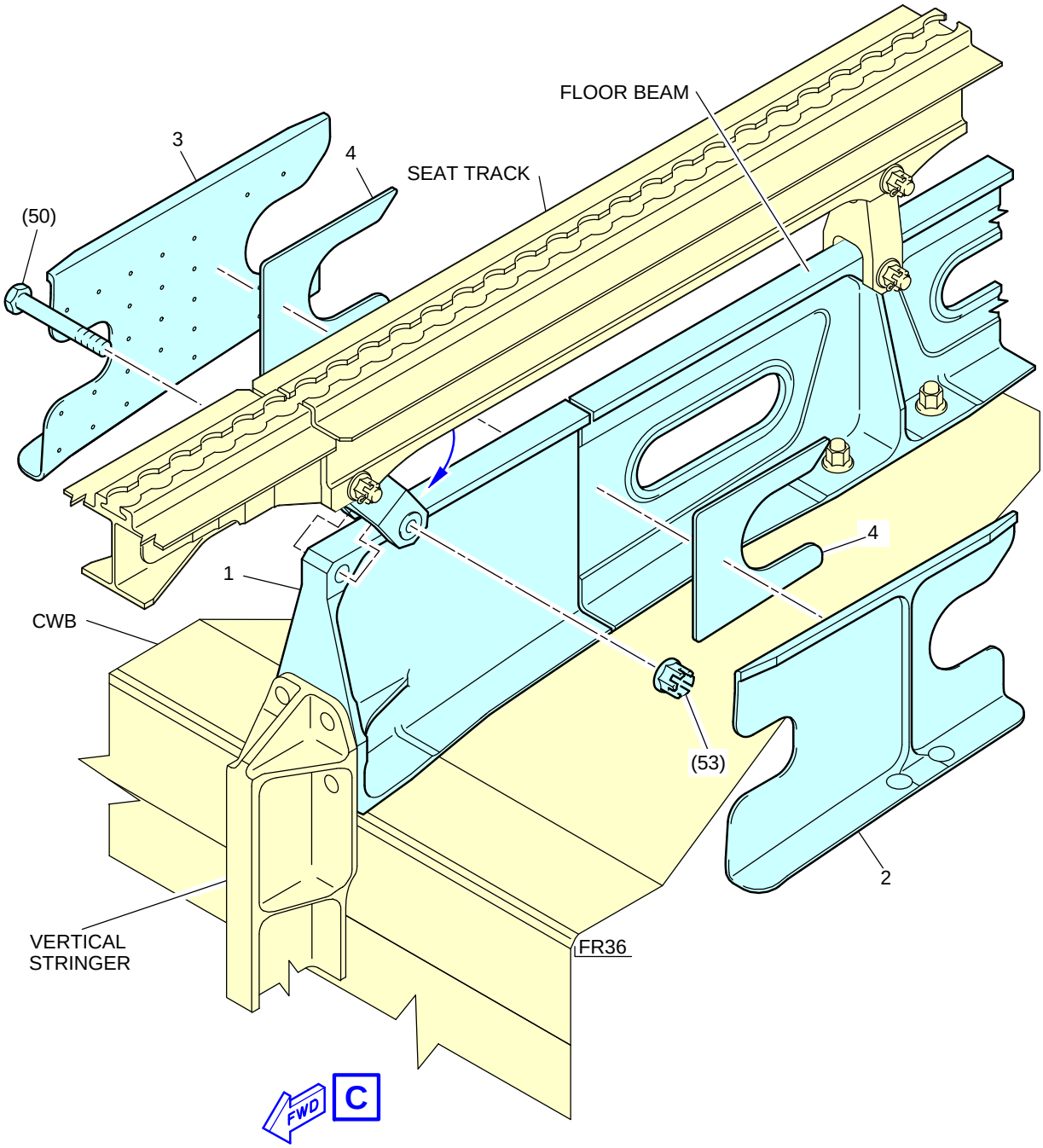


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

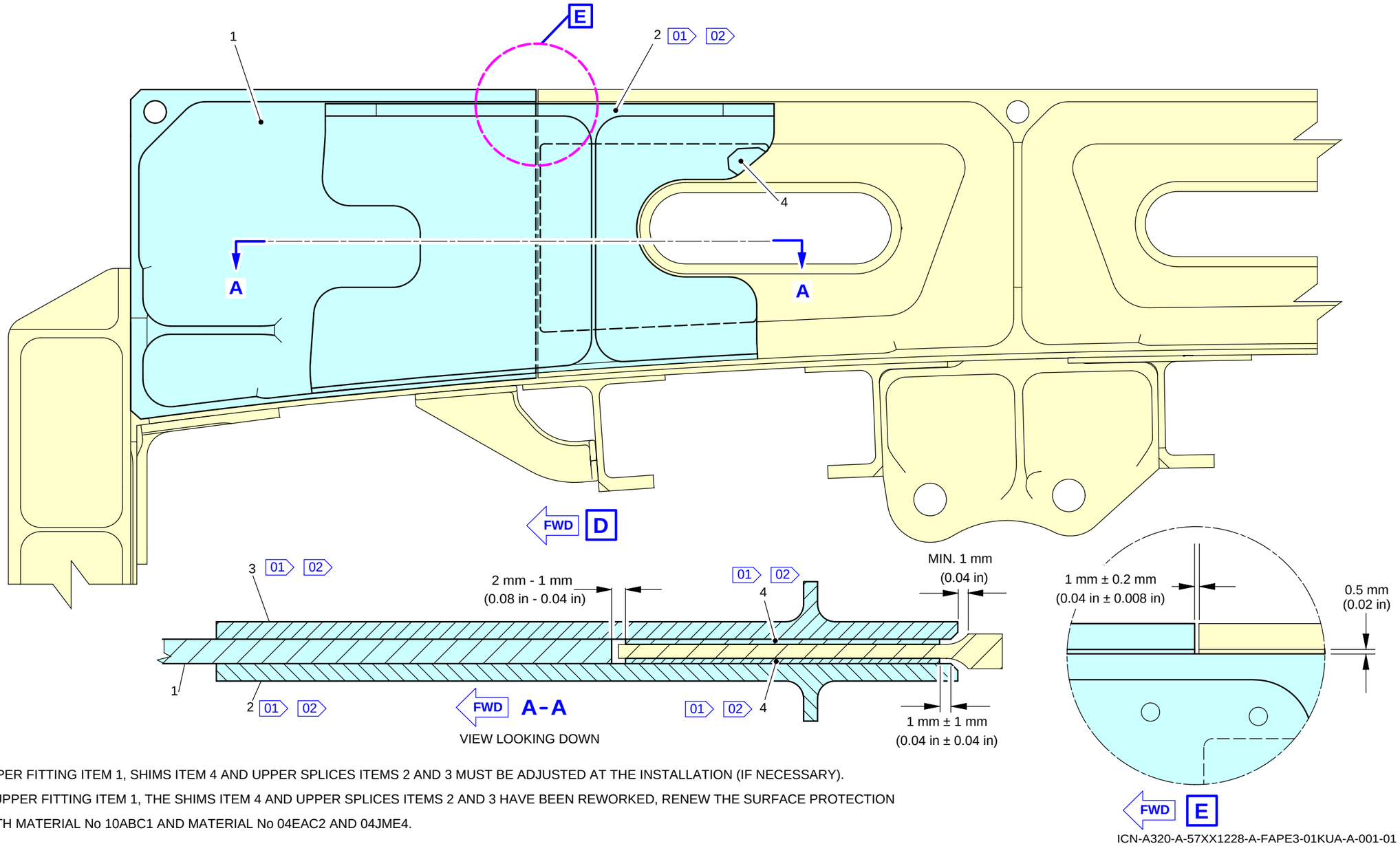
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(12) Task A320-A-57-XX-1228-02001-900A-A - Drill the New Parts on Y1292 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

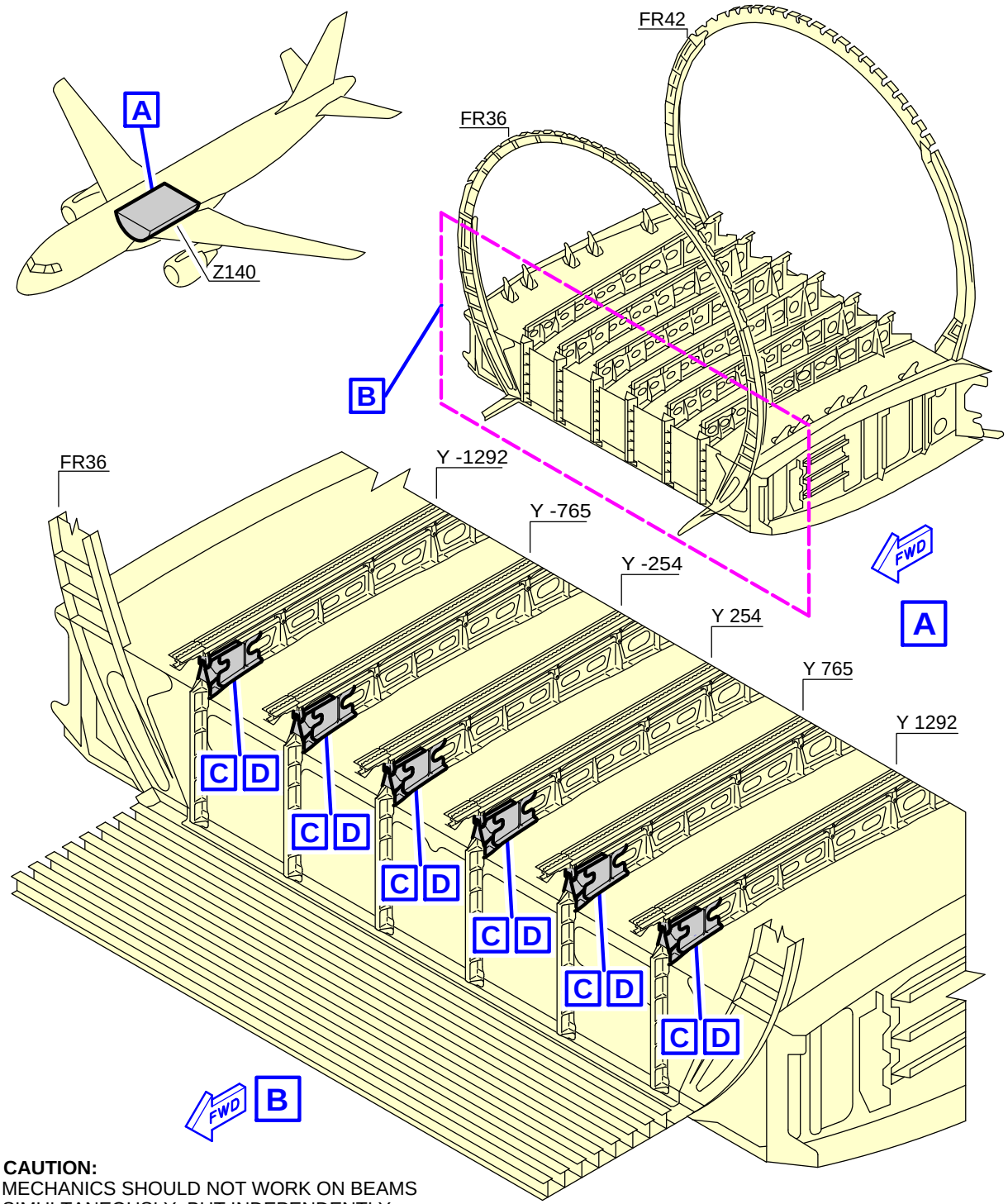
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

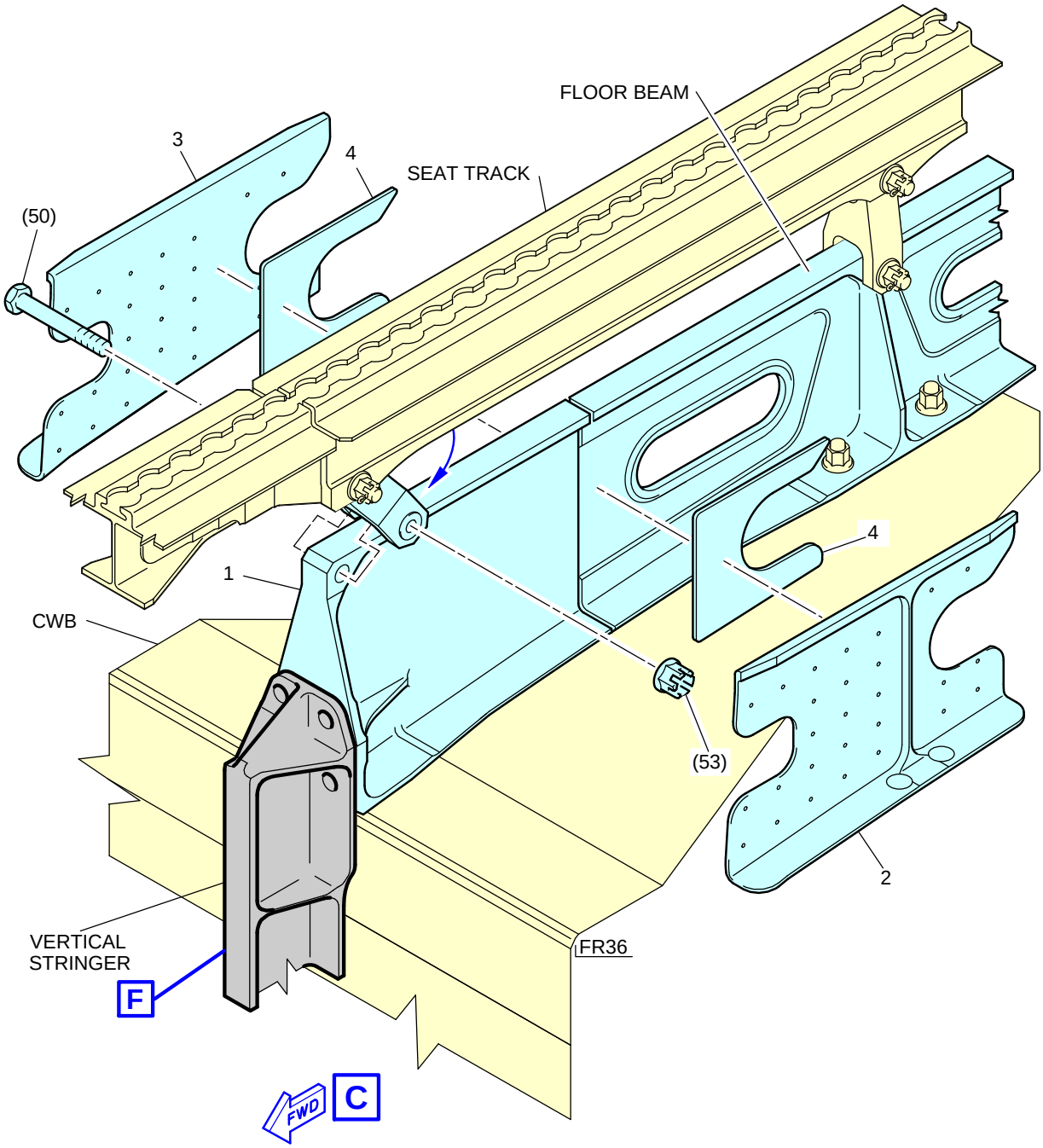


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

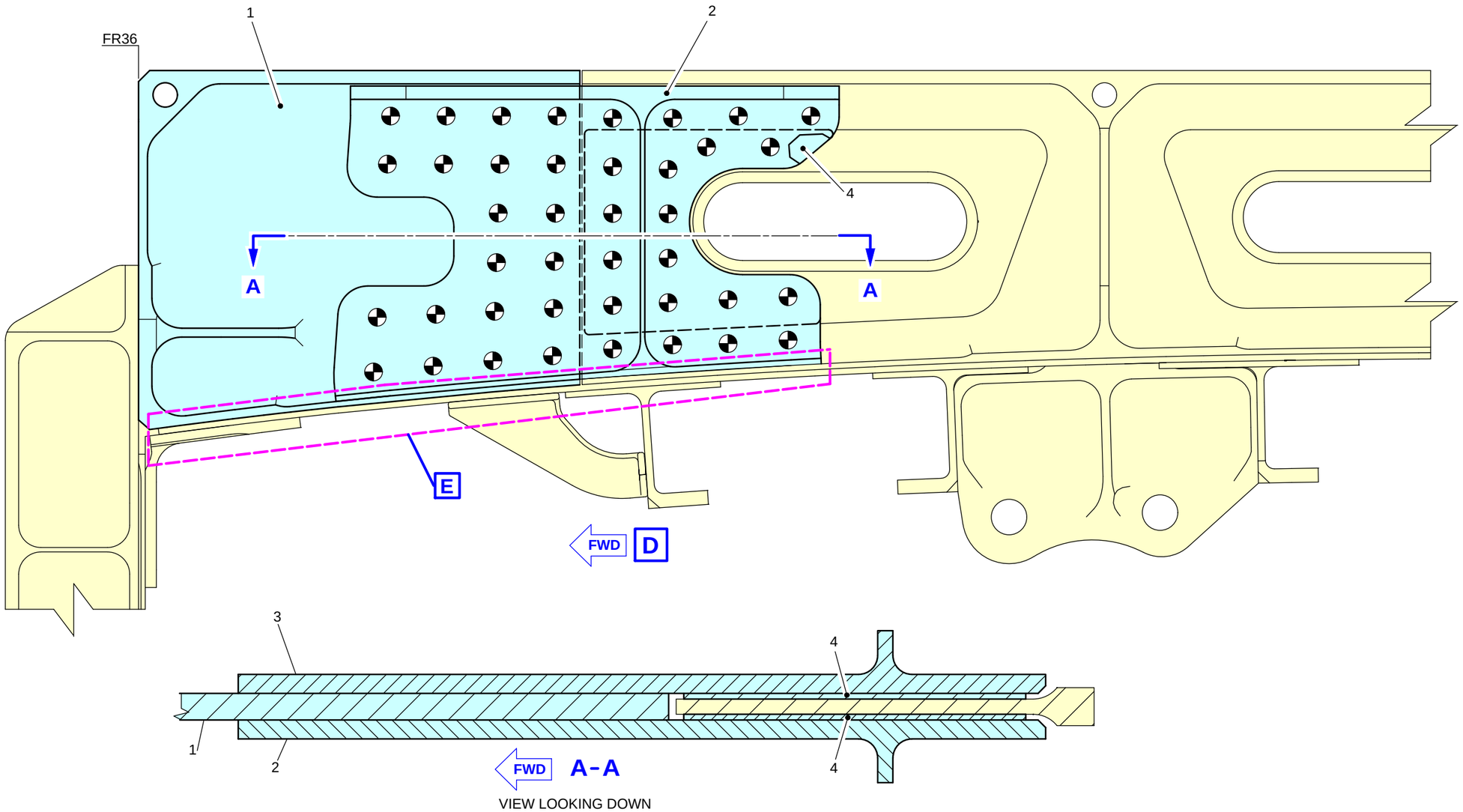
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

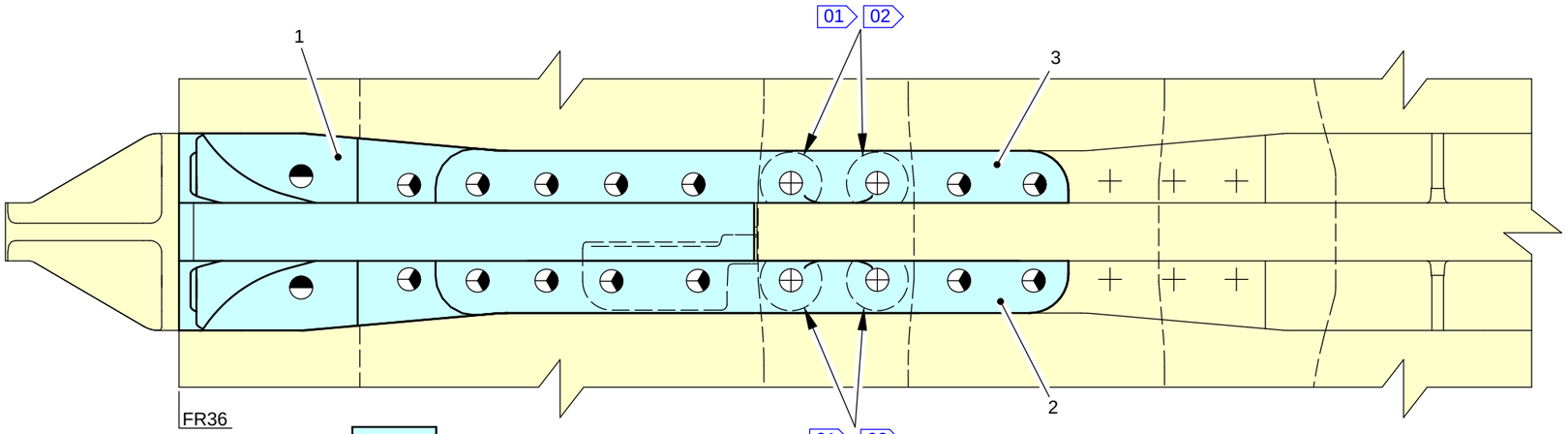


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

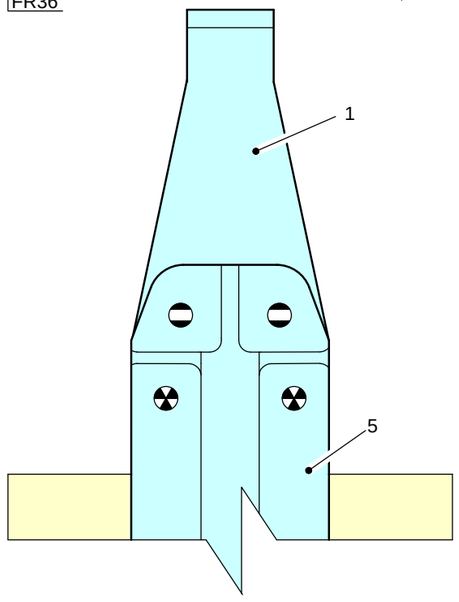
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(12) Task A320-A-57-XX-1228-02003-900A-A - Drill the New Parts on Y1292 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

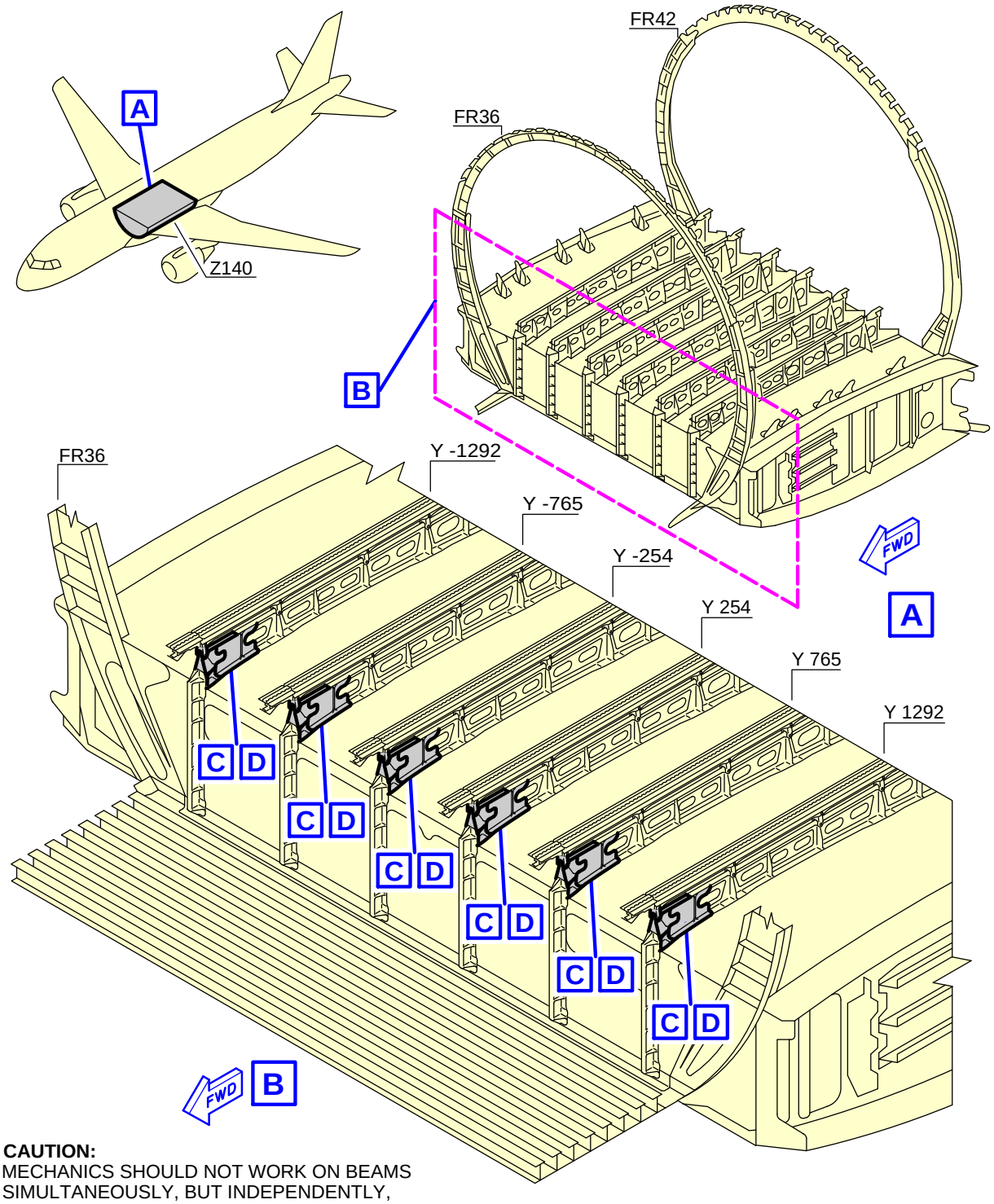
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

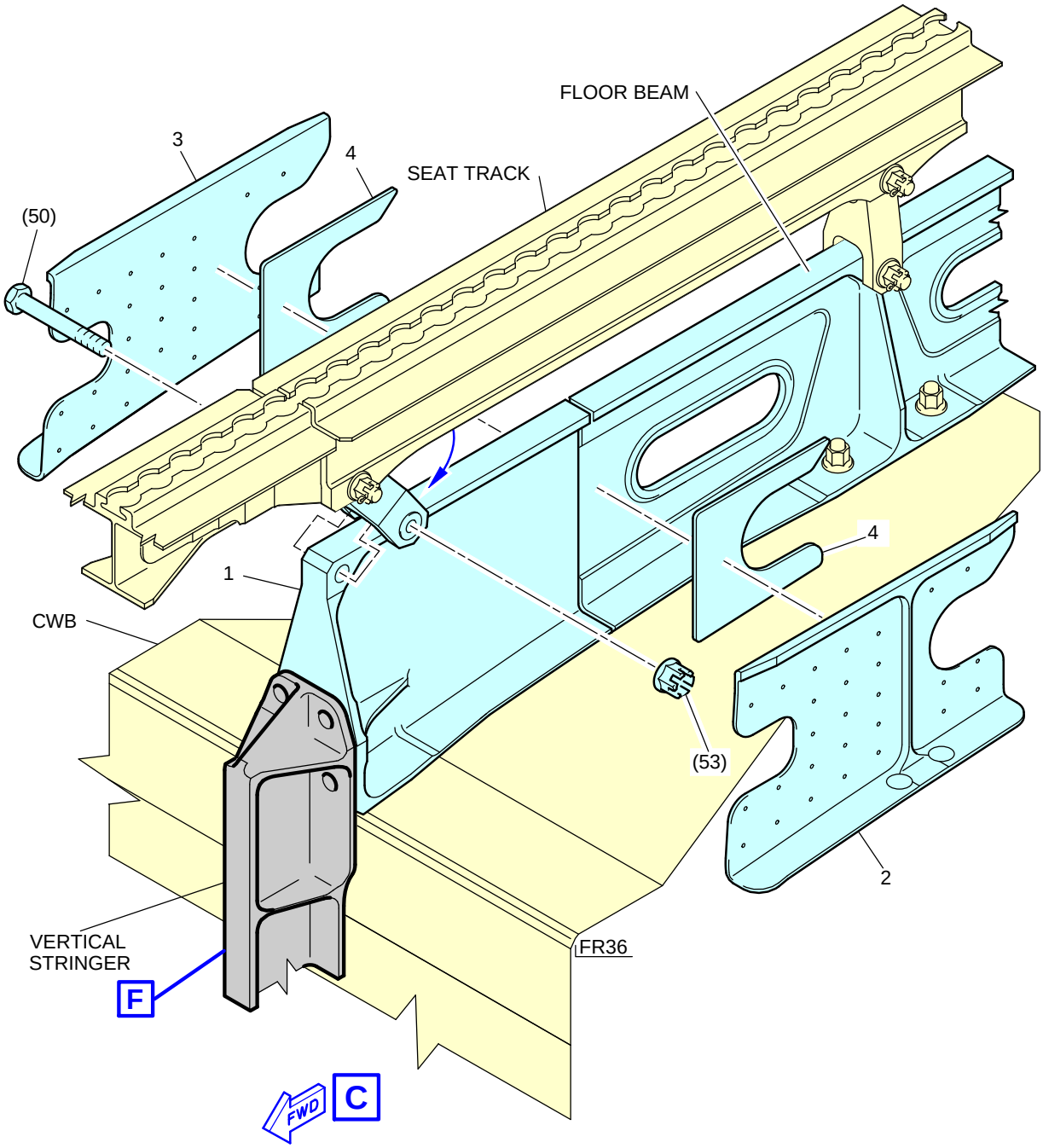


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

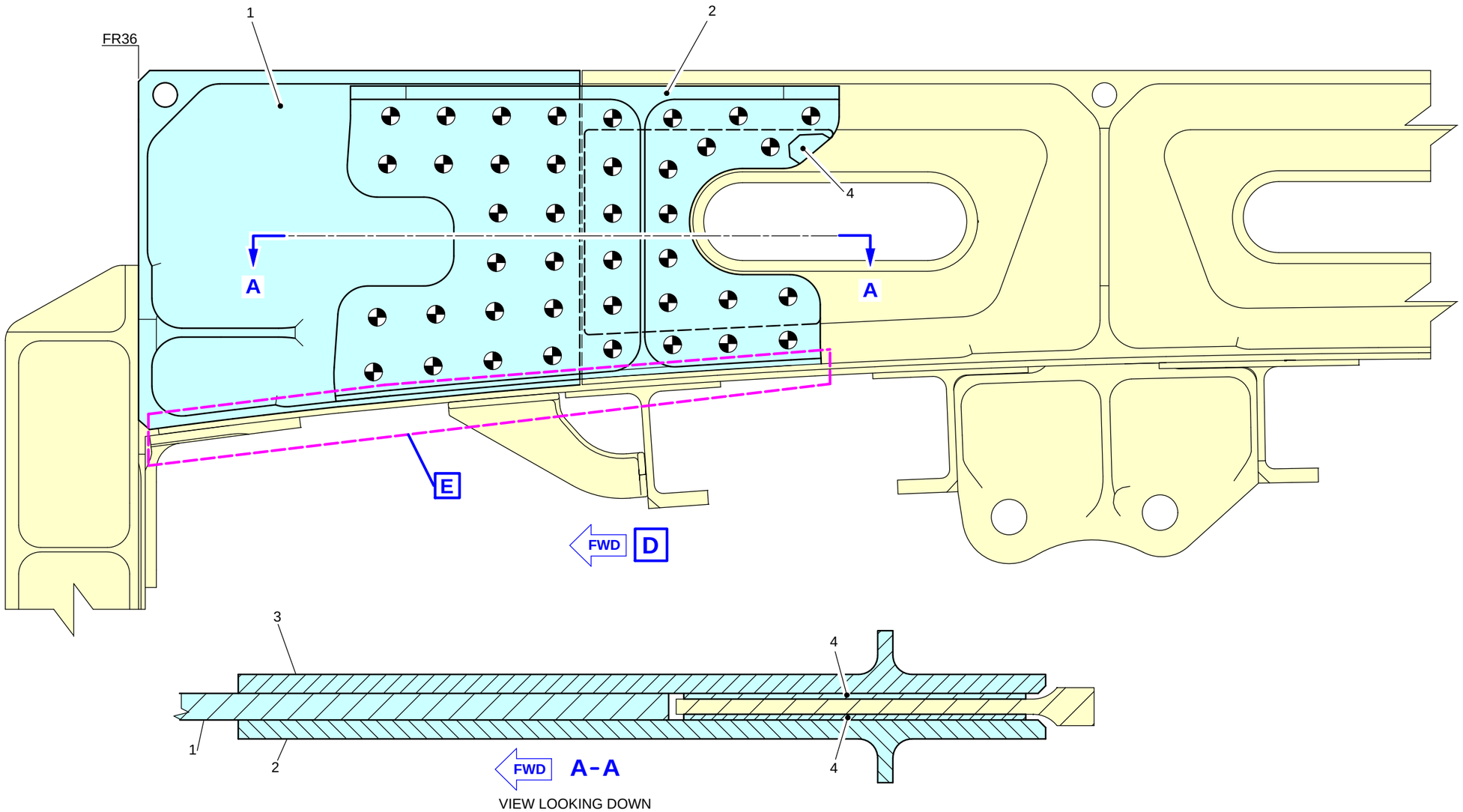
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

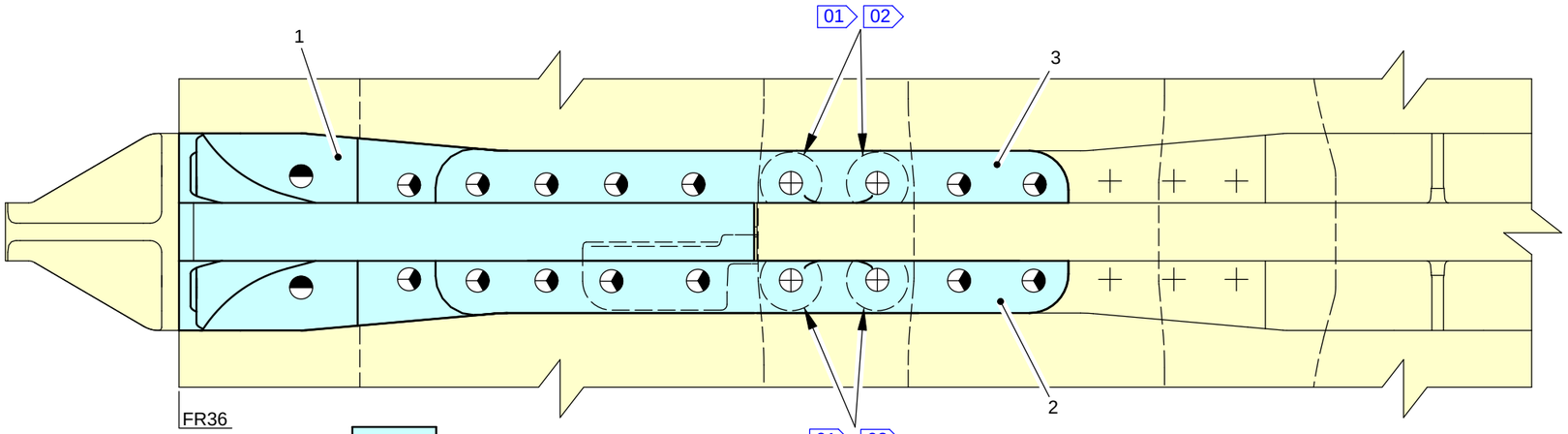


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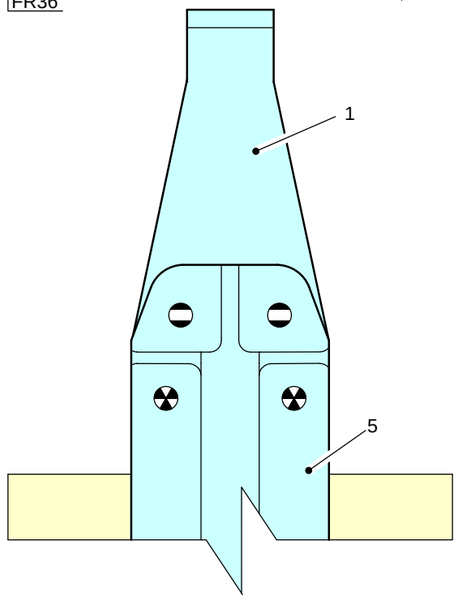
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(13) Task A320-A-57-XX-1228-03001-720A-A - Install the New Parts on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

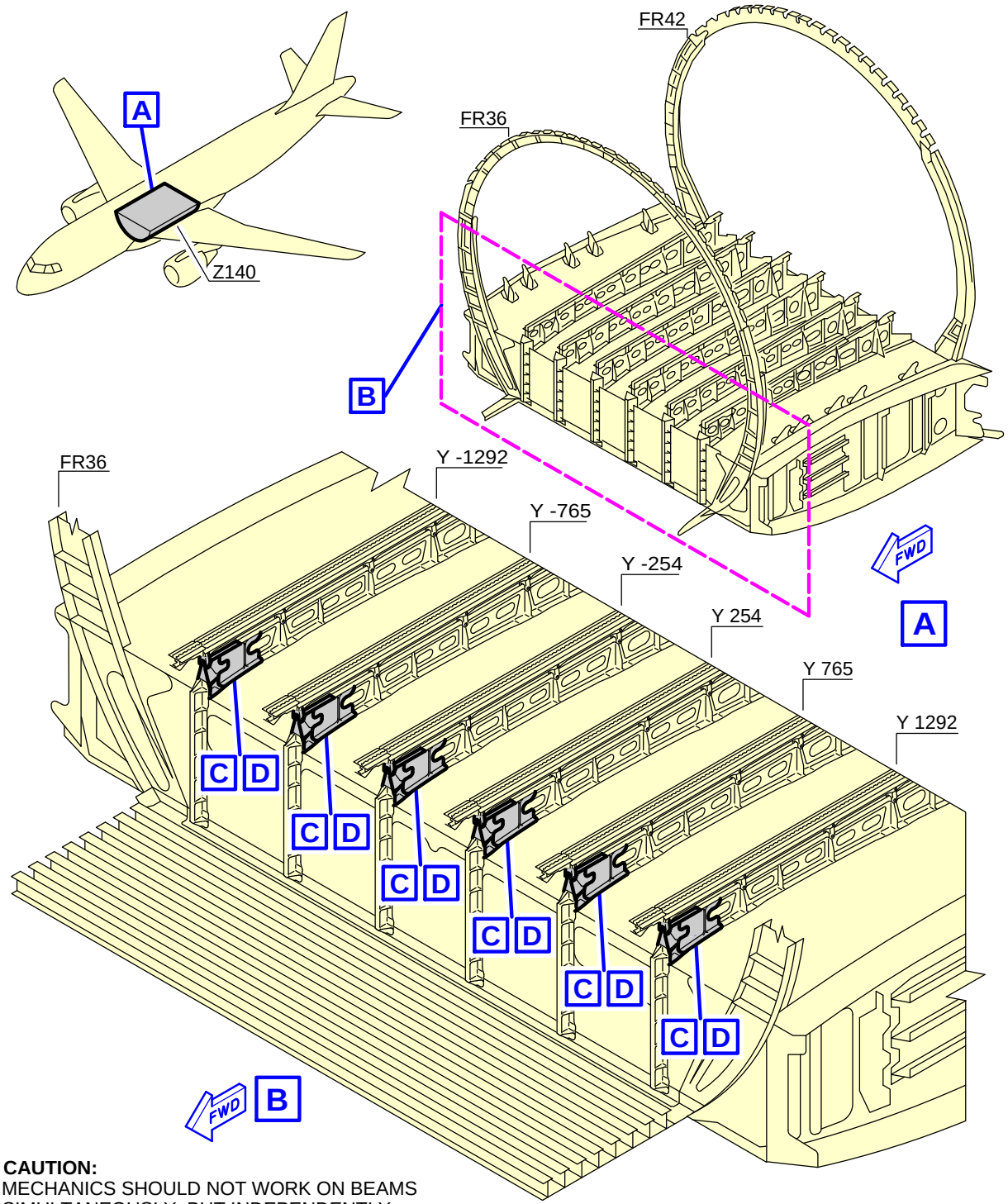
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

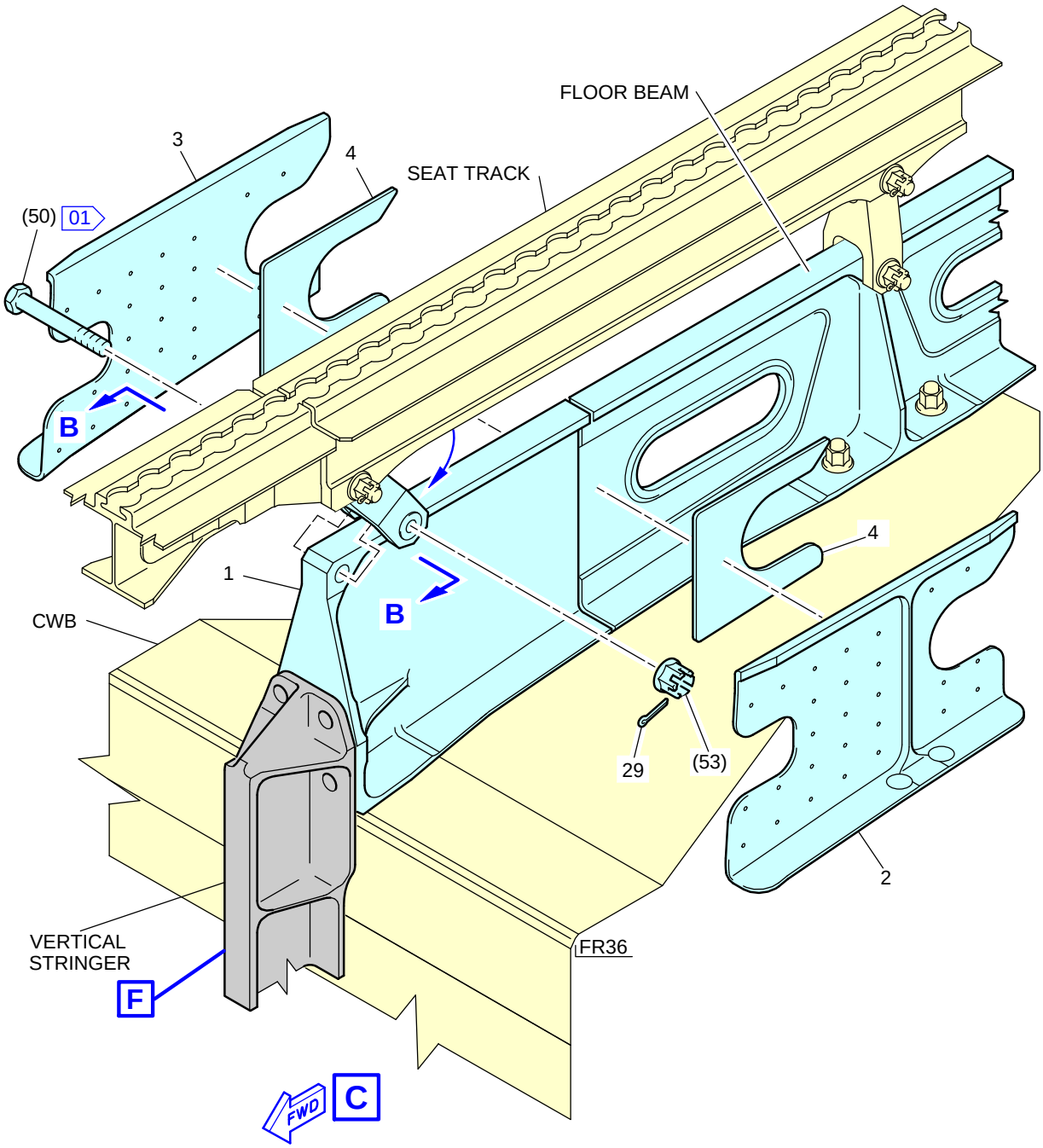


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



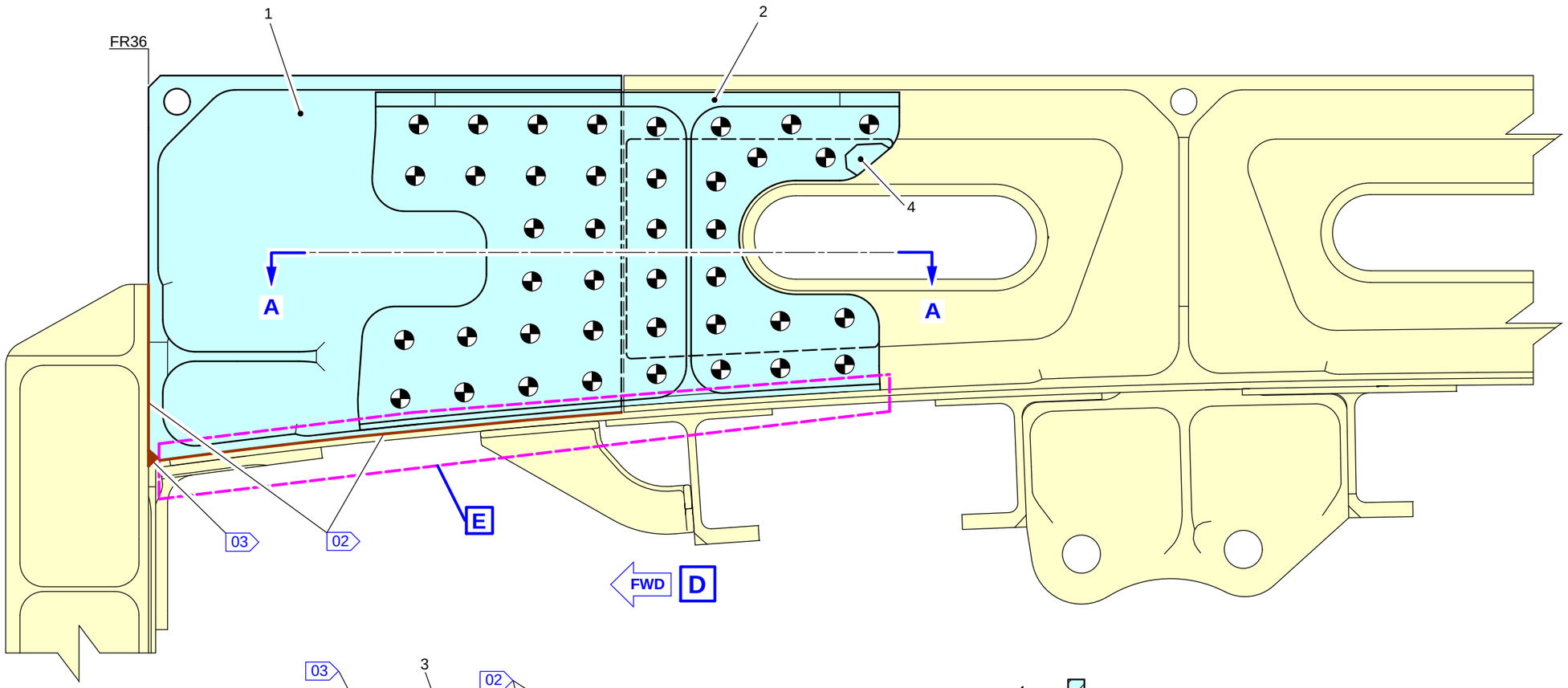
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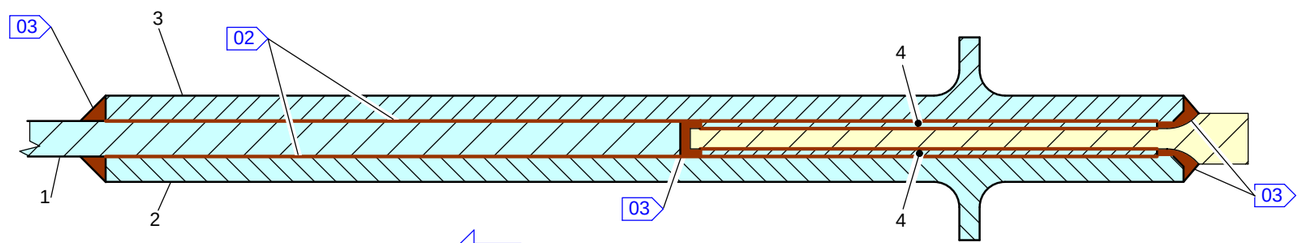
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

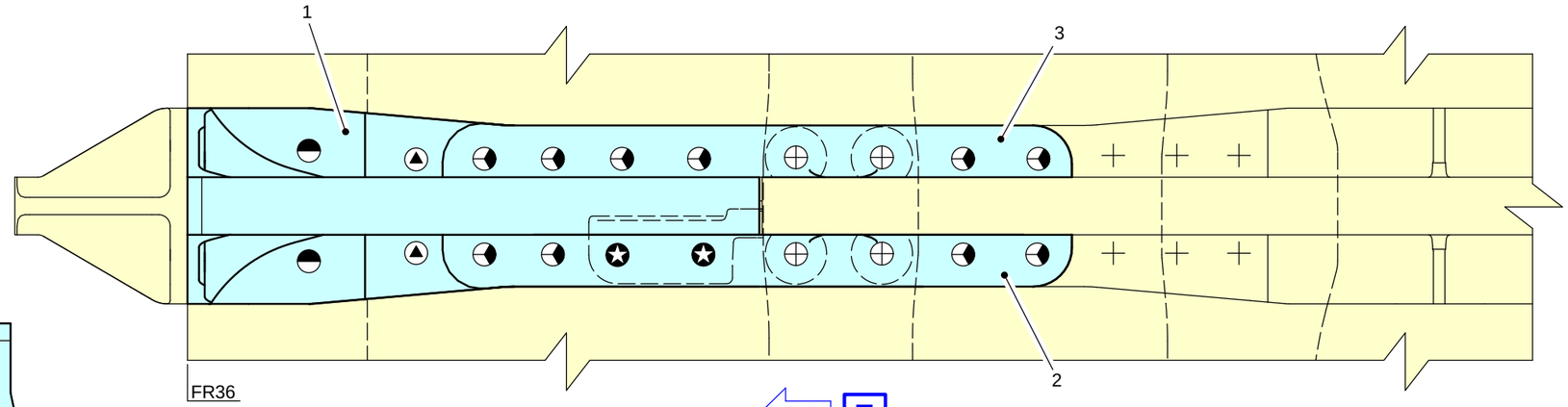
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

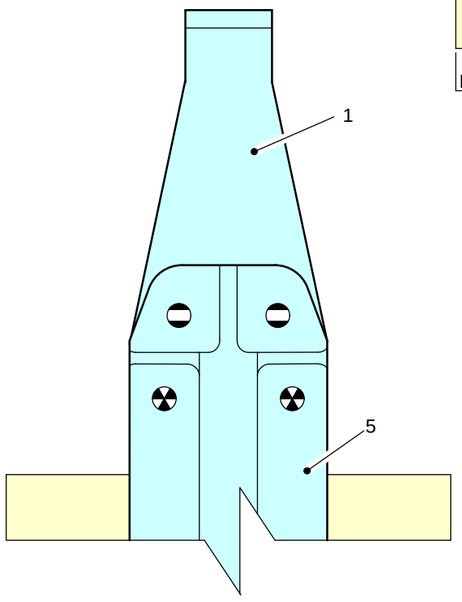
Installation of the New Parts at FR36

CONF 001 003 004



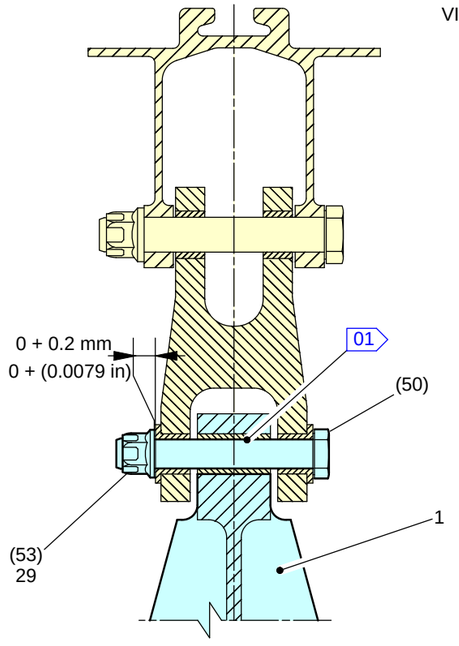


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 002

(13) Task A320-A-57-XX-1228-03002-720A-A - Install the New Parts on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

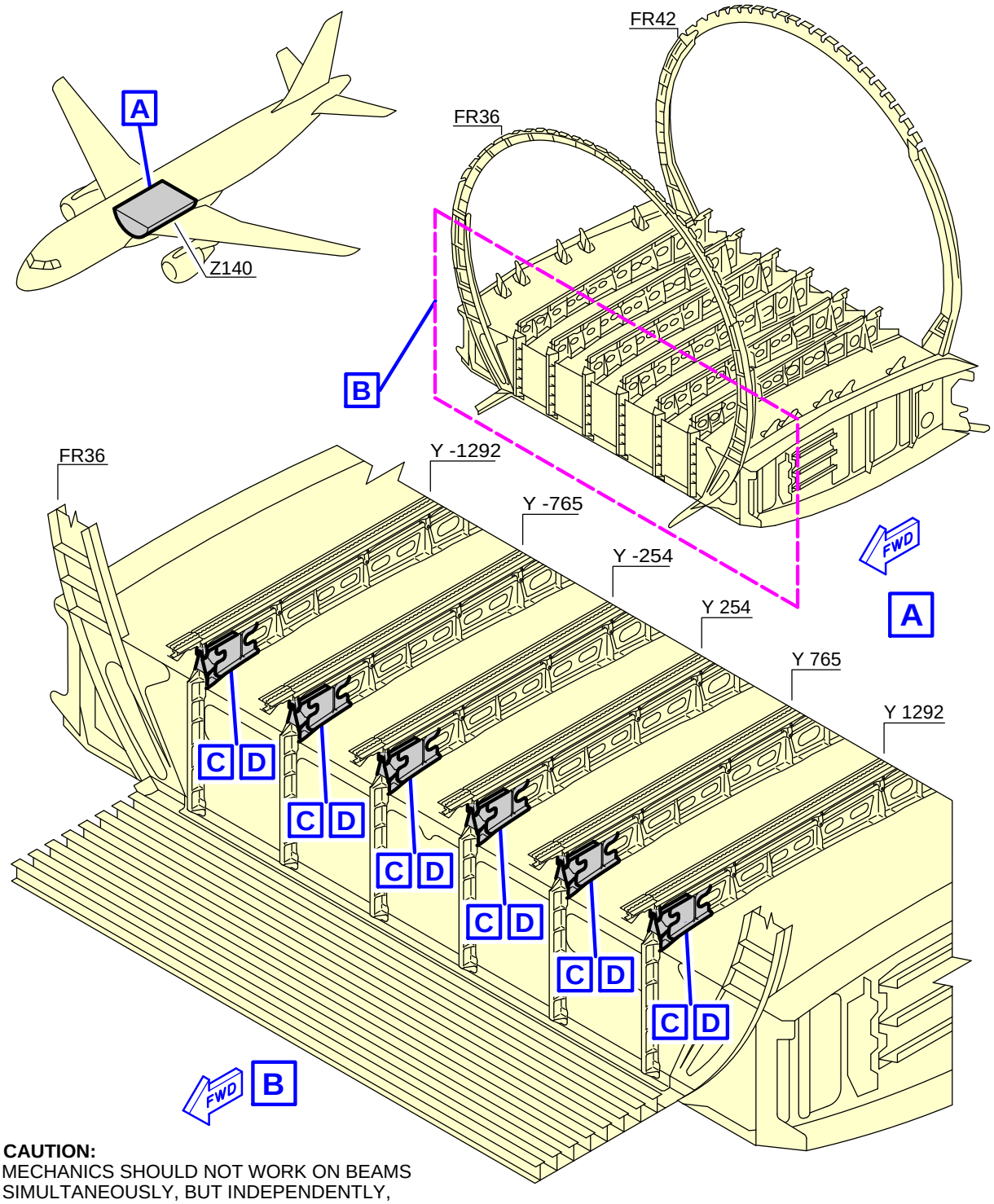
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

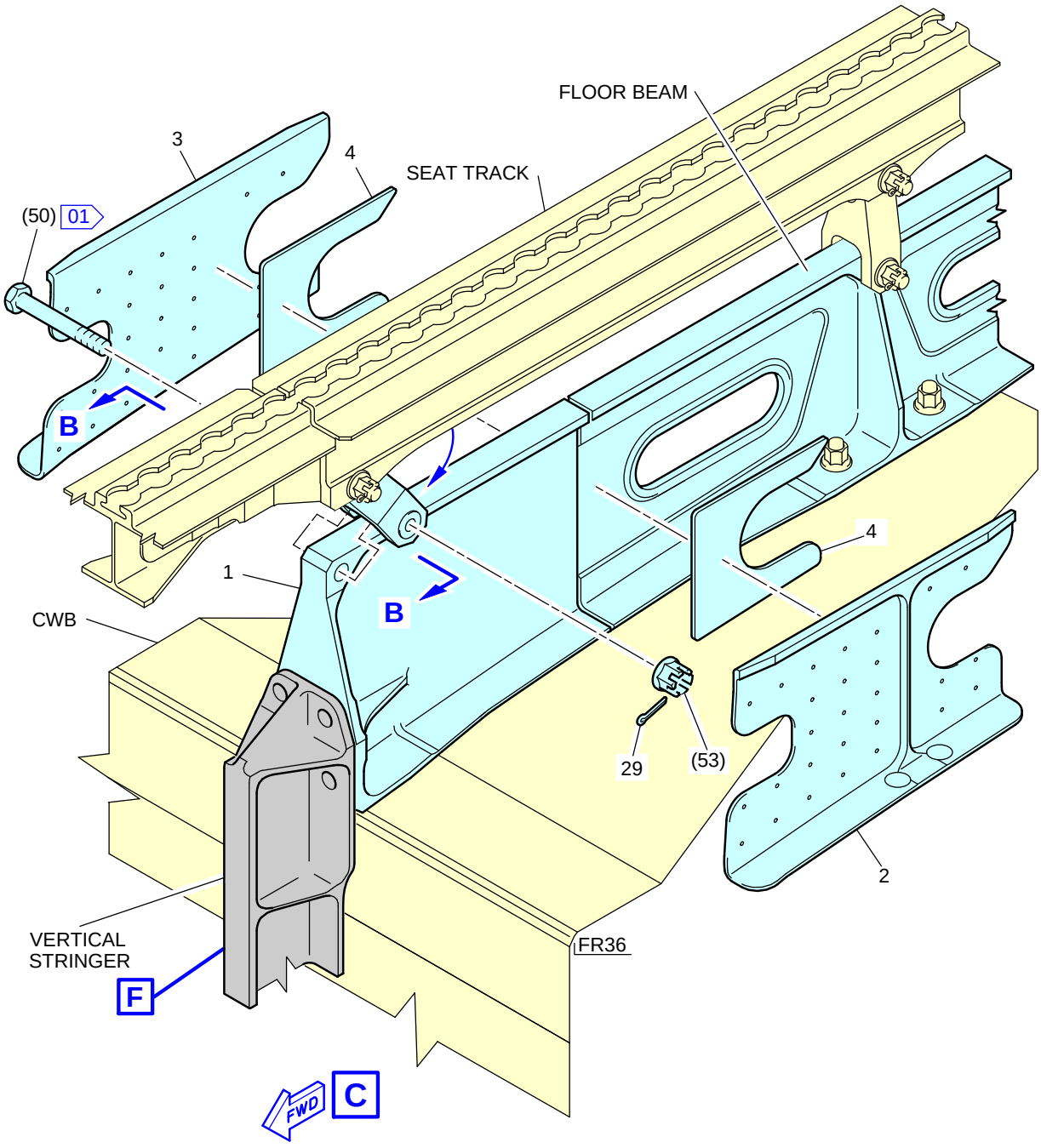


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



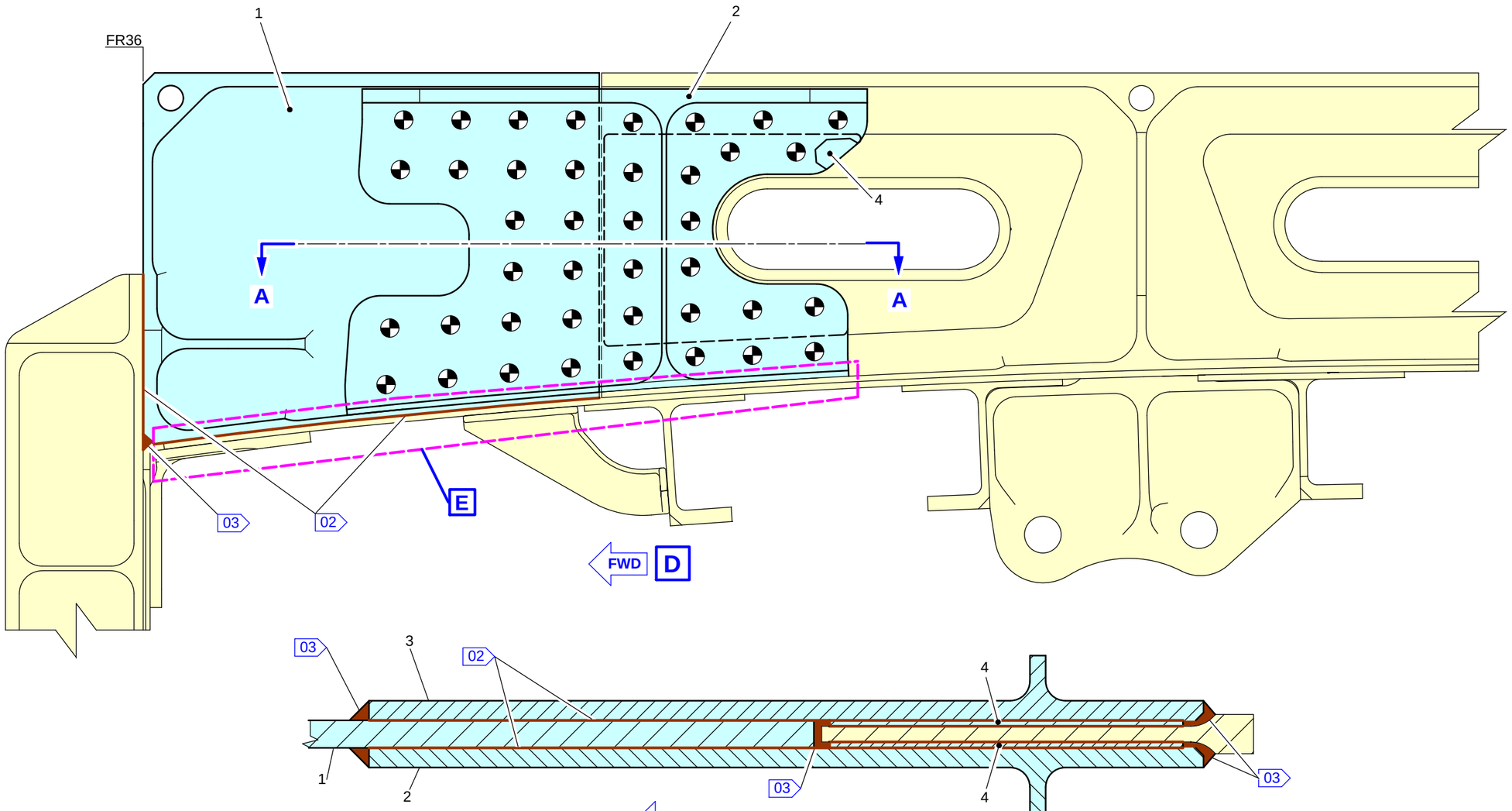
NOTE:

01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002



VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

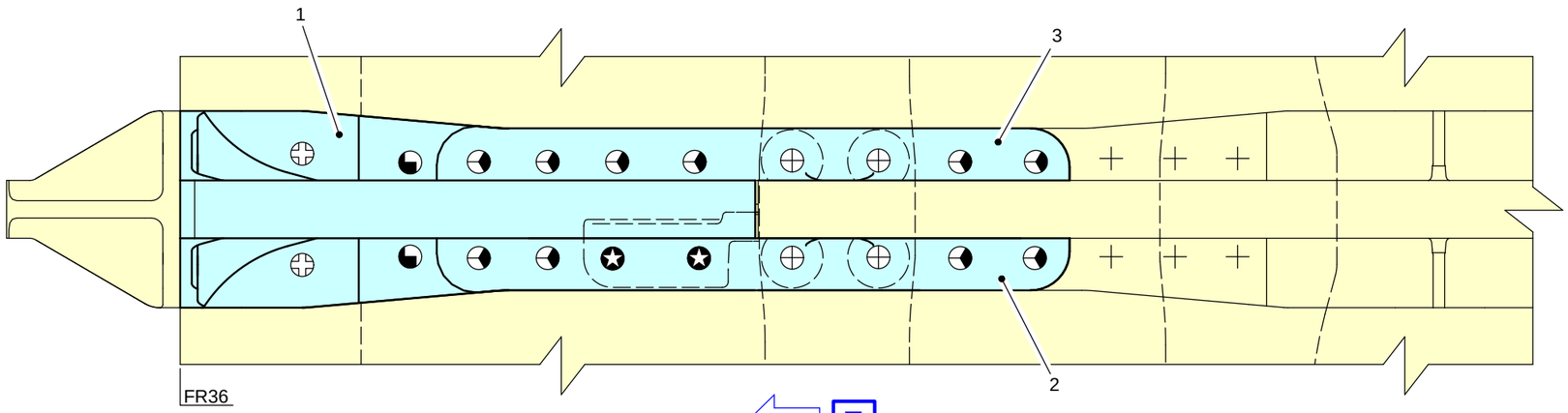
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

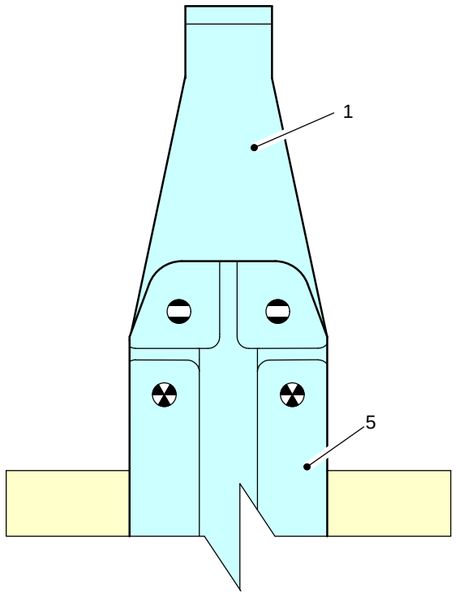
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

CONF 002

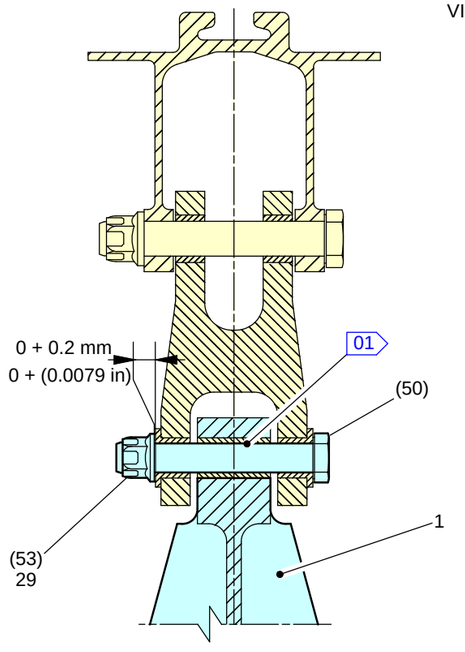


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(14) Task A320-A-57-XX-1228-01001-250A-A - Protect the Fasteners and the New Parts on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

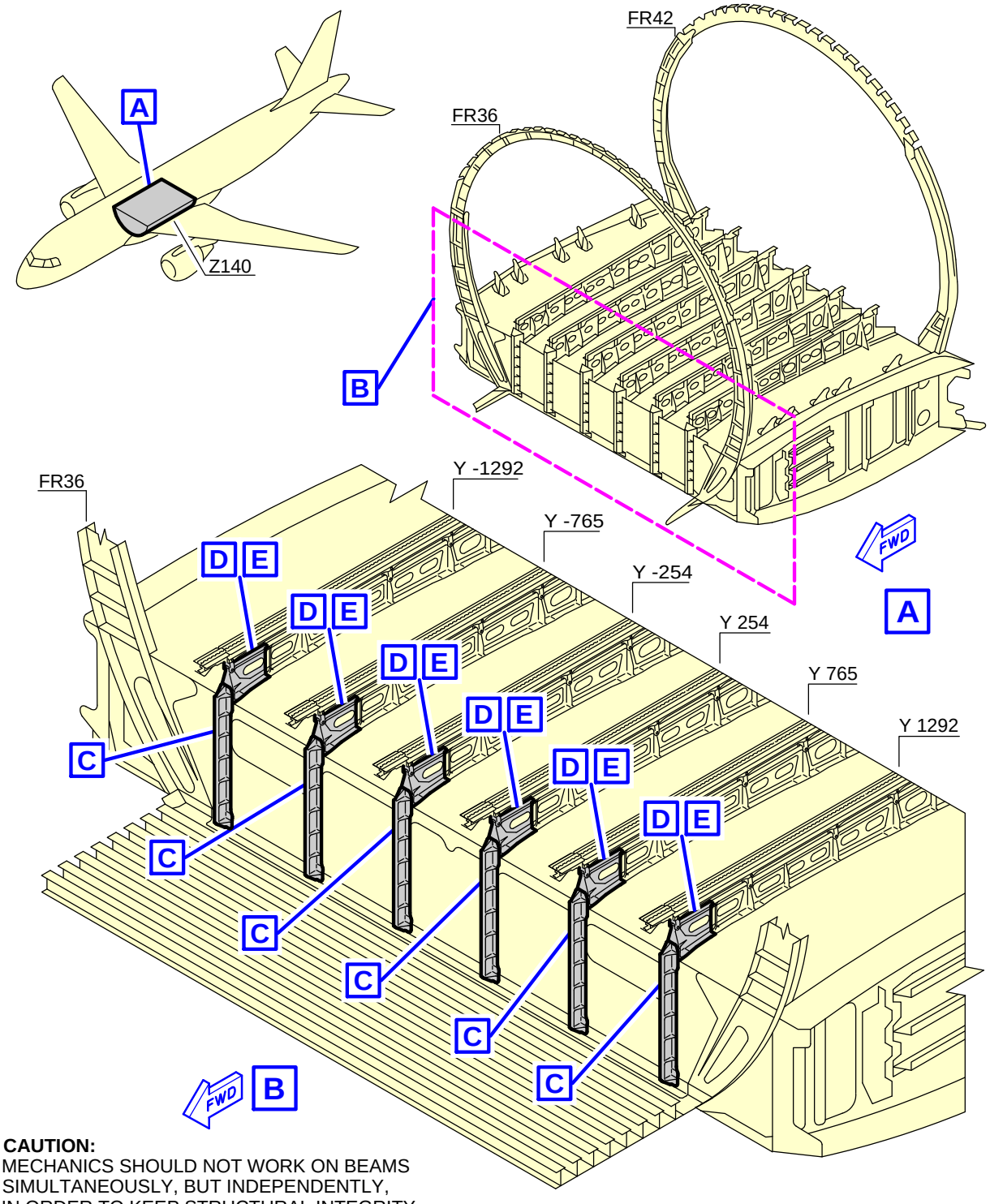
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

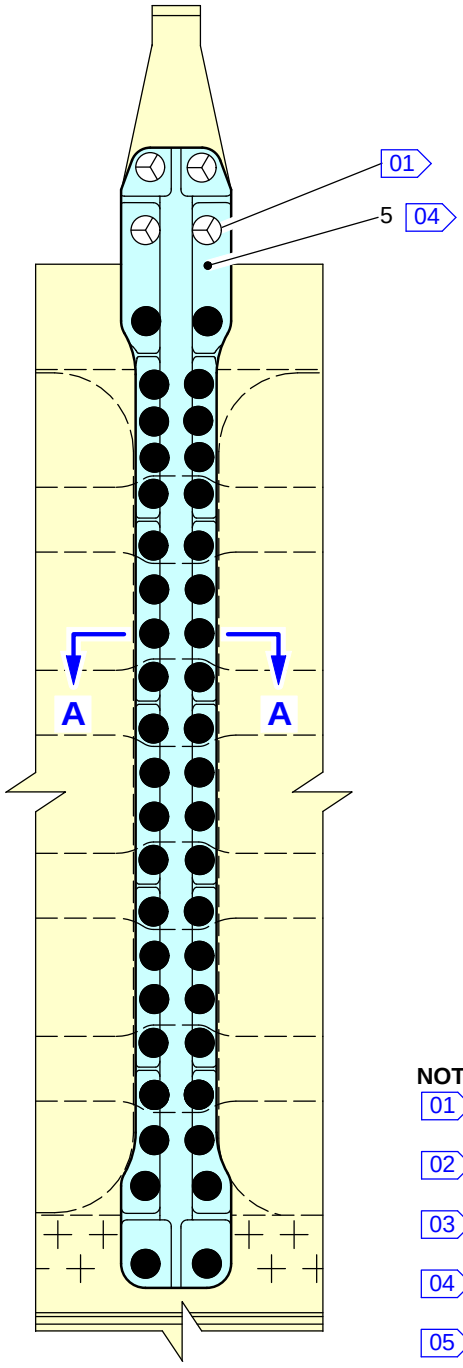


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

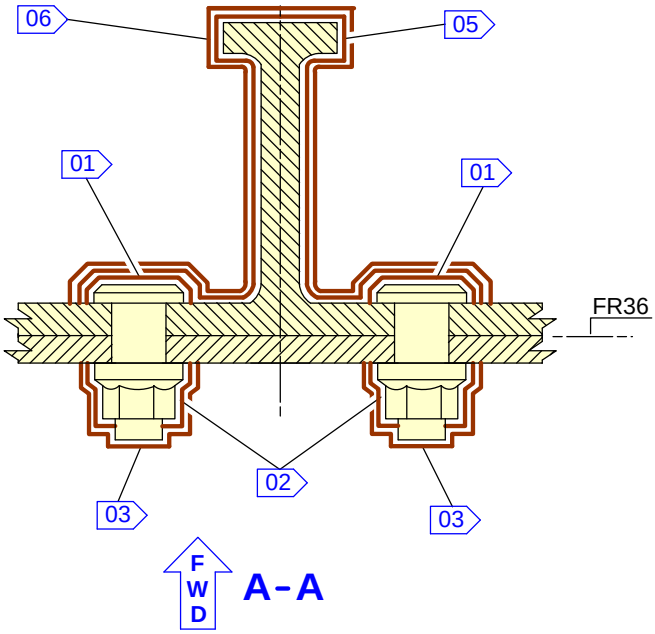
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊘	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

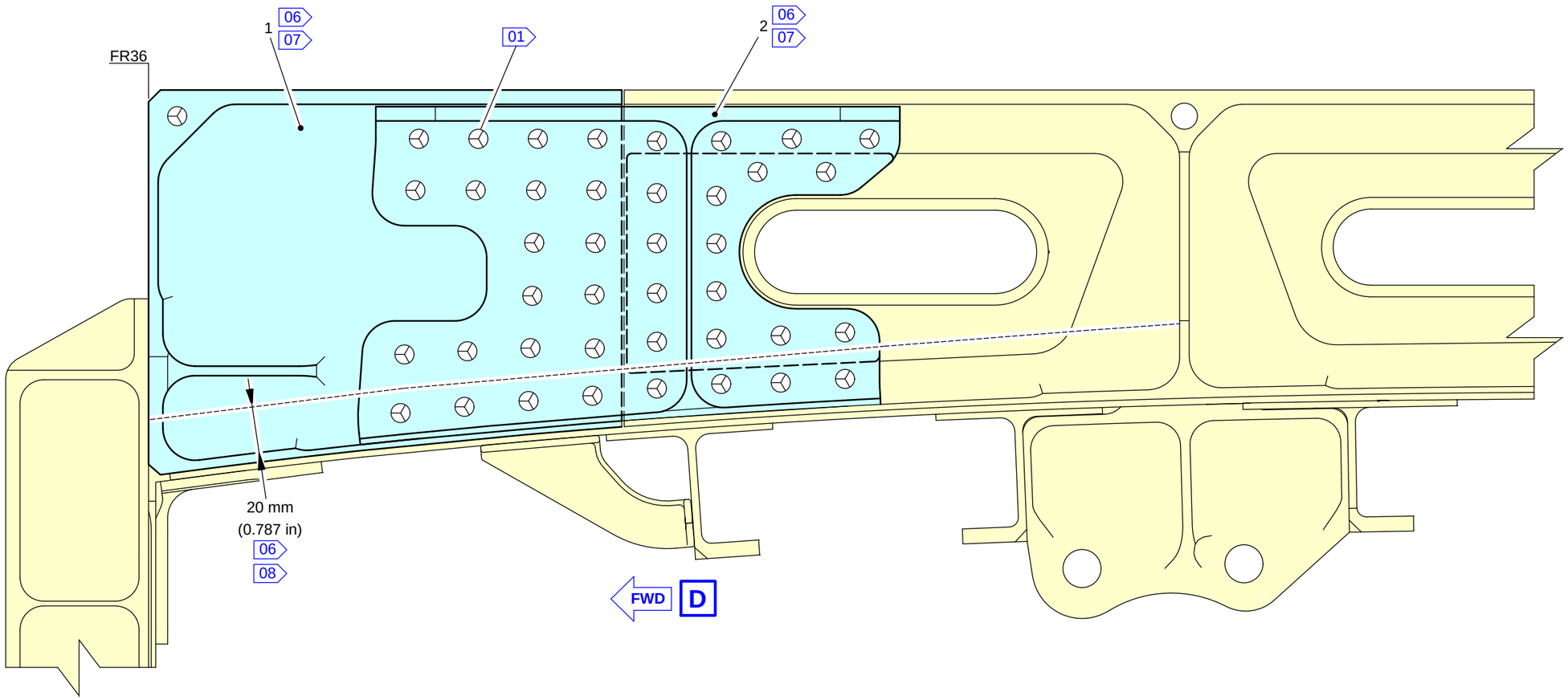
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

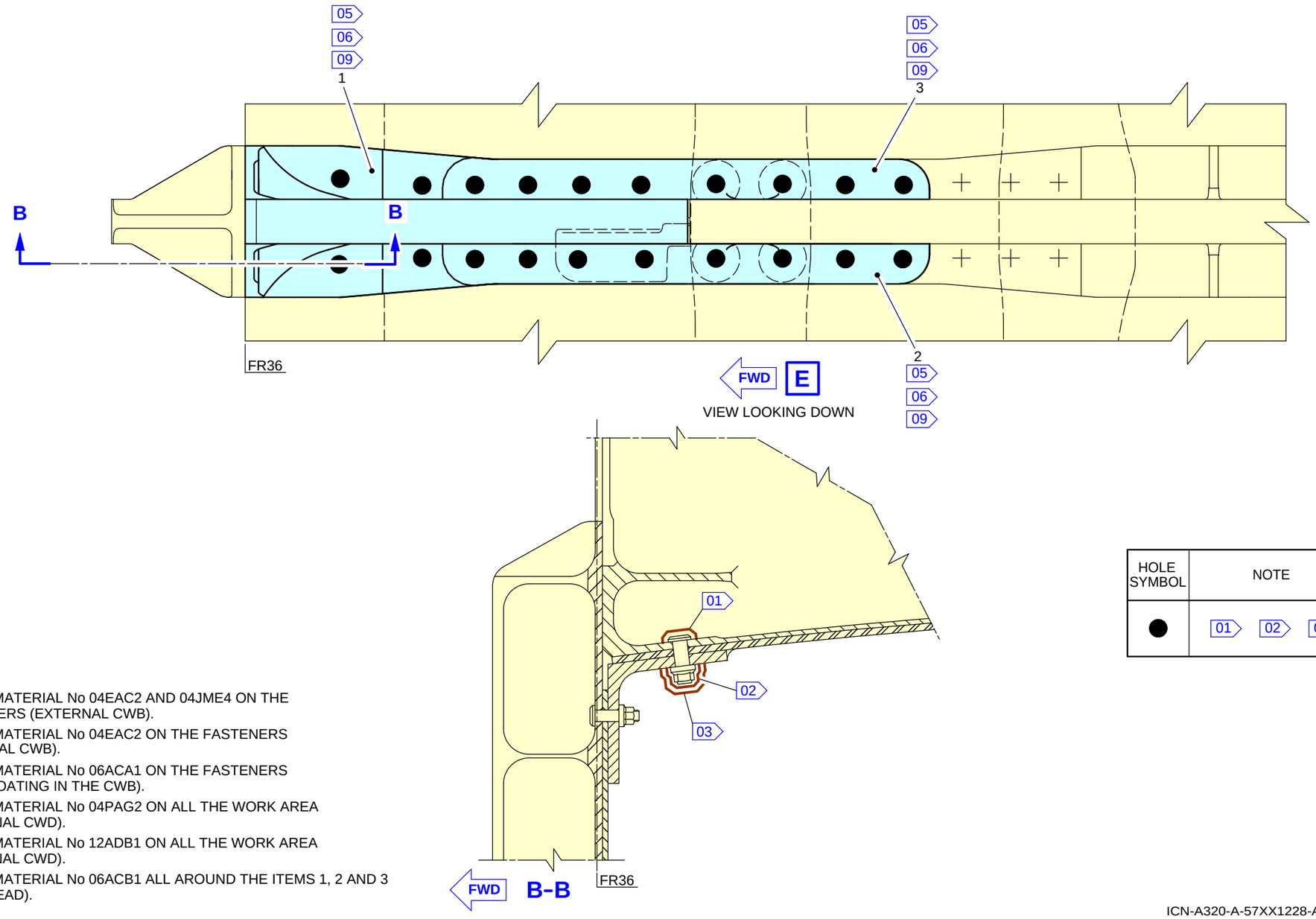
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(14) Task A320-A-57-XX-1228-01002-250A-A - Protect the Fasteners and the New Parts on Y1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

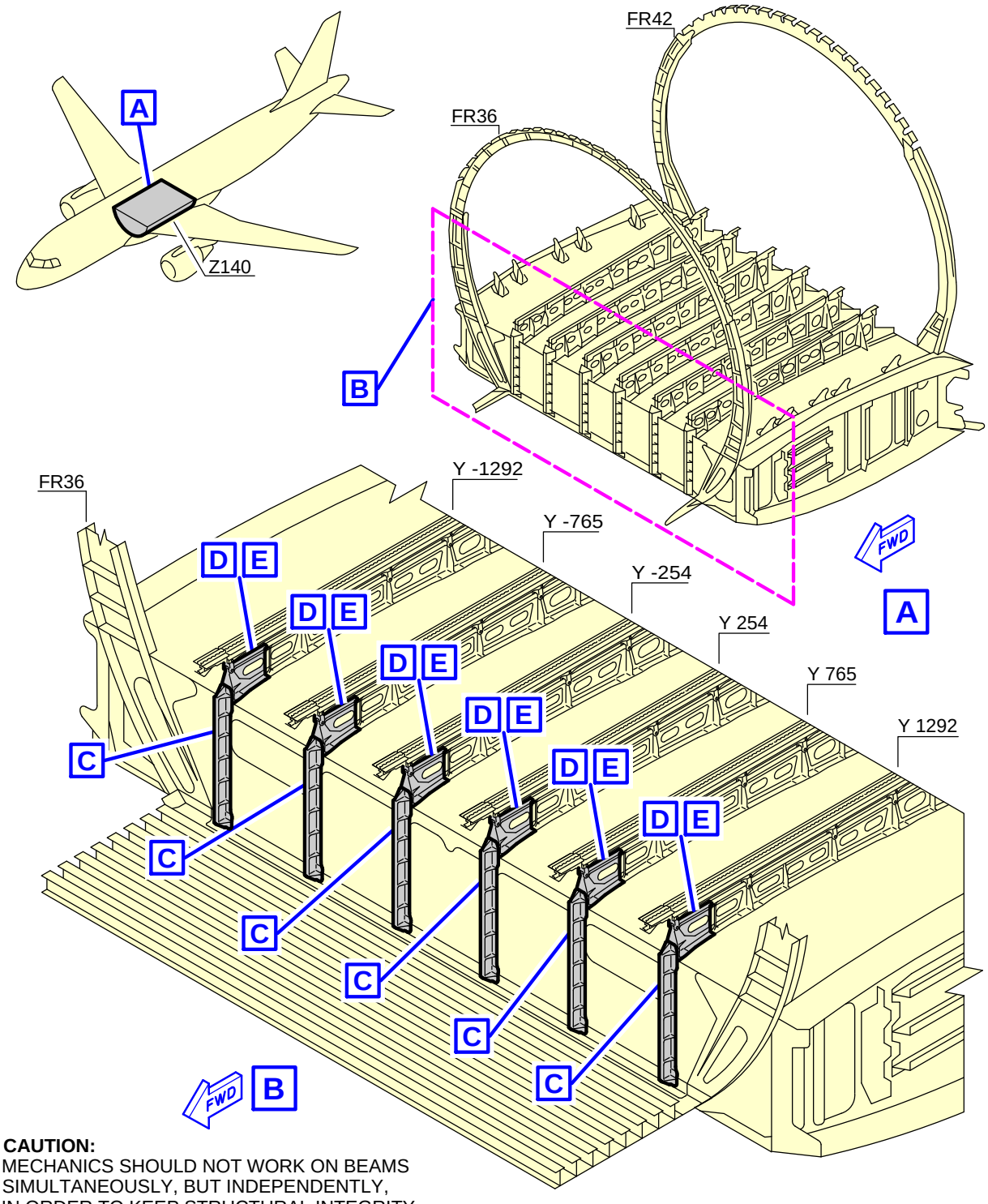
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

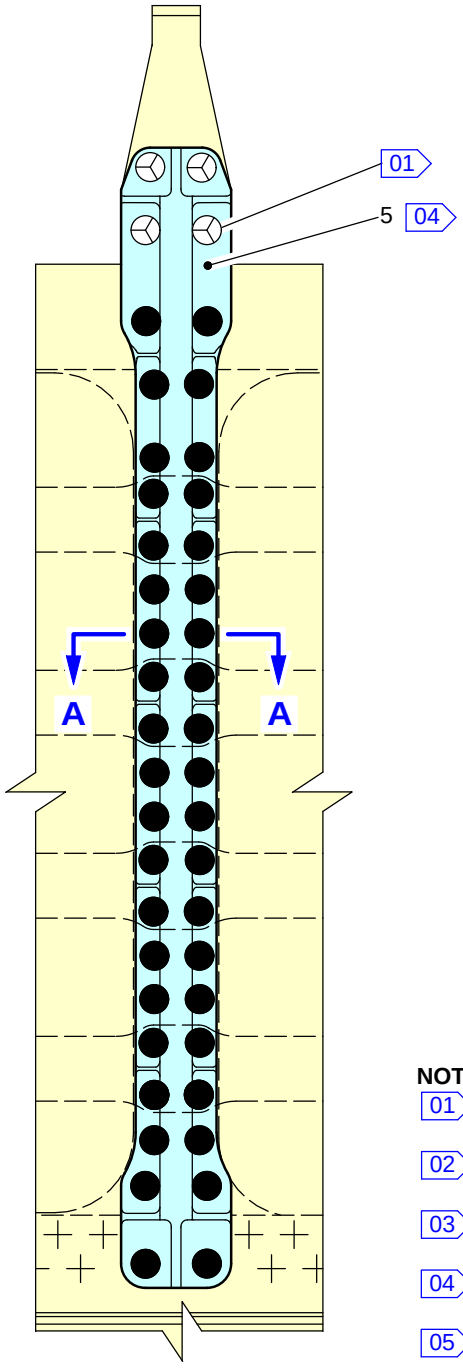


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

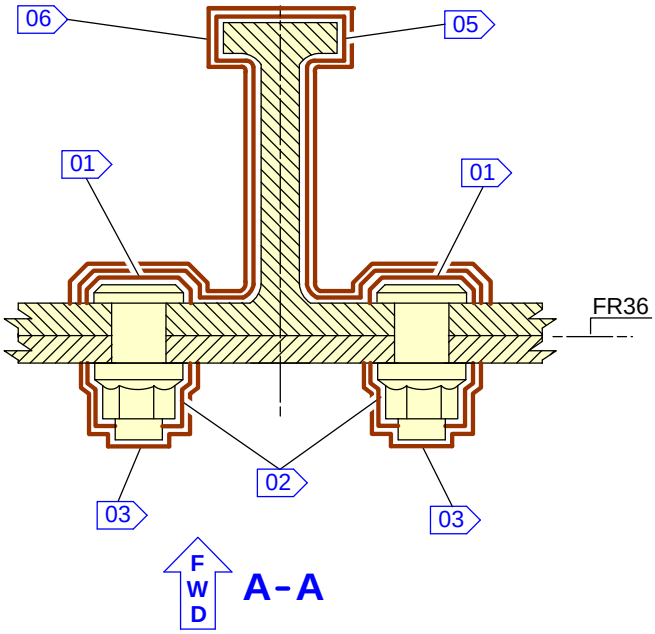
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

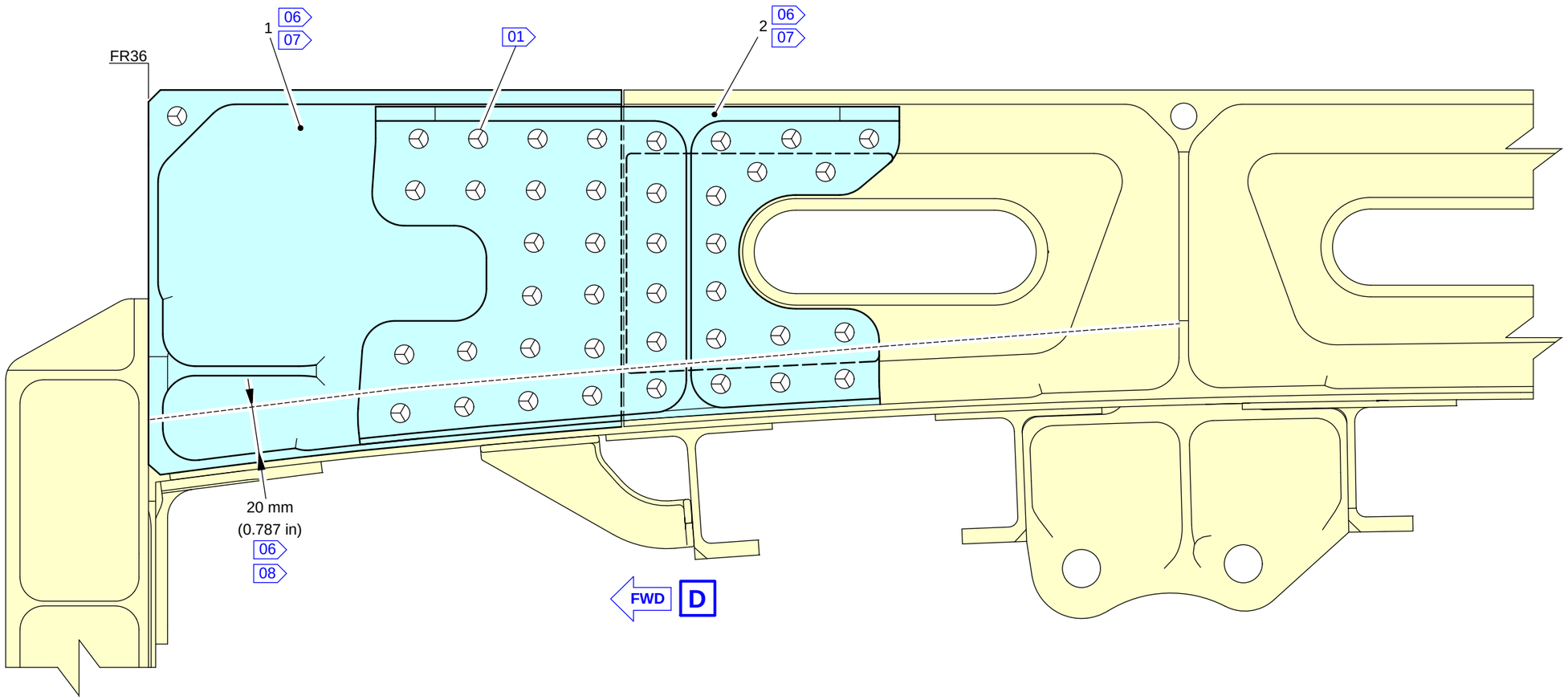
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

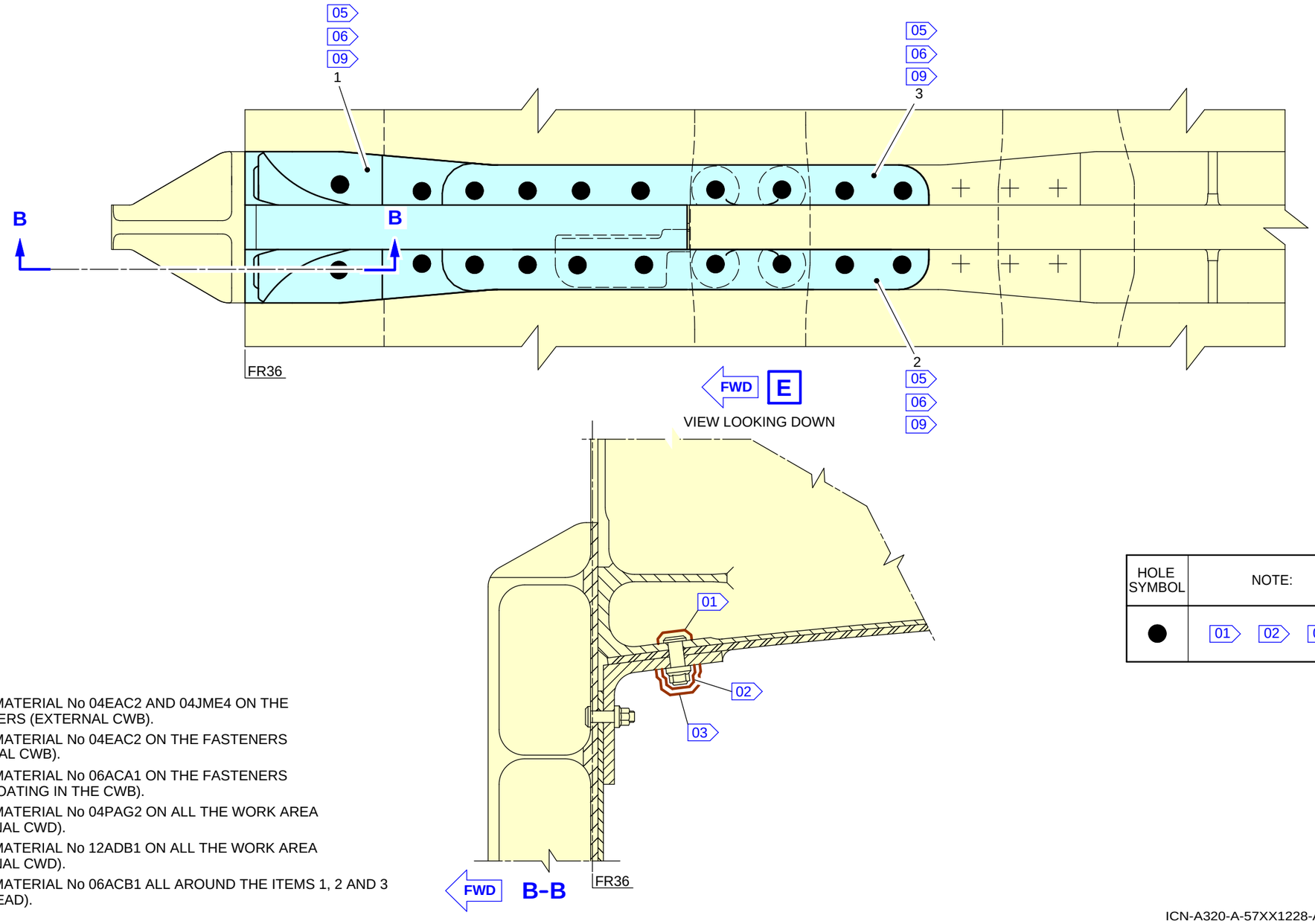
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

(15) Task A320-A-57-XX-1228-07001-520A-A - Remove the Strut Lower Attachment on Y765 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

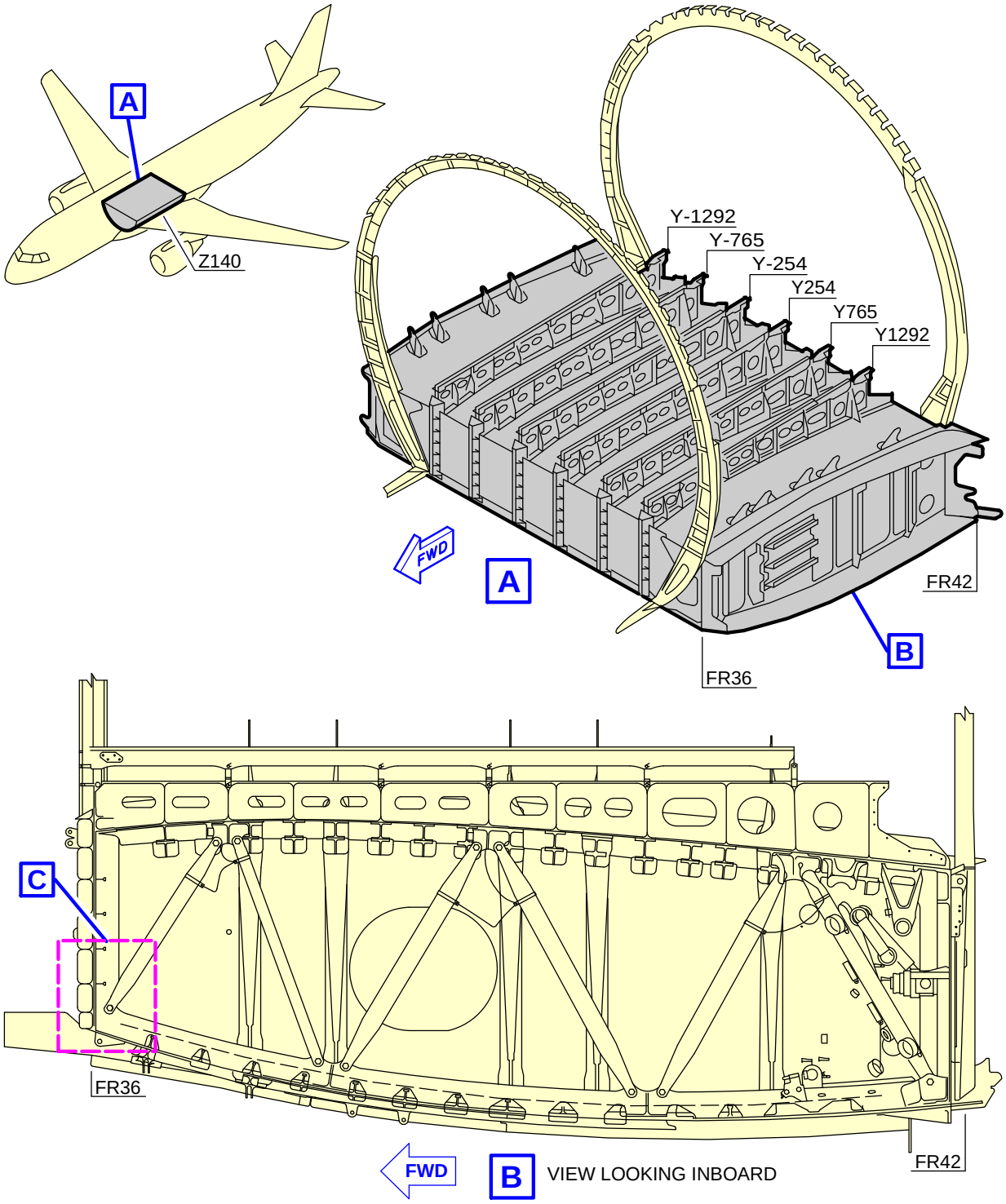
1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain

1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

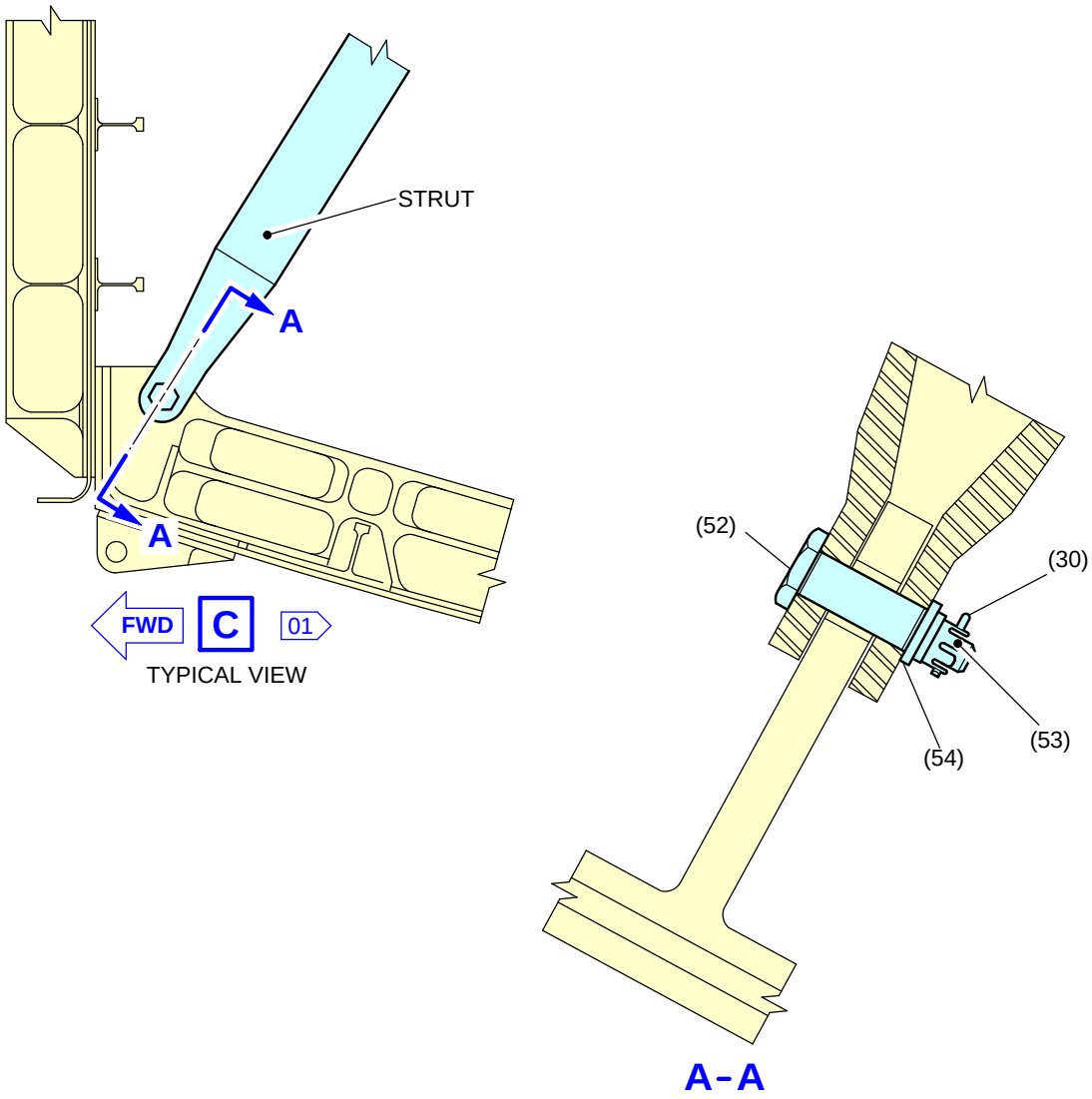
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(16) Task A320-A-57-XX-1228-08001-520A-A - Remove the Vertical Stringer on Y765 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

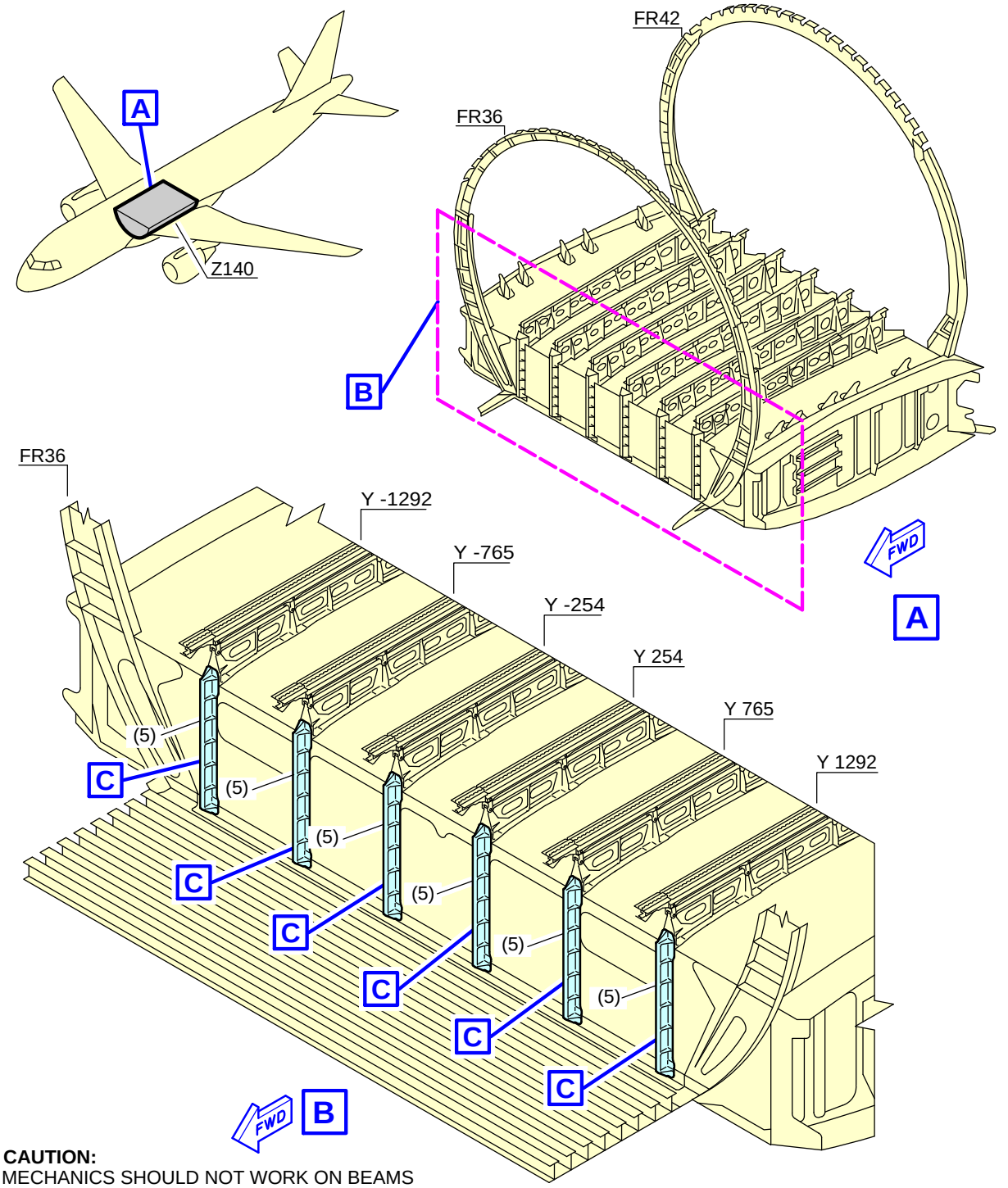
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-08ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

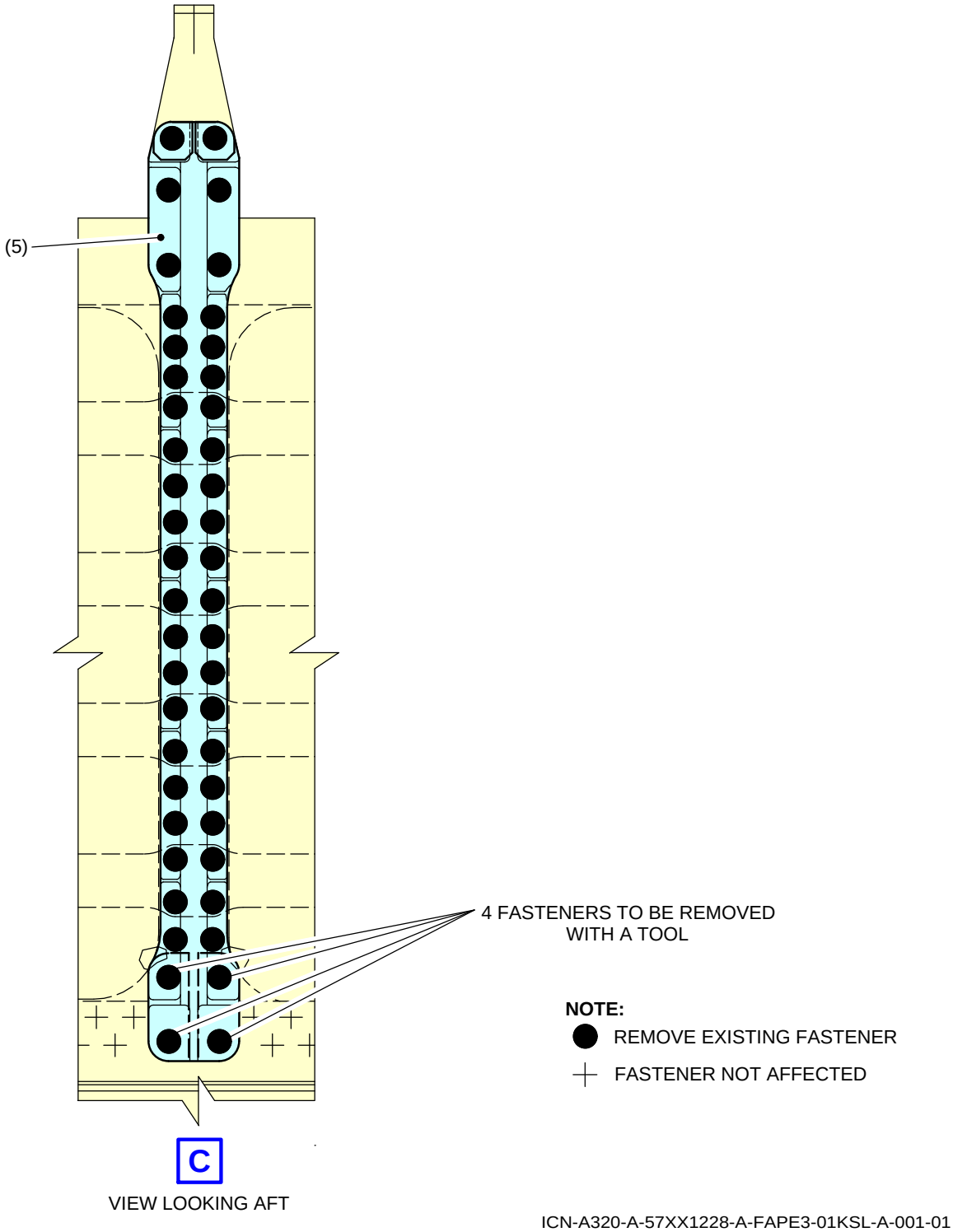


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

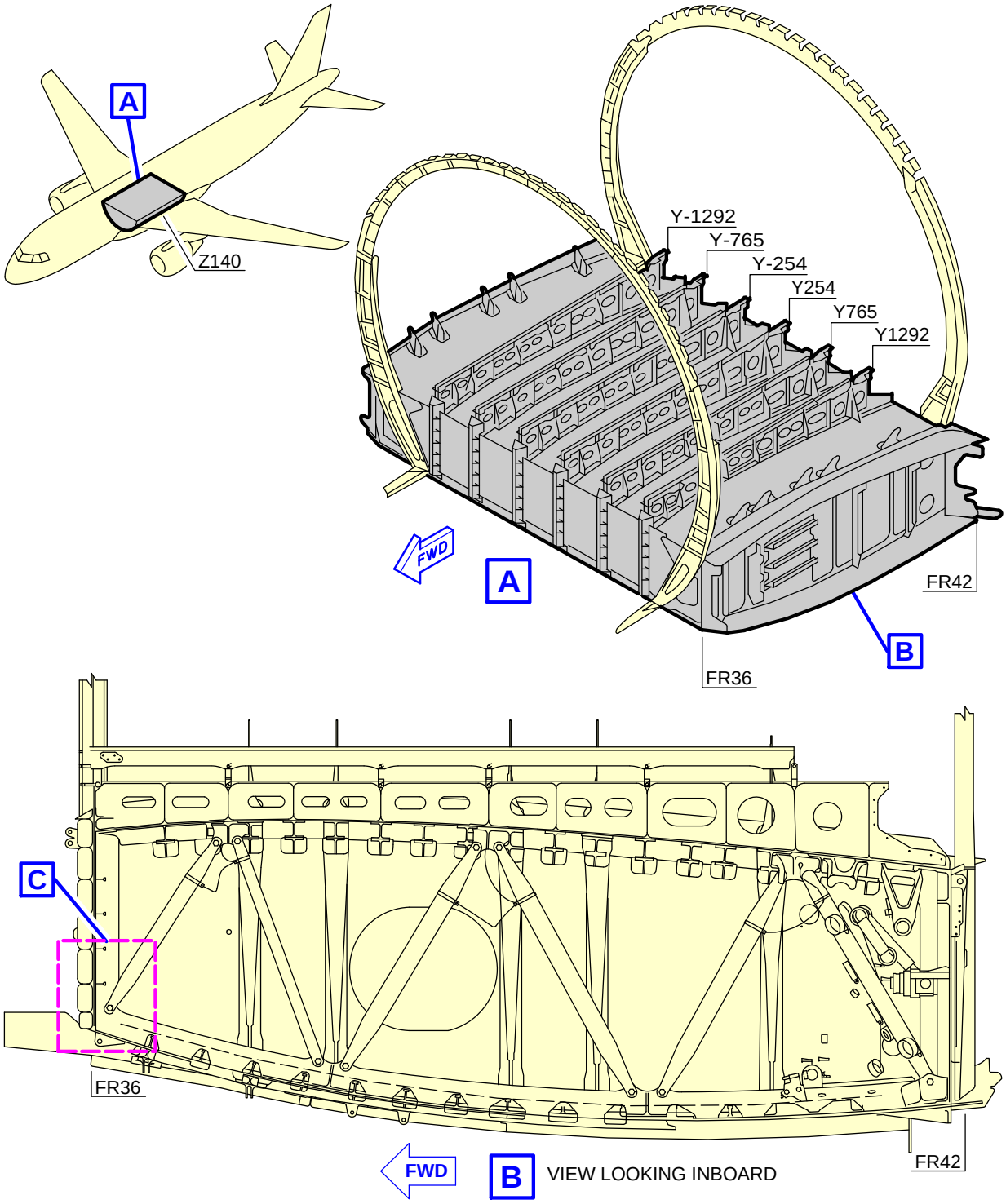
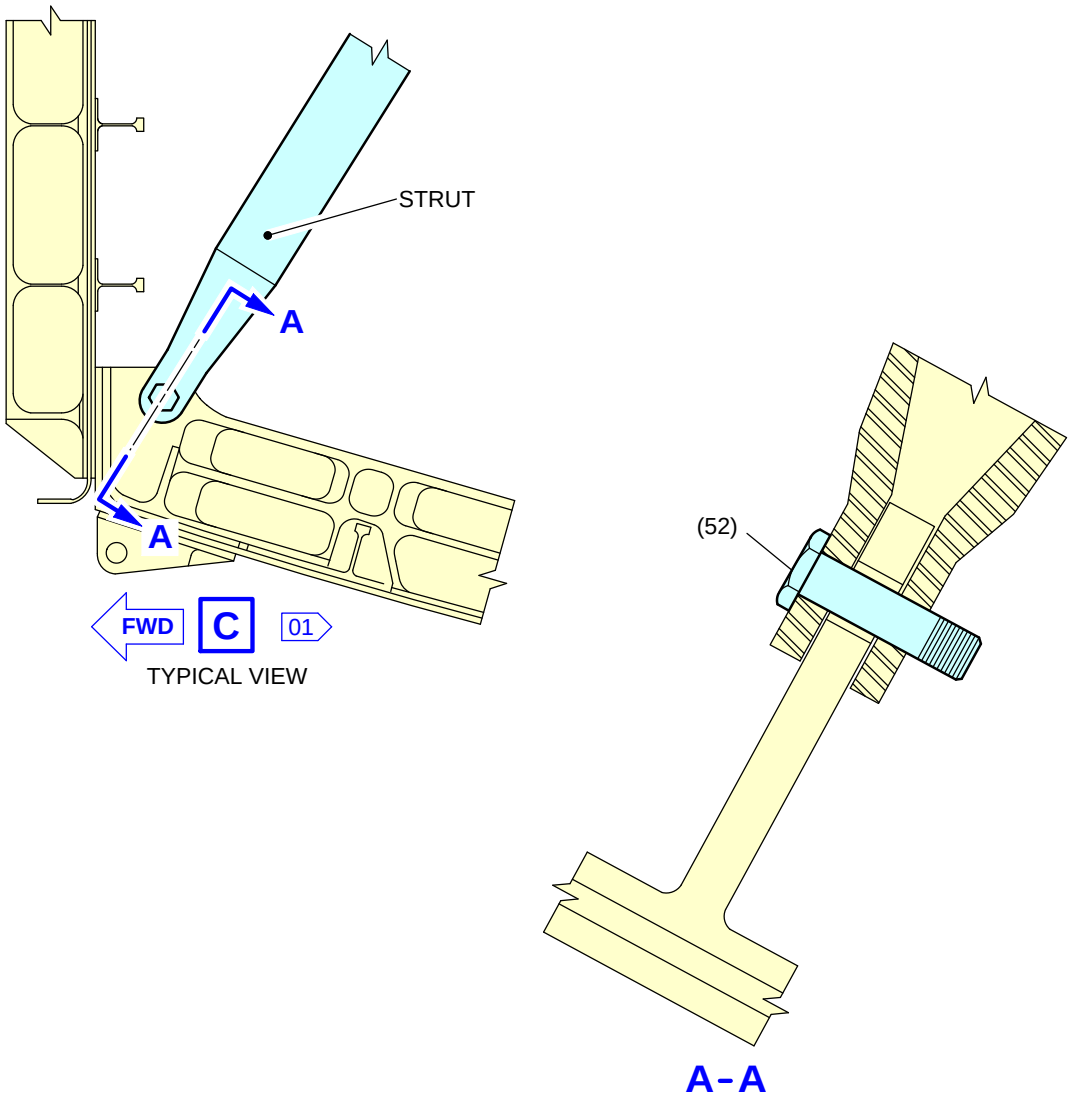


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(16) Task A320-A-57-XX-1228-08002-520A-A - Remove the Vertical Stringer on Y765 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

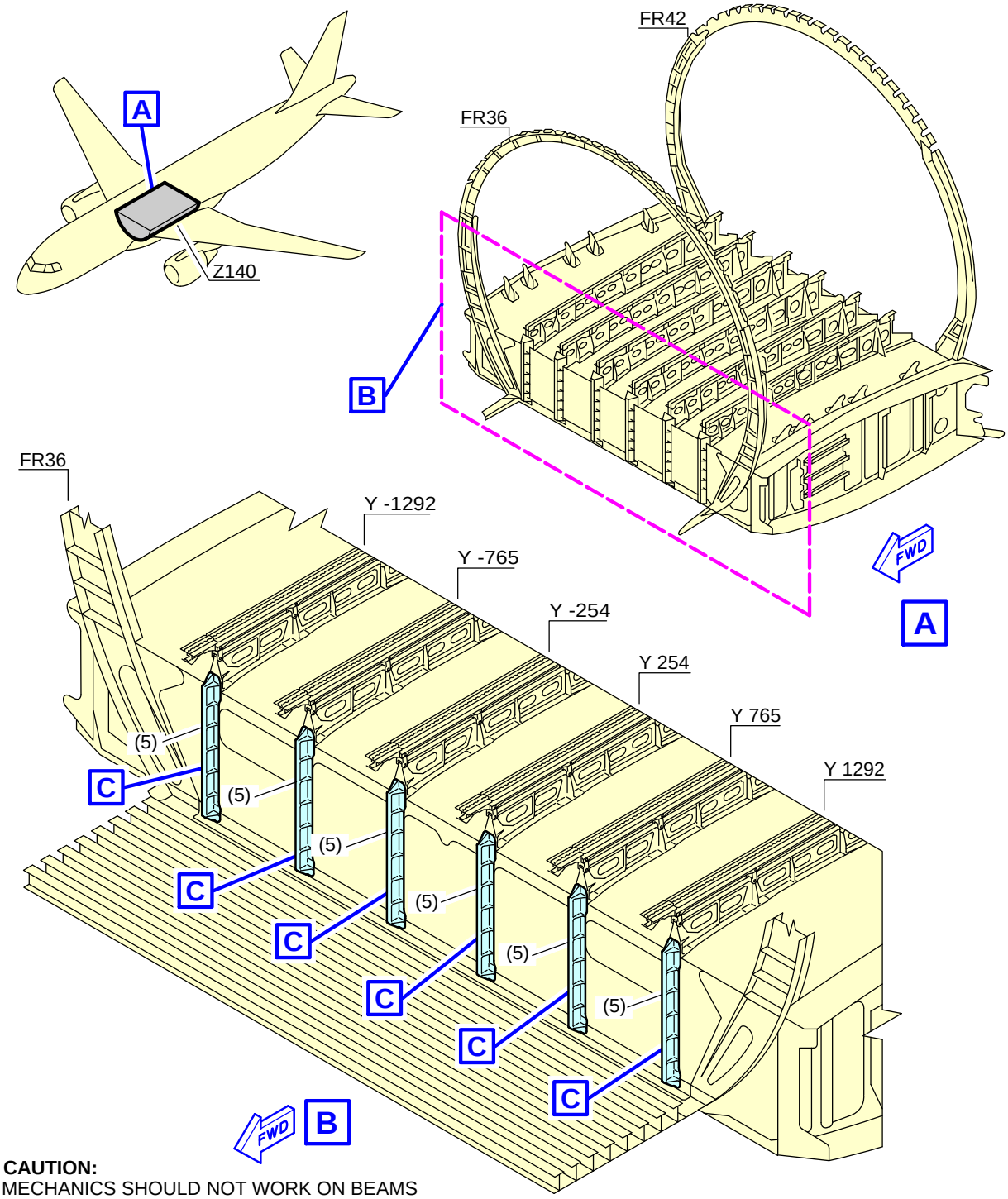
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-08ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

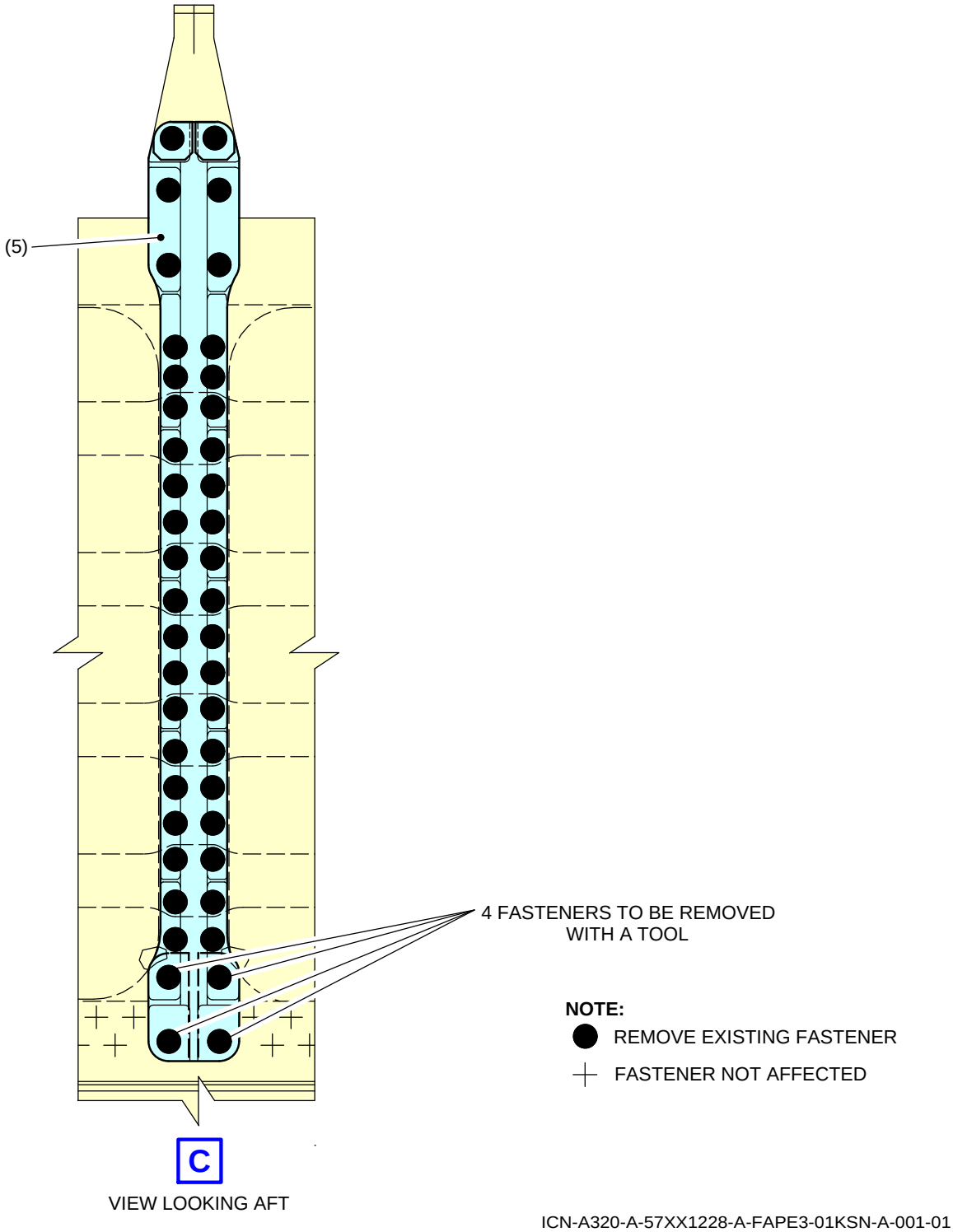


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

CONF 002

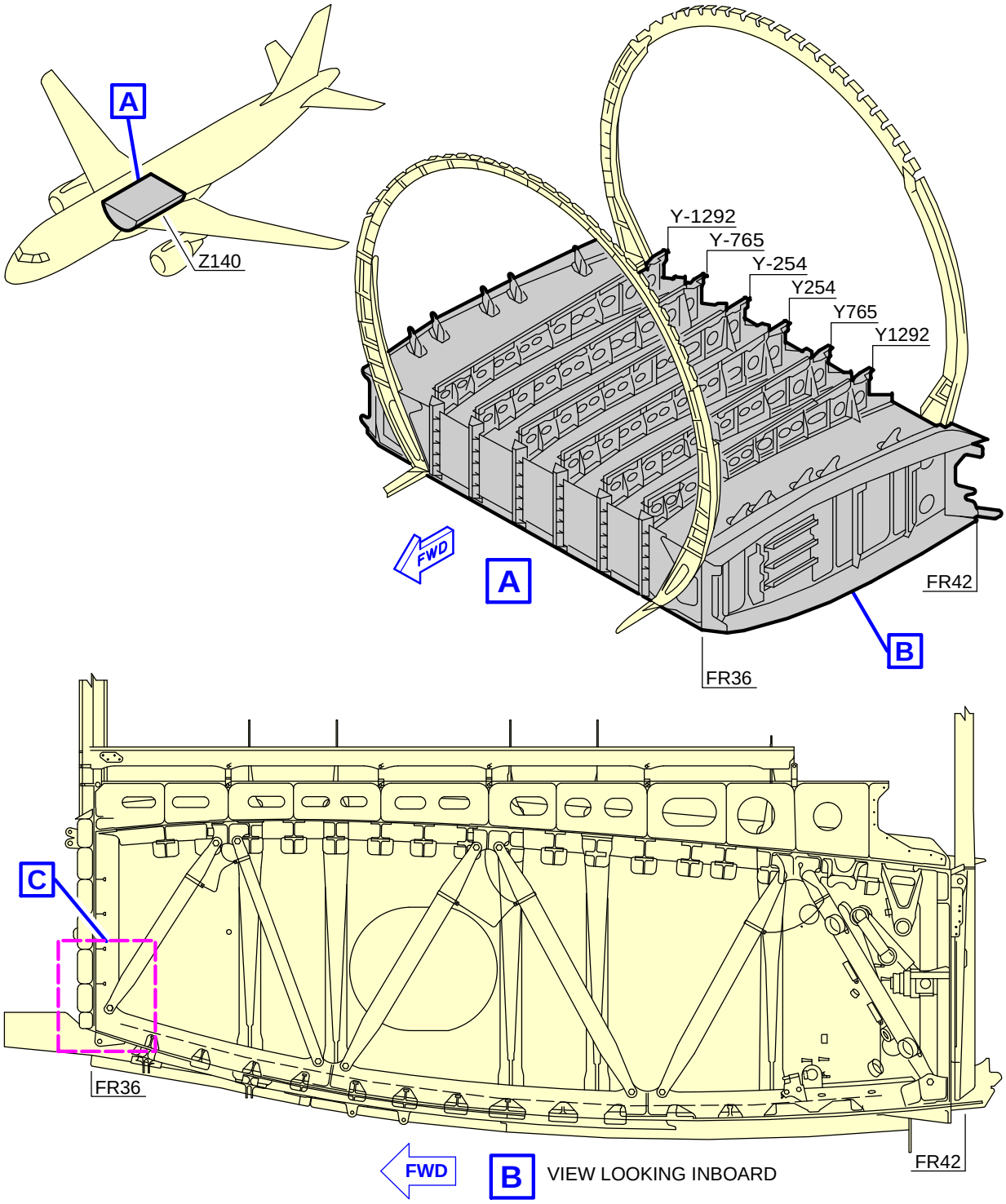
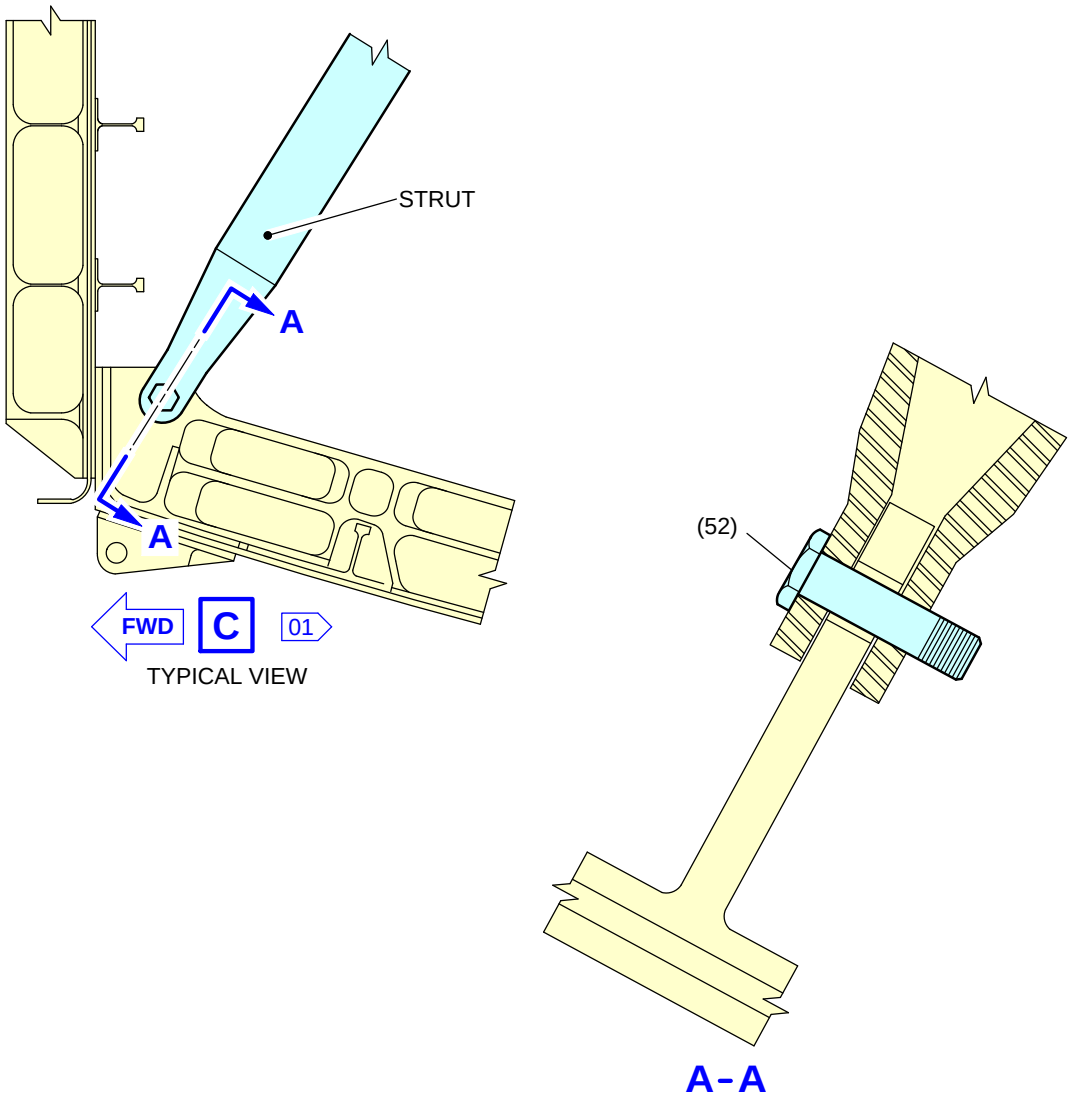


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(17) Task A320-A-57-XX-1228-03001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - 08BAA9
General

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-03ZZZ-900Z-A.

CONF 001 003 004

(18) Task A320-A-57-XX-1228-03001-900A-A - Drill the New Vertical Stringer on Y765 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER VERTICAL D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

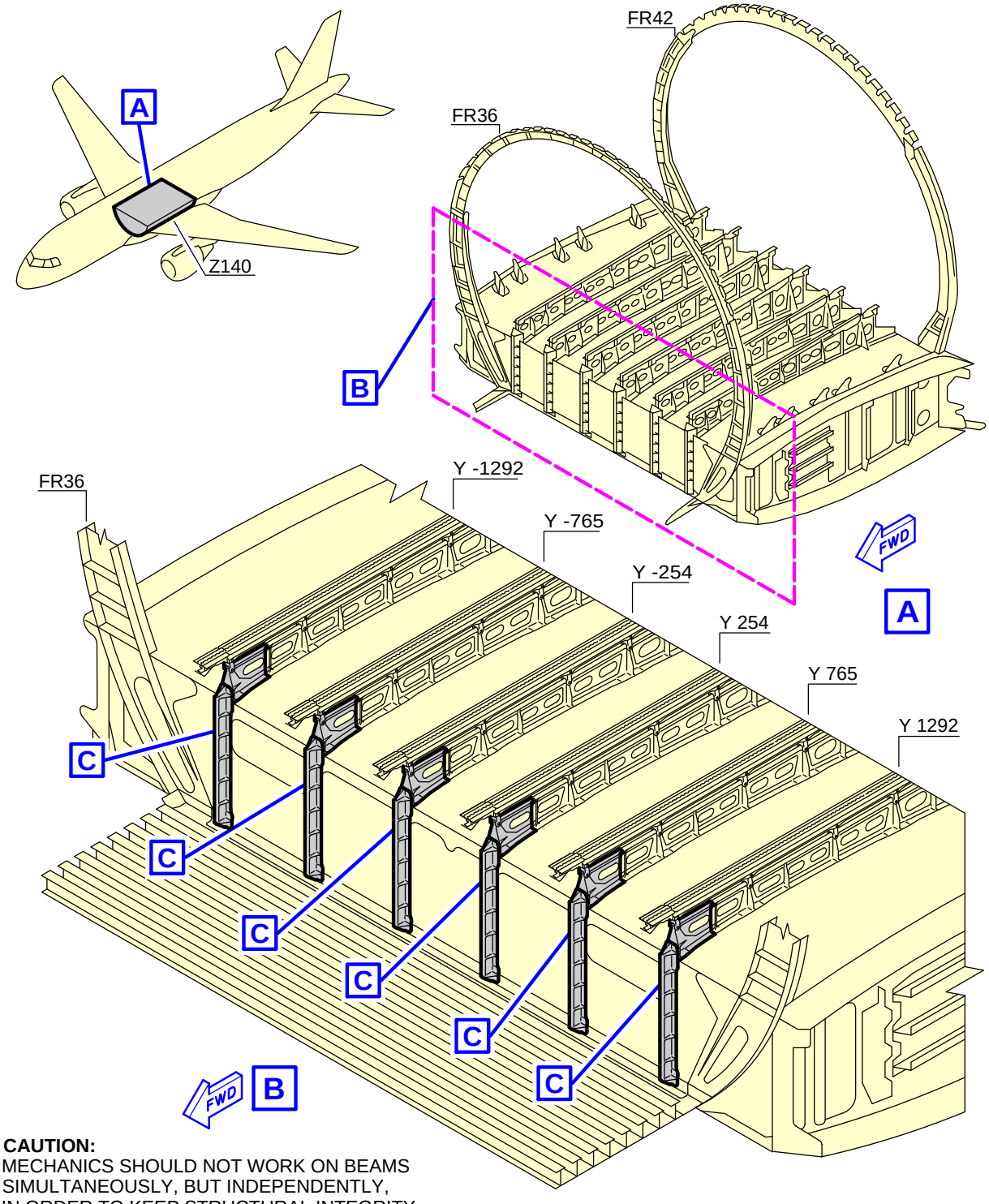
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 001 003 004

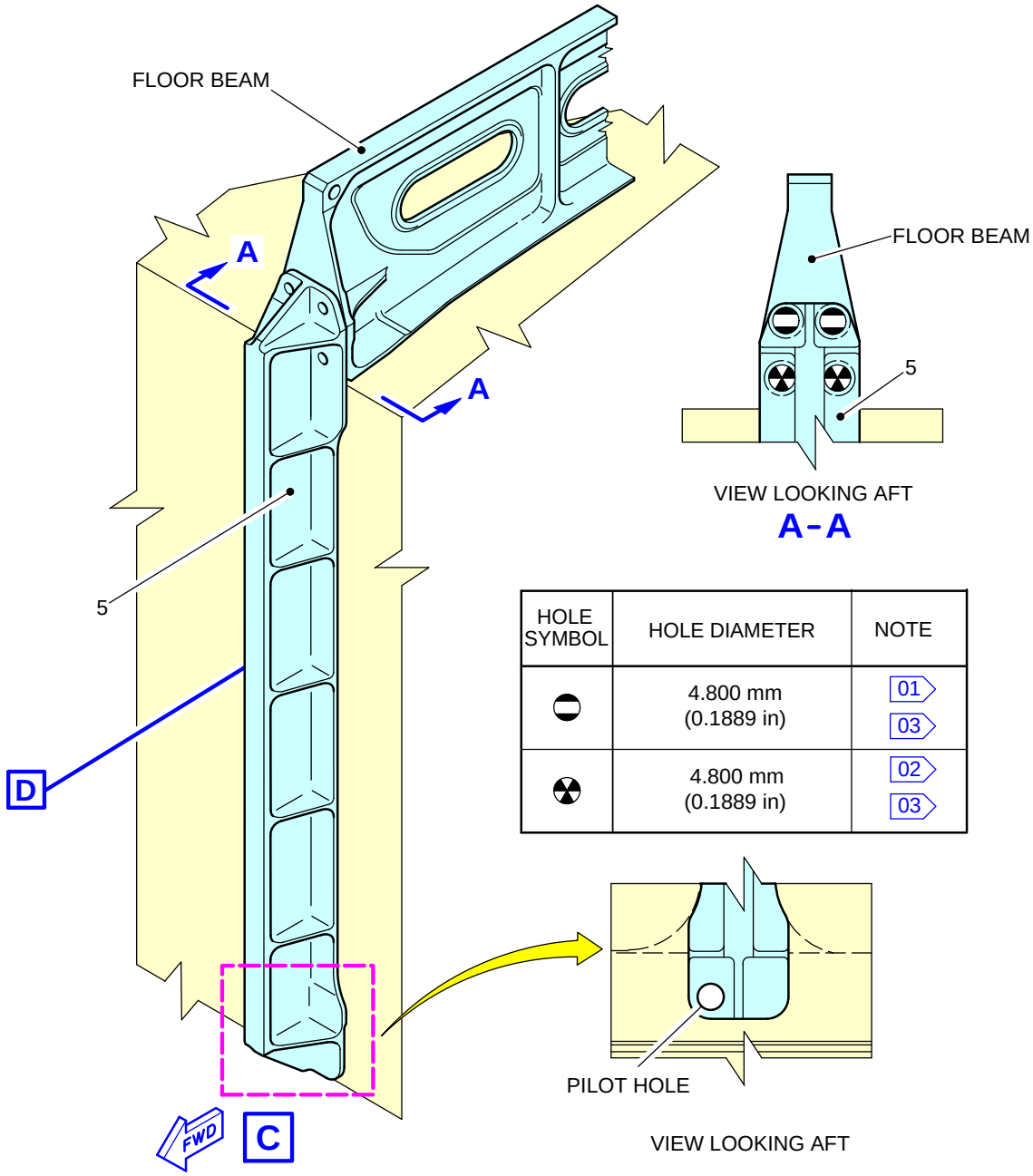


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

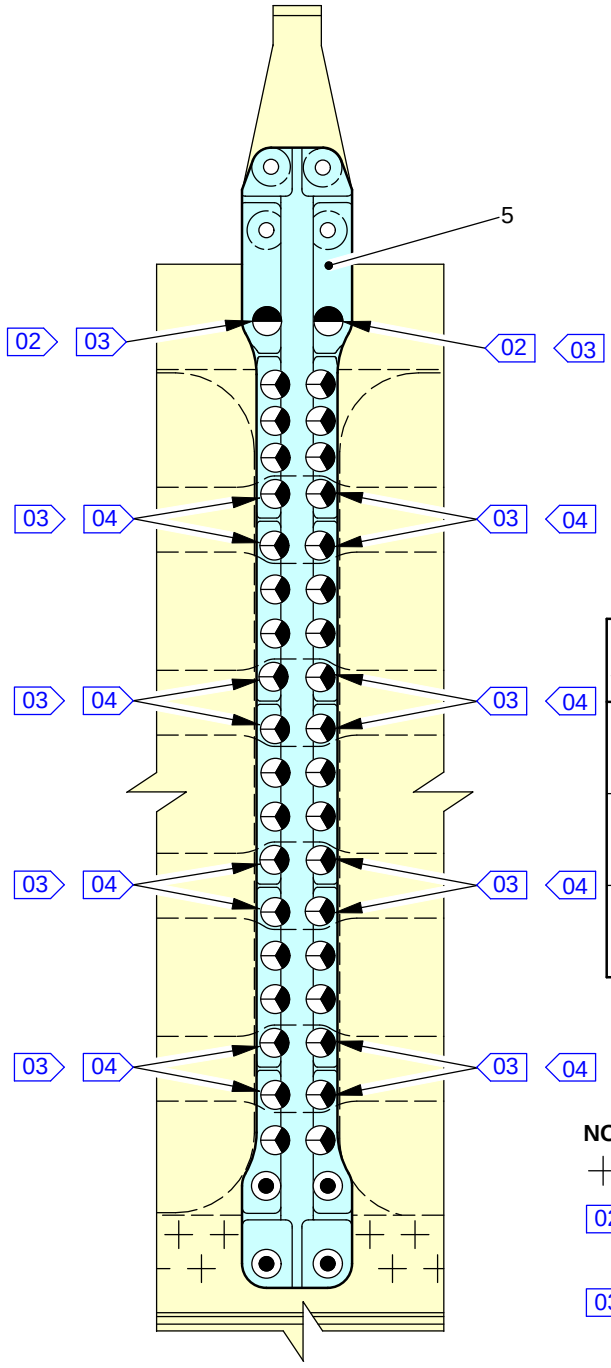
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

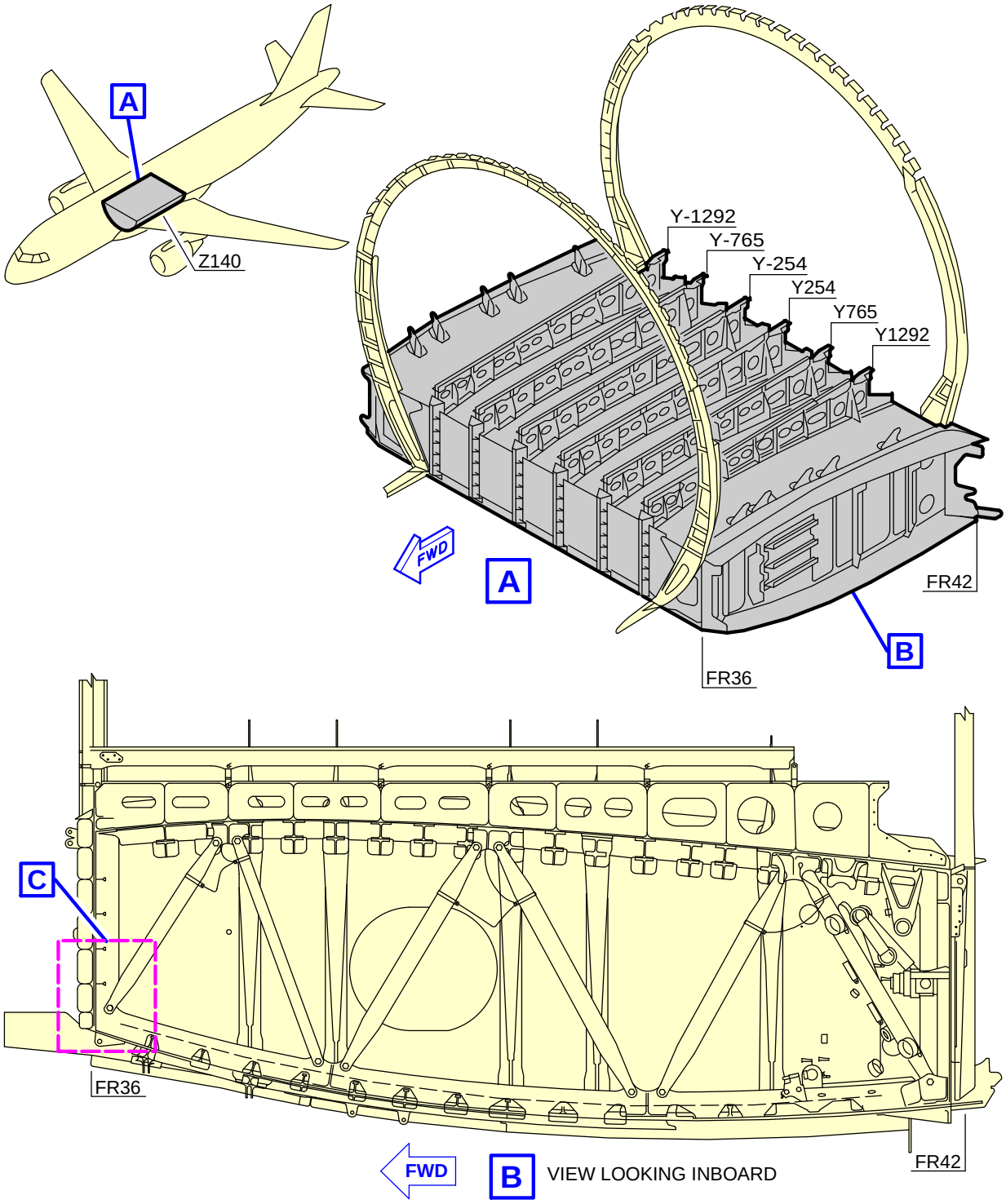
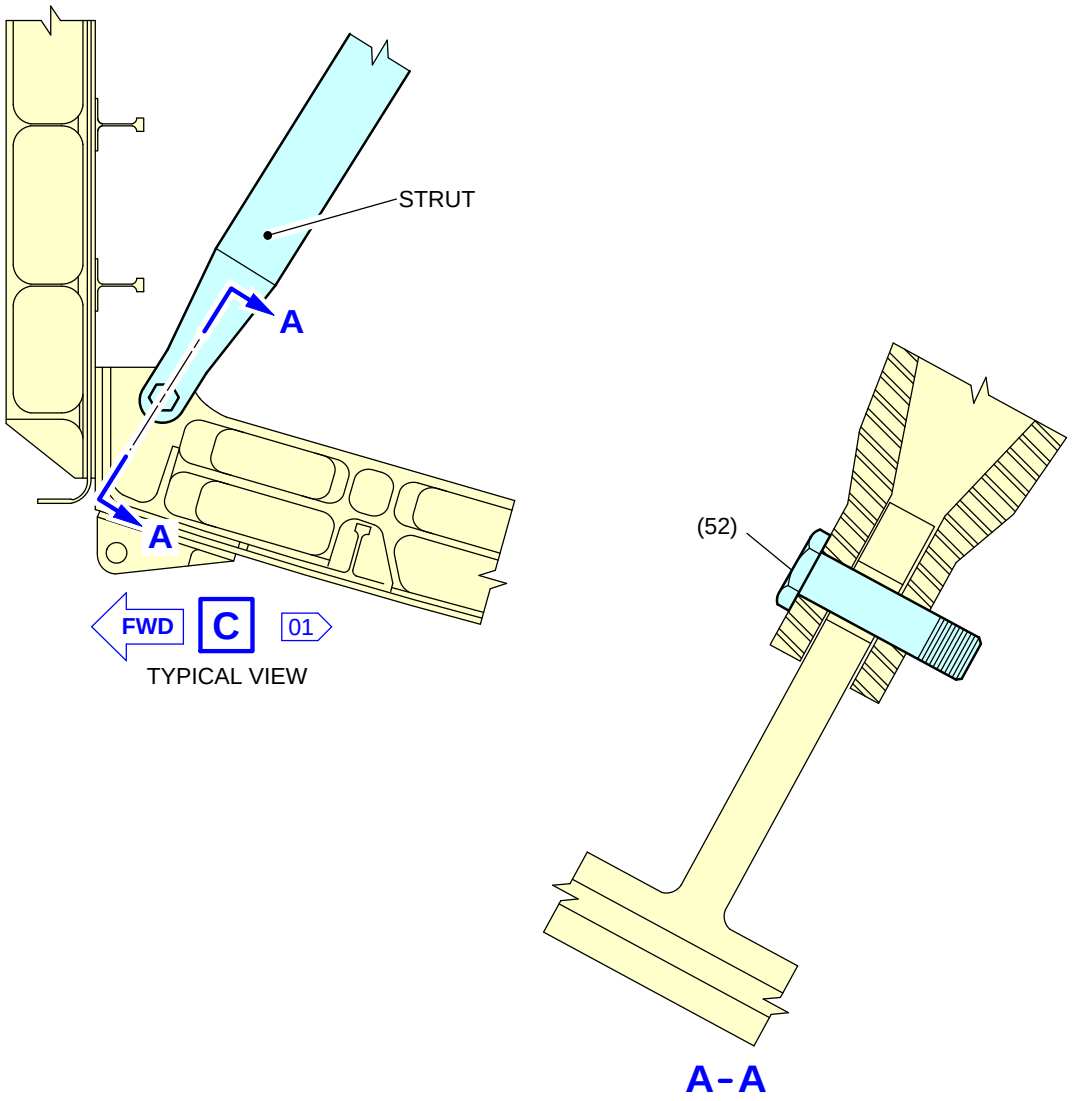


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(18) Task A320-A-57-XX-1228-03002-900A-A - Drill the New Vertical Stringer on Y765 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER VERTICAL	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

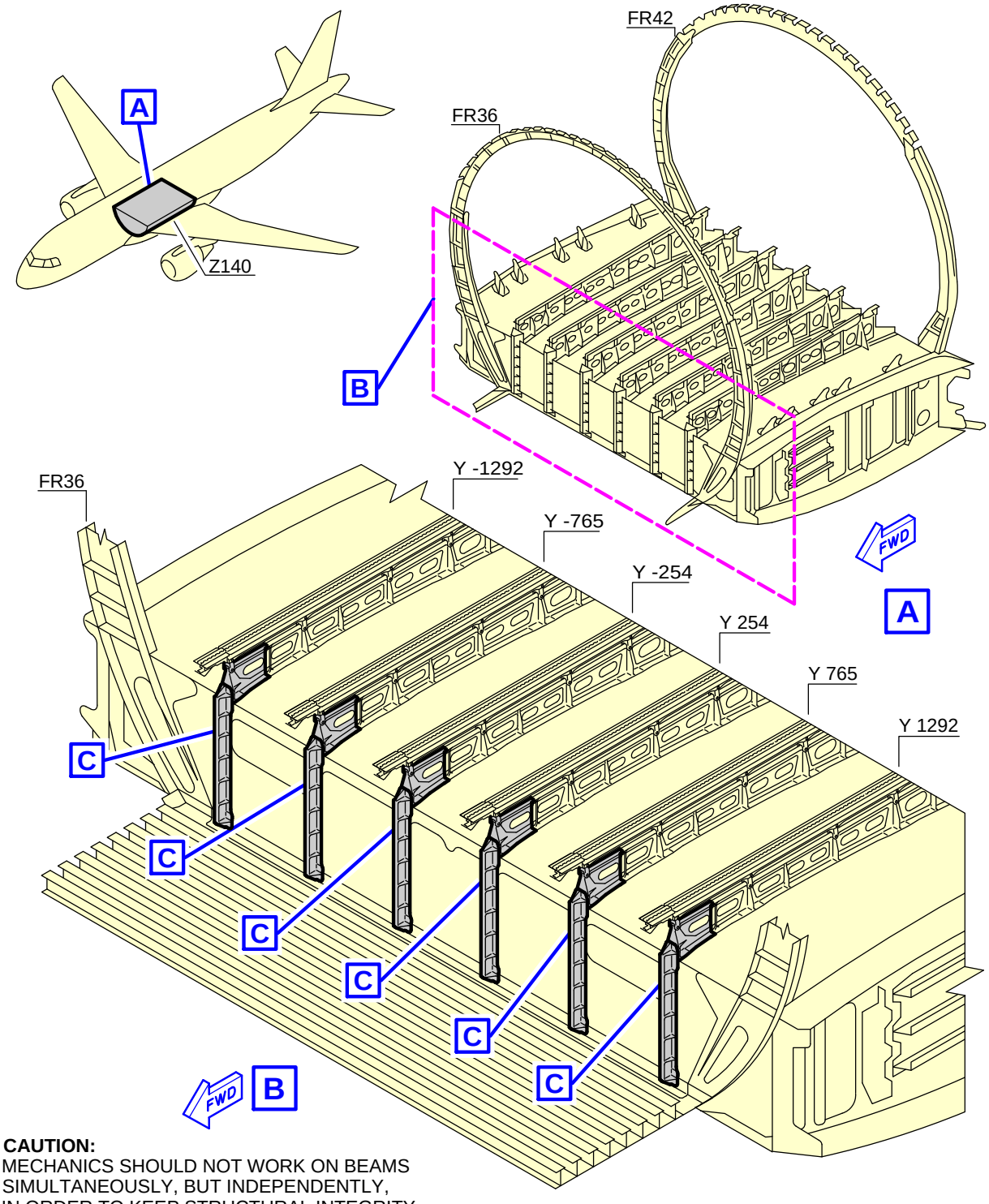
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

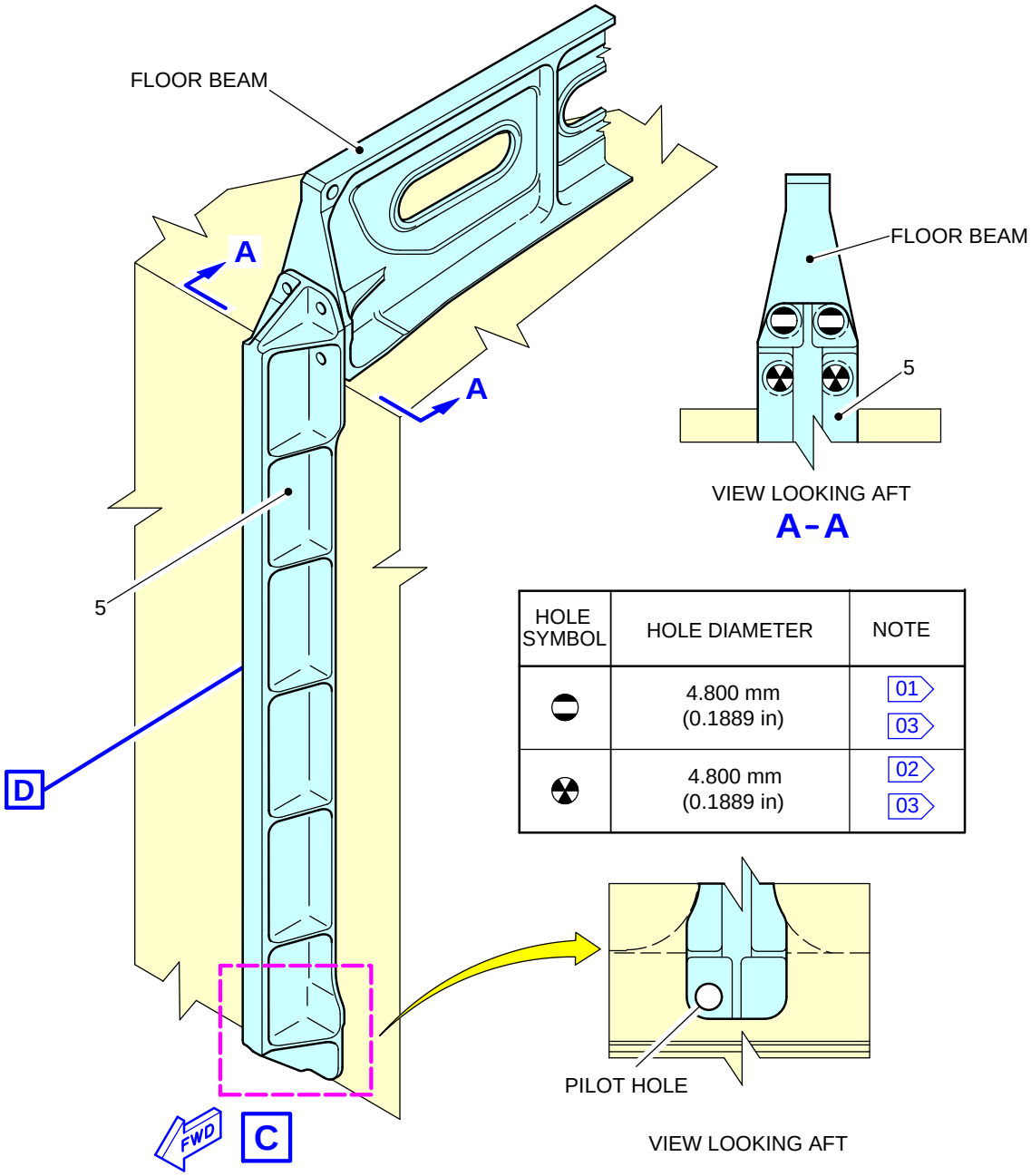


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

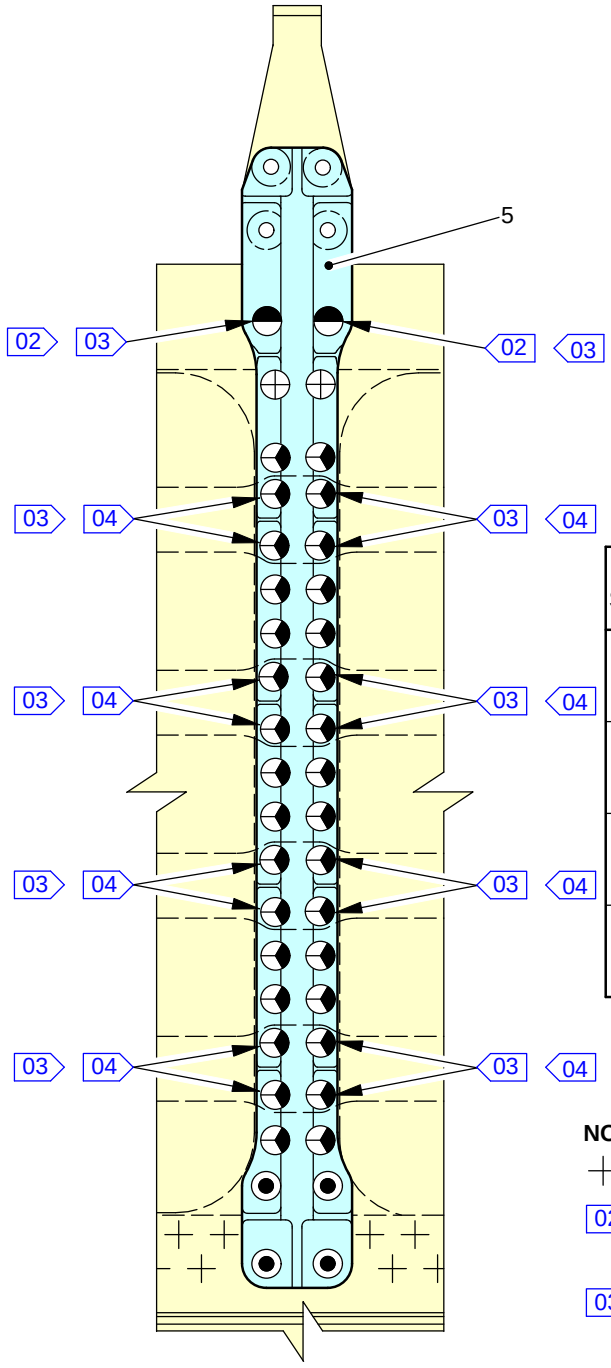
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

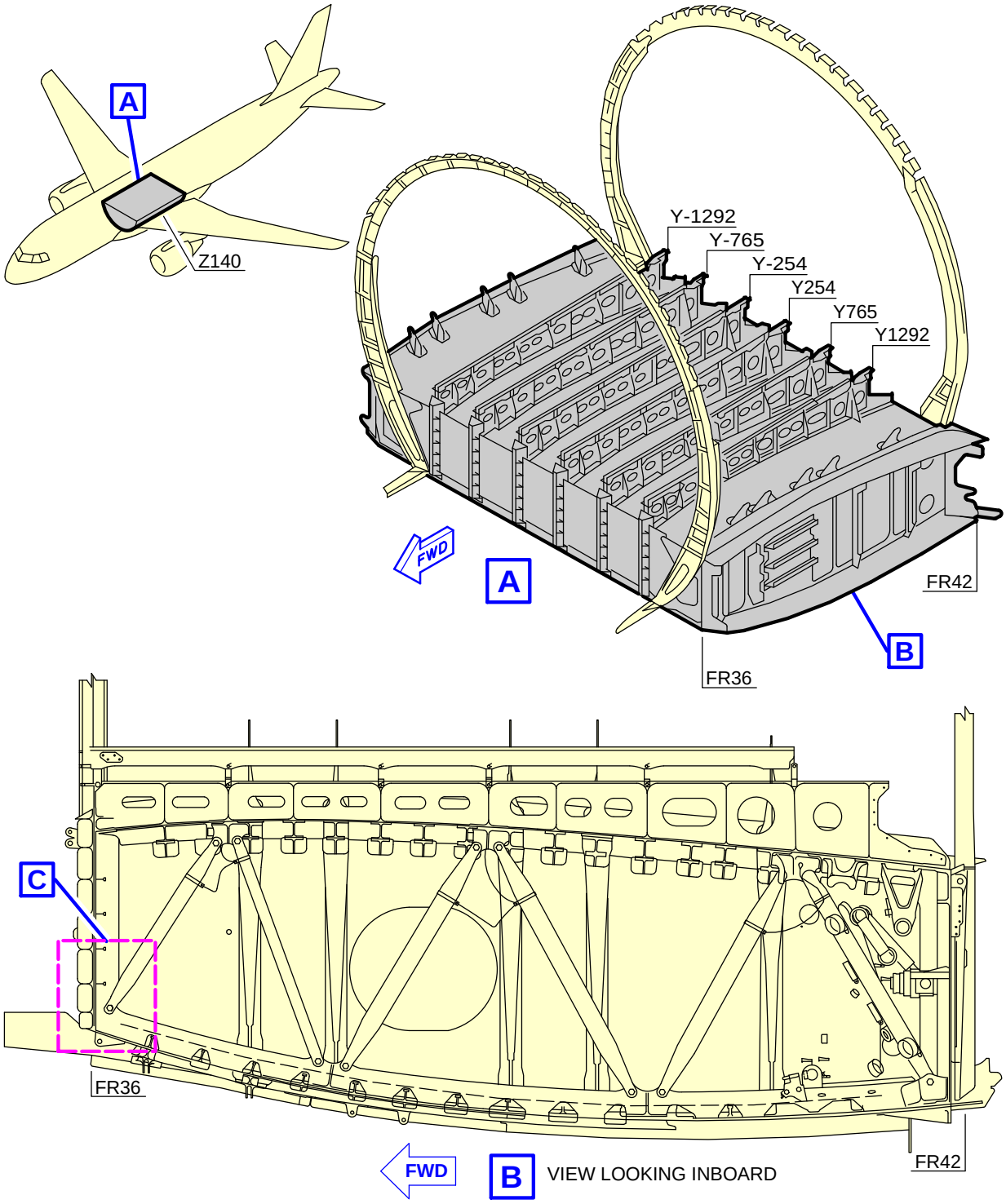
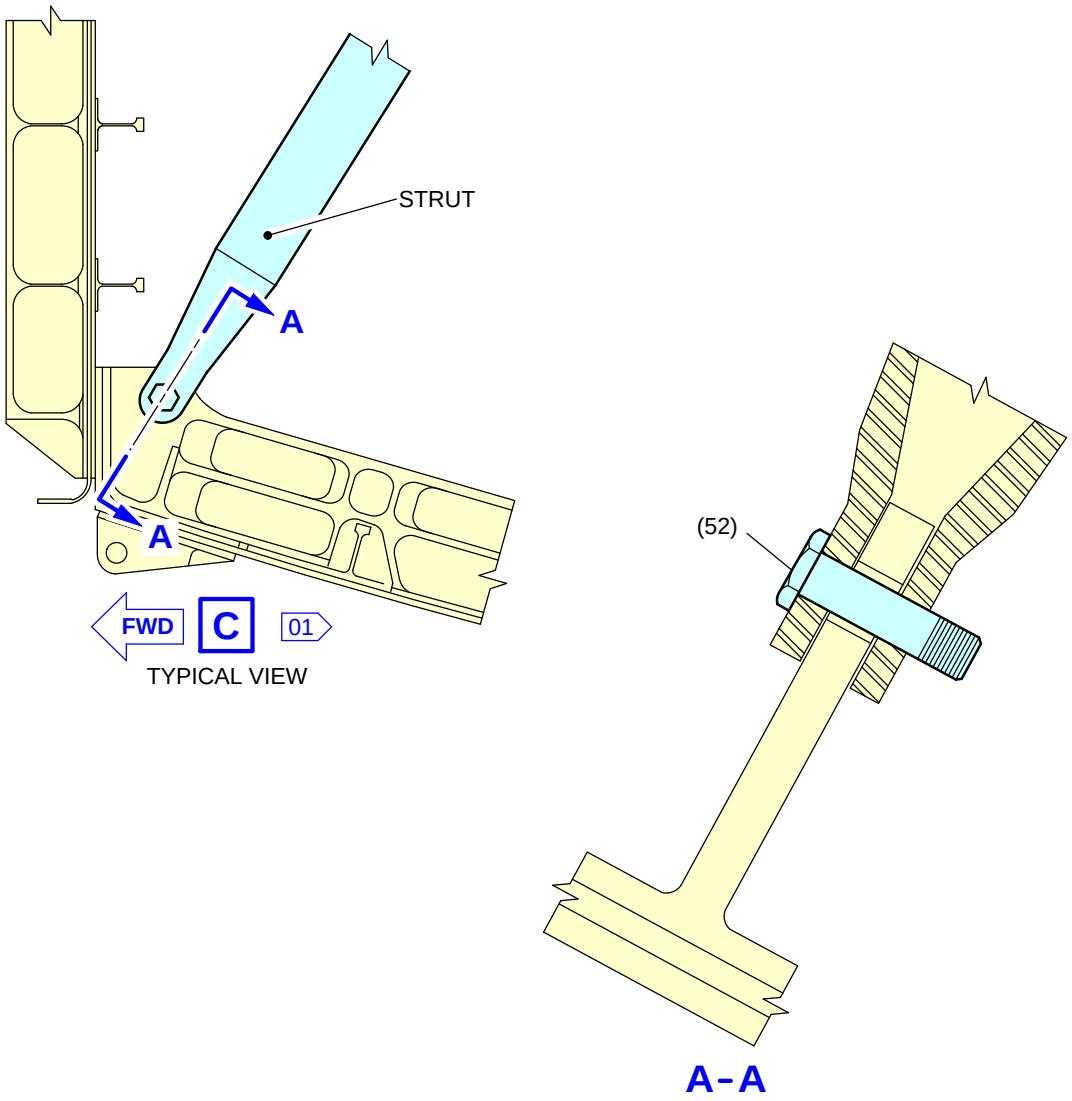


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(19) Task A320-A-57-XX-1228-08001-720A-A - Install the New Vertical Stringer on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001

Manuals/Drawings	References/Sheets
	06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

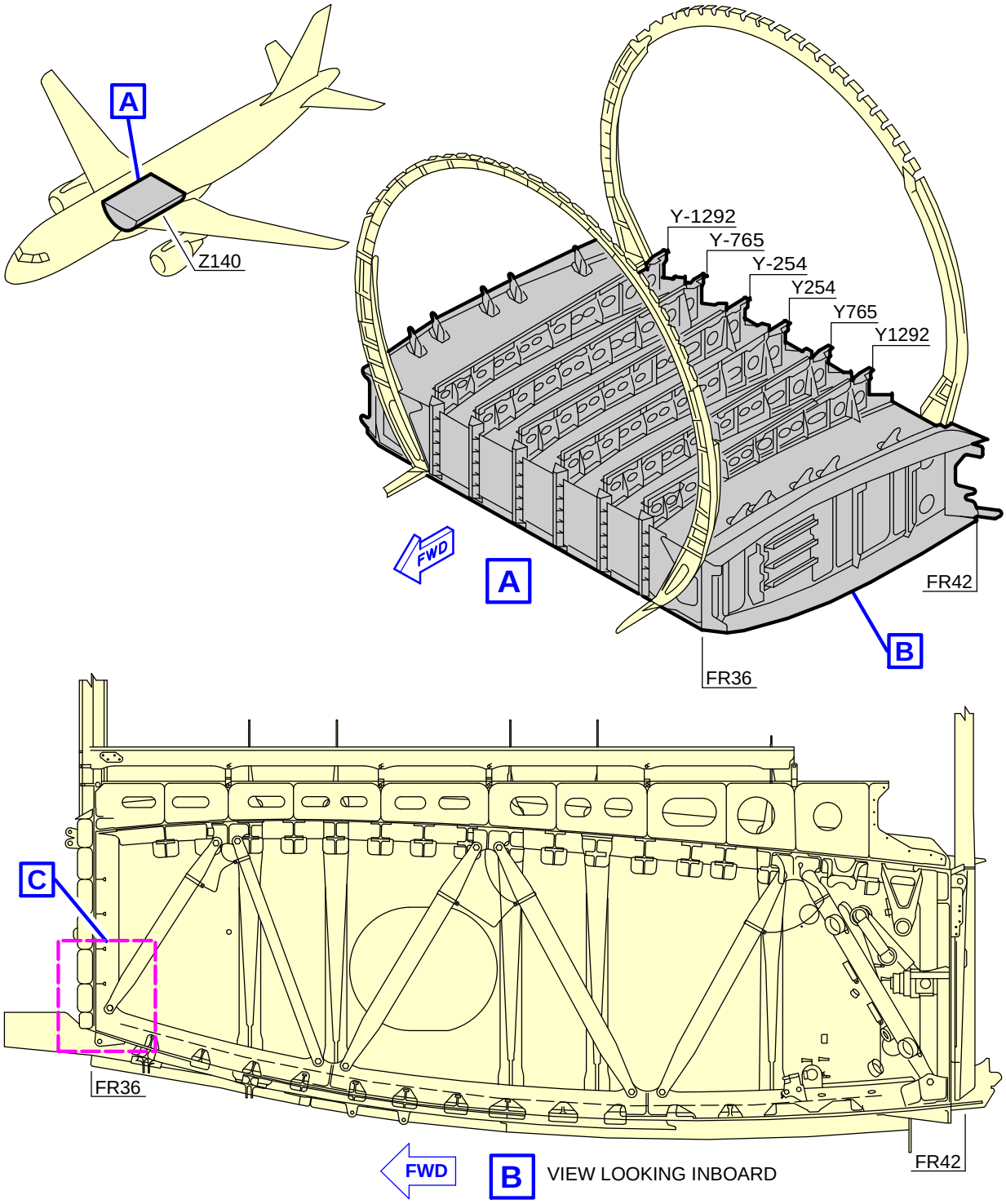
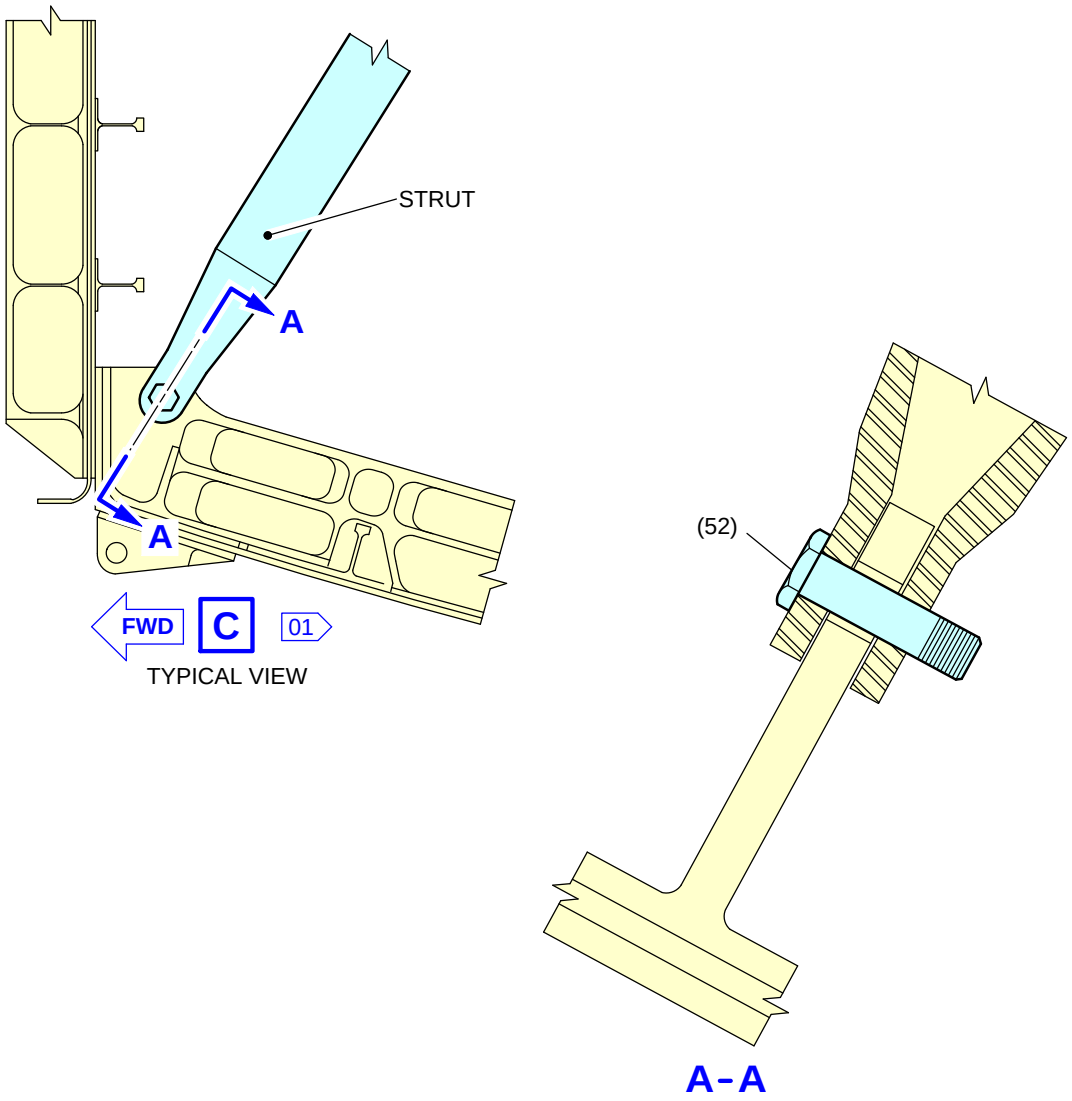


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



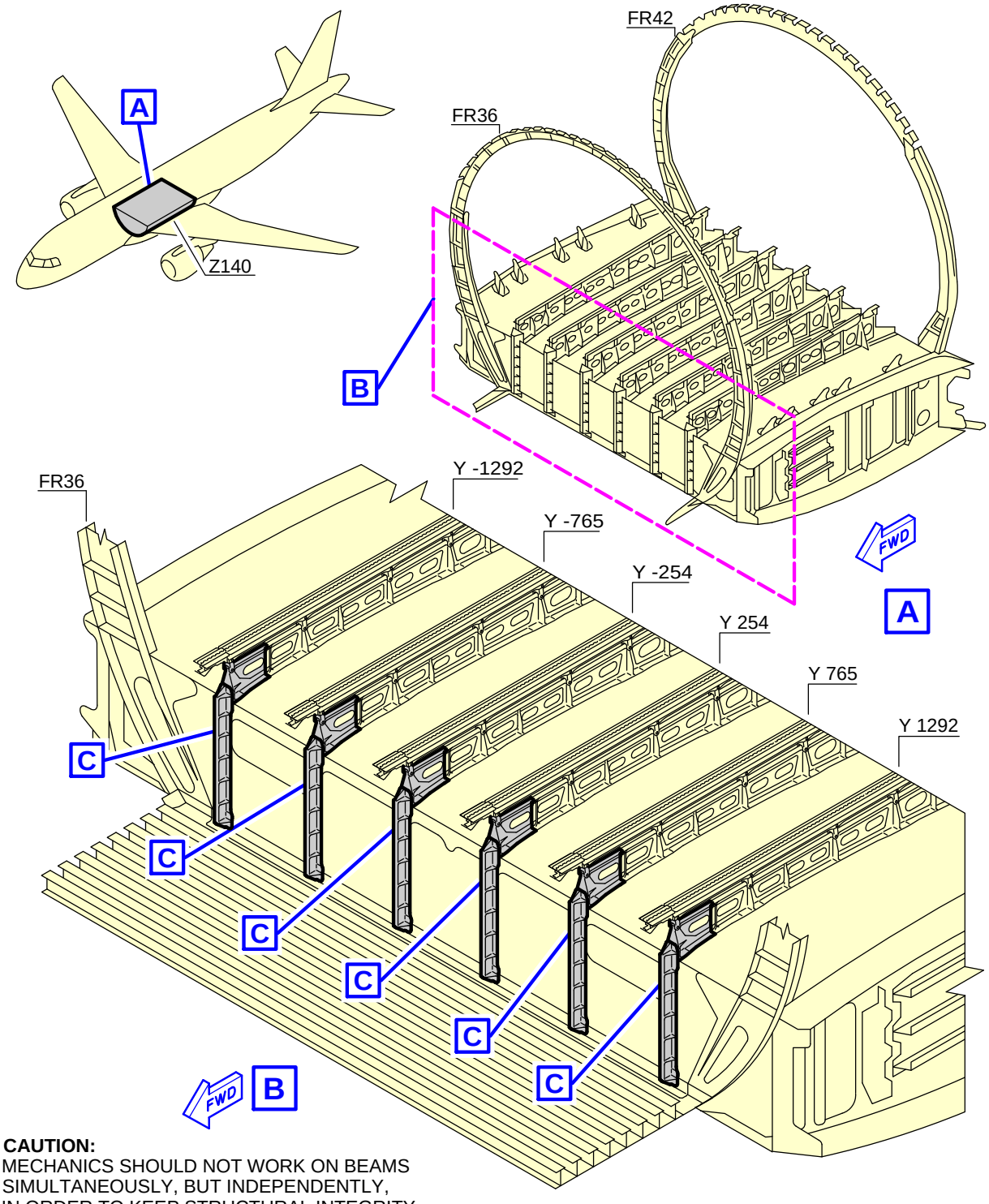
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

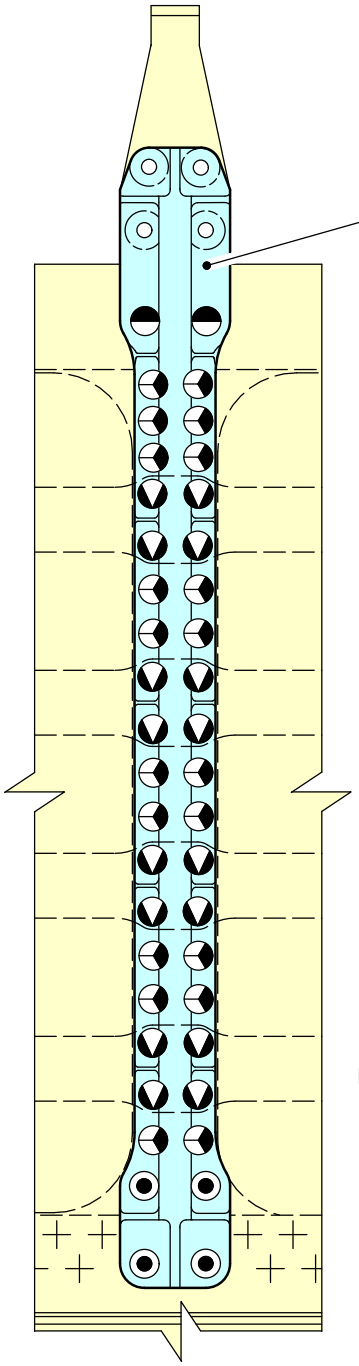


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(19) Task A320-A-57-XX-1228-08002-720A-A - Install the New Vertical Stringer on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

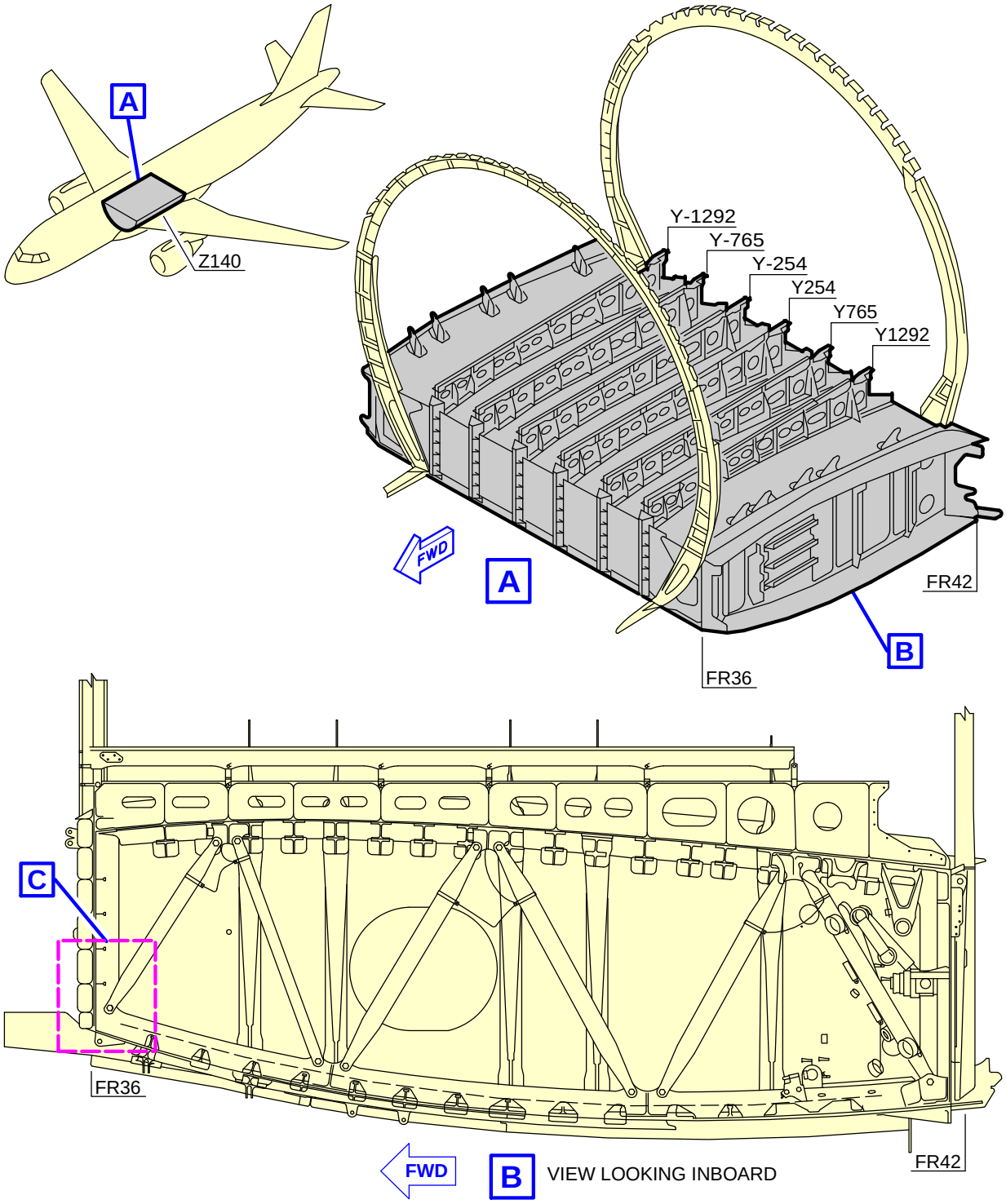
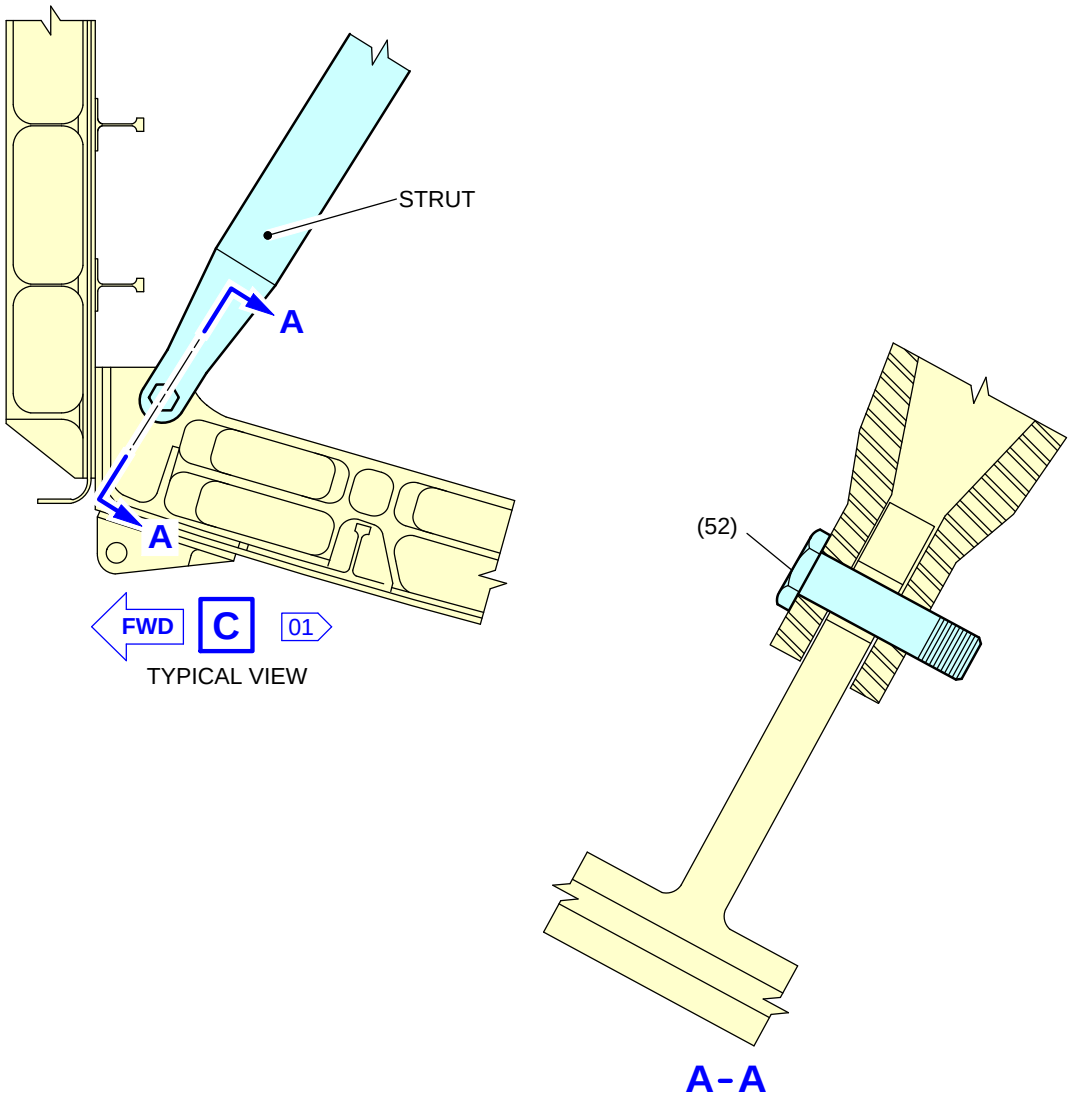


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



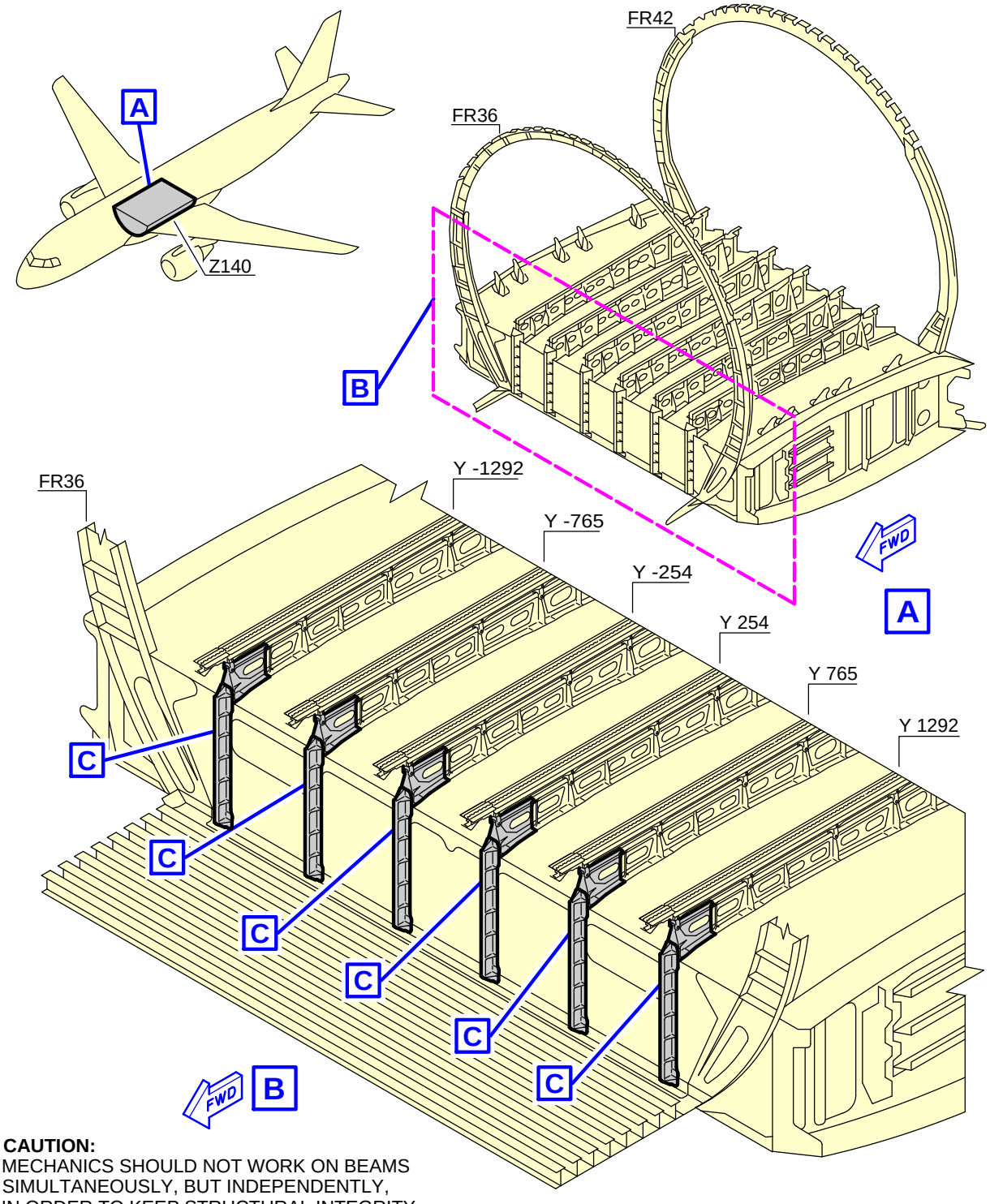
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

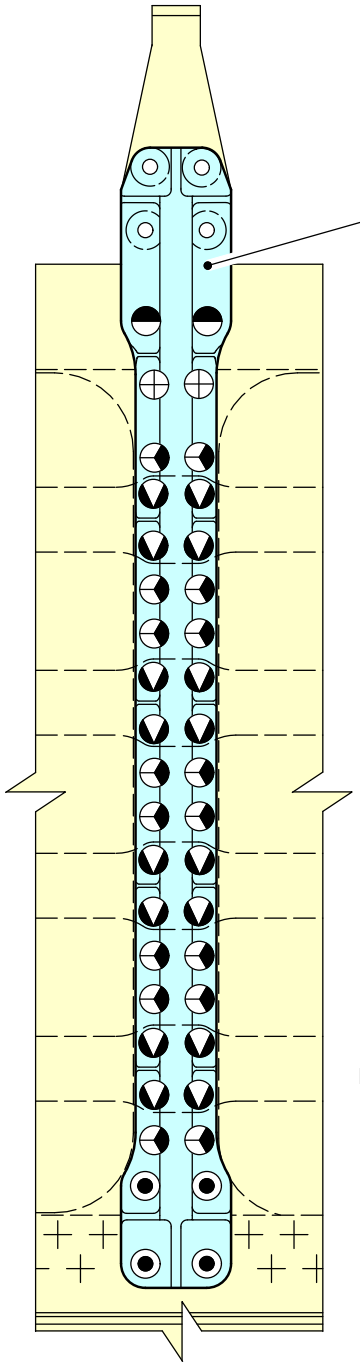


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(20) Task A320-A-57-XX-1228-12001-720A-A - Install the Strut Lower Attachment on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

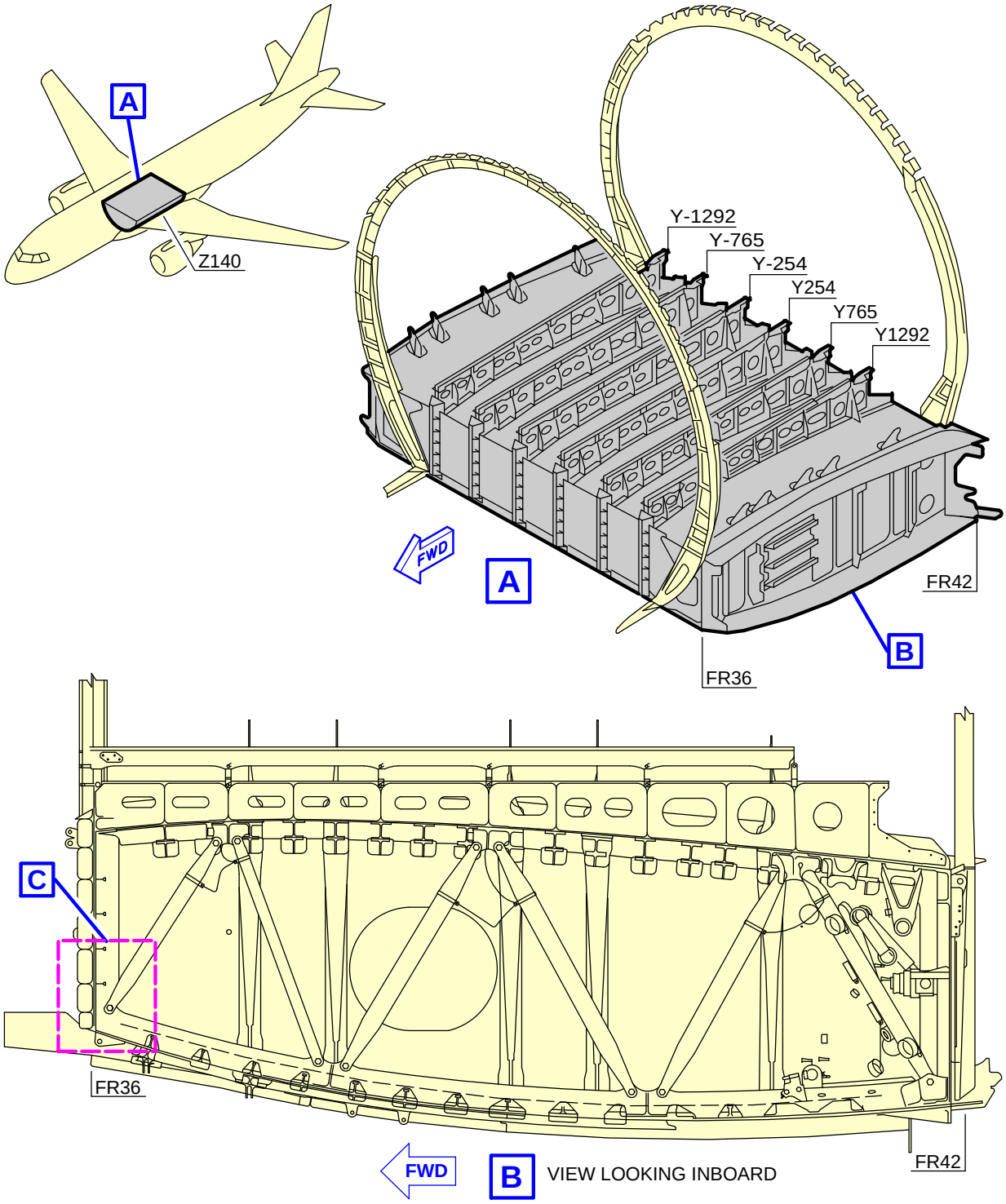
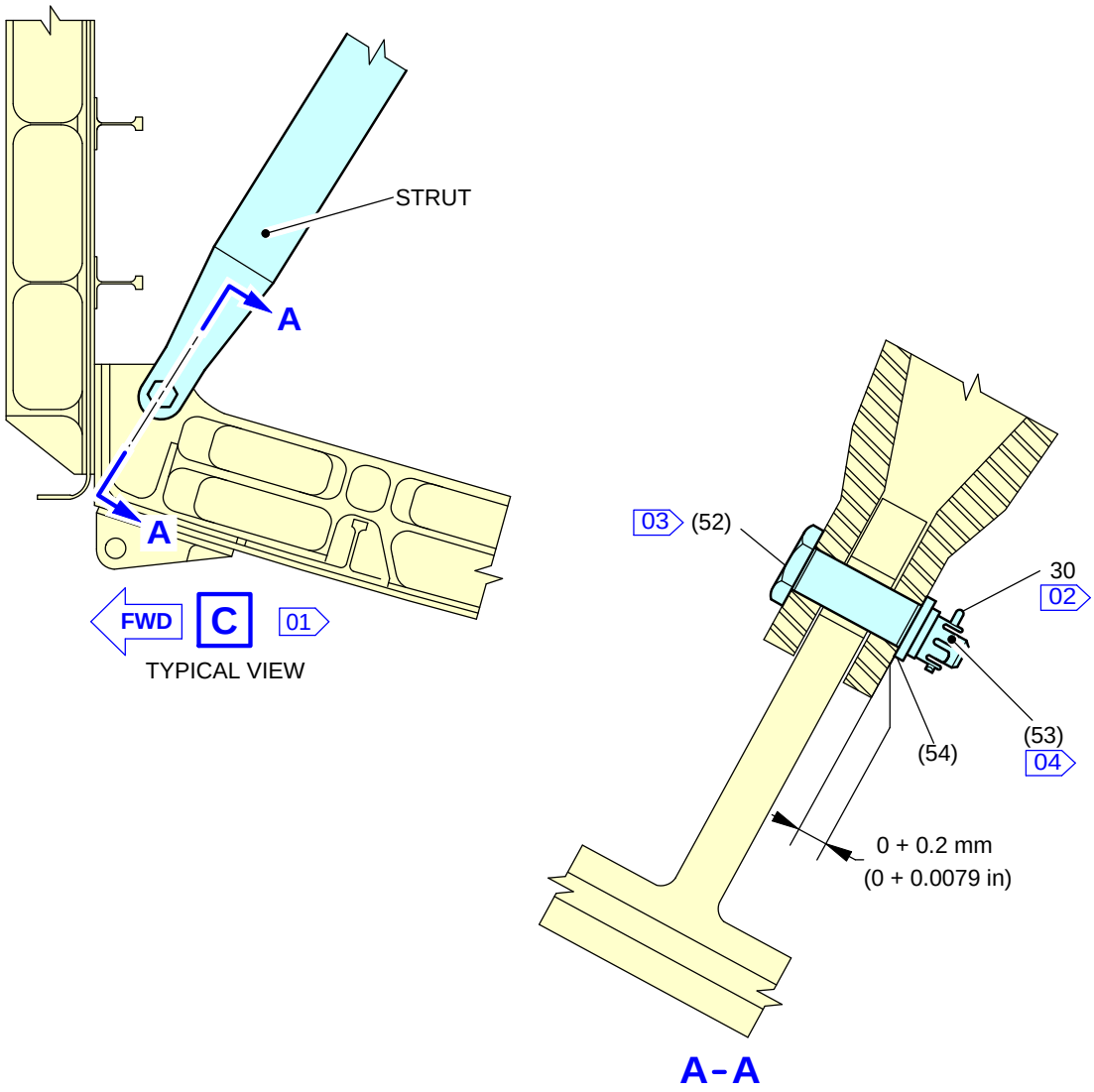


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(20) Task A320-A-57-XX-1228-12002-720A-A - Install the Strut Lower Attachment on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

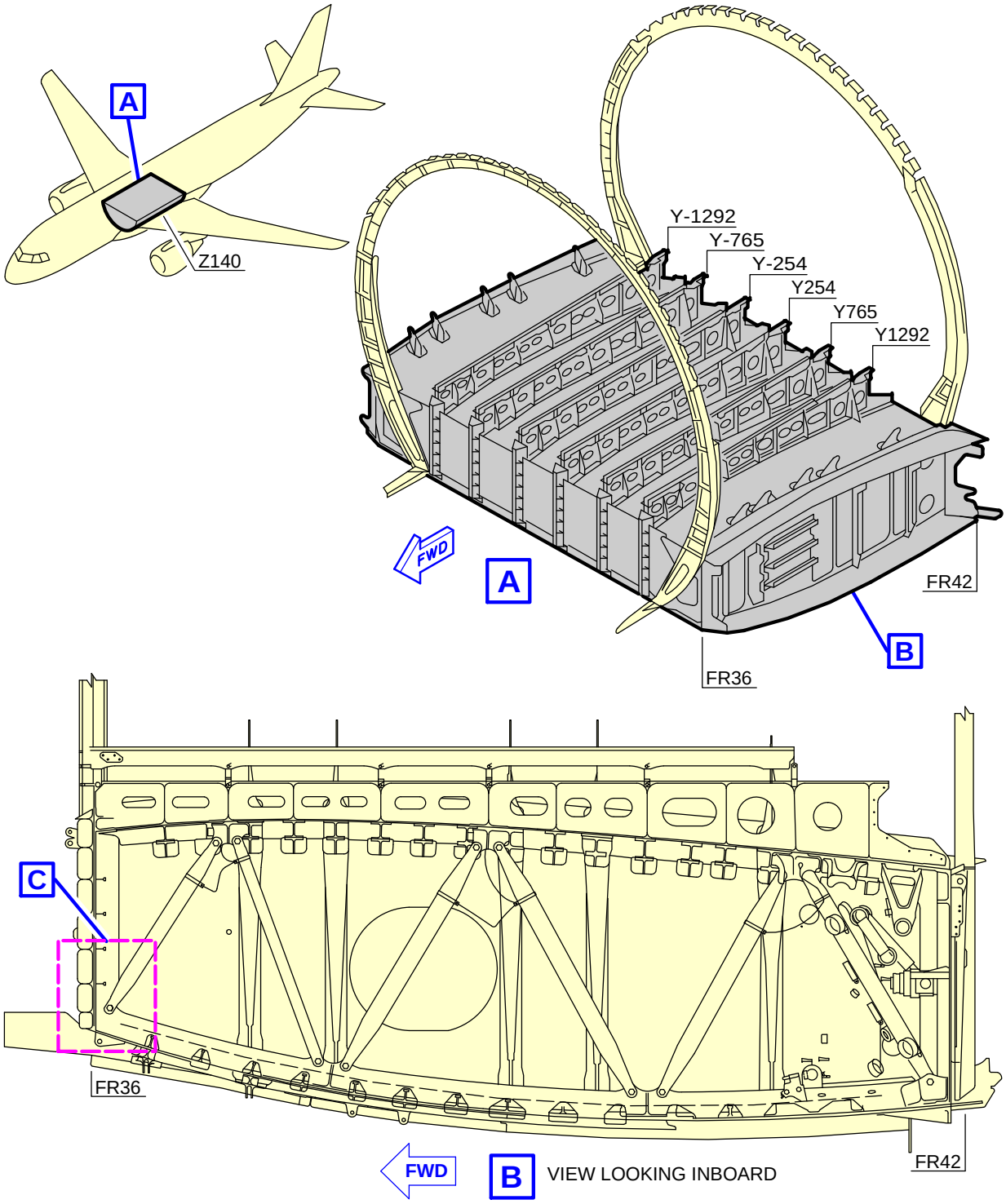
3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

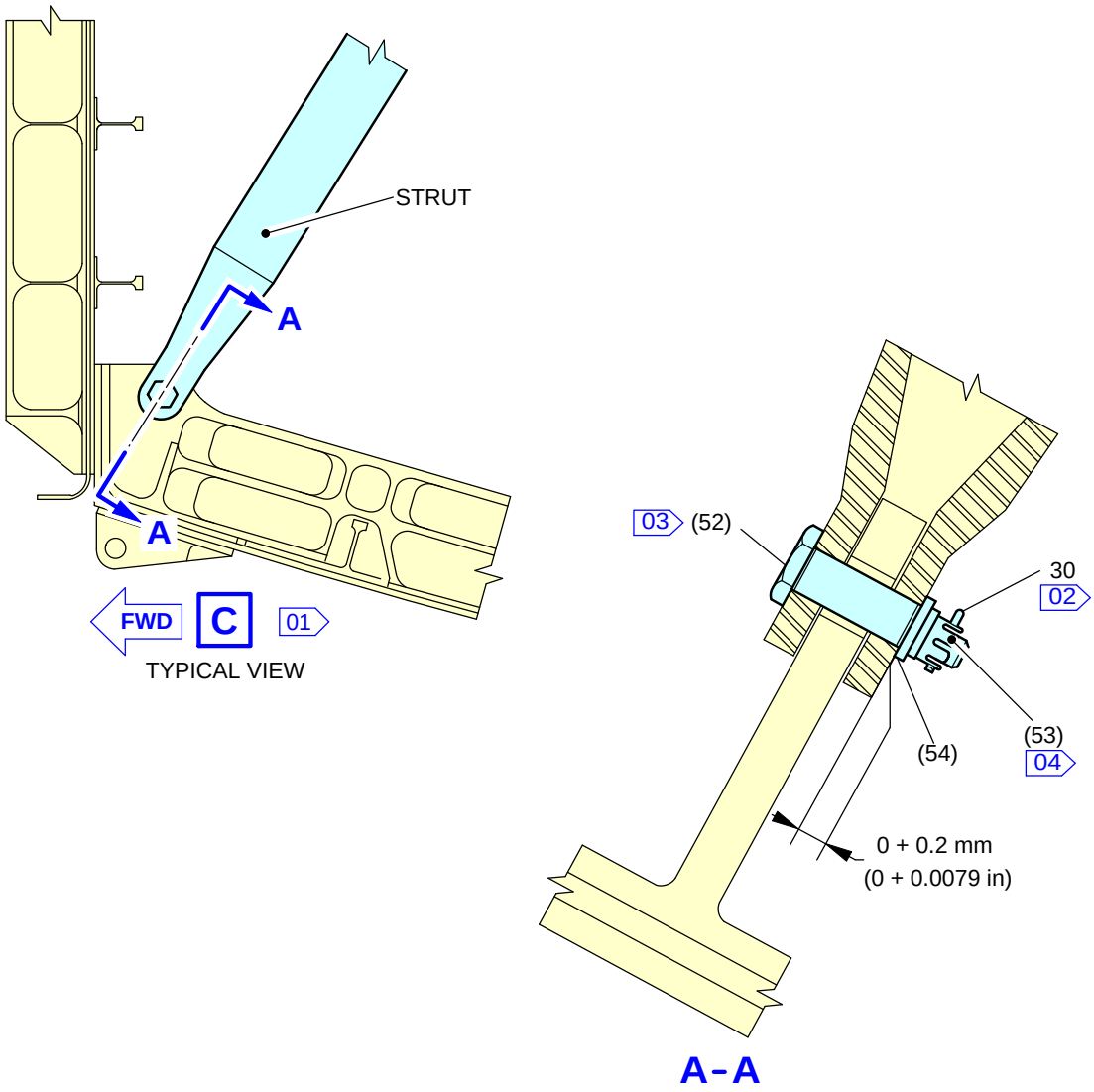
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(21) Task A320-A-57-XX-1228-09001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

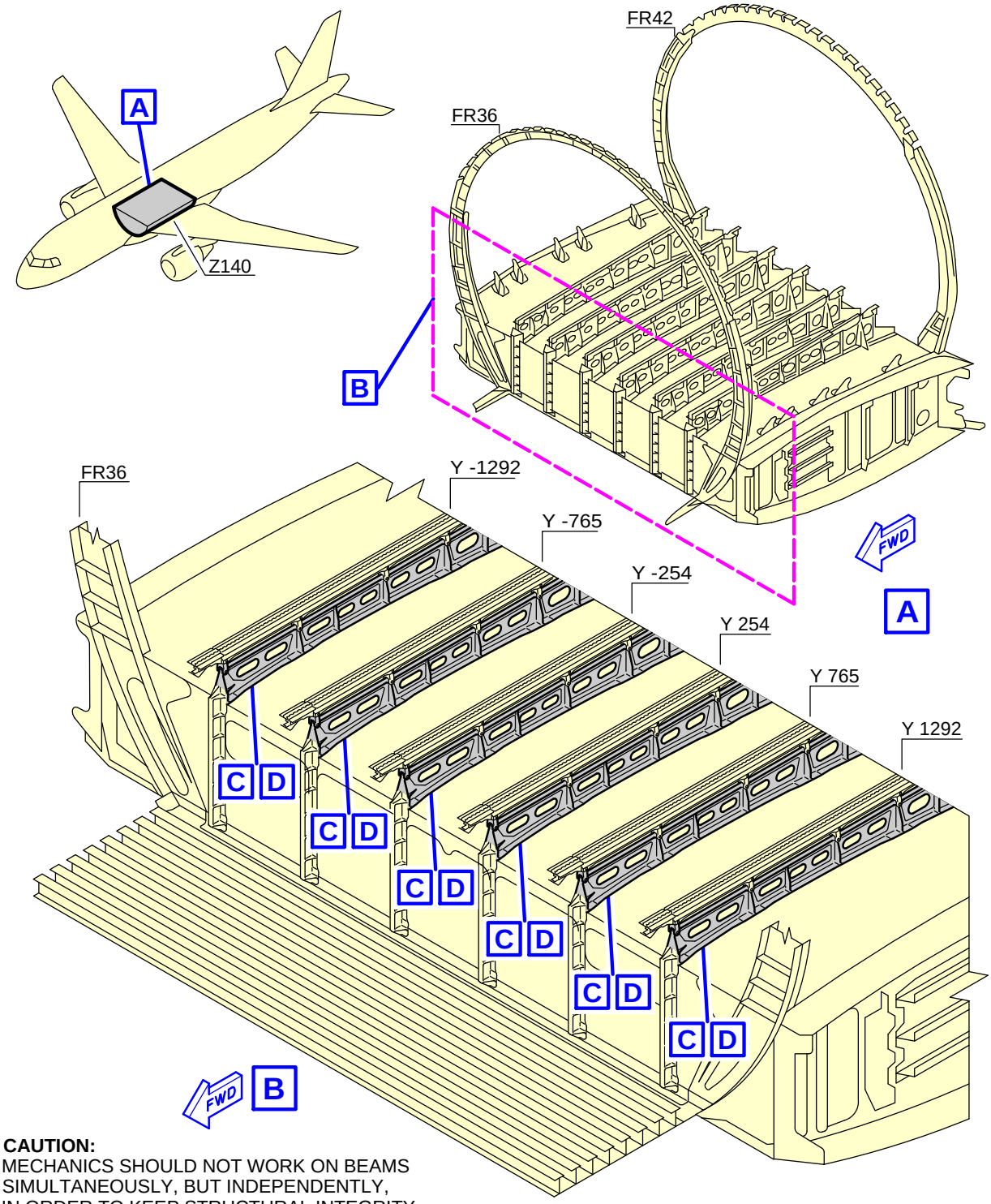
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-10ZZZ-720Z-A.

CONF ALL

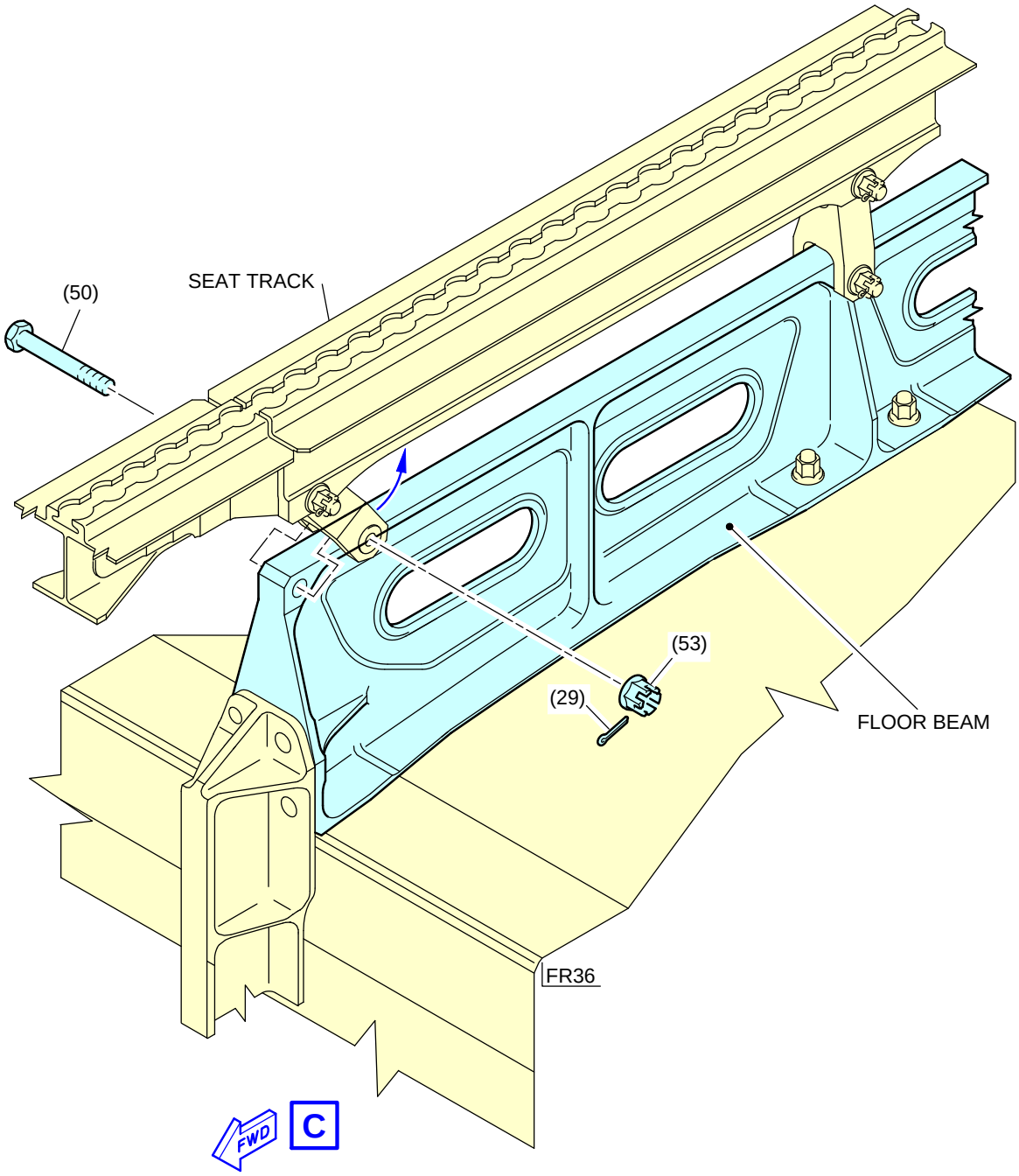


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

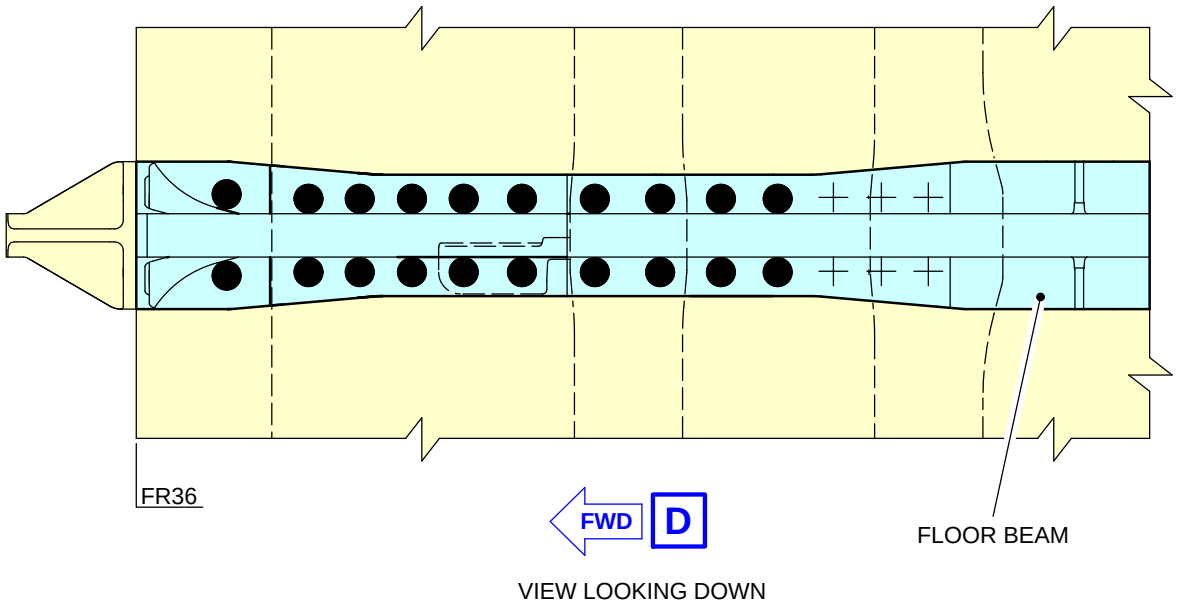
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(22) Task A320-A-57-XX-1228-02001-650A-A - Cut out the Forward End Floor Beam on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
240	

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

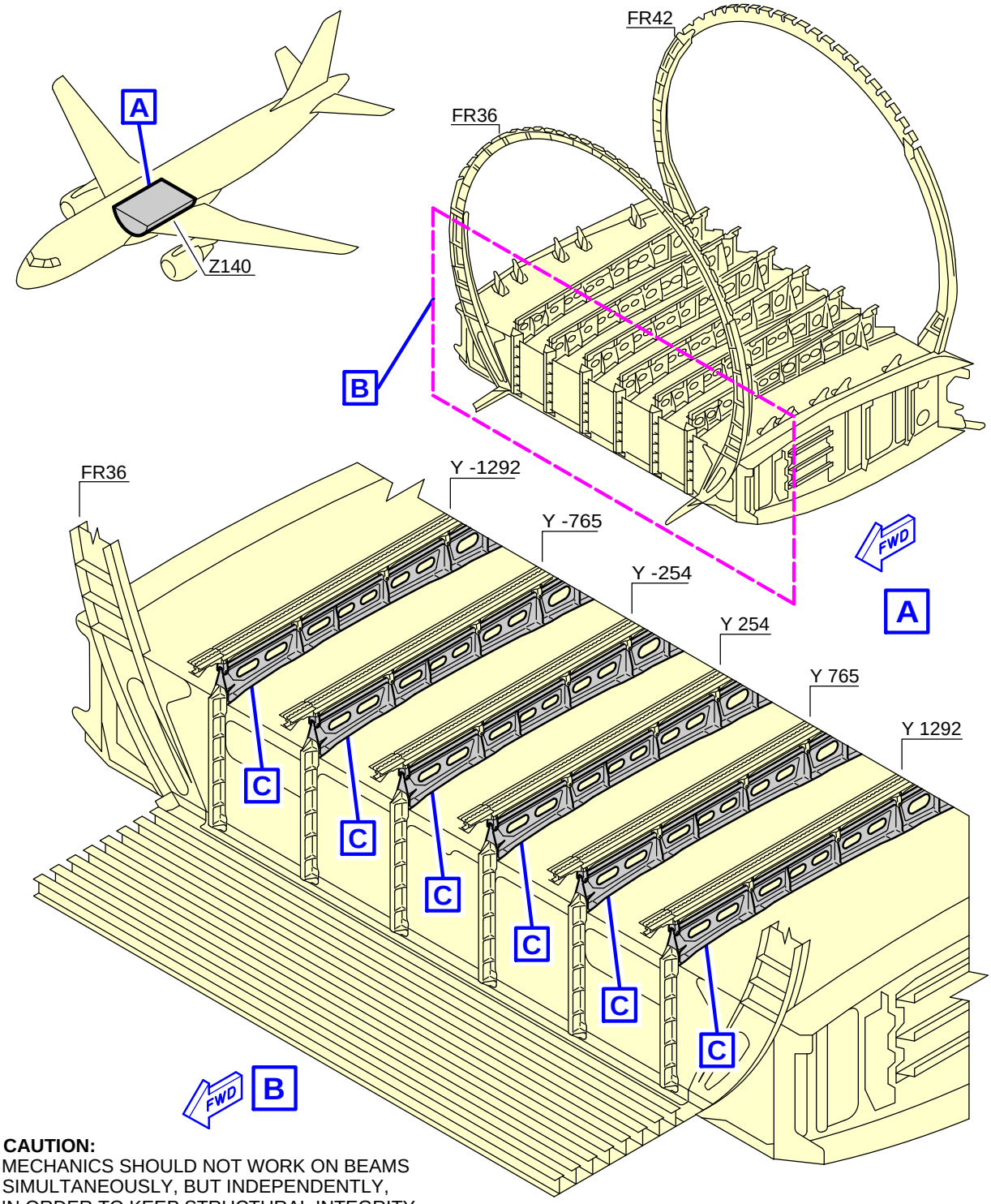
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

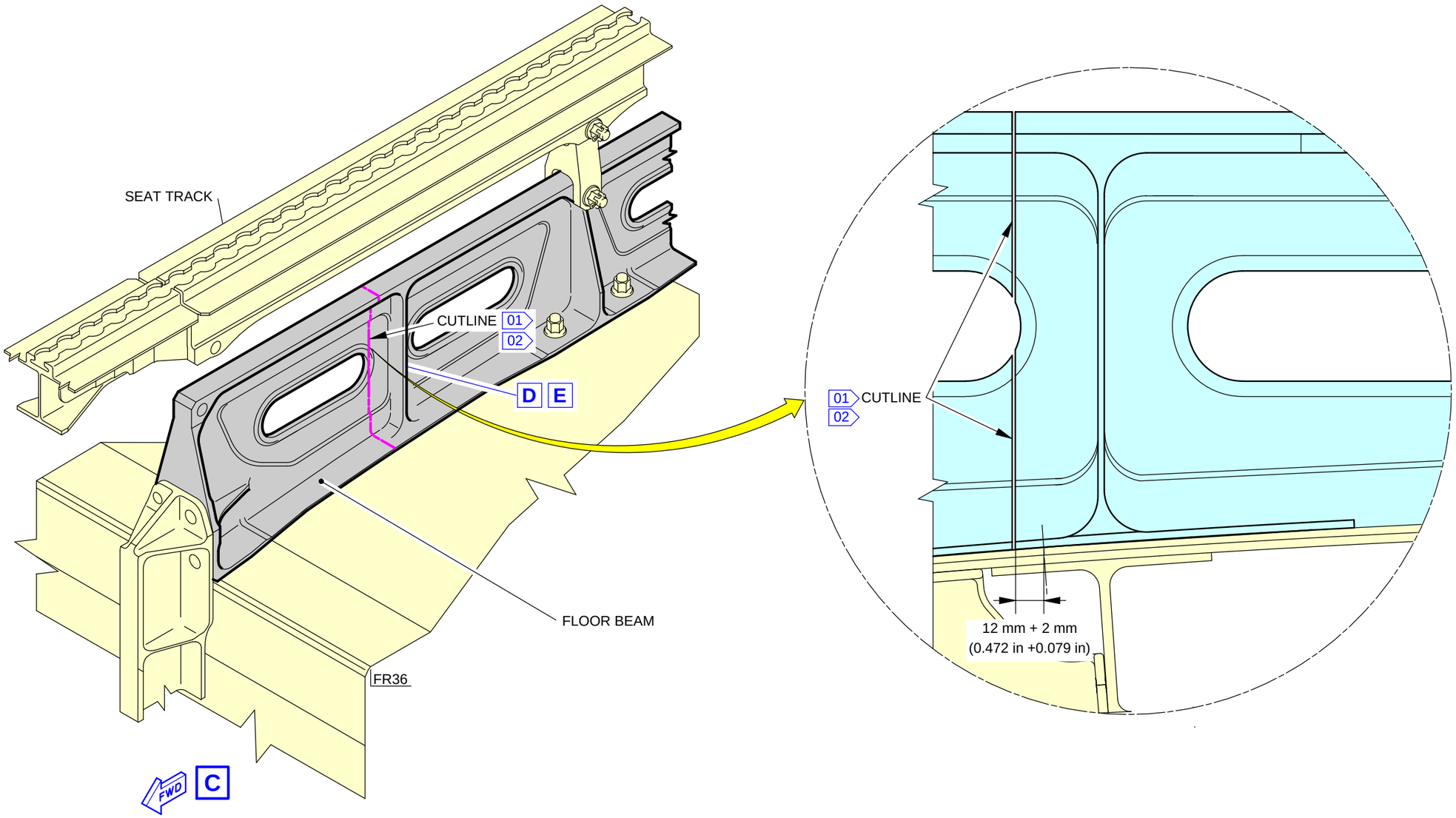


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

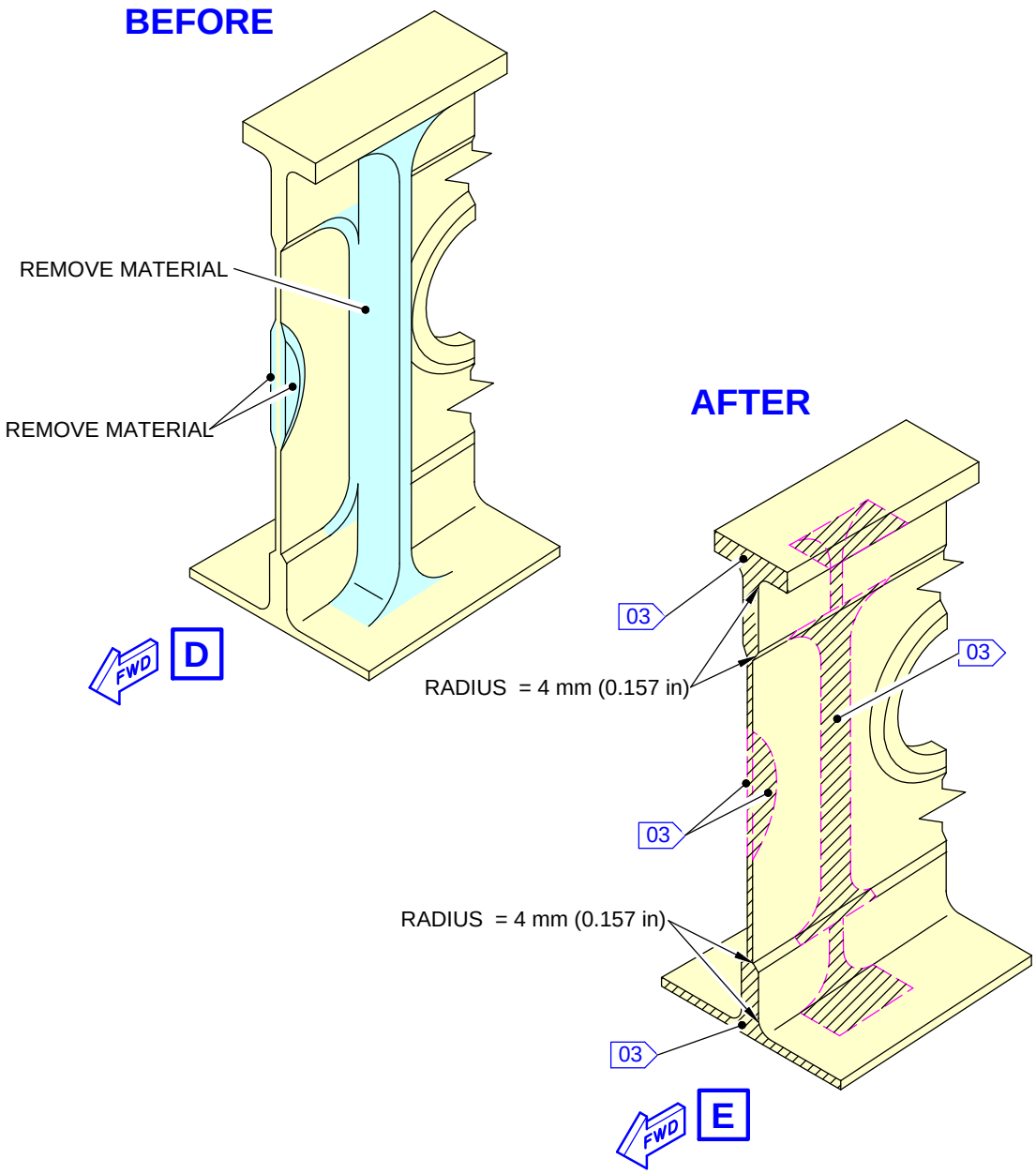
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(23) Task A320-A-57-XX-1228-04001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-09ZZZ-720Z-C.

CONF 001 003 004

(24) Task A320-A-57-XX-1228-09001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

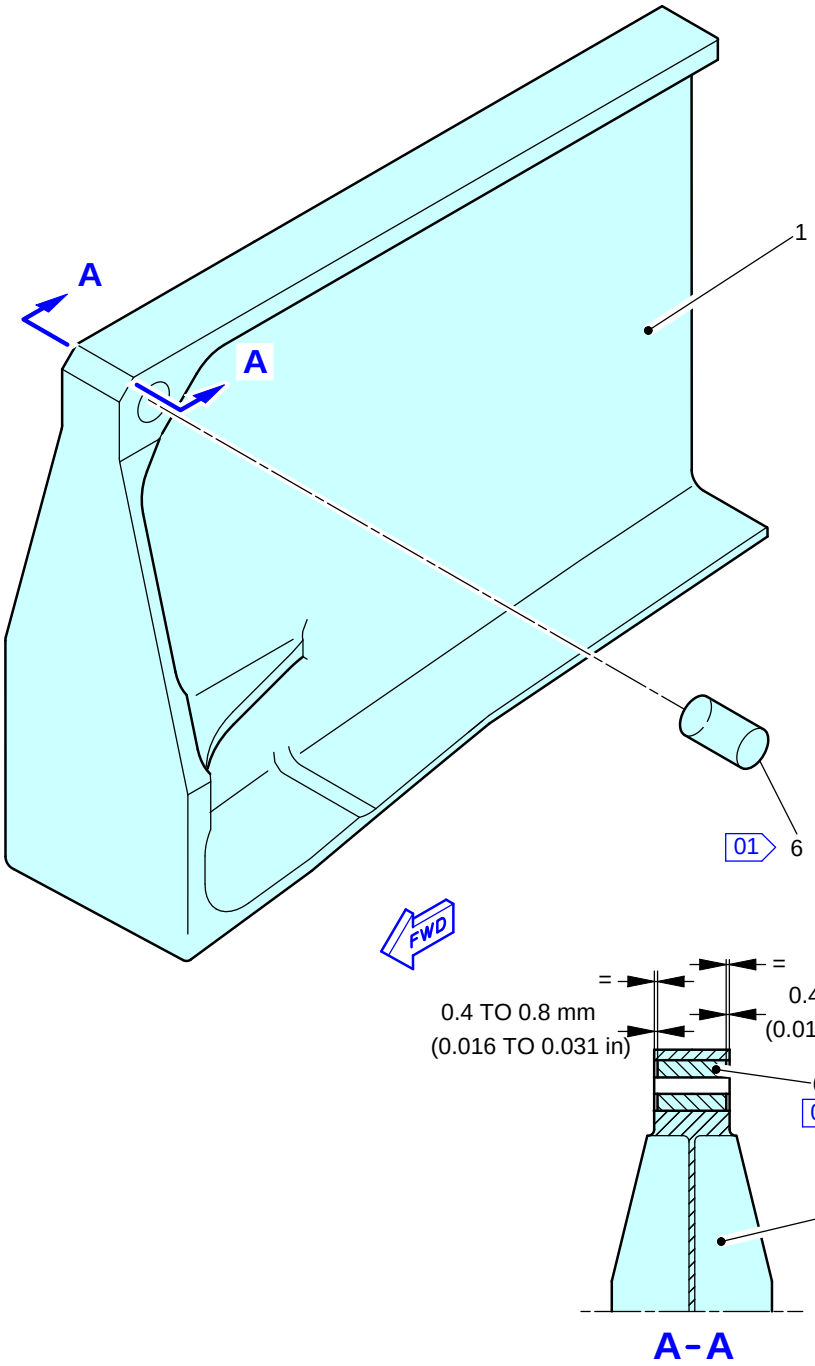
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(24) Task A320-A-57-XX-1228-09002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y765 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

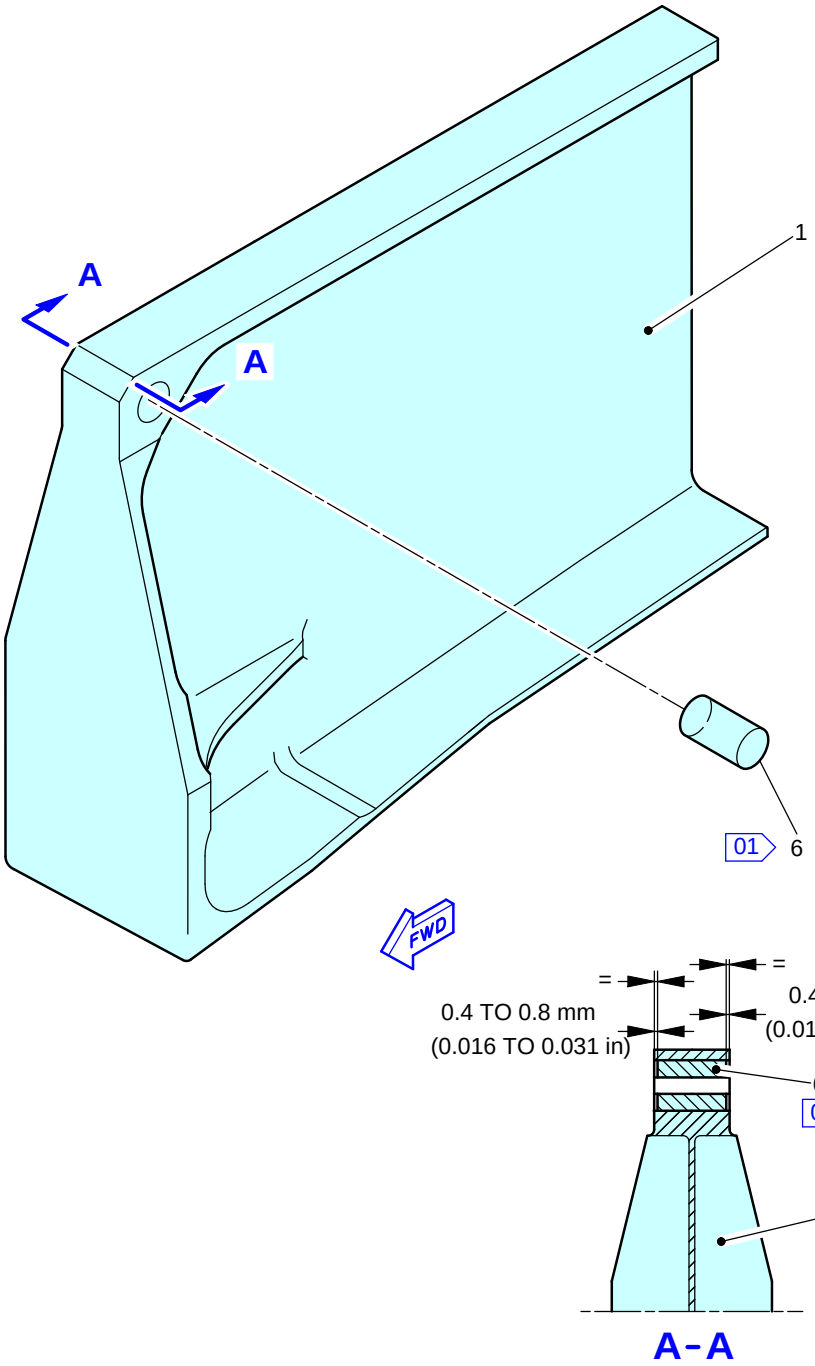
2 Install:

1	BUSHING	D5713006420000	Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(25) Task A320-A-57-XX-1228-02001-270A-A - Temporarily, Install the New Parts for Adjustment on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

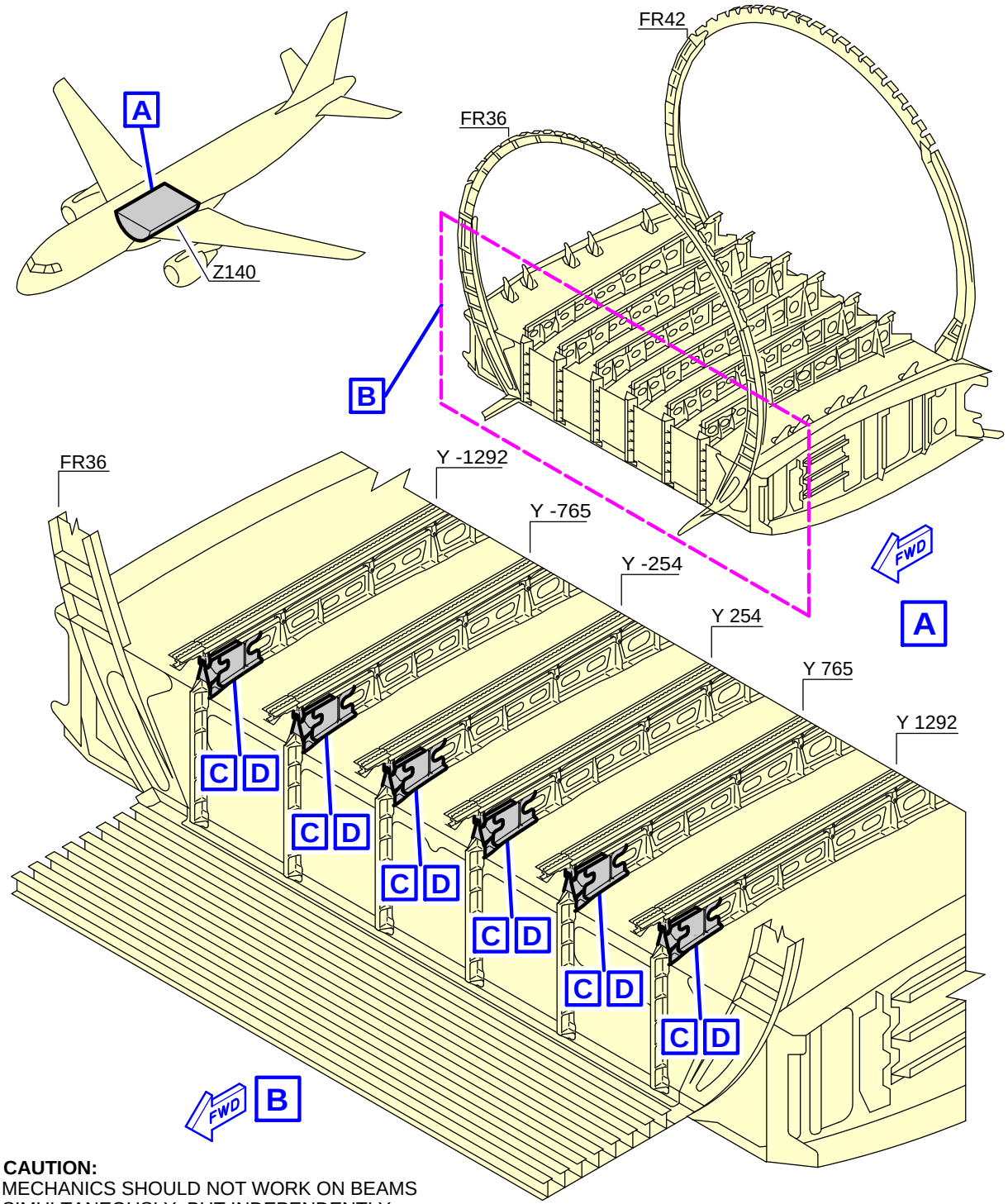
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

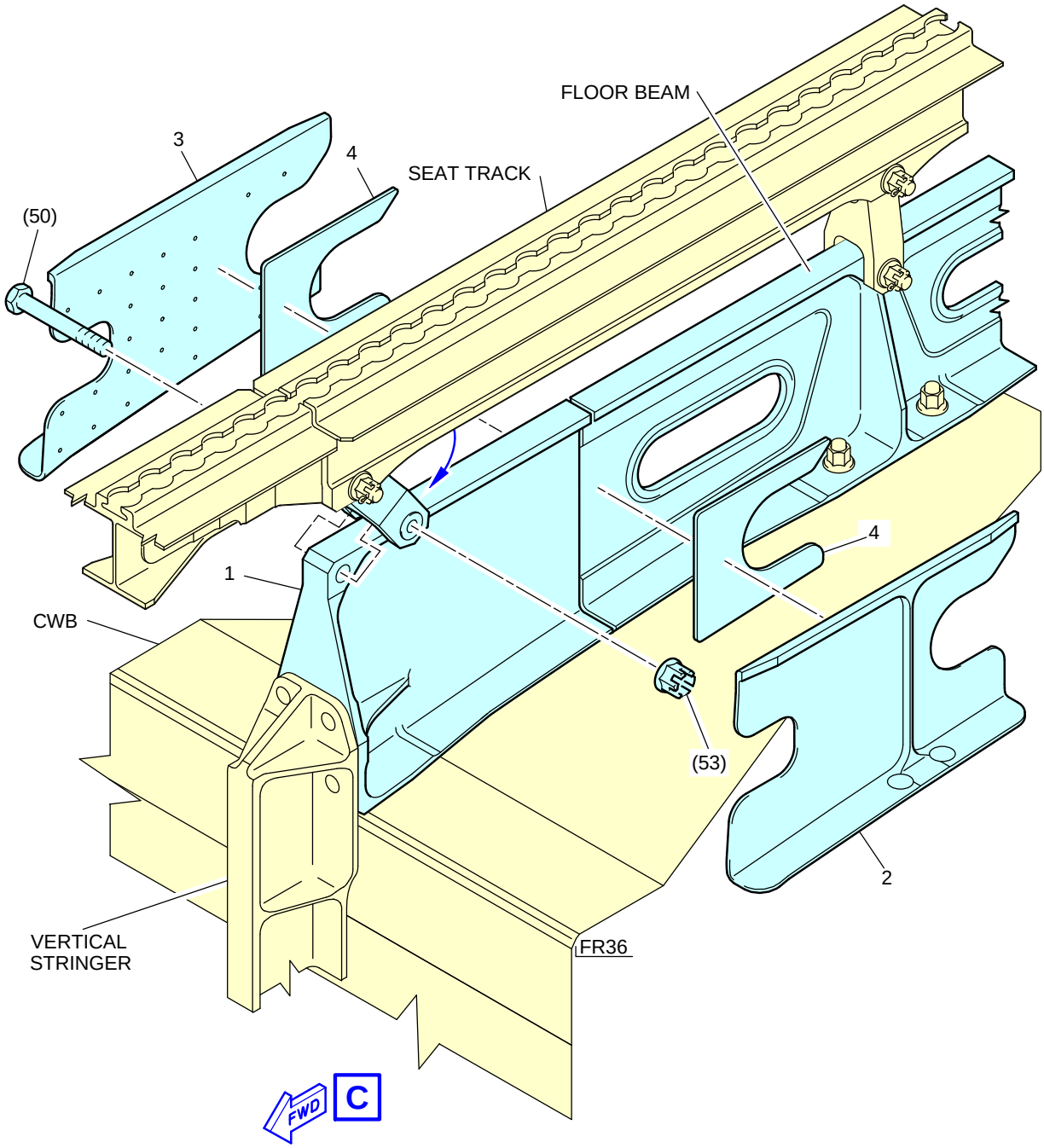


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

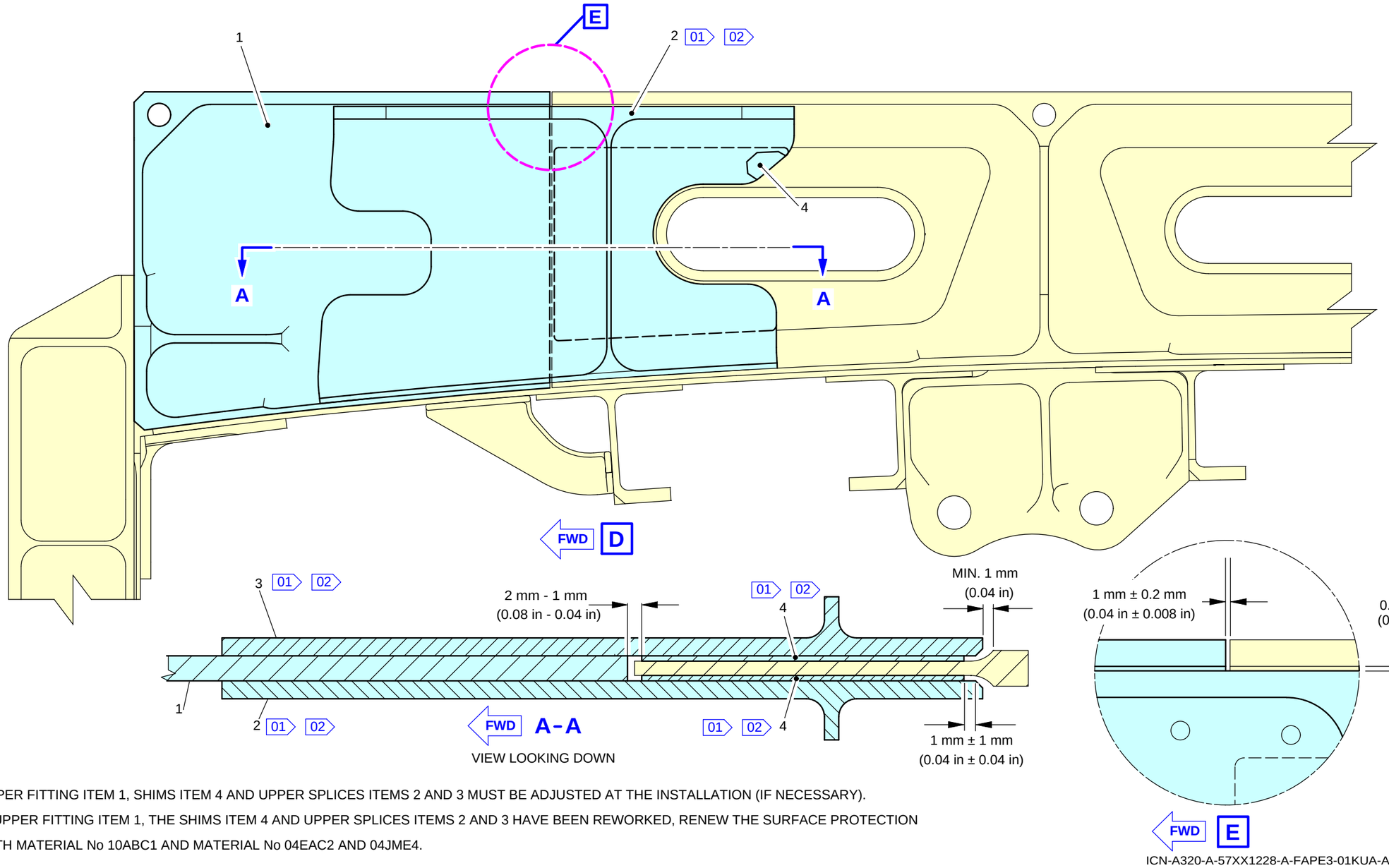
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(25) Task A320-A-57-XX-1228-02002-270A-A - Temporarily, Install the New Parts for Adjustment on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

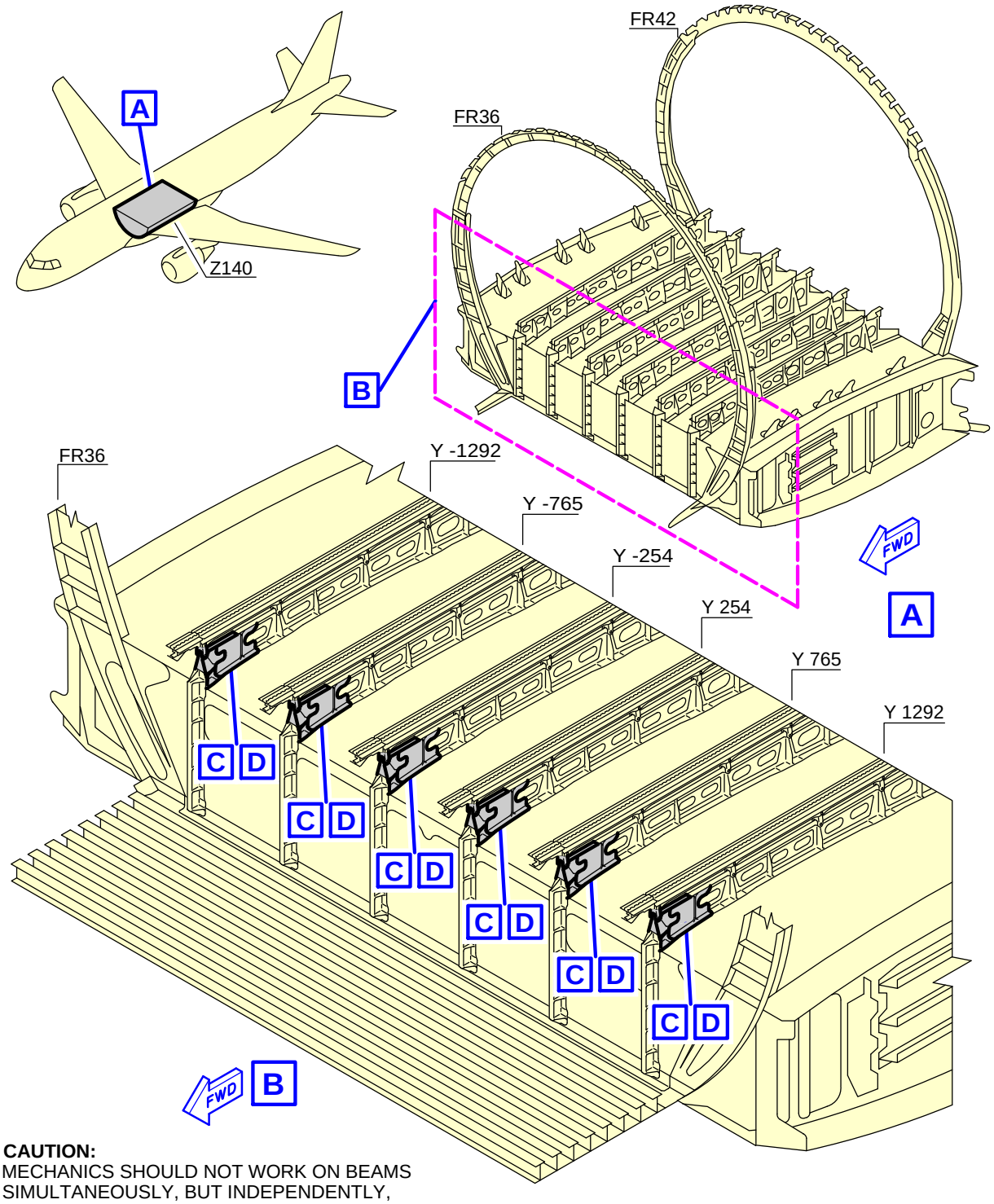
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

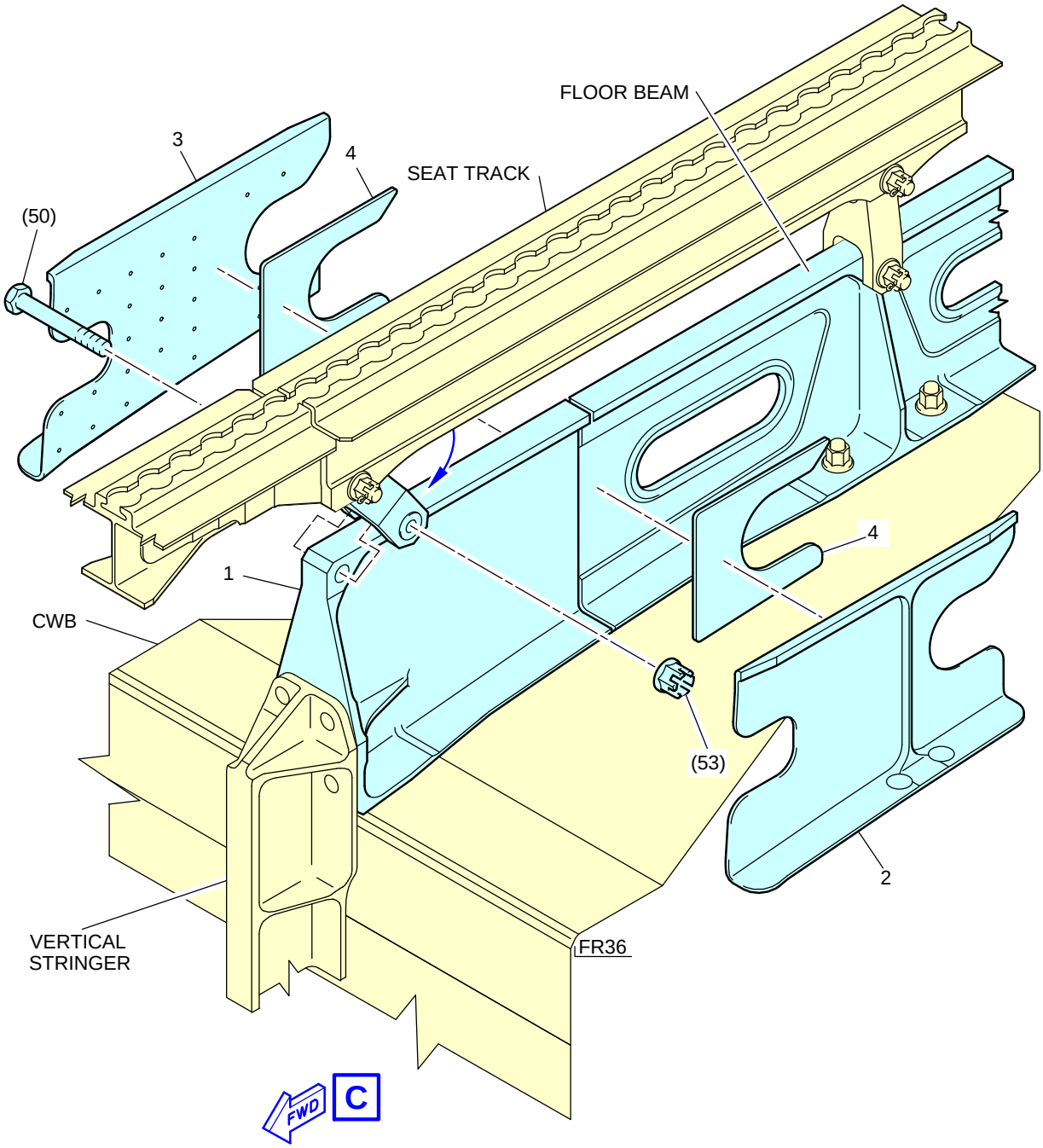


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

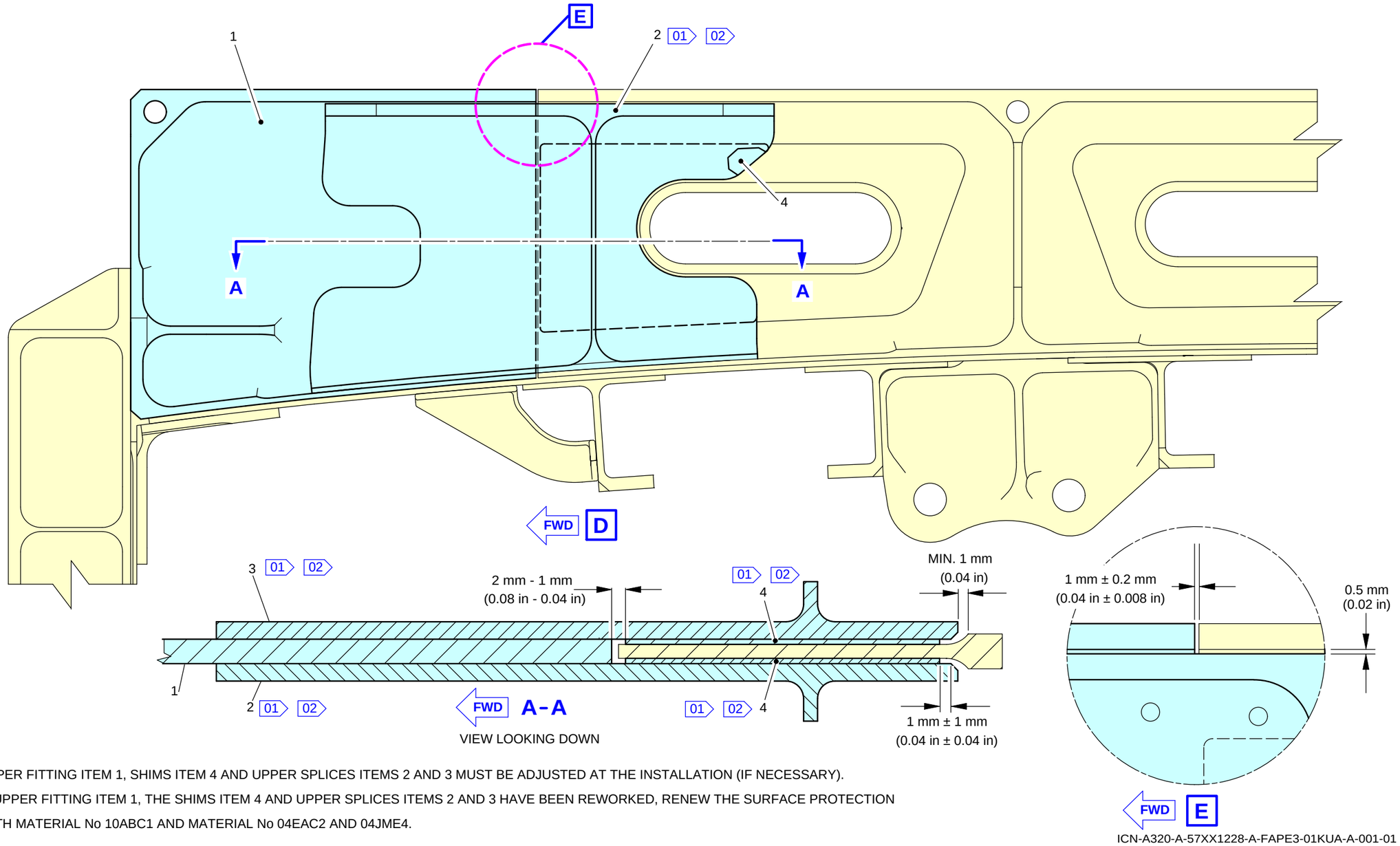
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(26) Task A320-A-57-XX-1228-04001-900A-A - Drill the New Parts on Y765 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

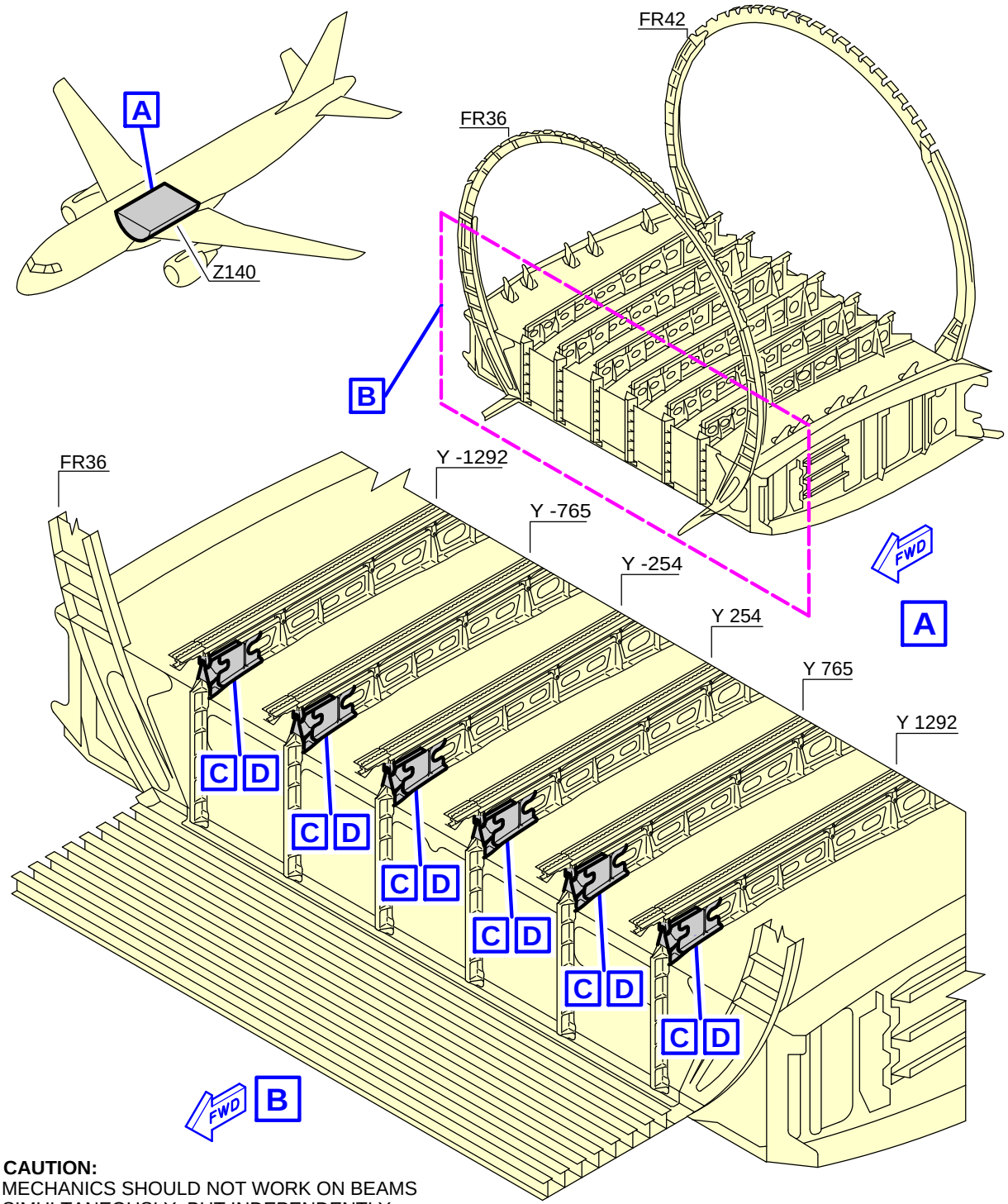
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

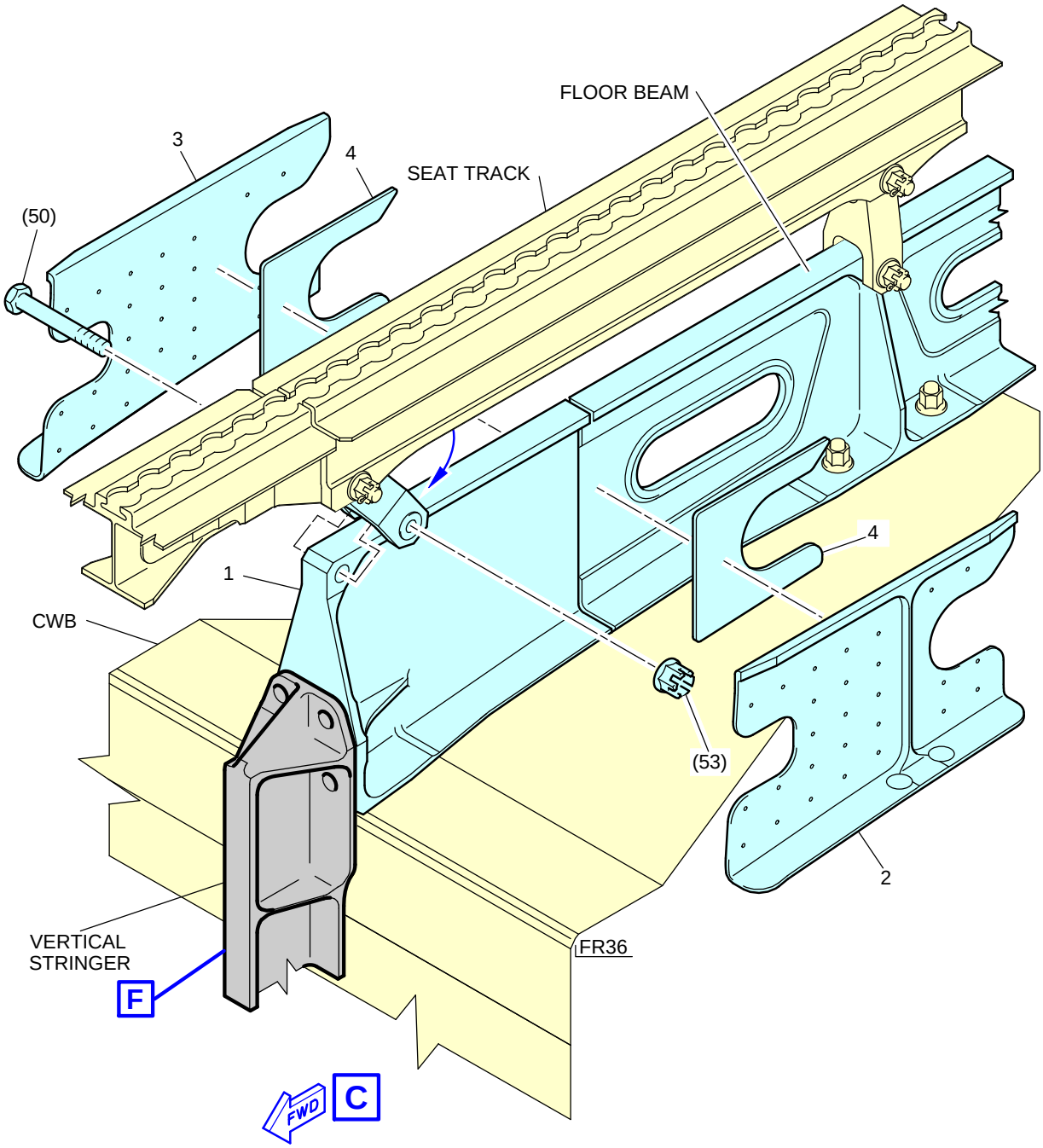


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

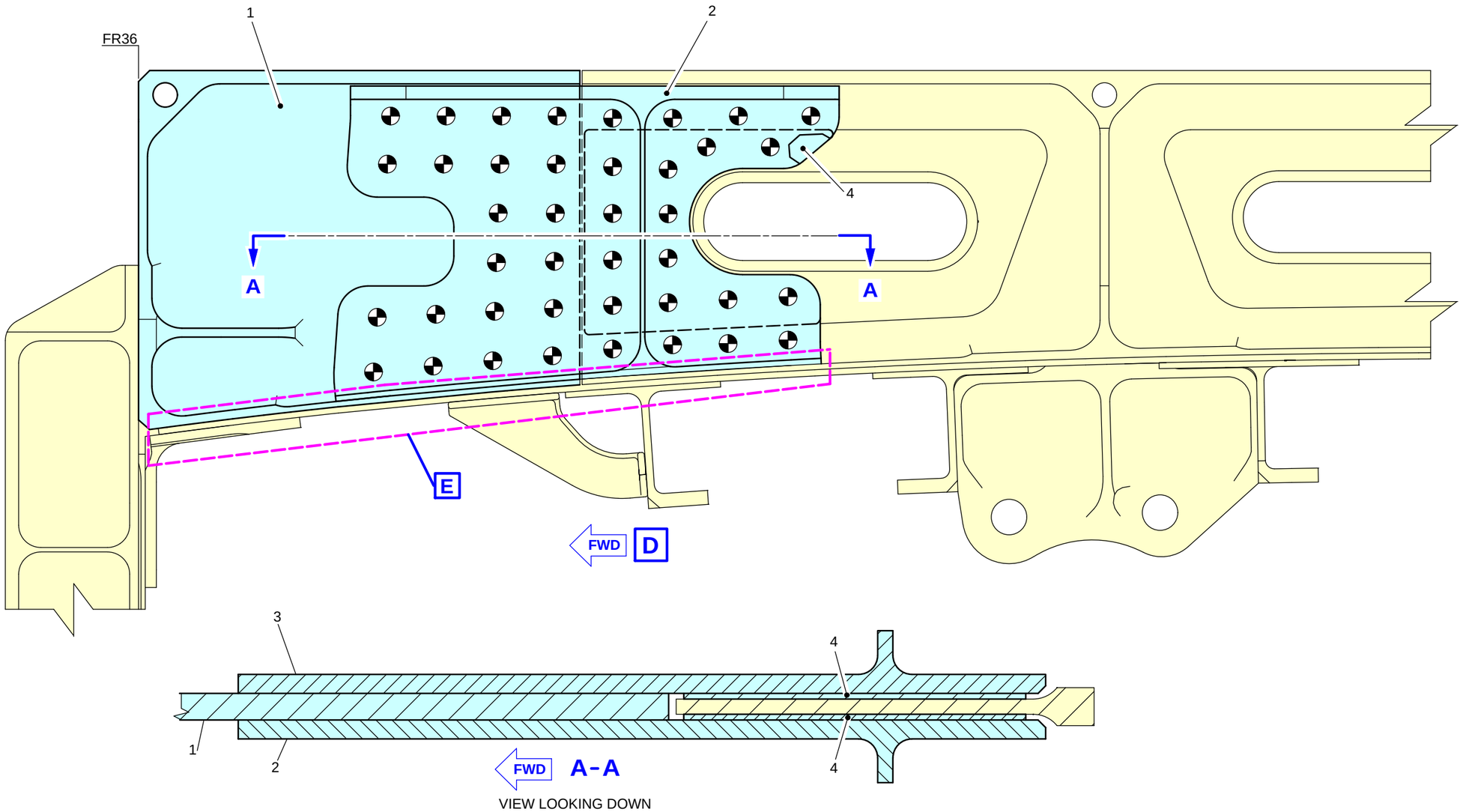
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

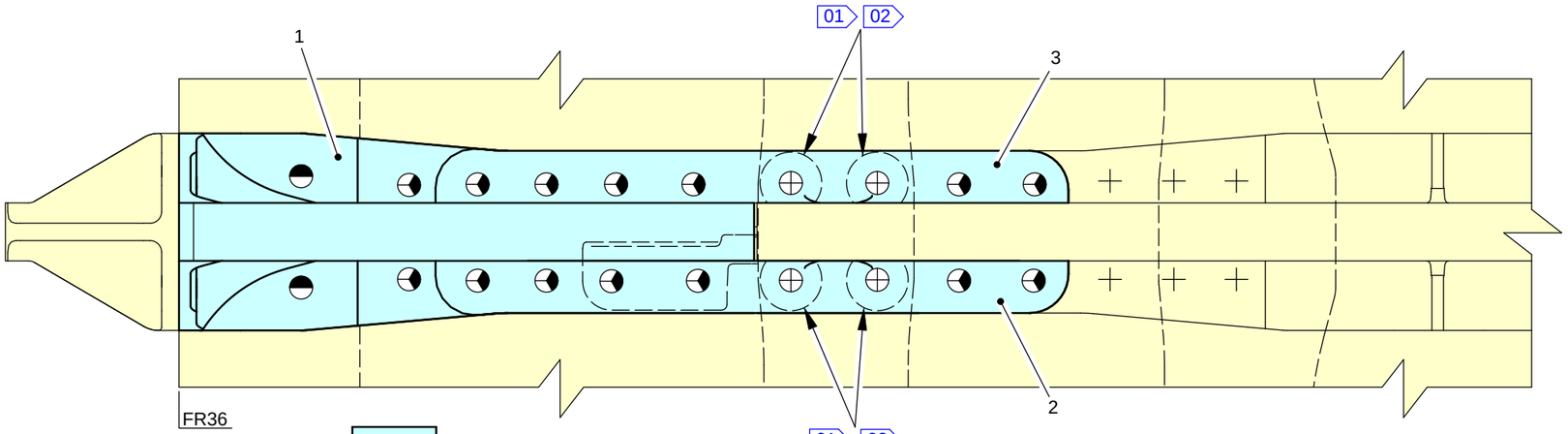


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

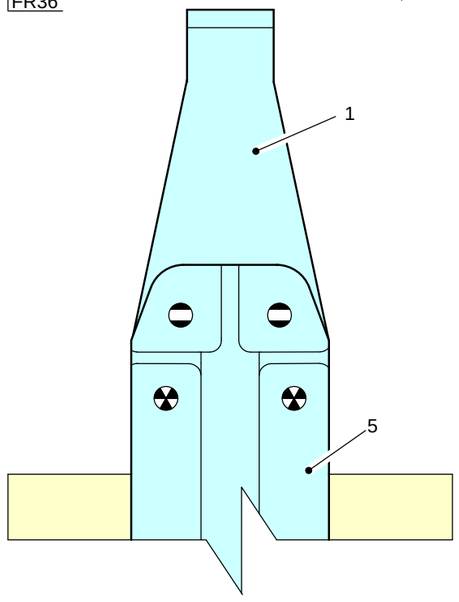
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◒	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(26) Task A320-A-57-XX-1228-04002-900A-A - Drill the New Parts on Y765 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

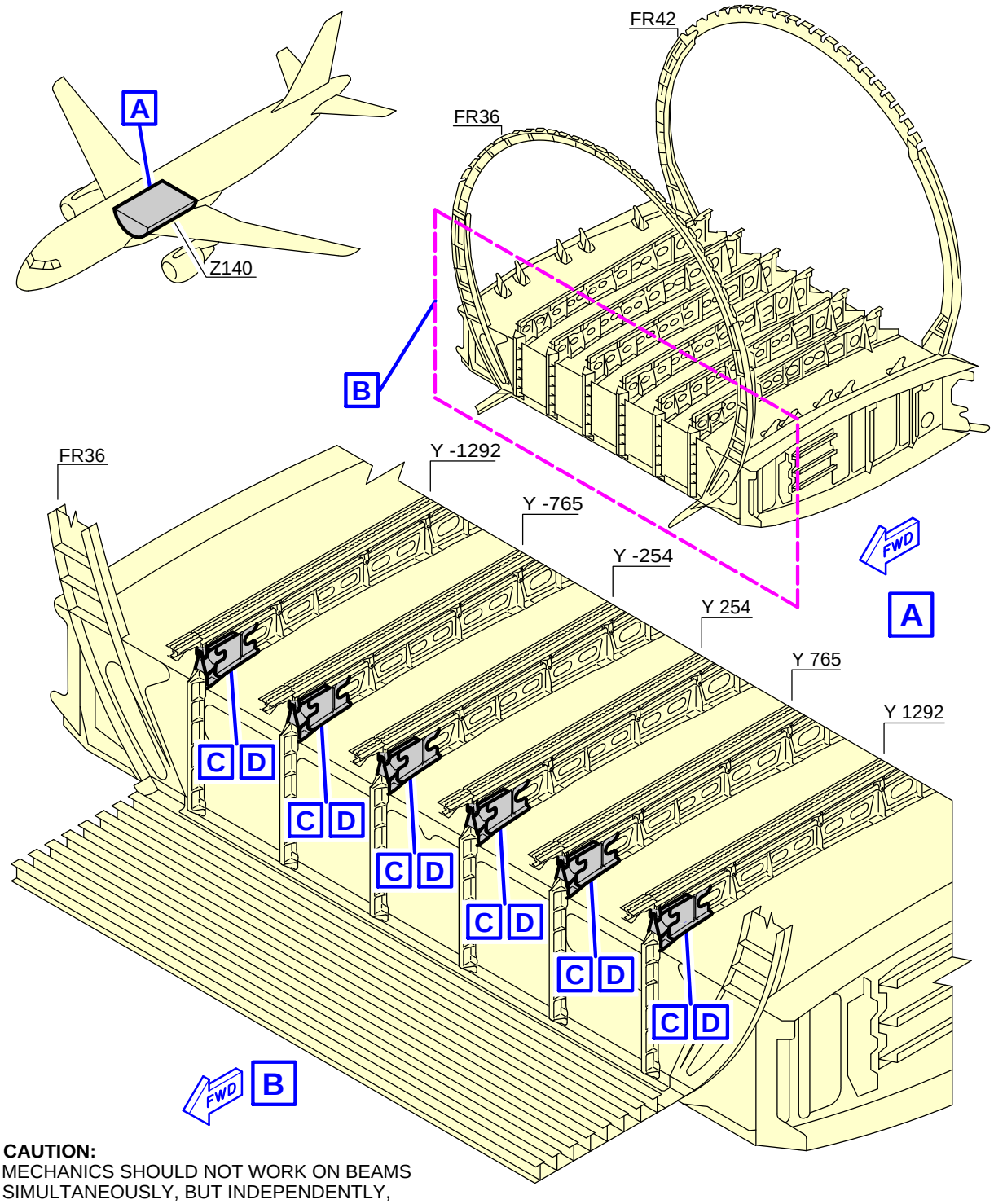
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

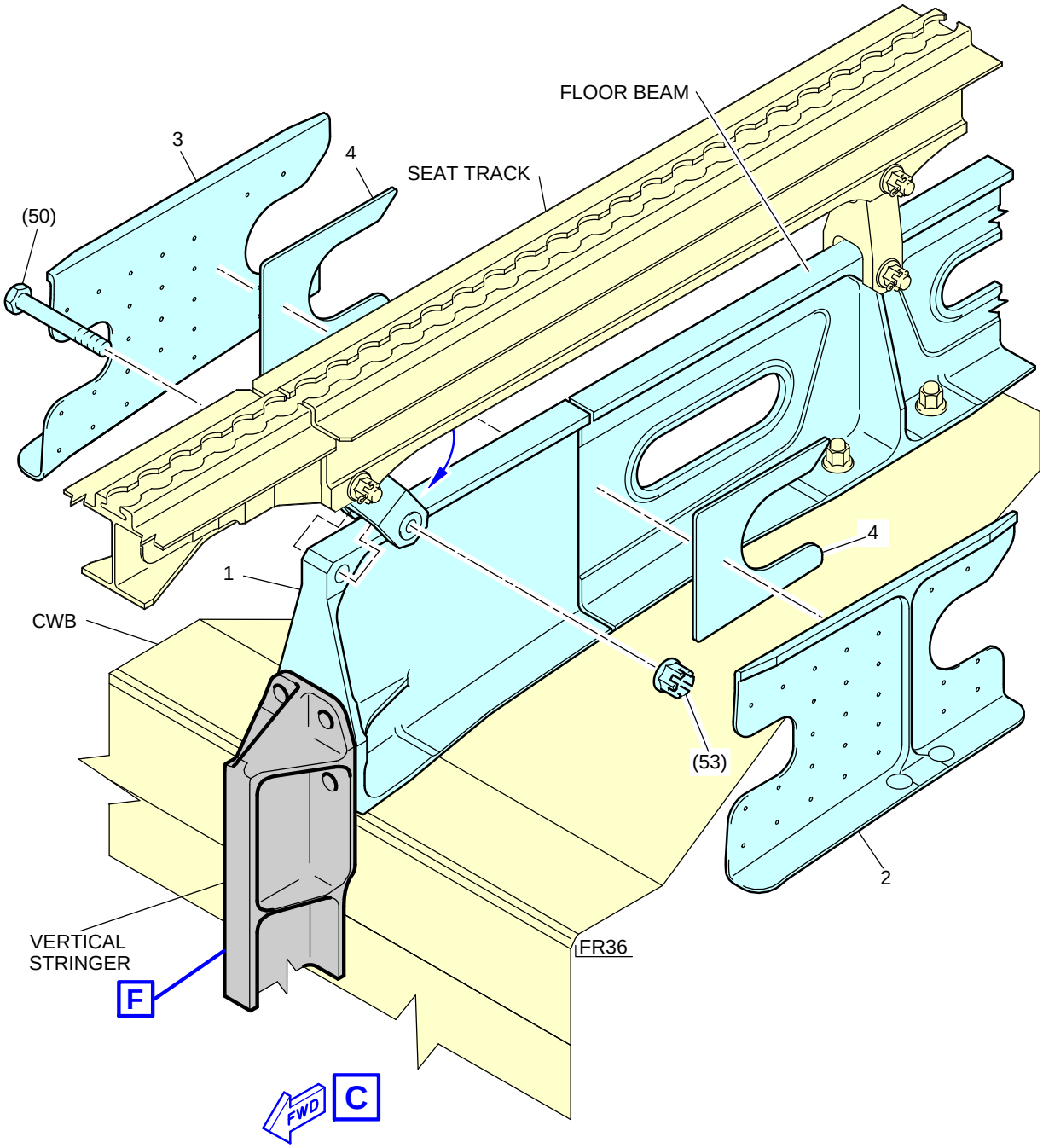


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

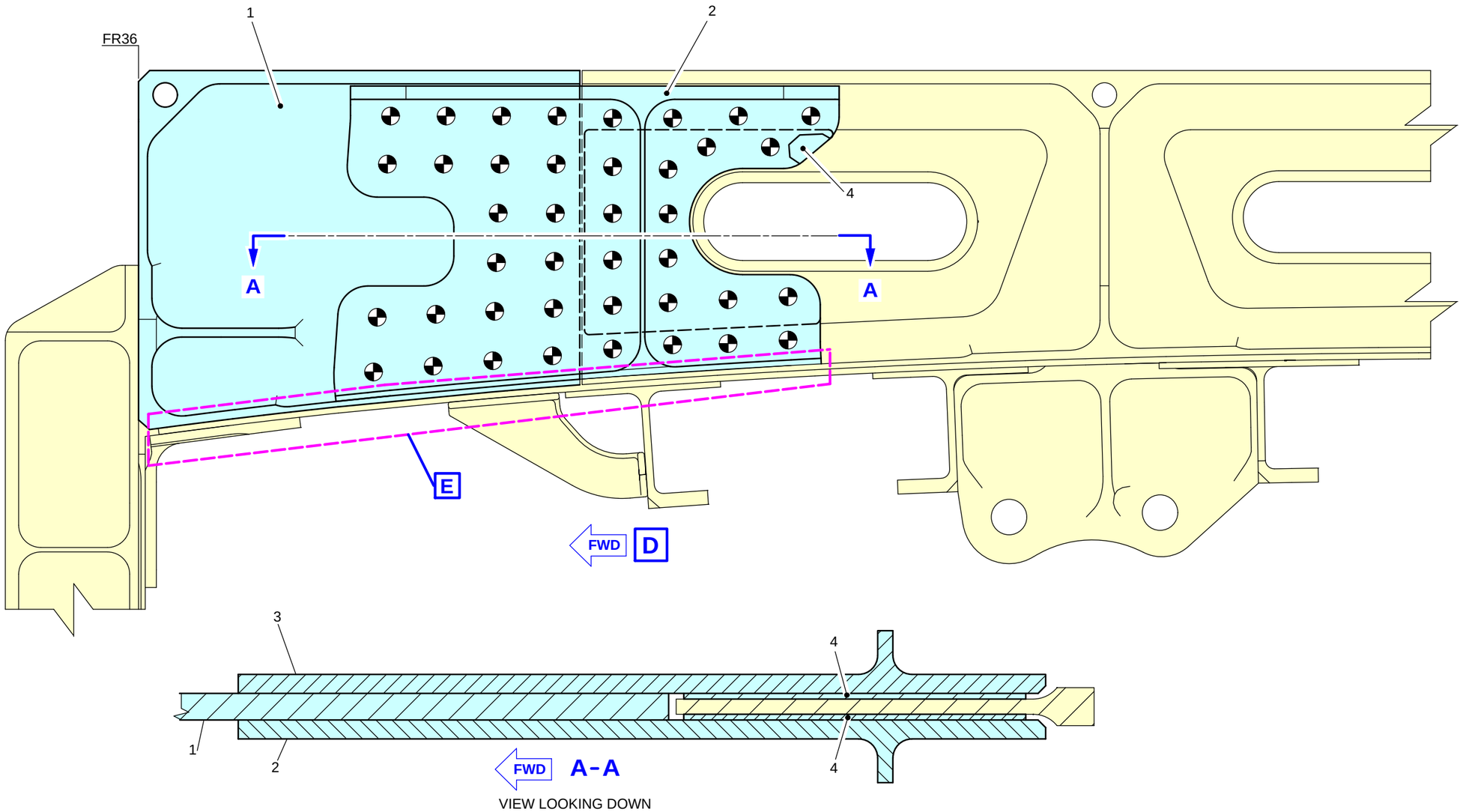
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

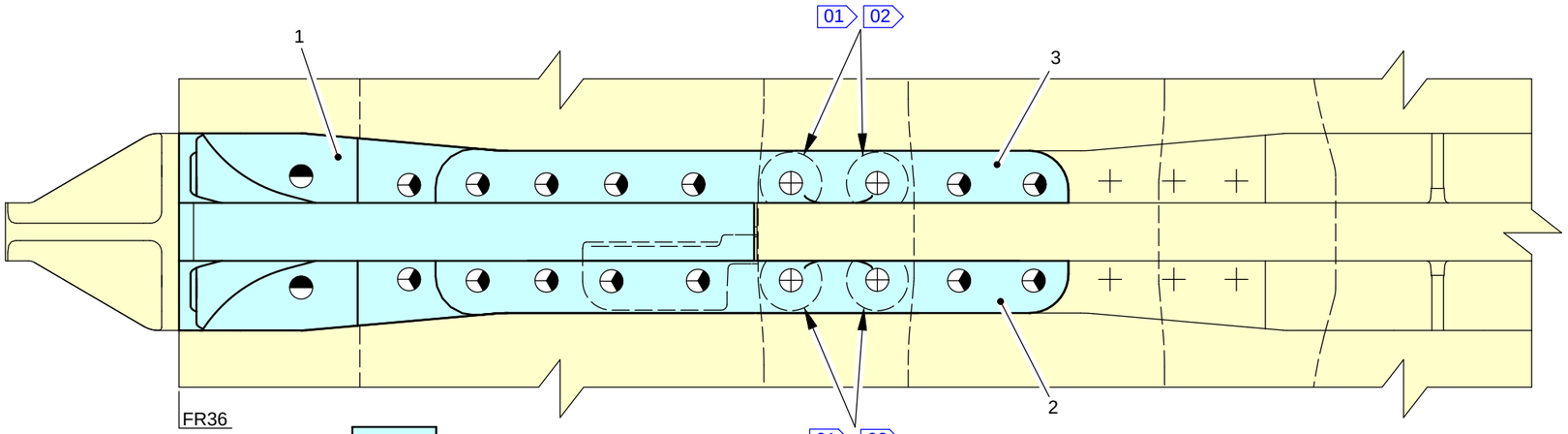


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

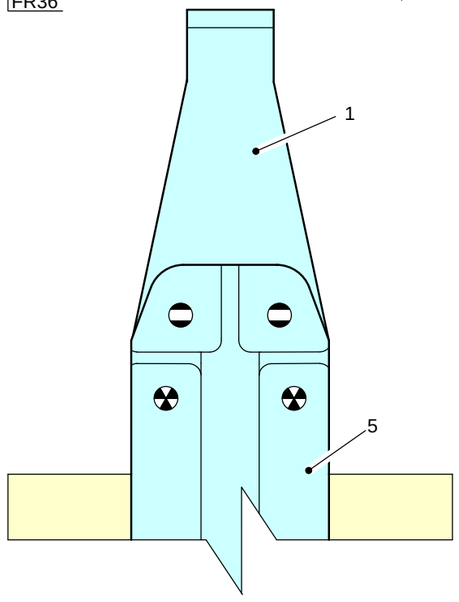
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(27) Task A320-A-57-XX-1228-10001-720A-A - Install the New Parts on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE with:	D0041005420200	Item 3	
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1		
	to the mating surface of all the parts.			

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

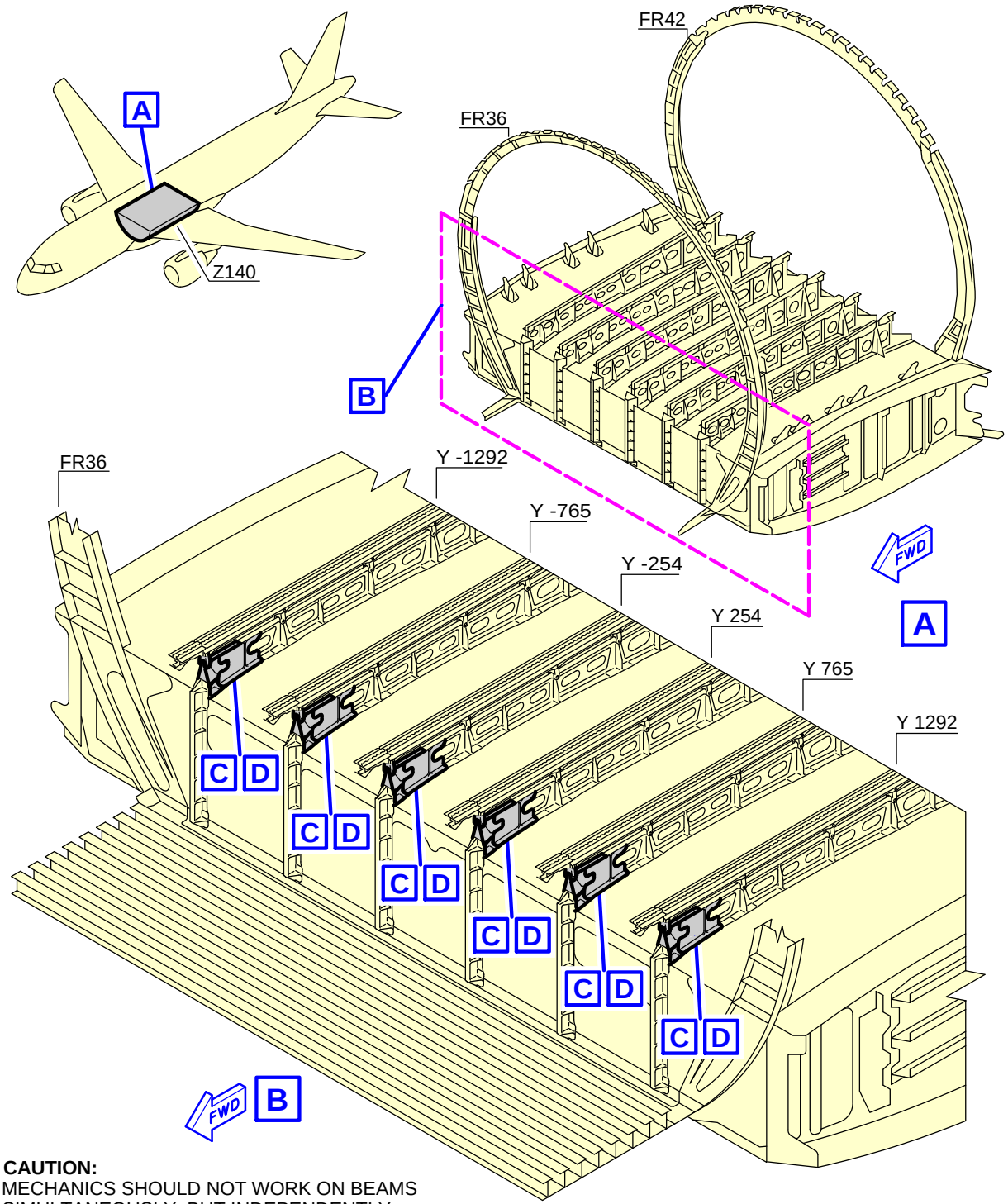
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

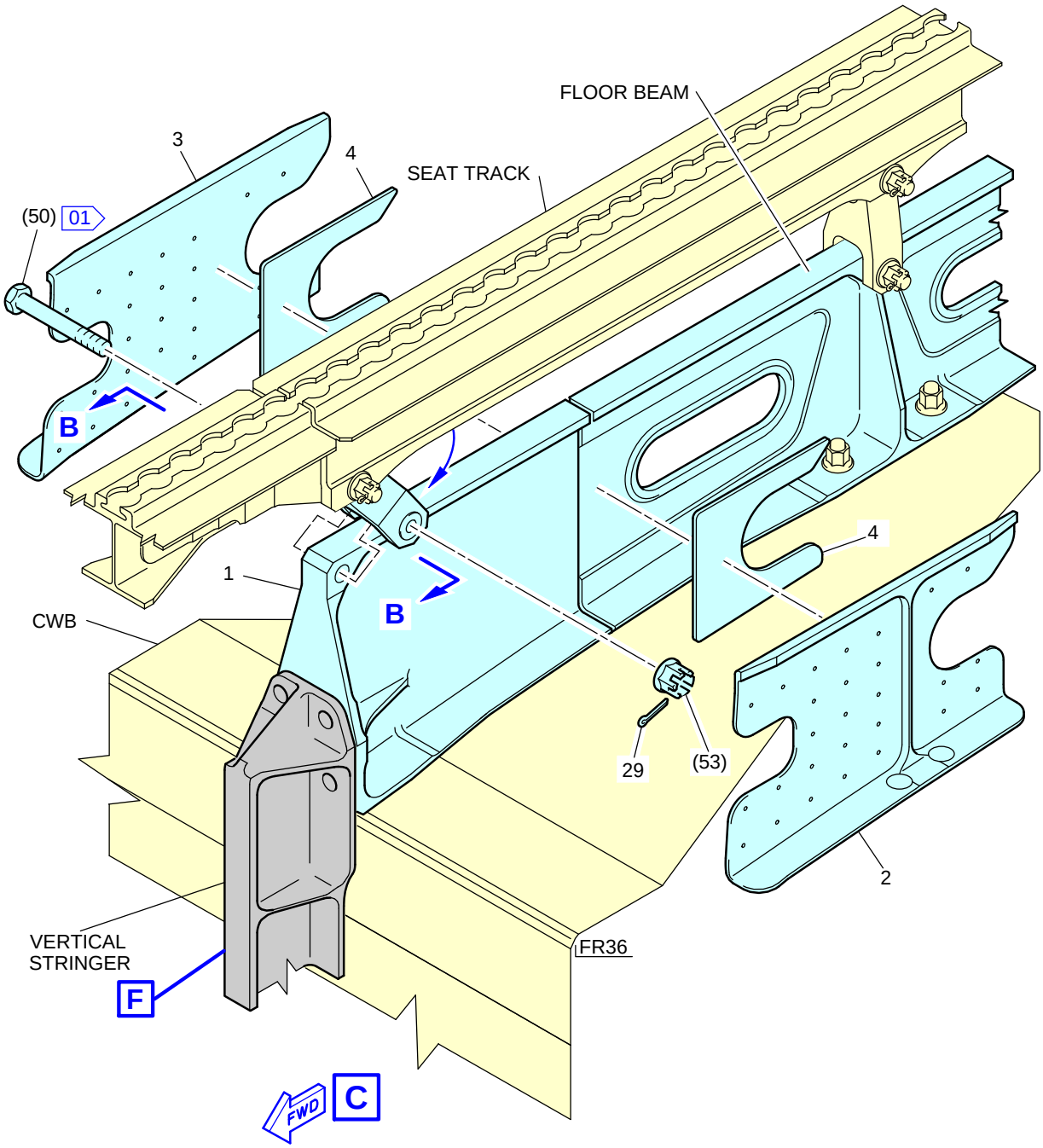


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



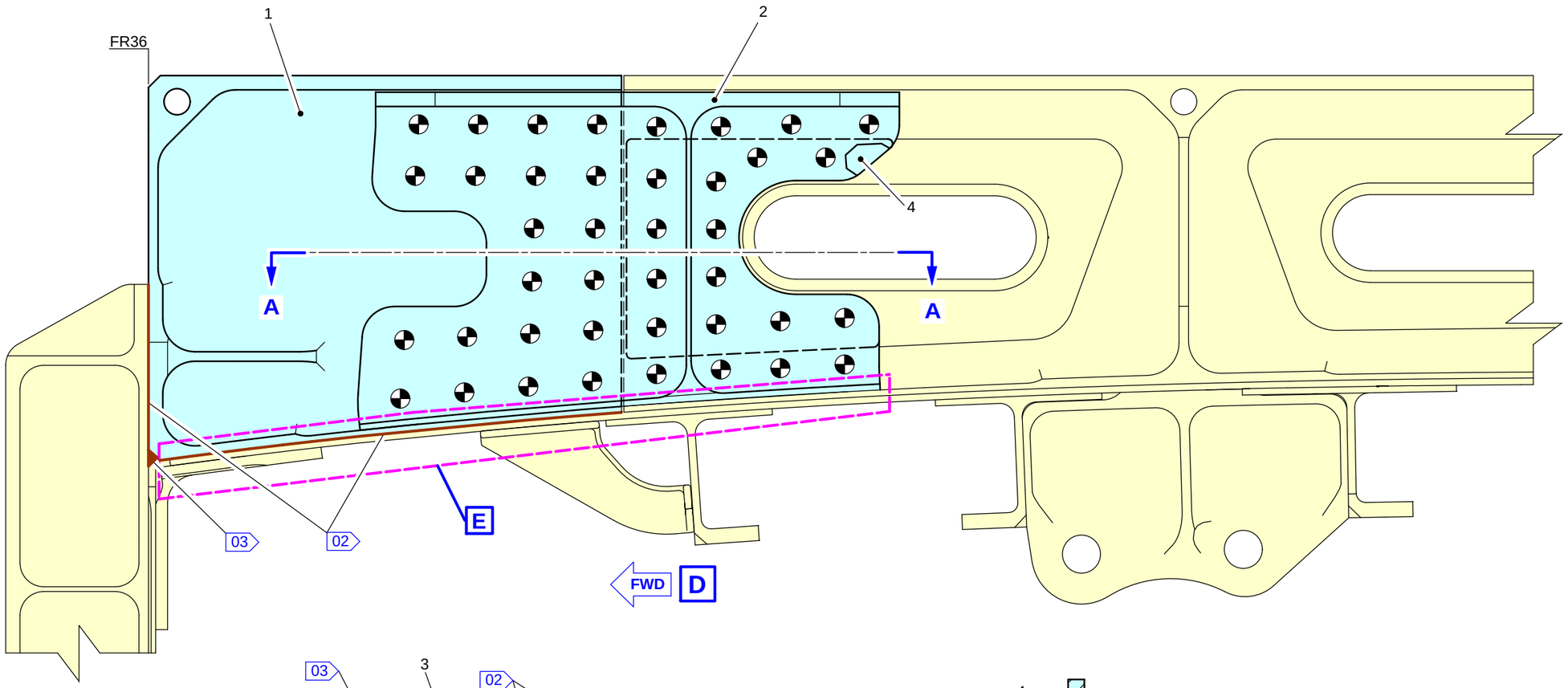
NOTE:

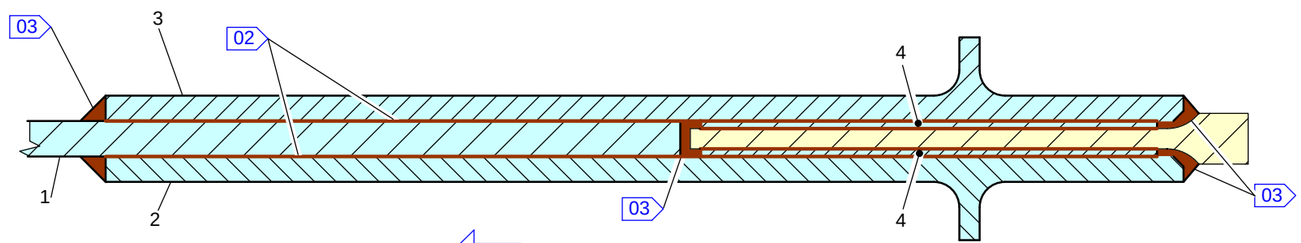
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

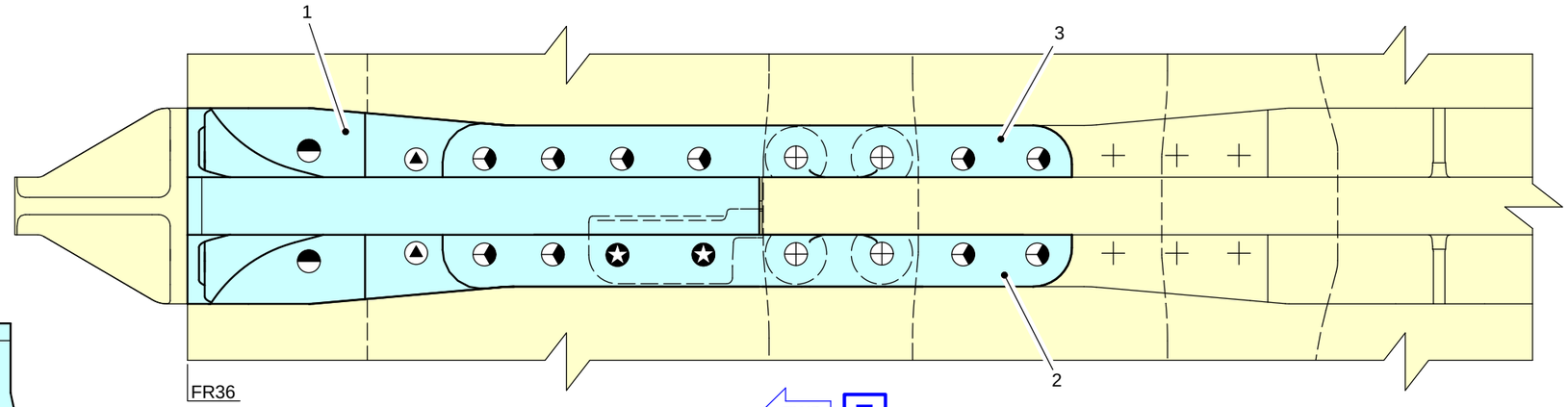
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

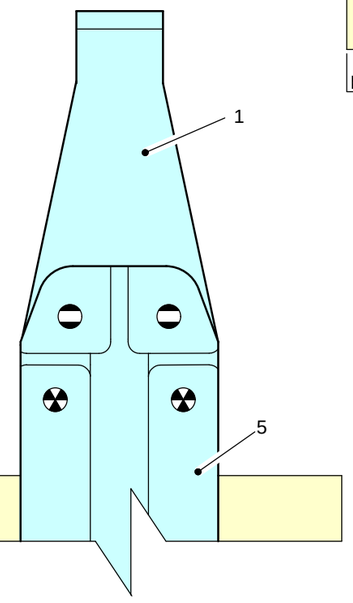
ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

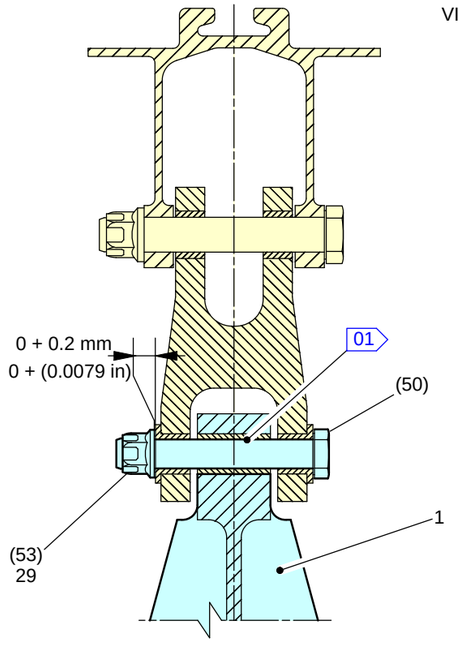
CONF 001 003 004





F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

FWD E

VIEW LOOKING DOWN

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 002

(27) Task A320-A-57-XX-1228-10002-720A-A - Install the New Parts on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

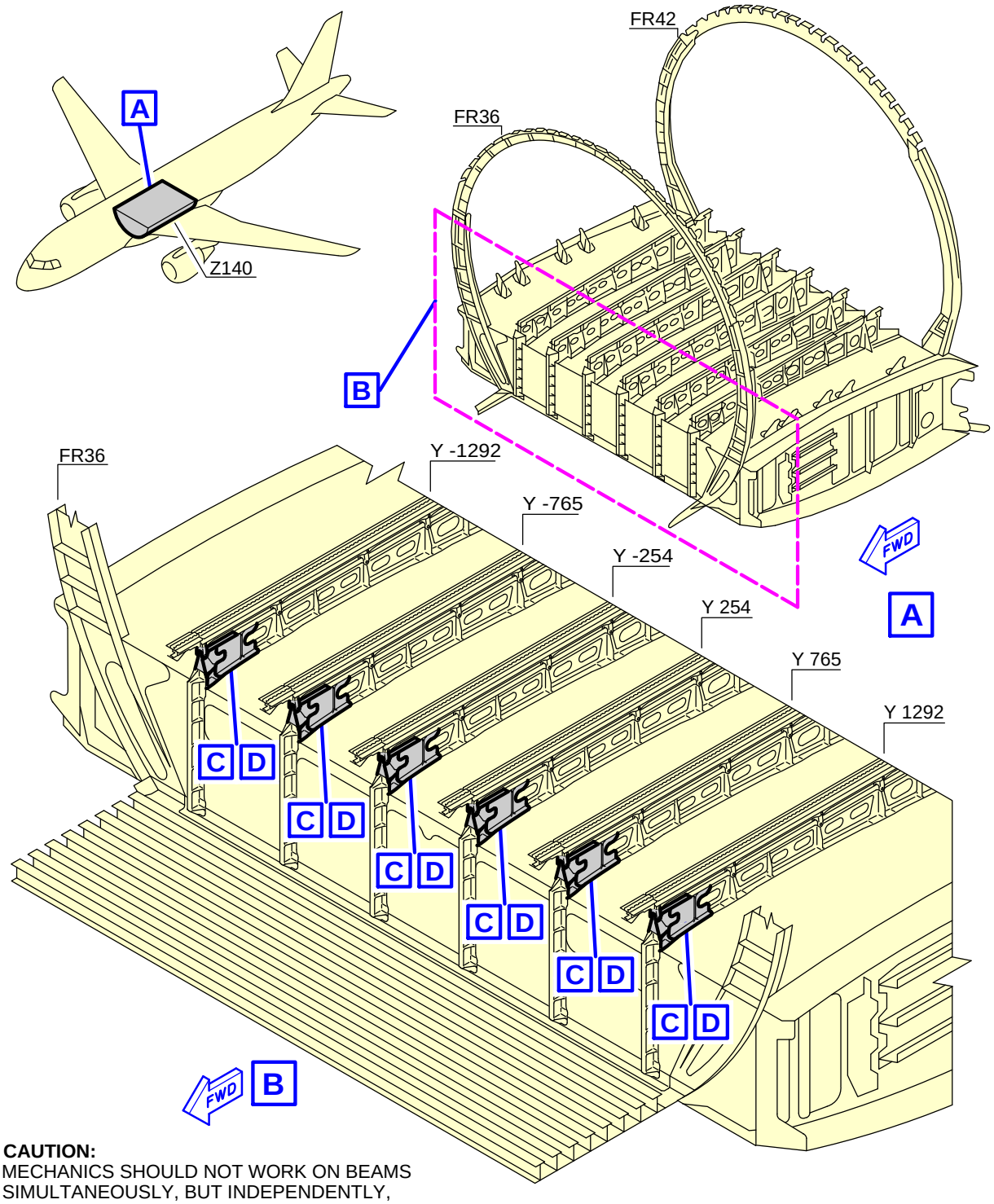
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

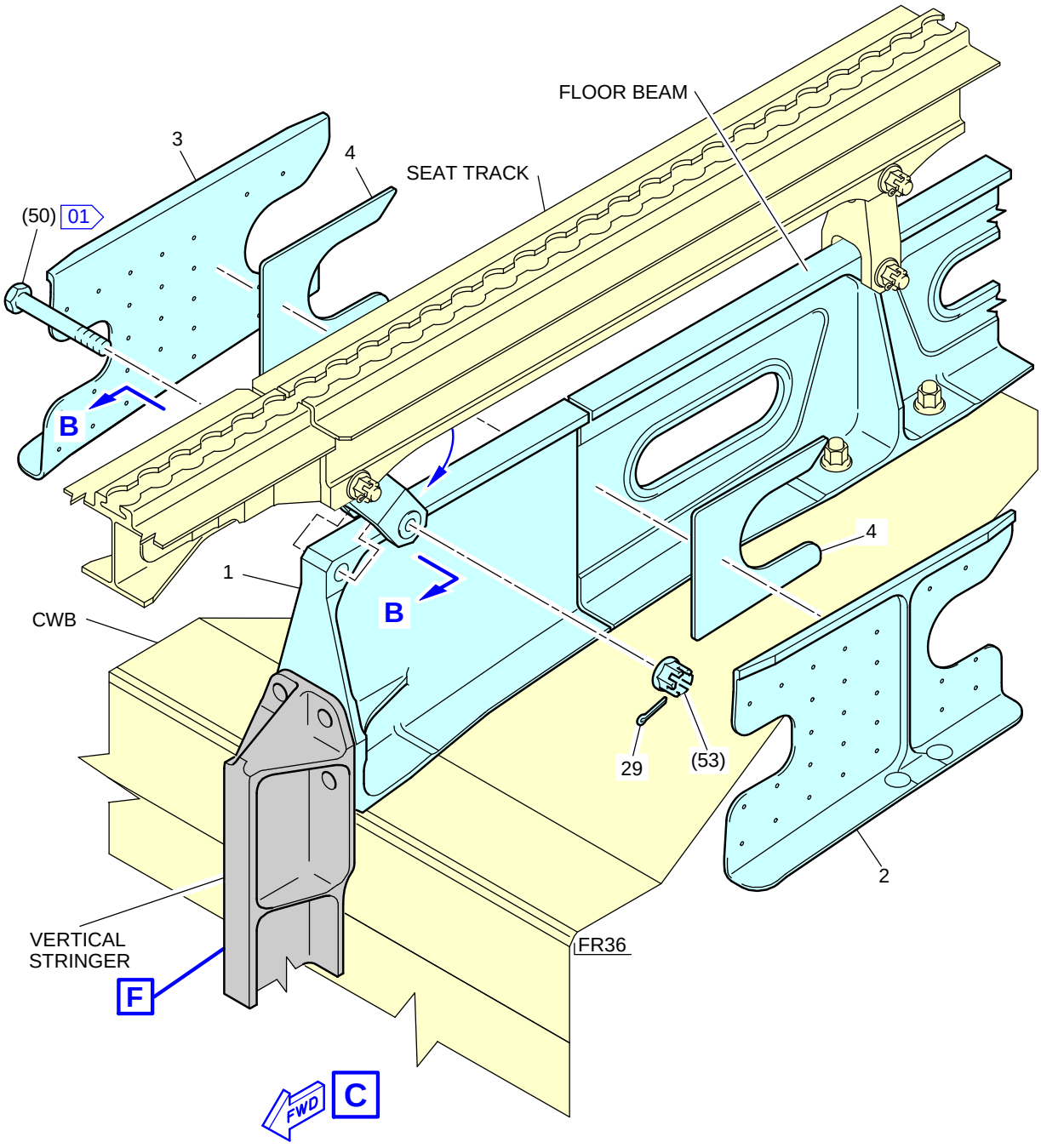


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



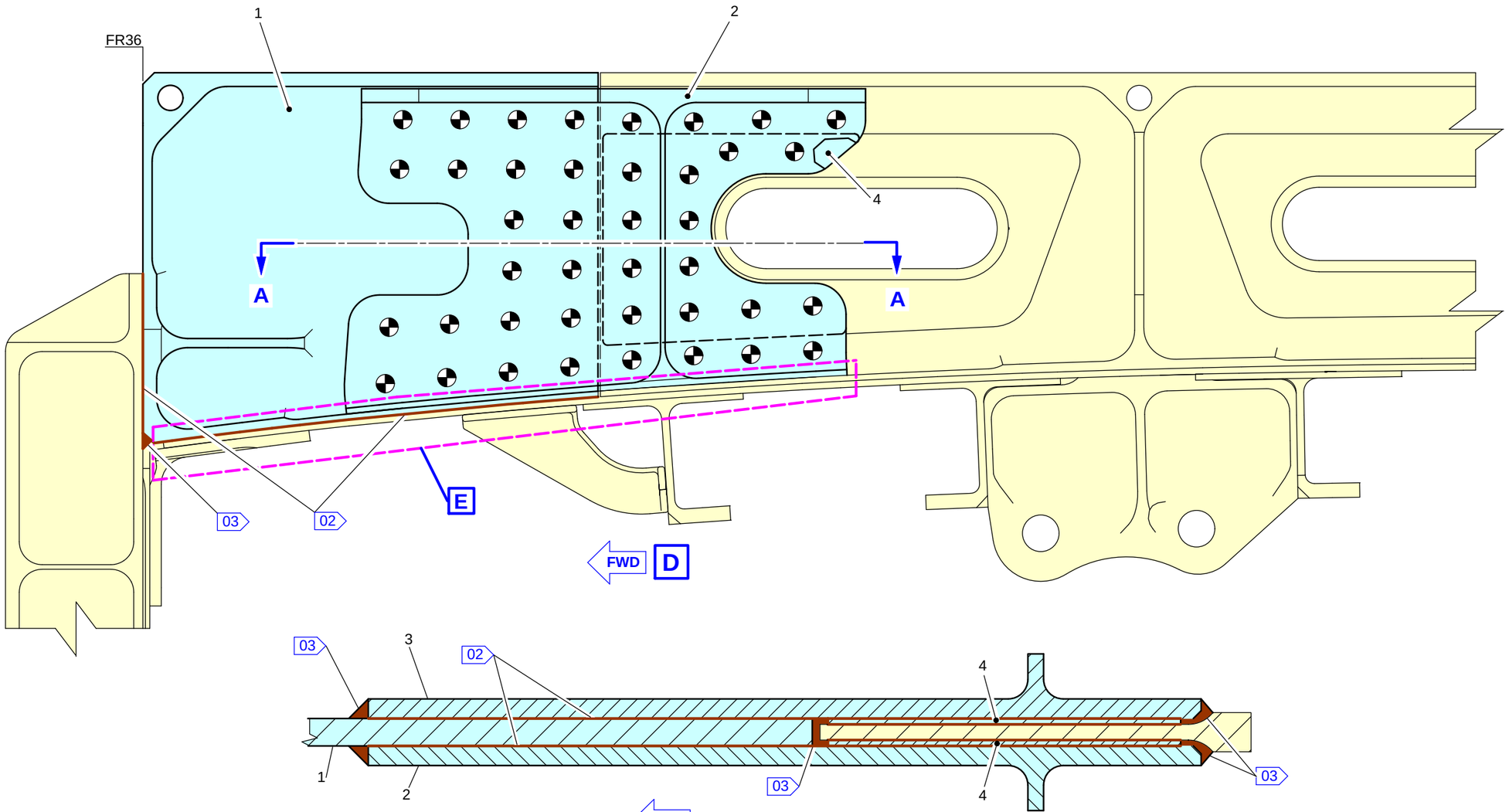
NOTE:

01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002



VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

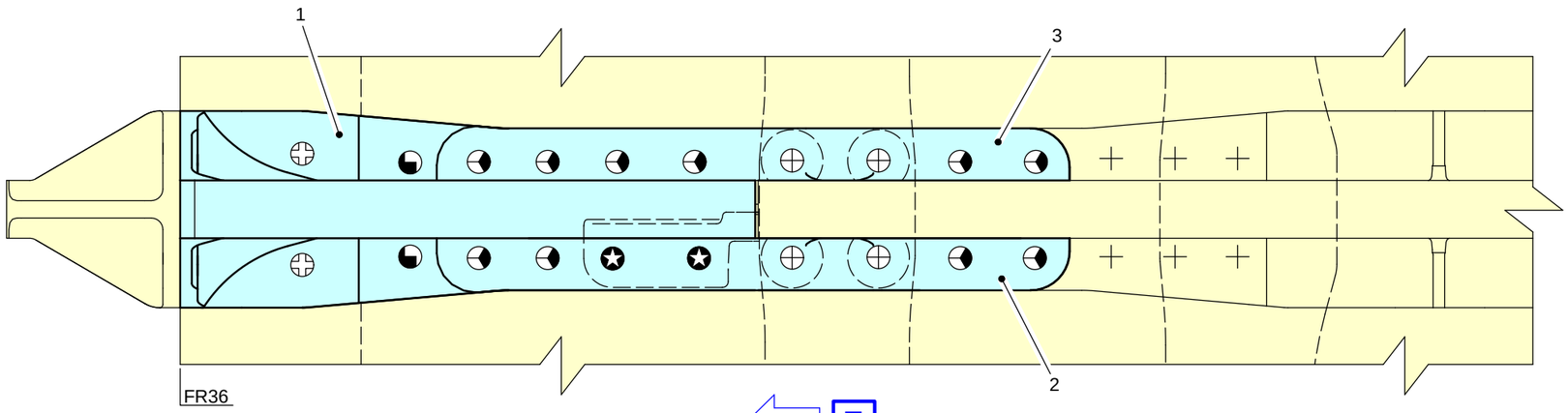
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

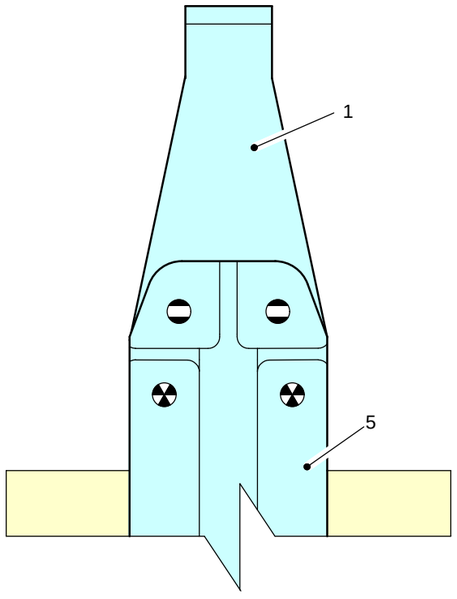
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

CONF 002

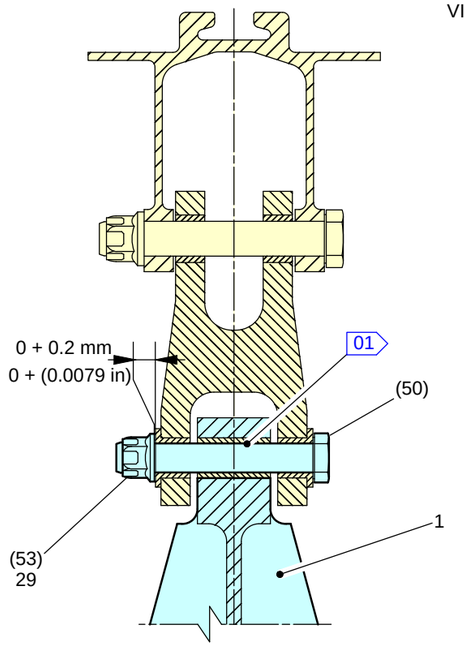


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(28) Task A320-A-57-XX-1228-02001-250A-A - Protect the Fasteners and the New Parts on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

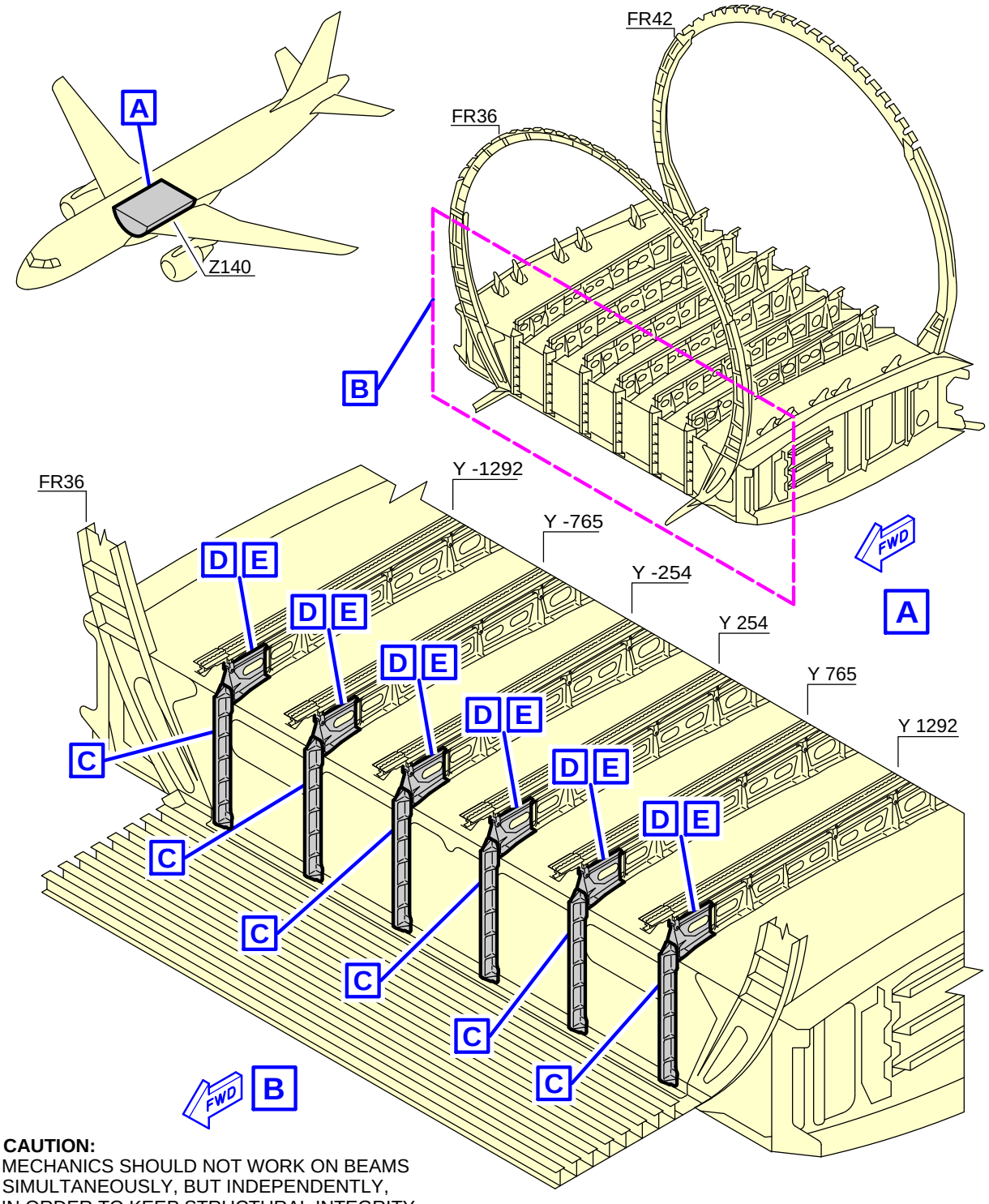
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

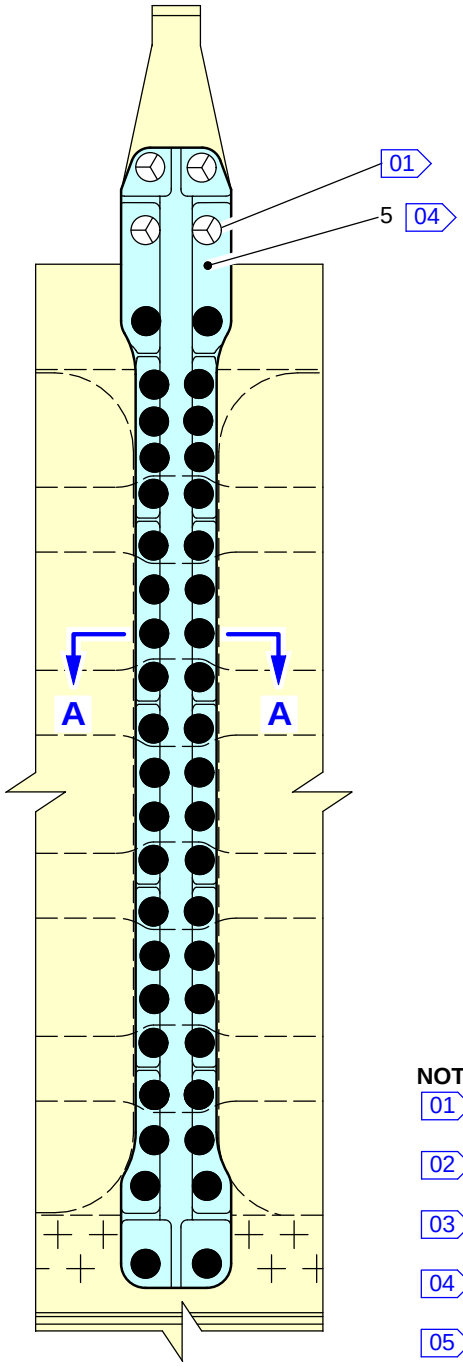


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

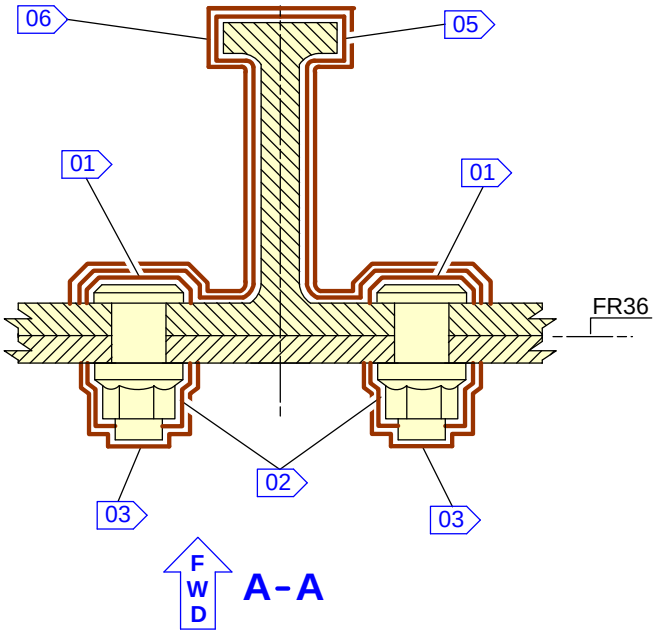
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

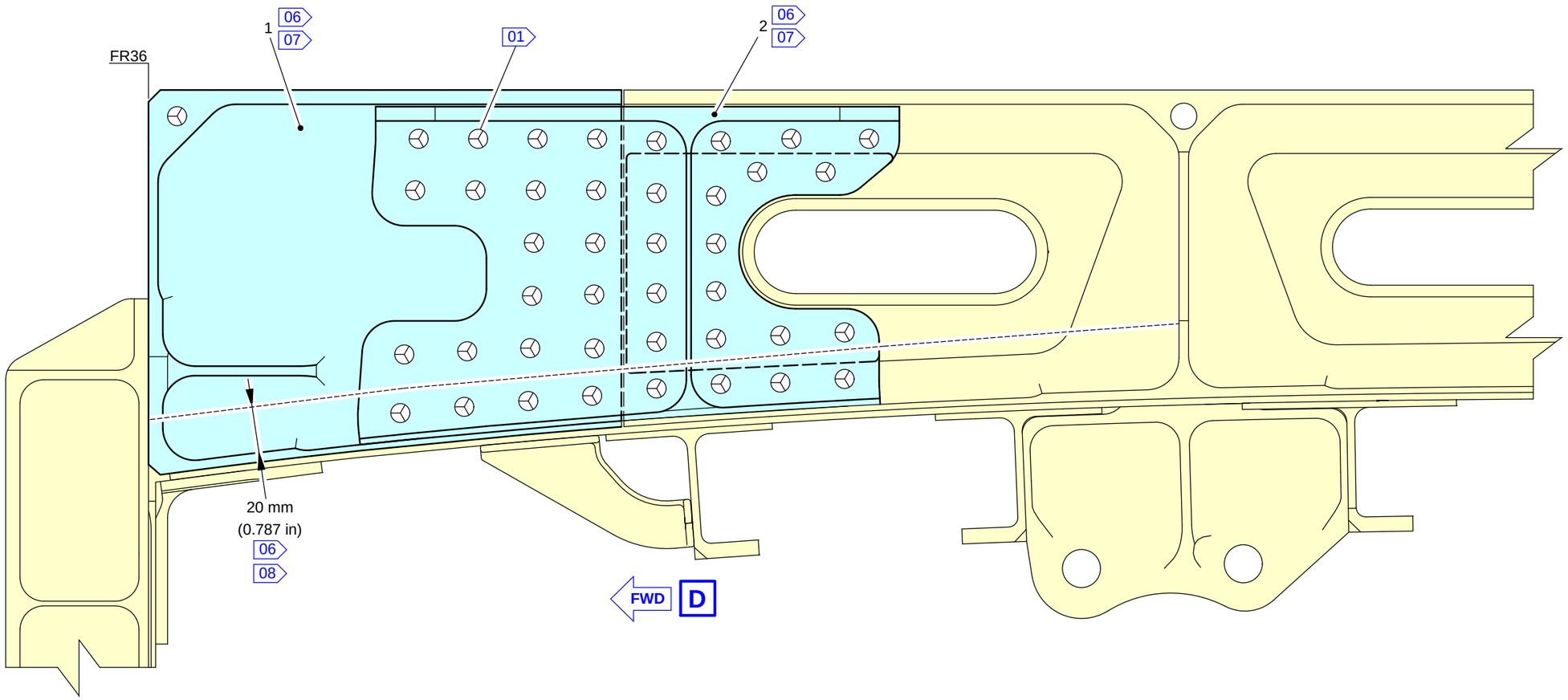
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



HOLE SYMBOL	NOTE
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

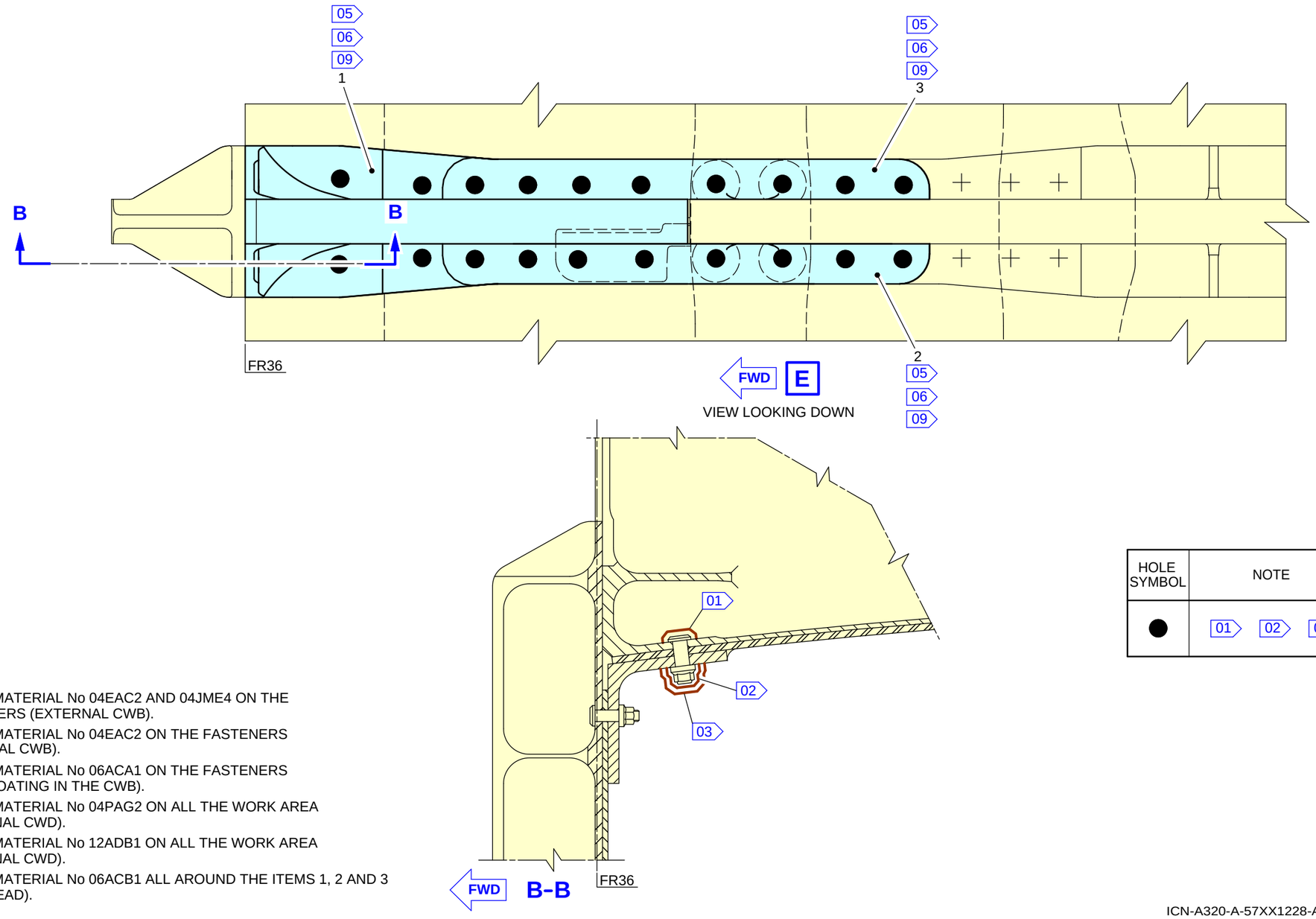
08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(28) Task A320-A-57-XX-1228-02002-250A-A - Protect the Fasteners and the New Parts on Y765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

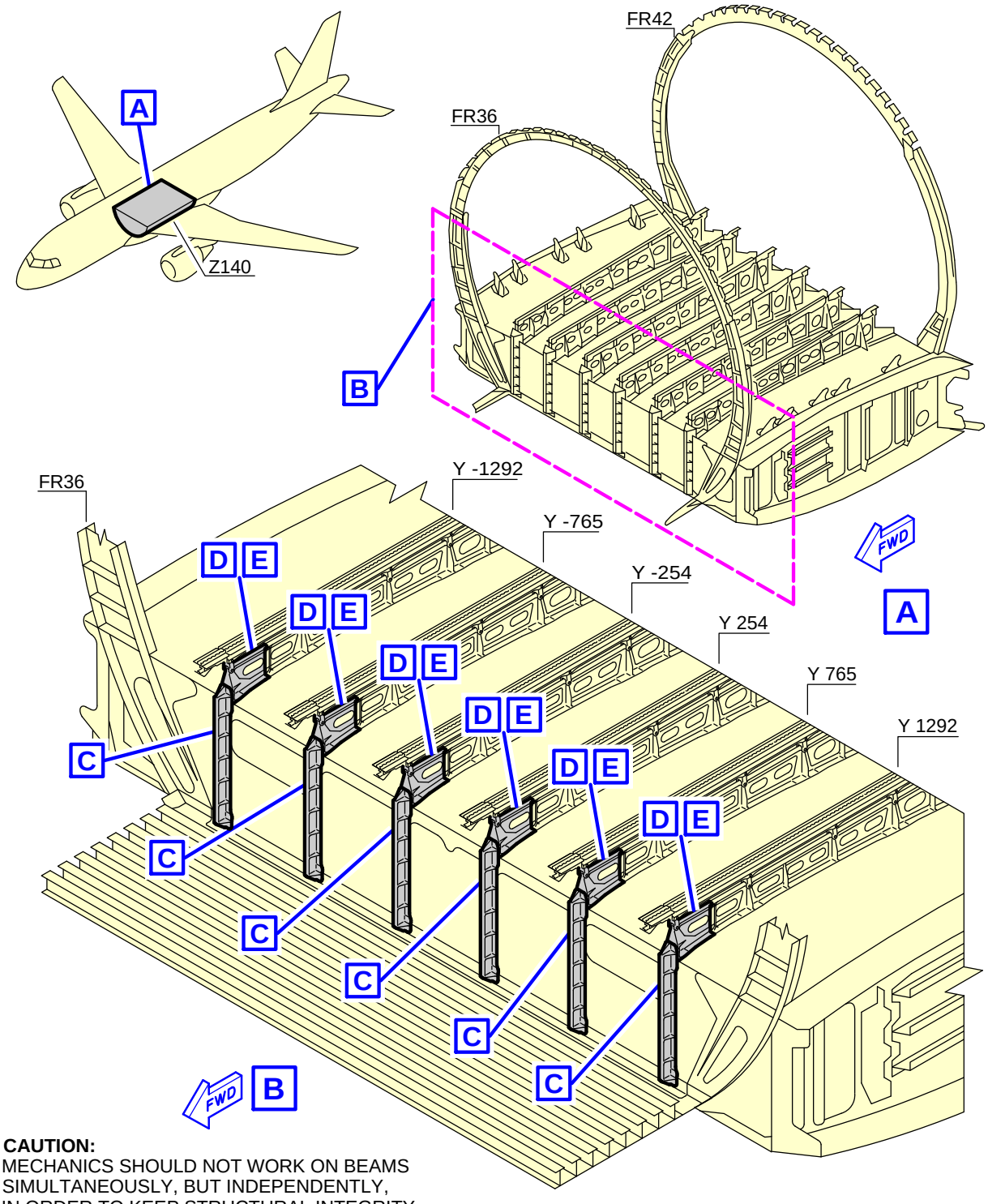
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

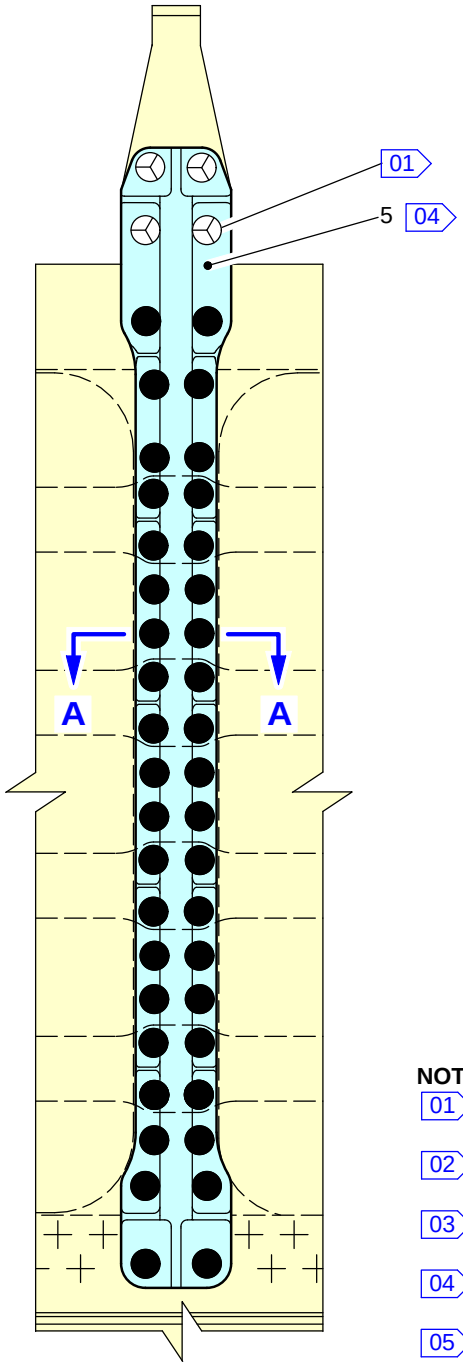


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

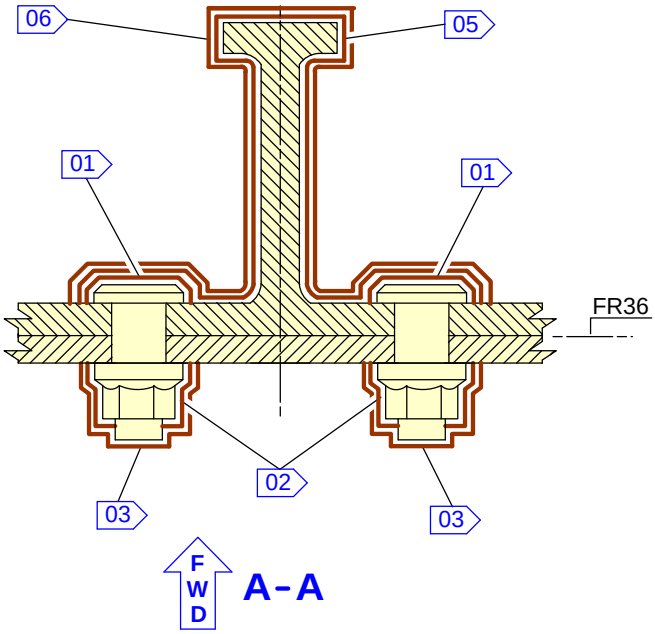
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

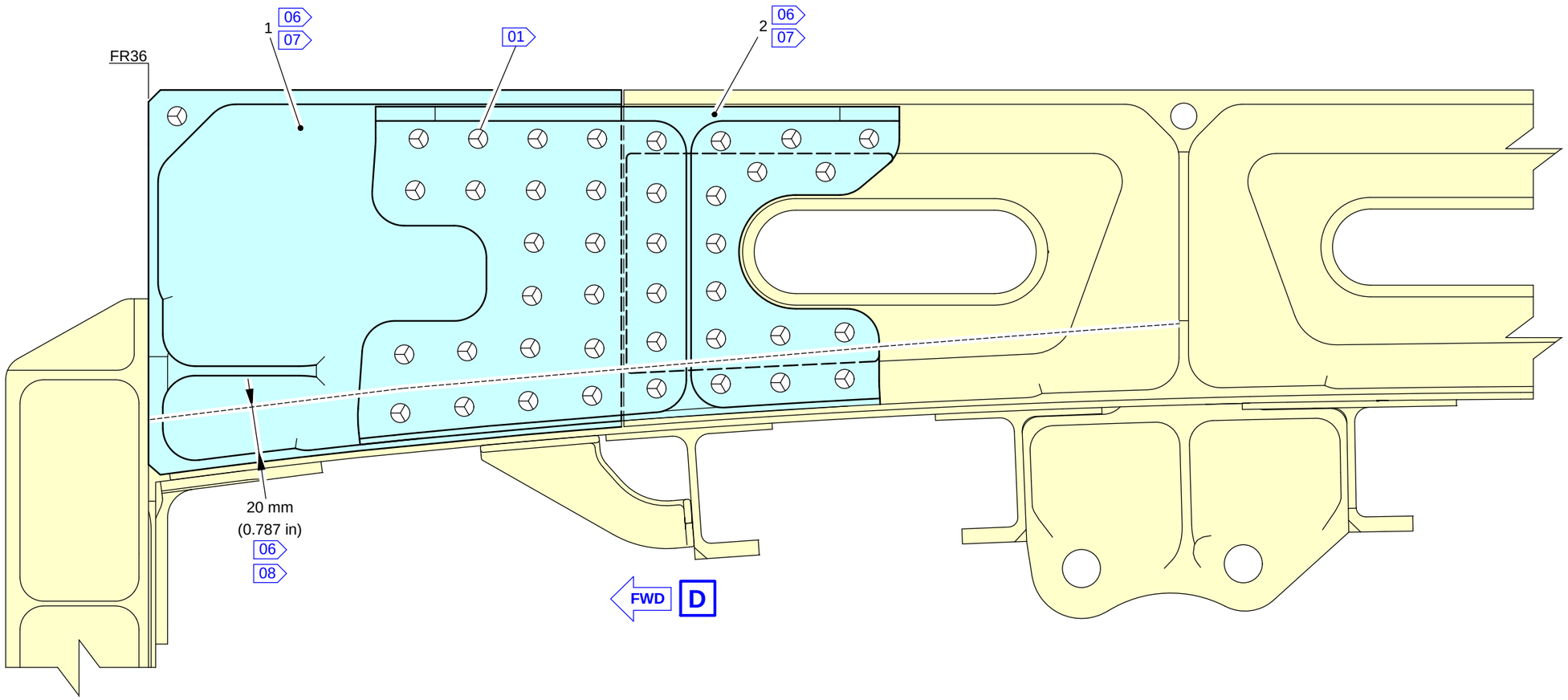
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



HOLE SYMBOL	NOTE
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

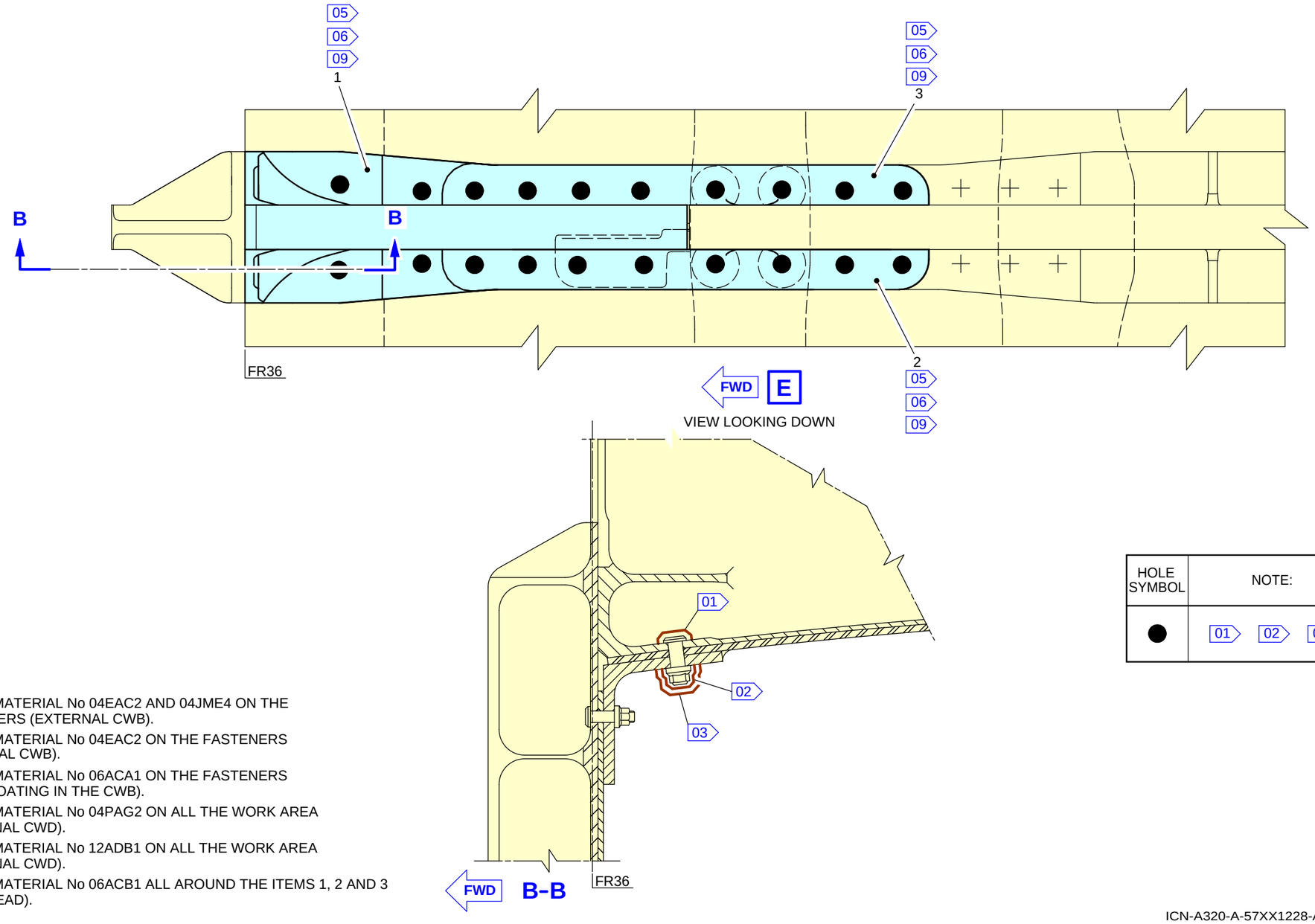
08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

(29) Task A320-A-57-XX-1228-10001-520A-A - Remove the Strut Lower Attachment on Y254 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

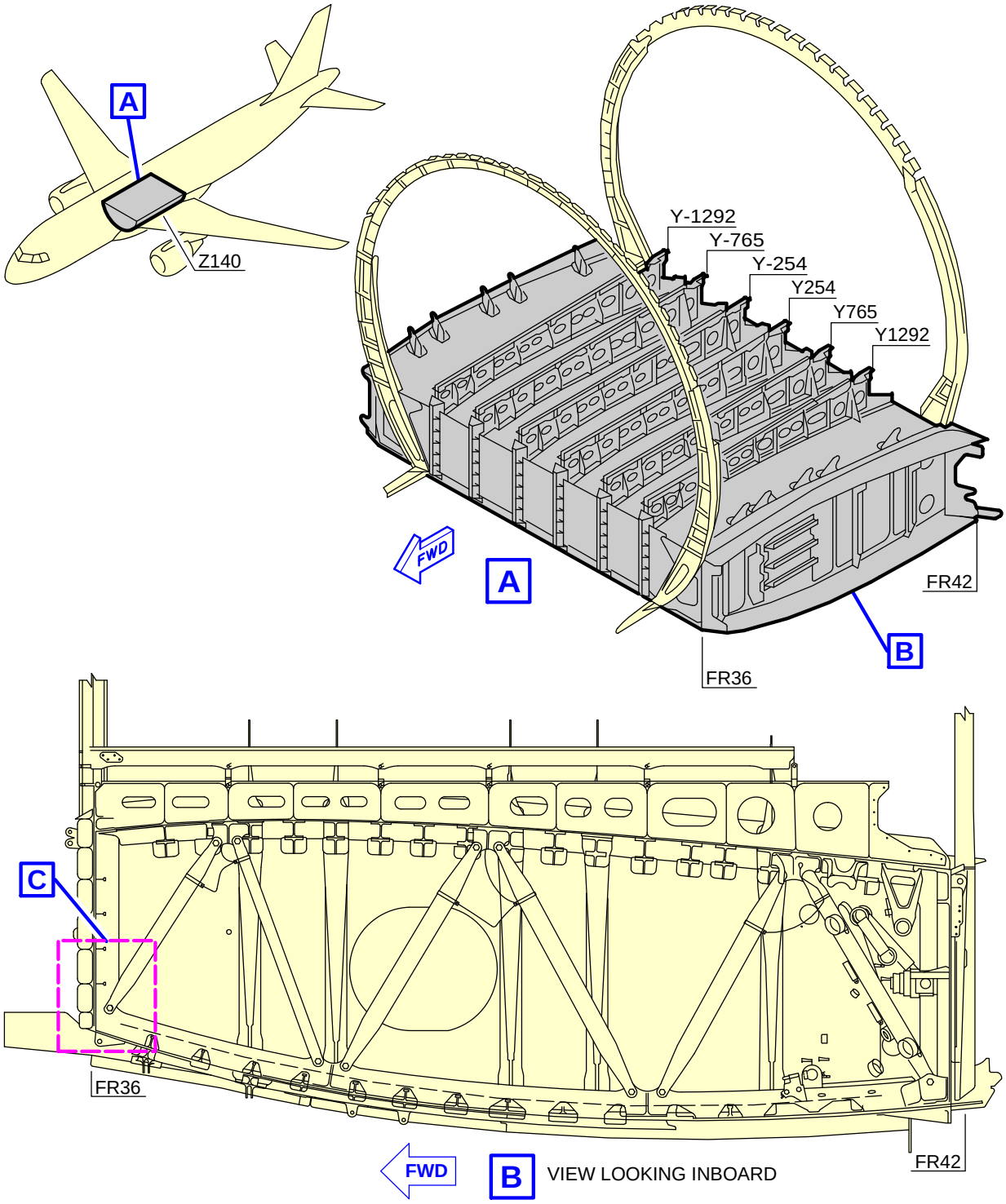
1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain

1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

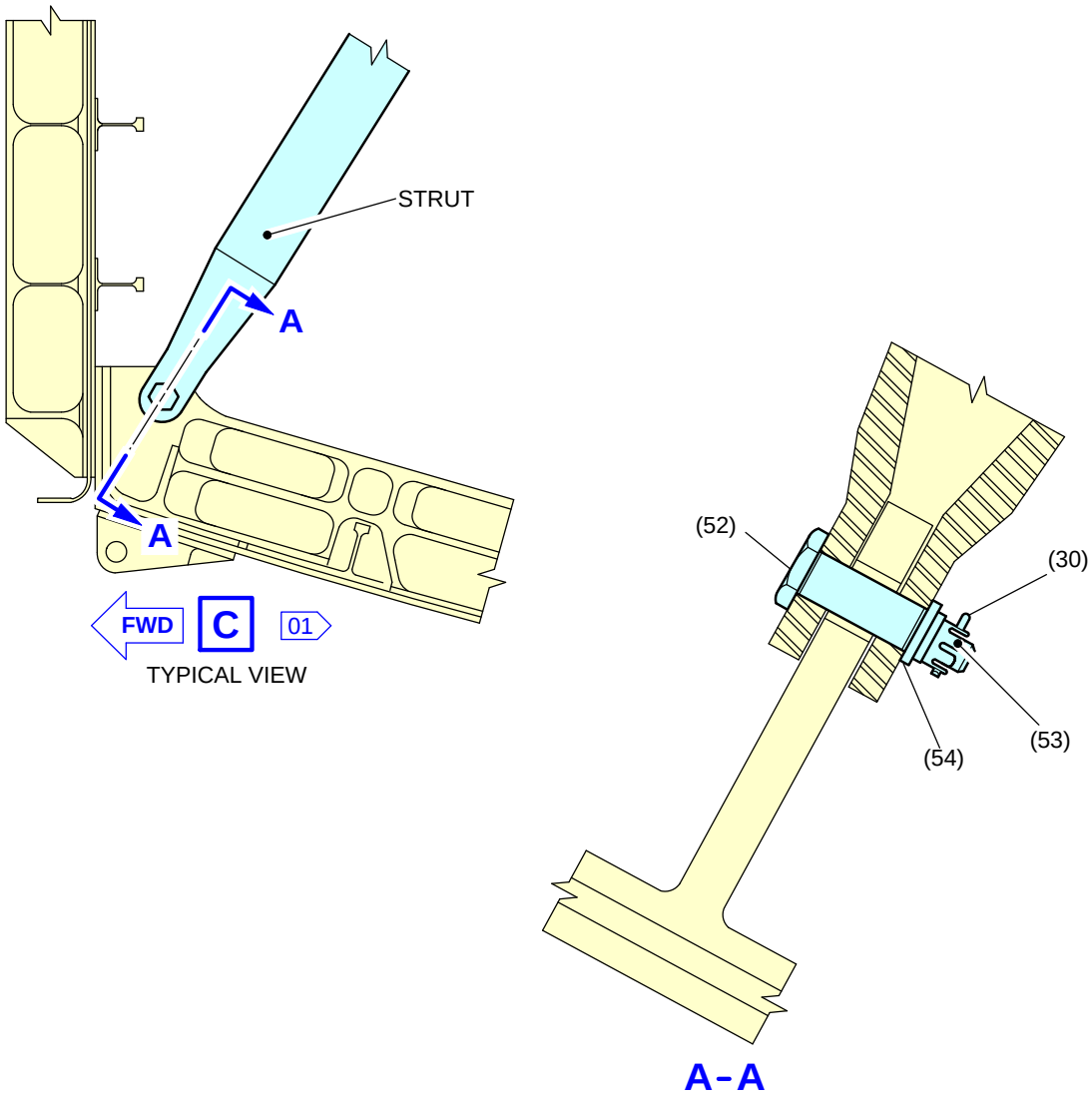
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(30) Task A320-A-57-XX-1228-11001-520A-A - Remove the Vertical Stringer on Y254 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

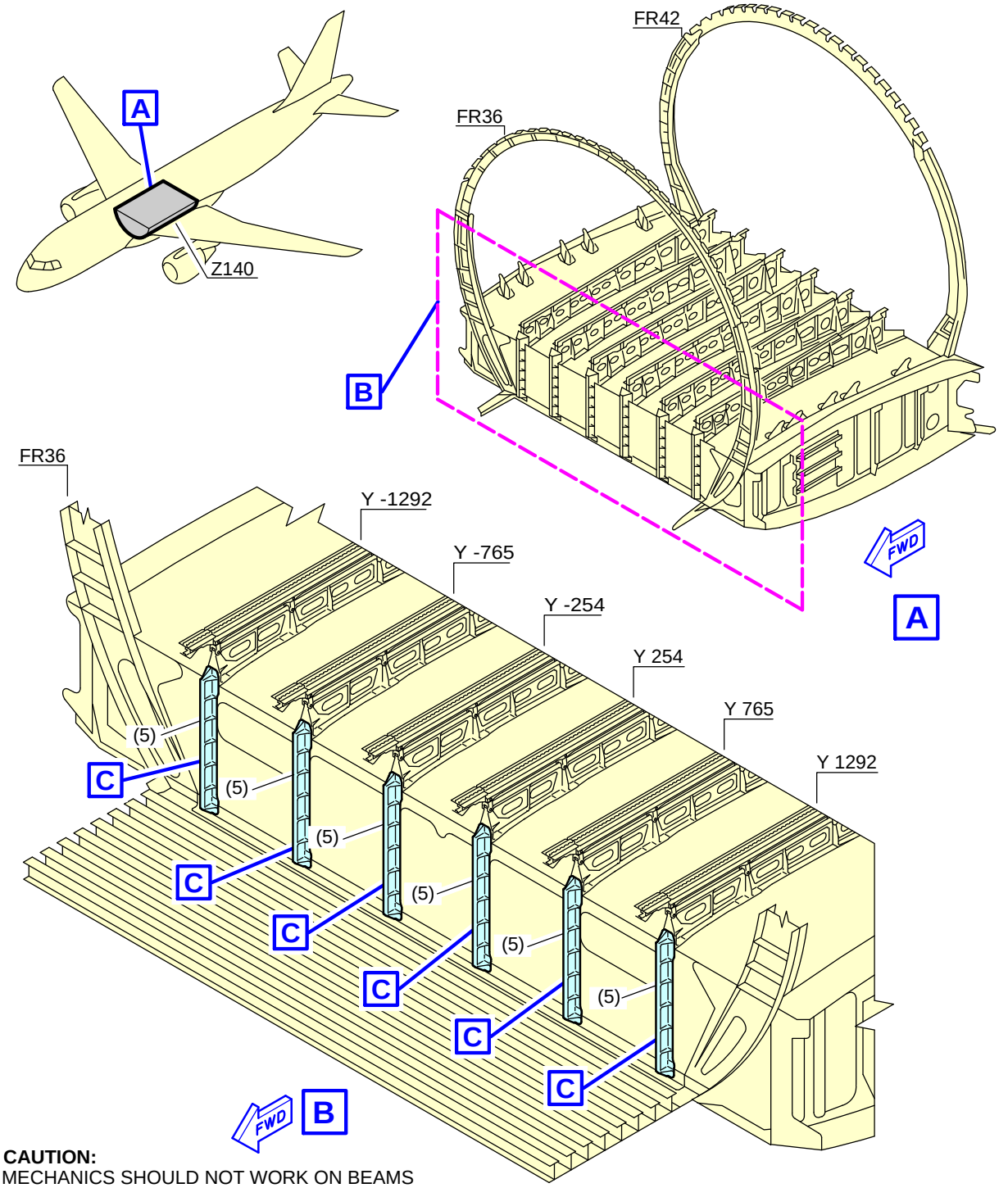
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-13ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

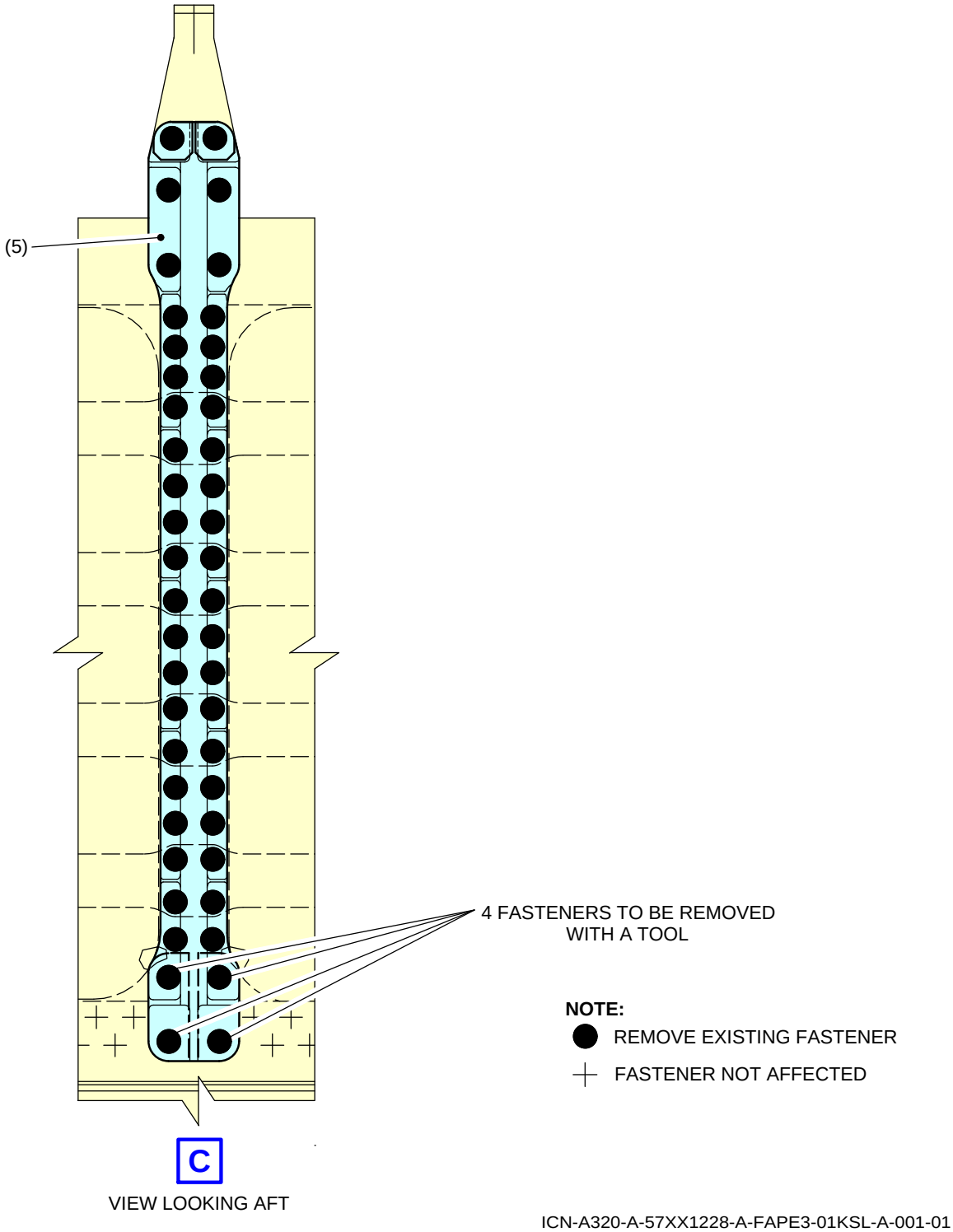


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

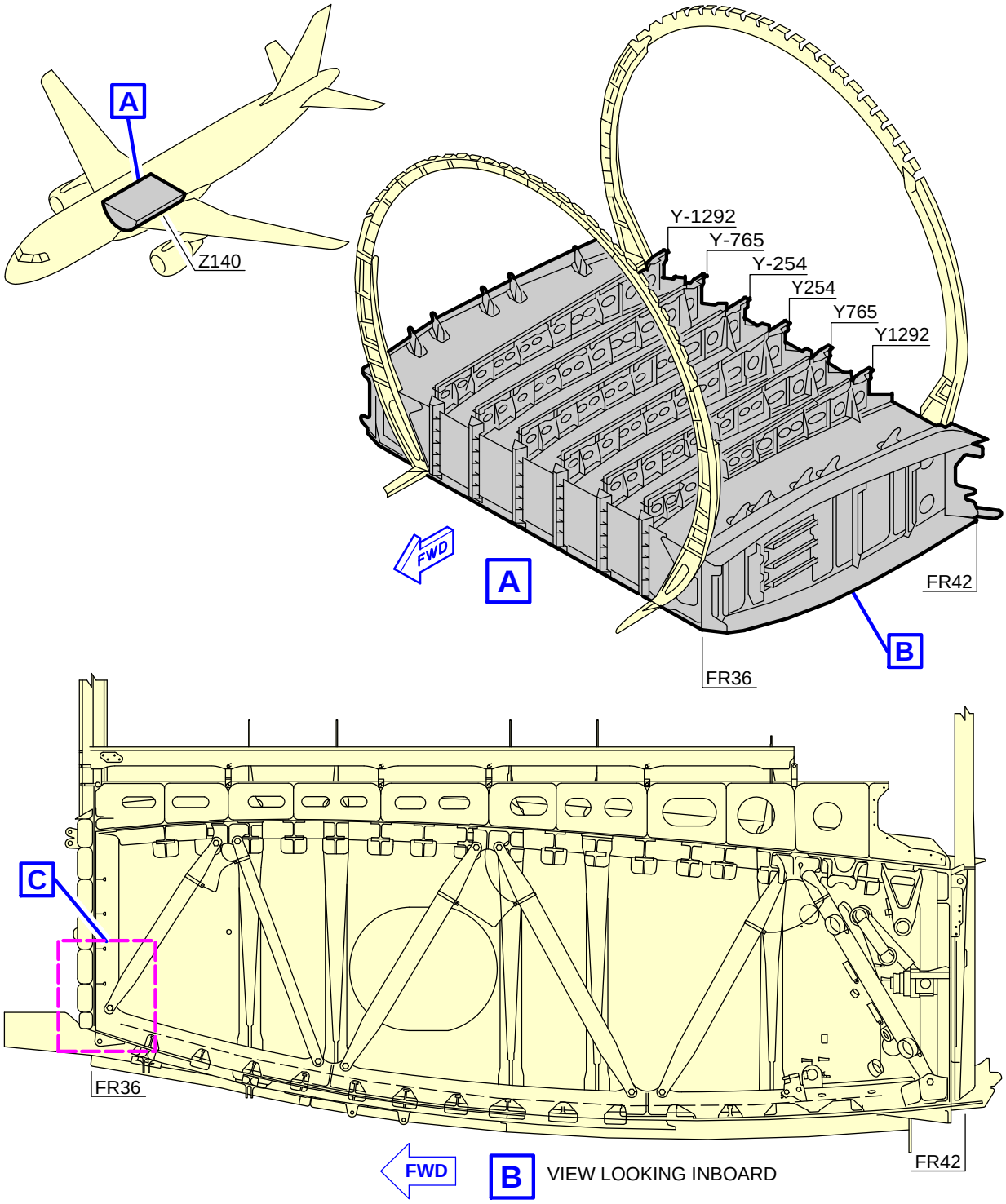
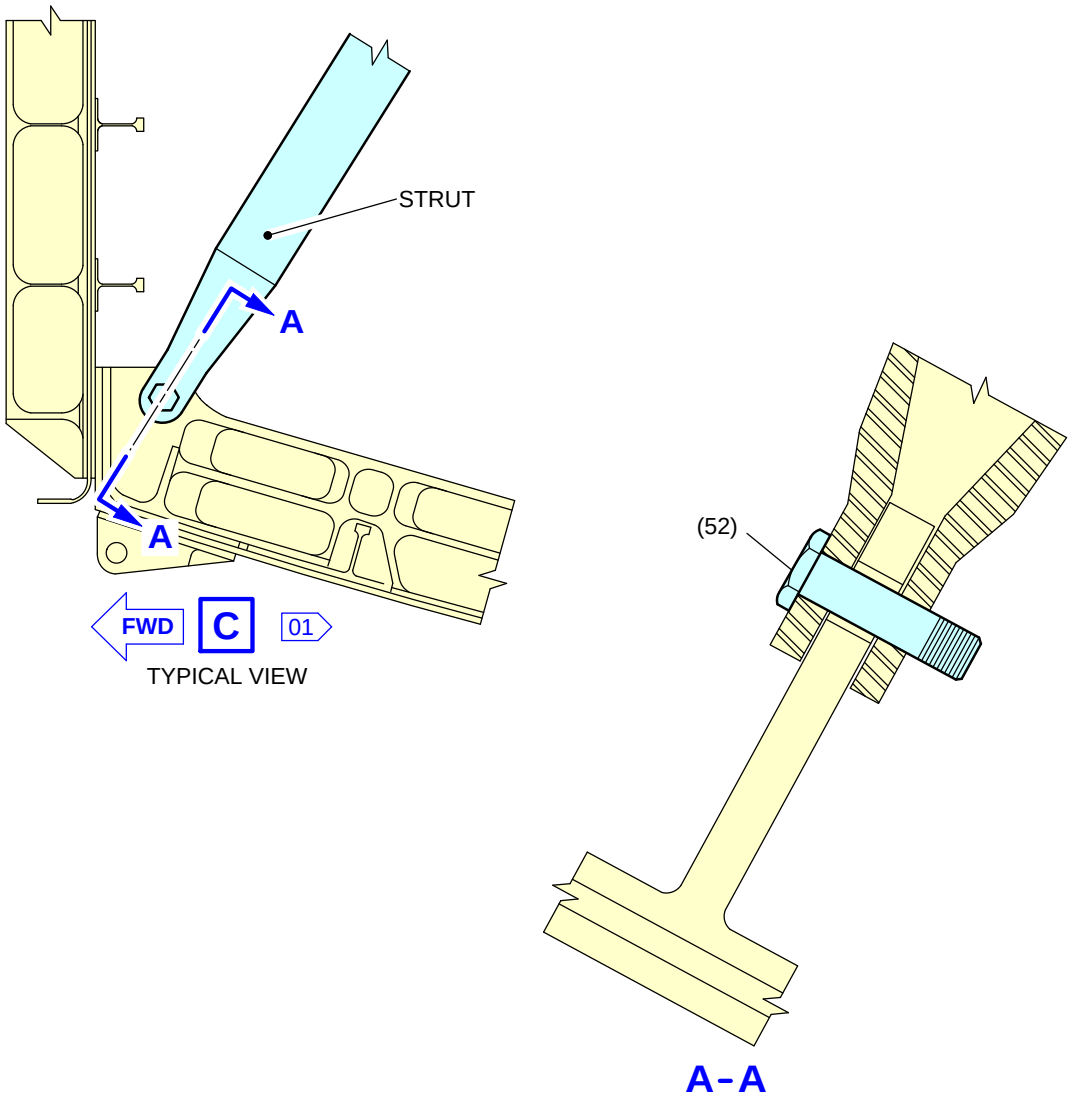


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(30) Task A320-A-57-XX-1228-11002-520A-A - Remove the Vertical Stringer on Y254 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, installation of the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

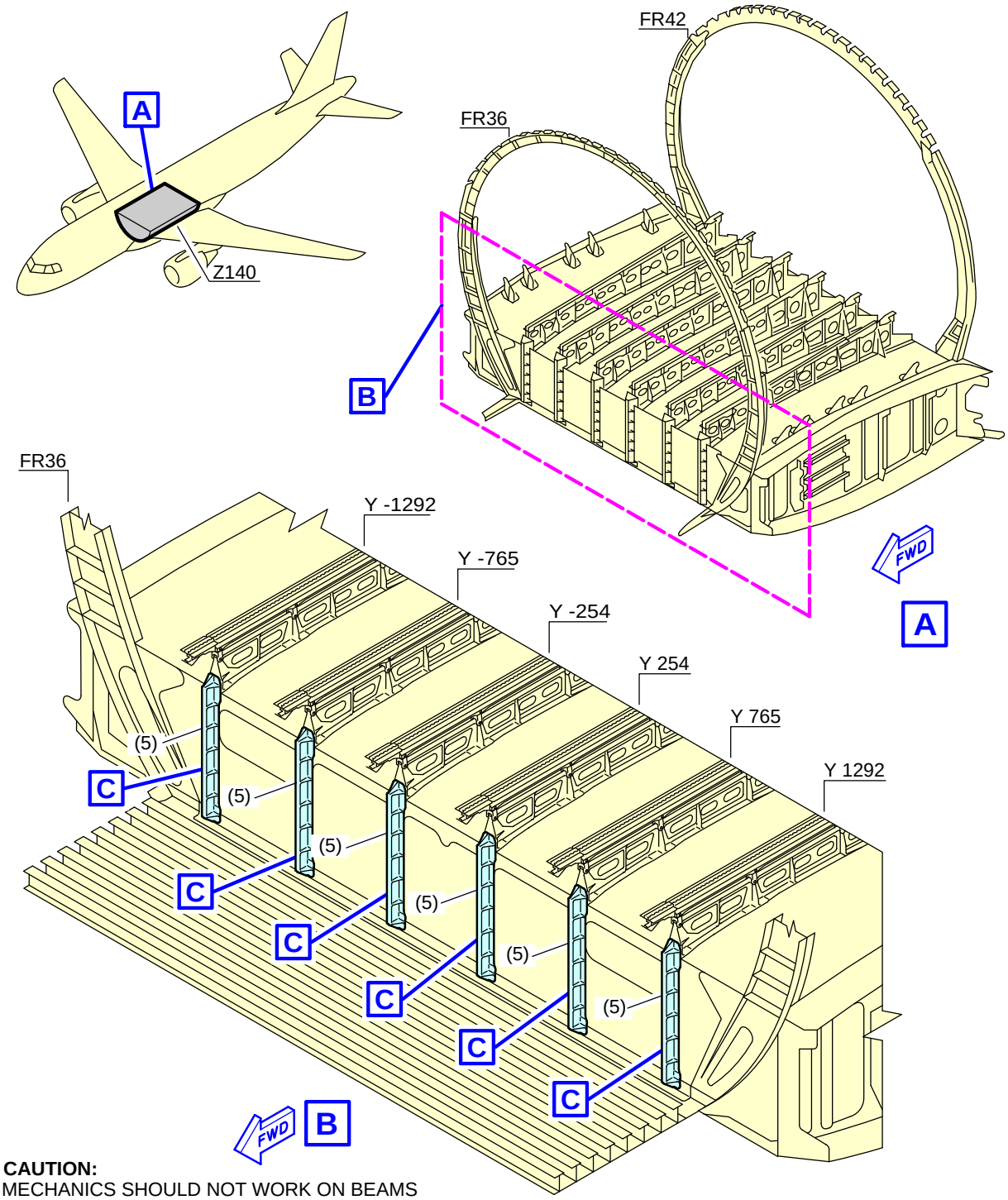
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-13ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

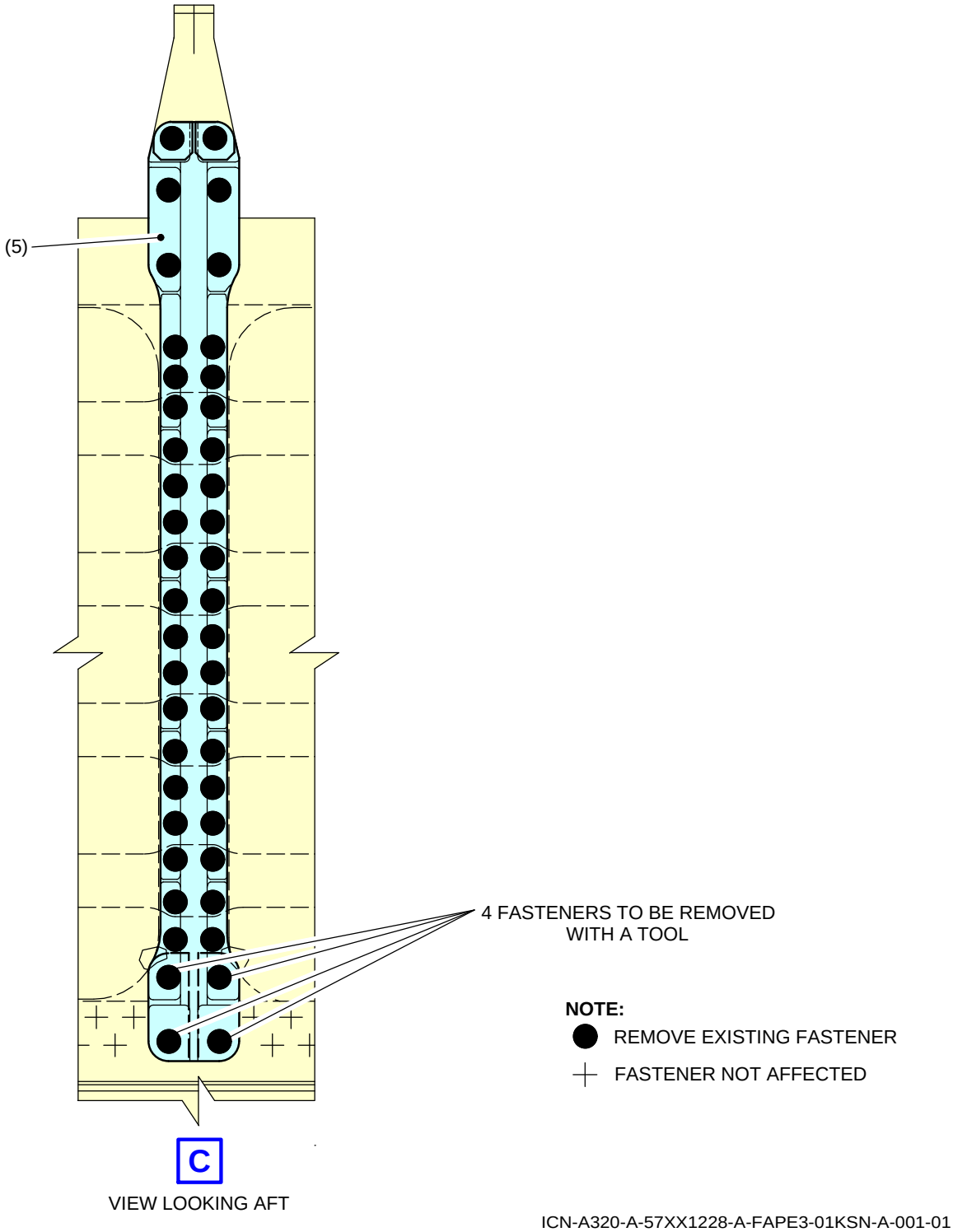


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

CONF 002

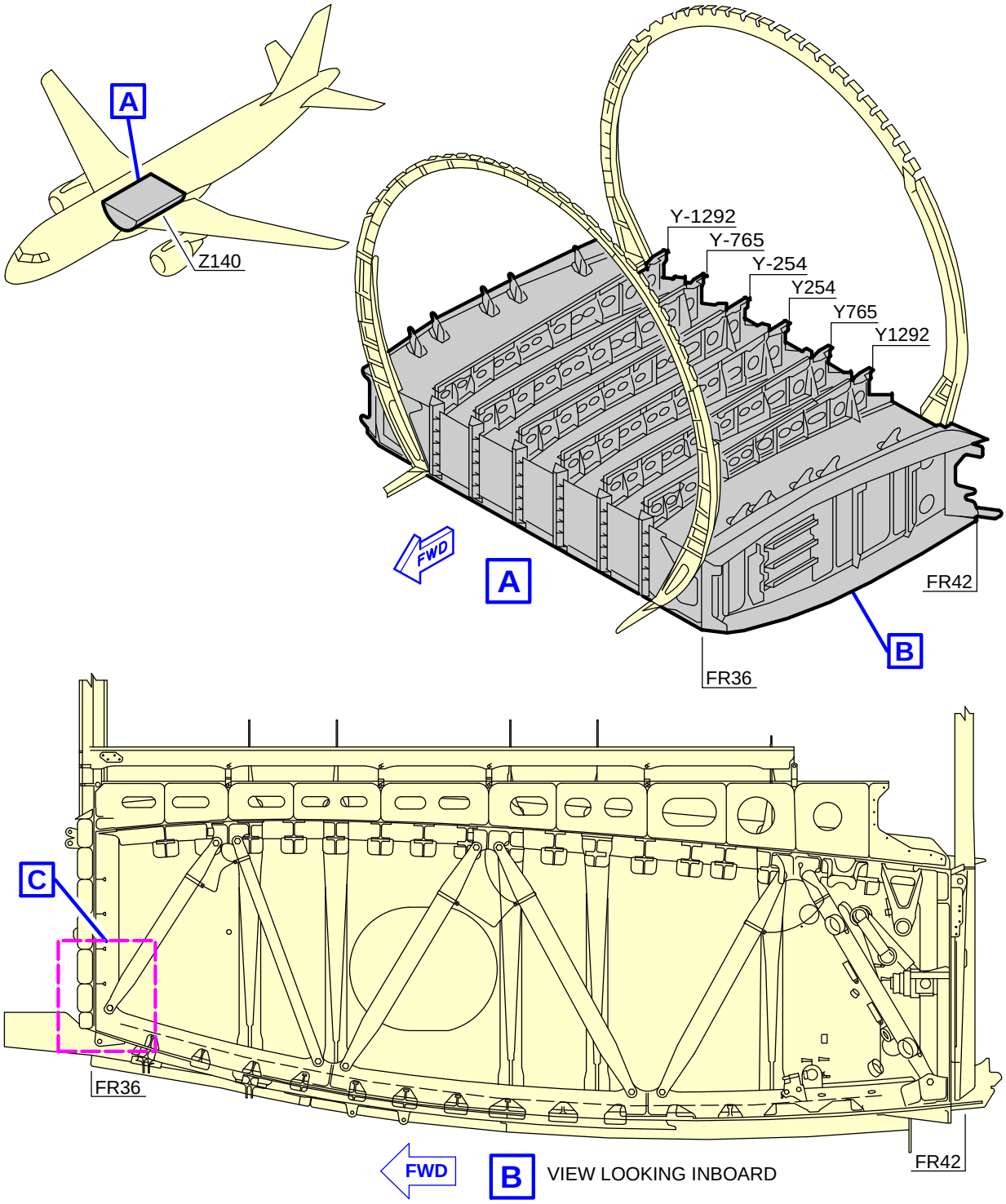
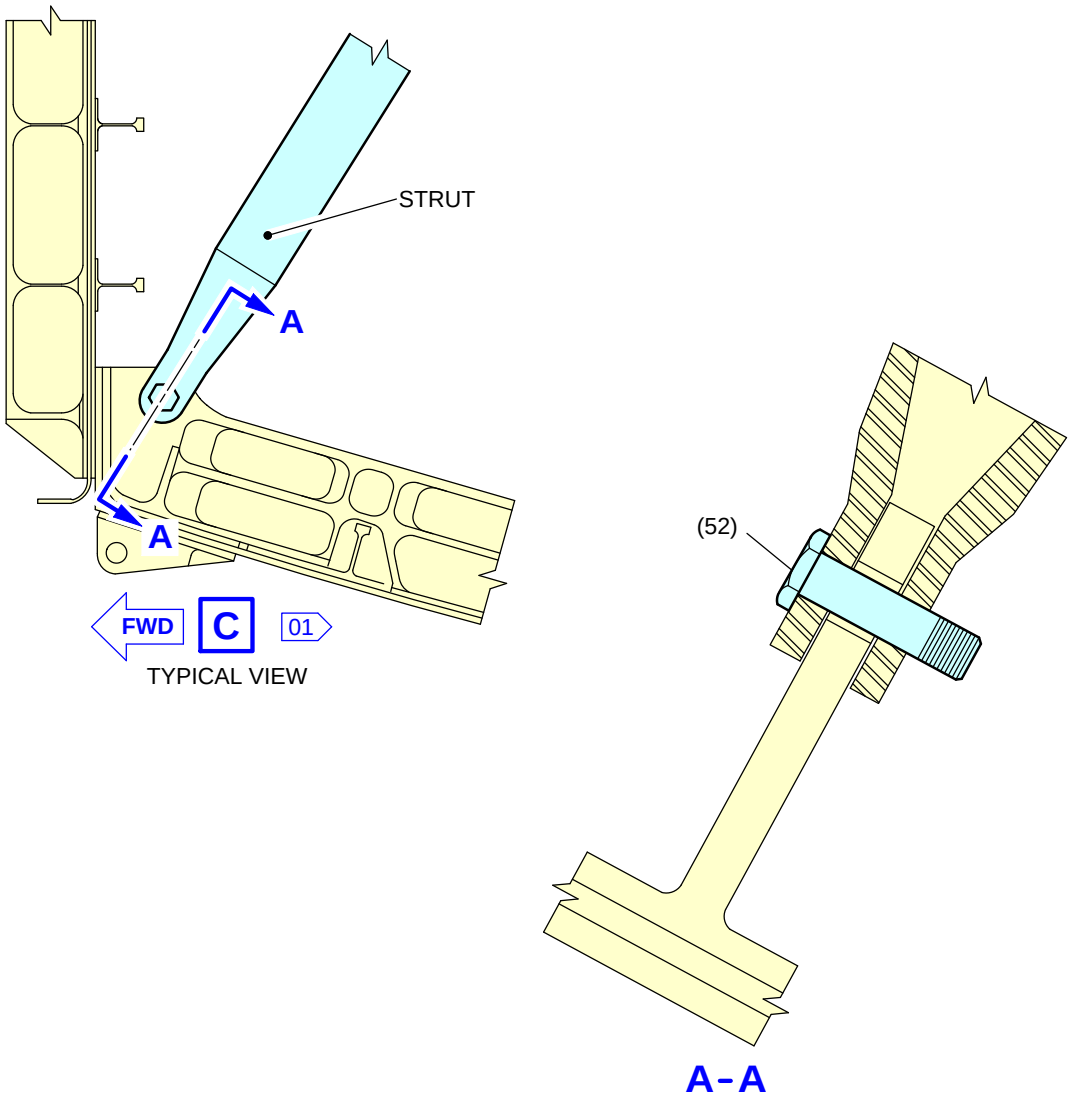


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(31) Task A320-A-57-XX-1228-05001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - 08BAA9
General

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-05ZZZ-900Z-A.

CONF 001 003 004

(32) Task A320-A-57-XX-1228-05001-900A-A - Drill the New Vertical Stringer on Y254 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER VERTICAL D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

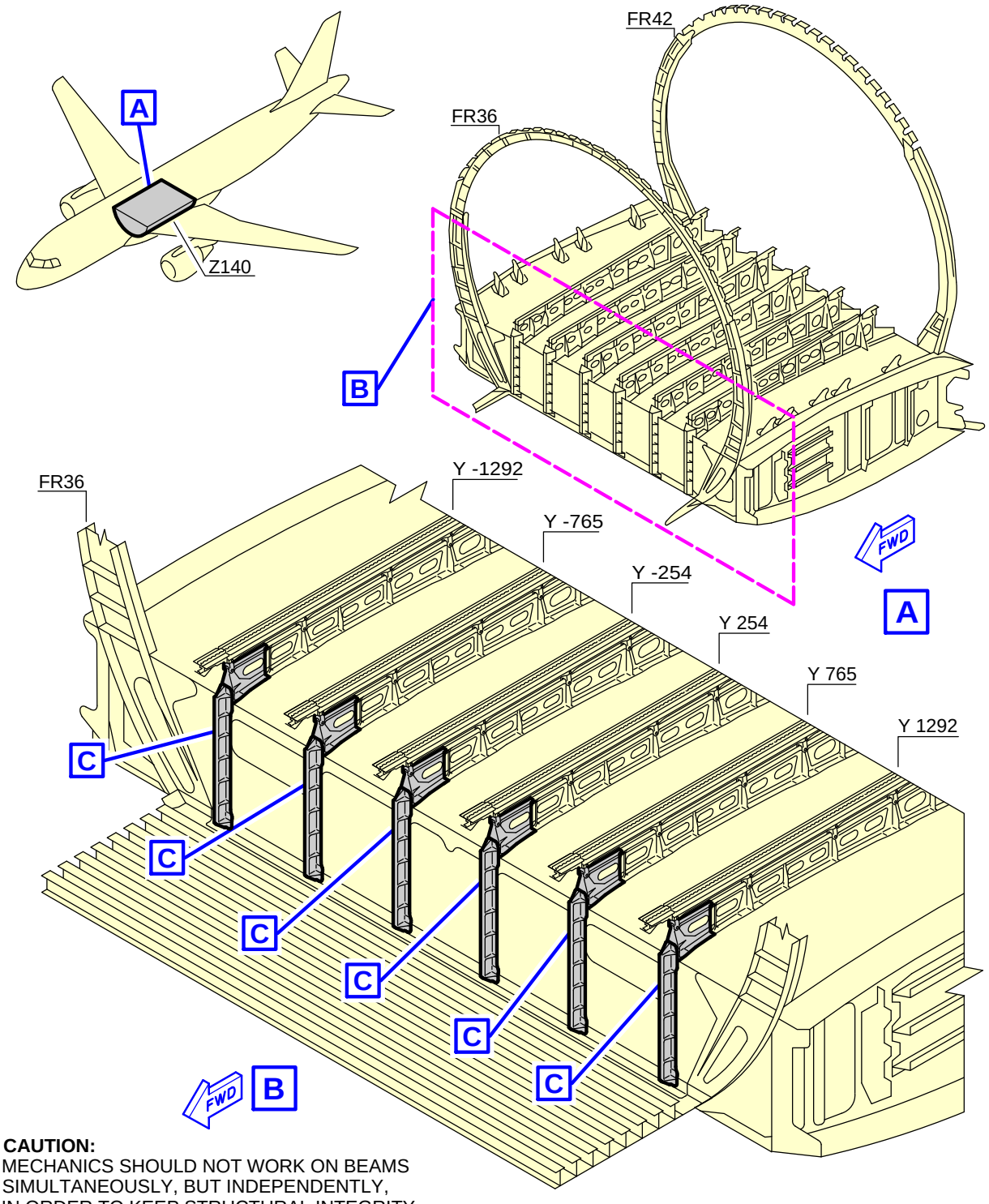
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 08CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 001 003 004

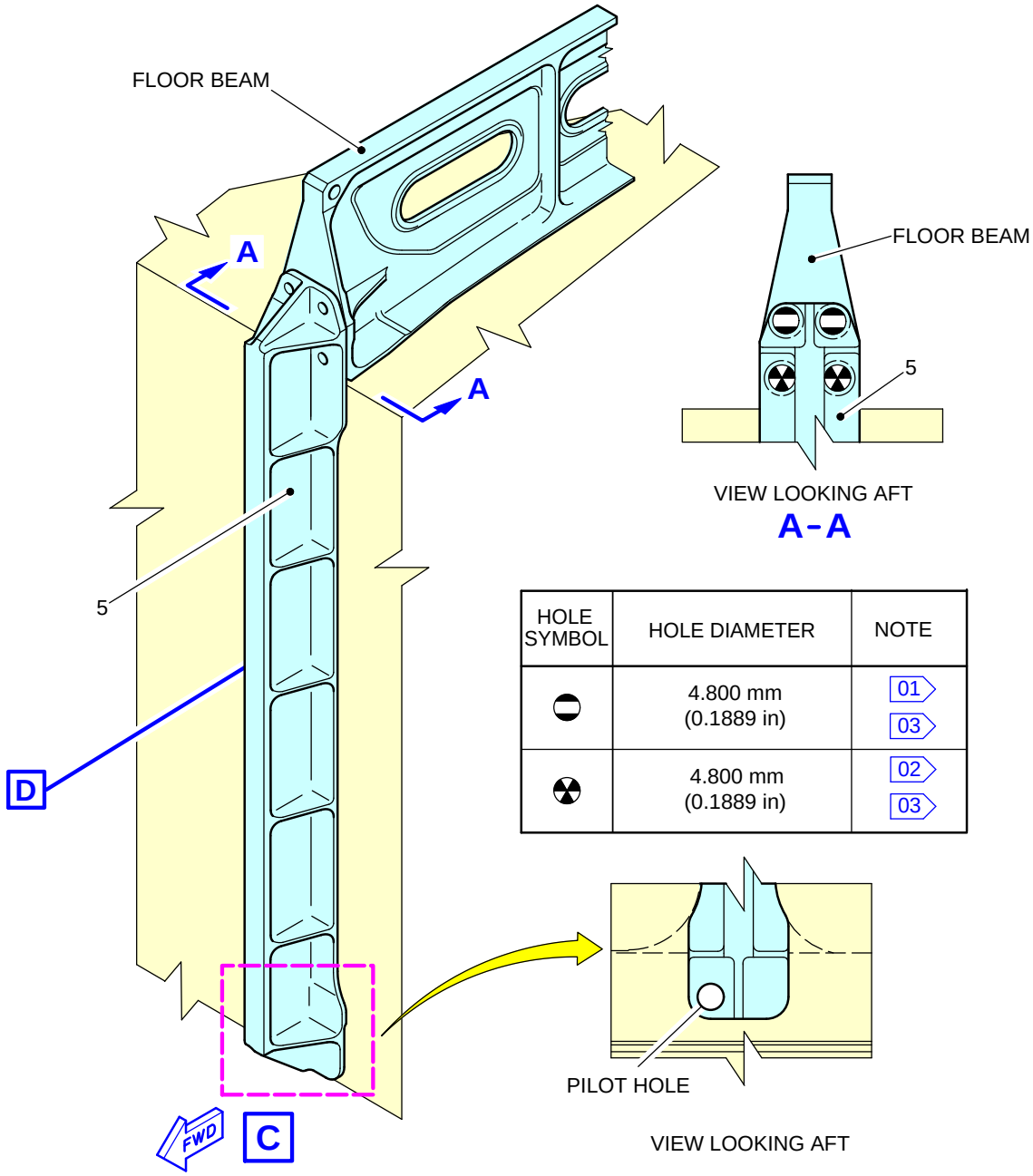


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

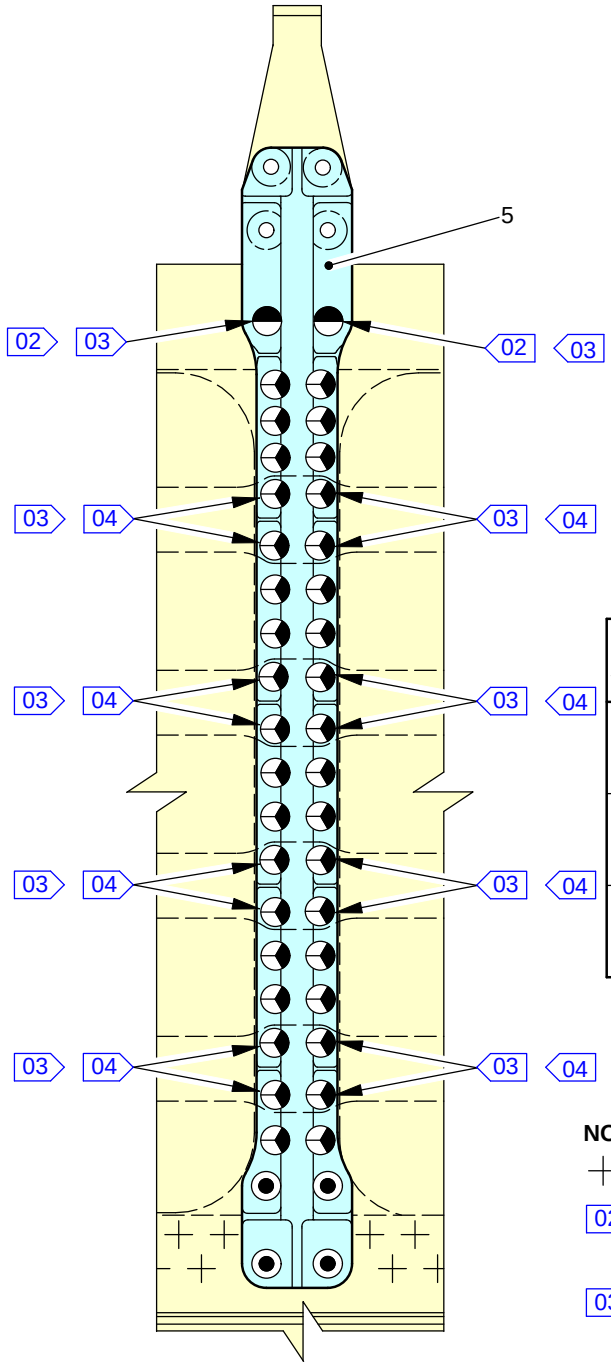
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

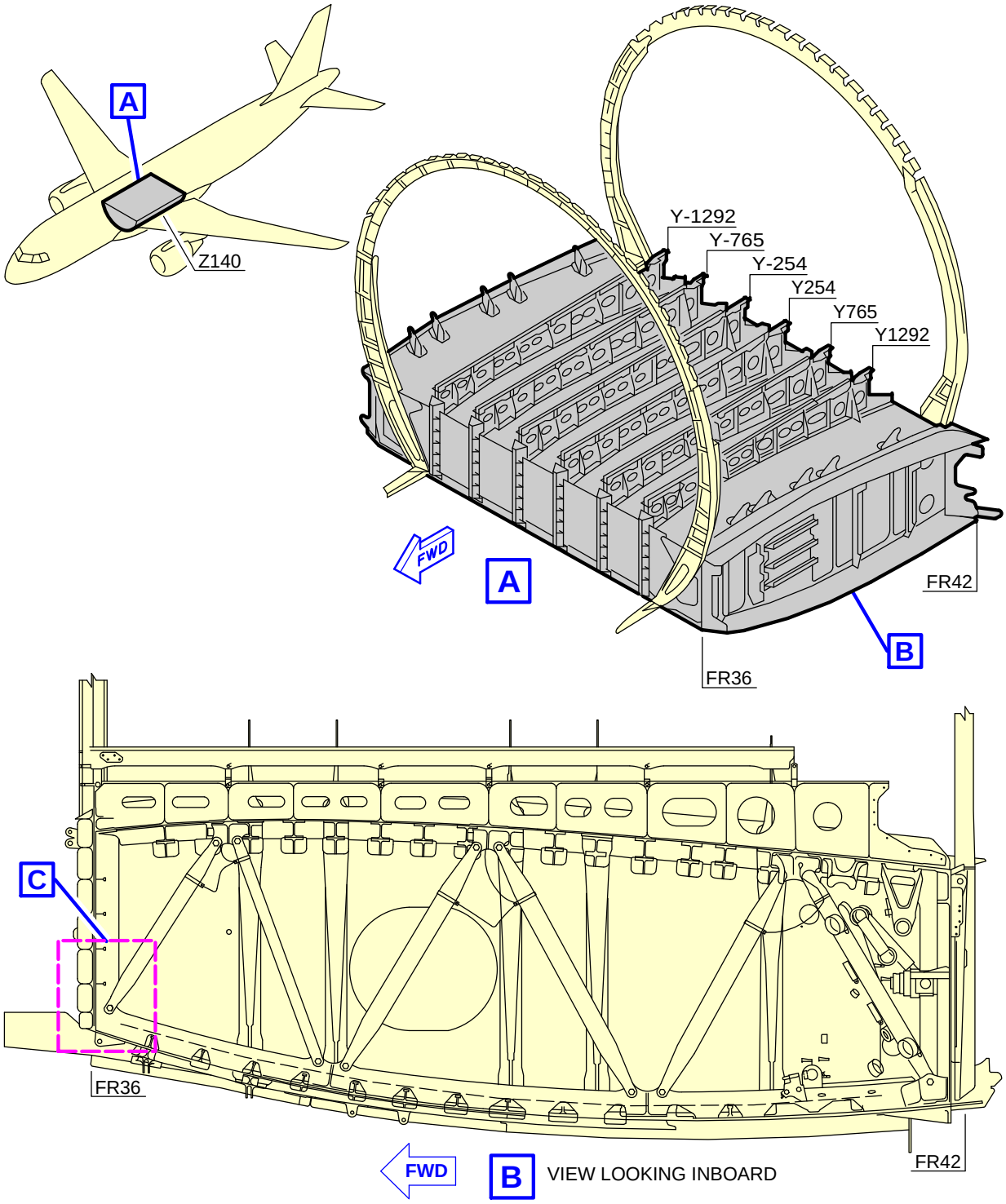
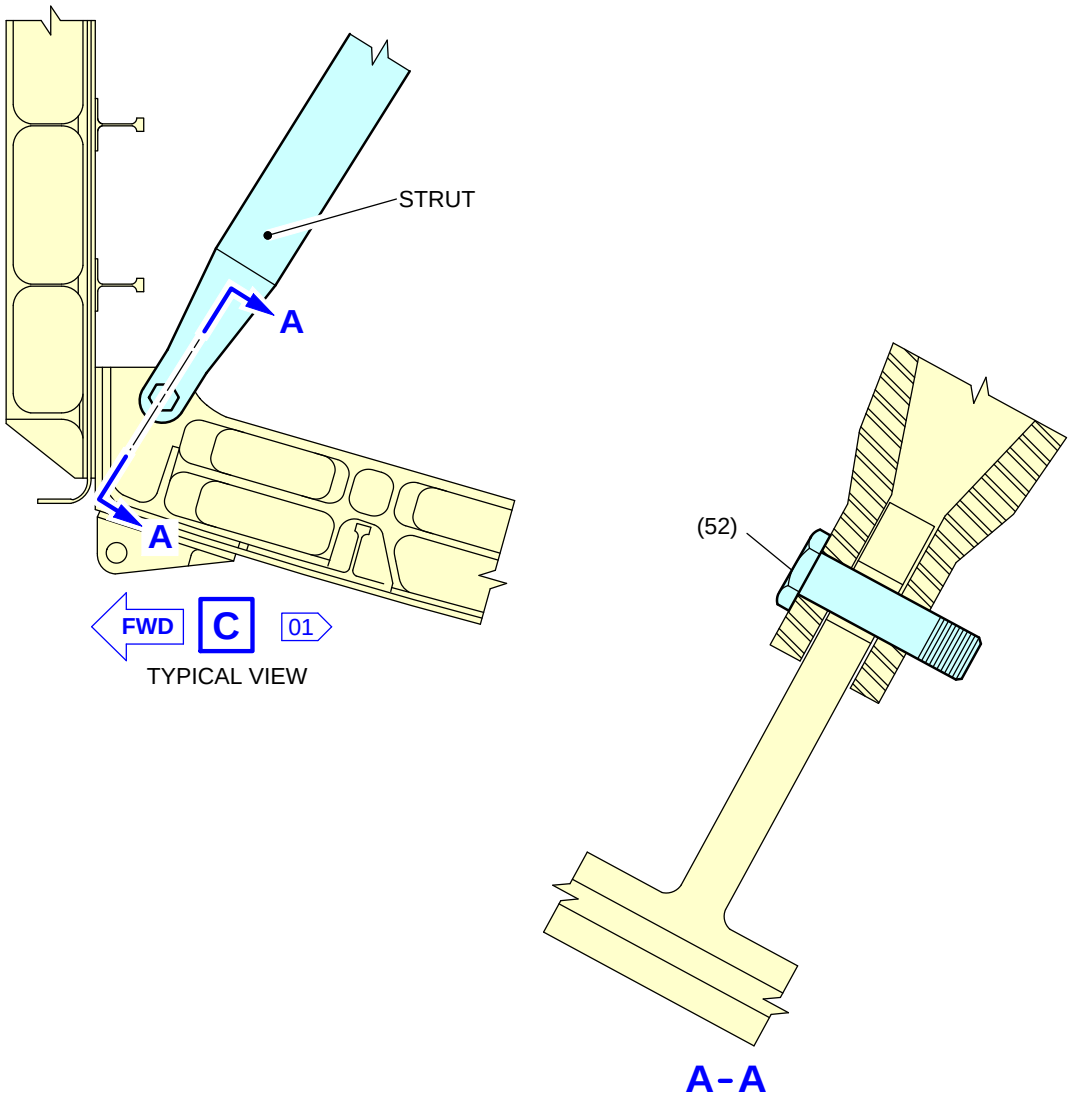


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(32) Task A320-A-57-XX-1228-05002-900A-A - Drill the New Vertical Stringer on Y254 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER VERTICAL	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

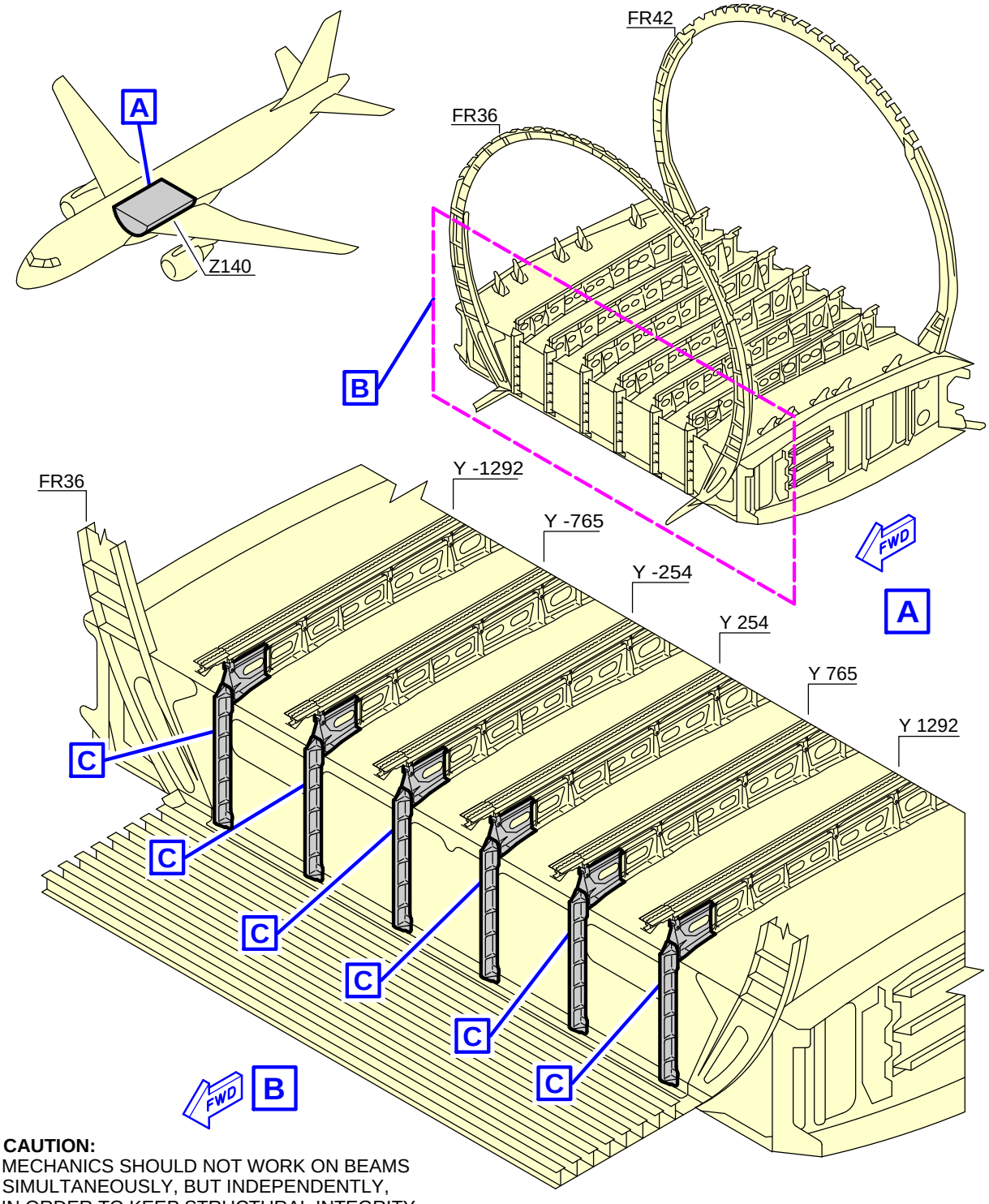
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

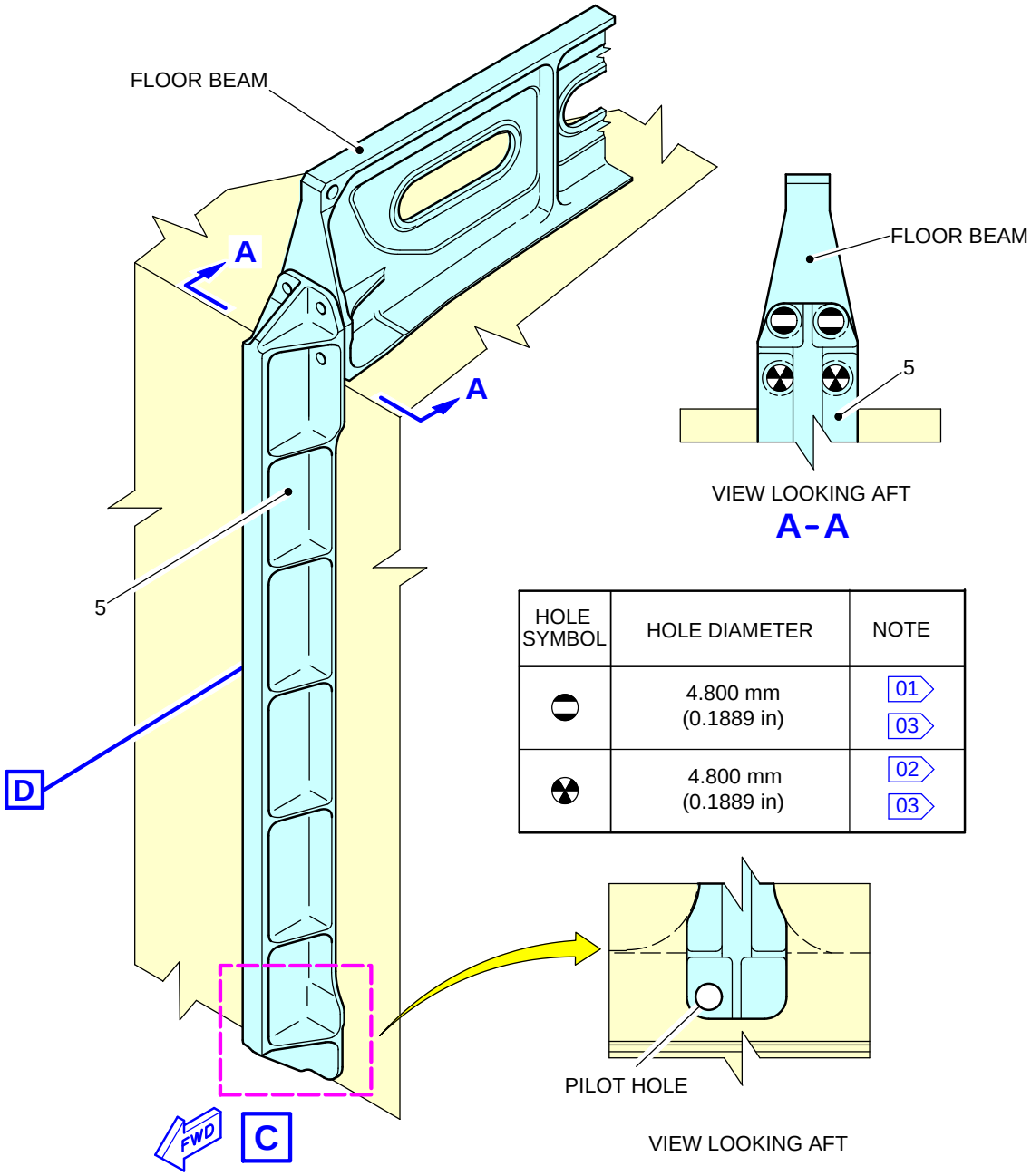


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

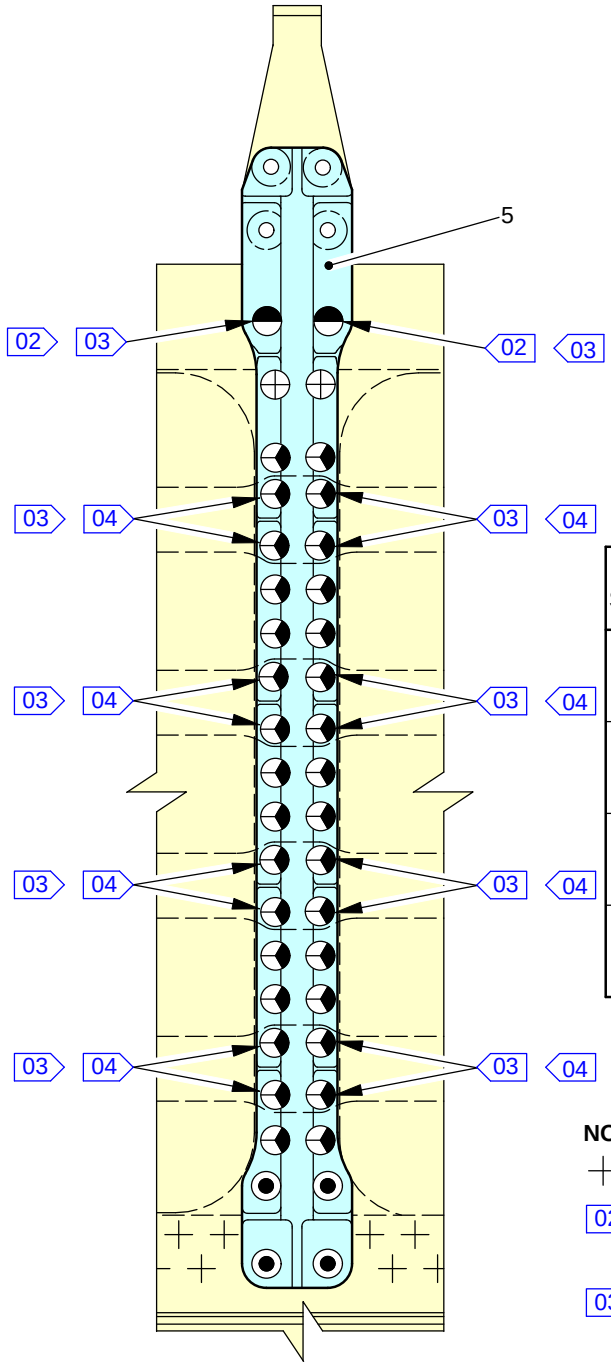
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

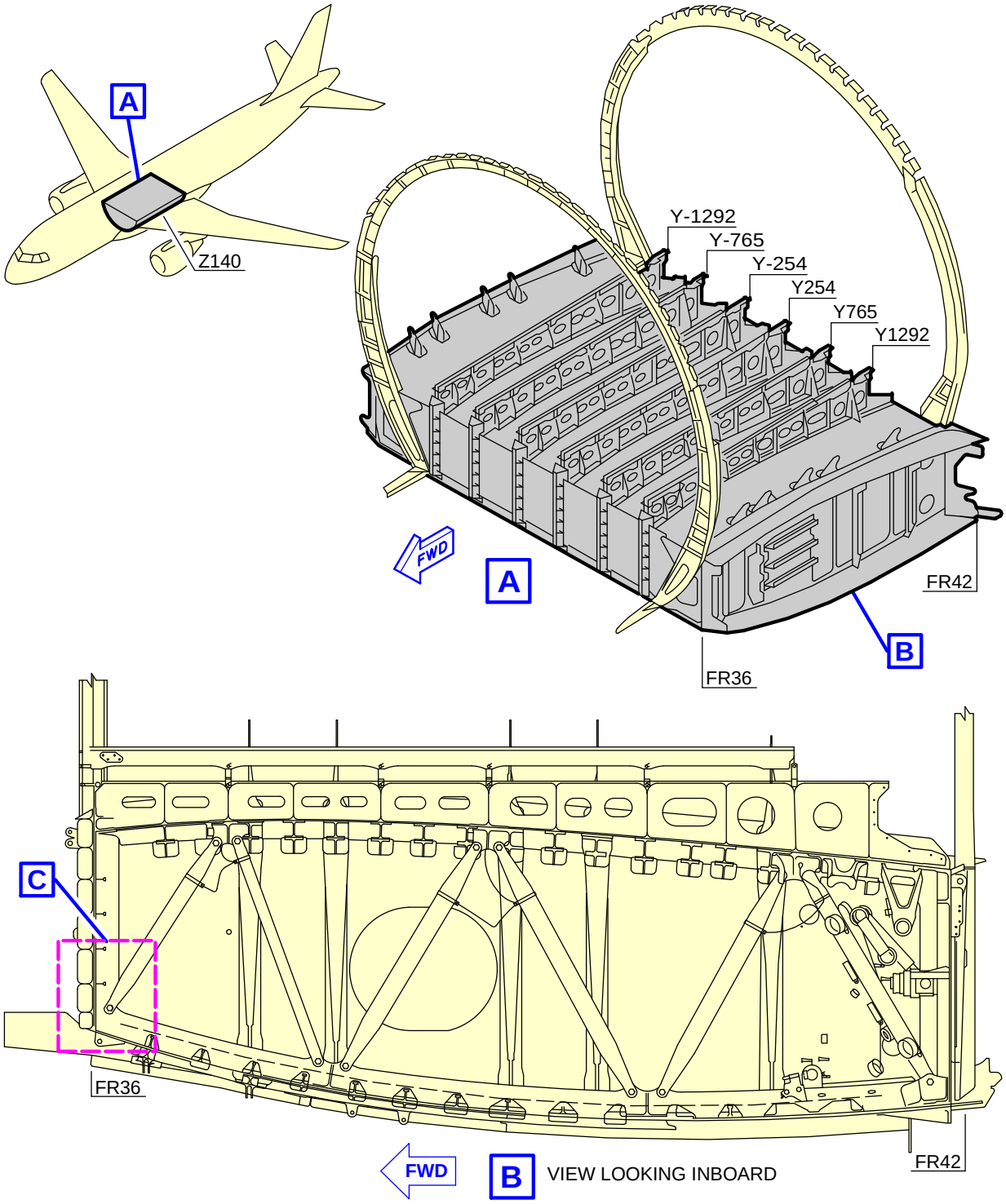
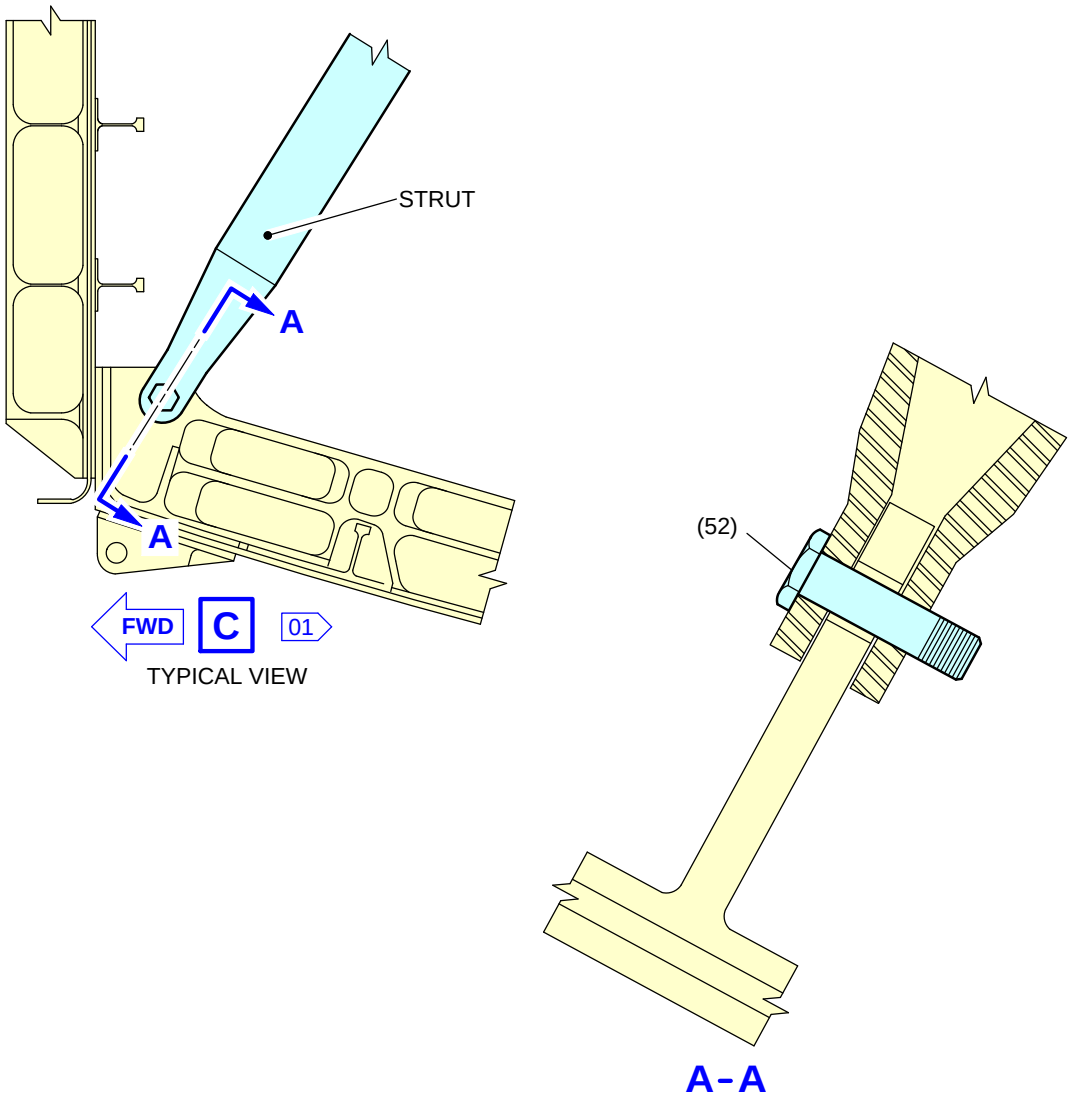


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(33) Task A320-A-57-XX-1228-13001-720A-A - Install the New Vertical Stringer on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001

Manuals/Drawings	References/Sheets
	06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

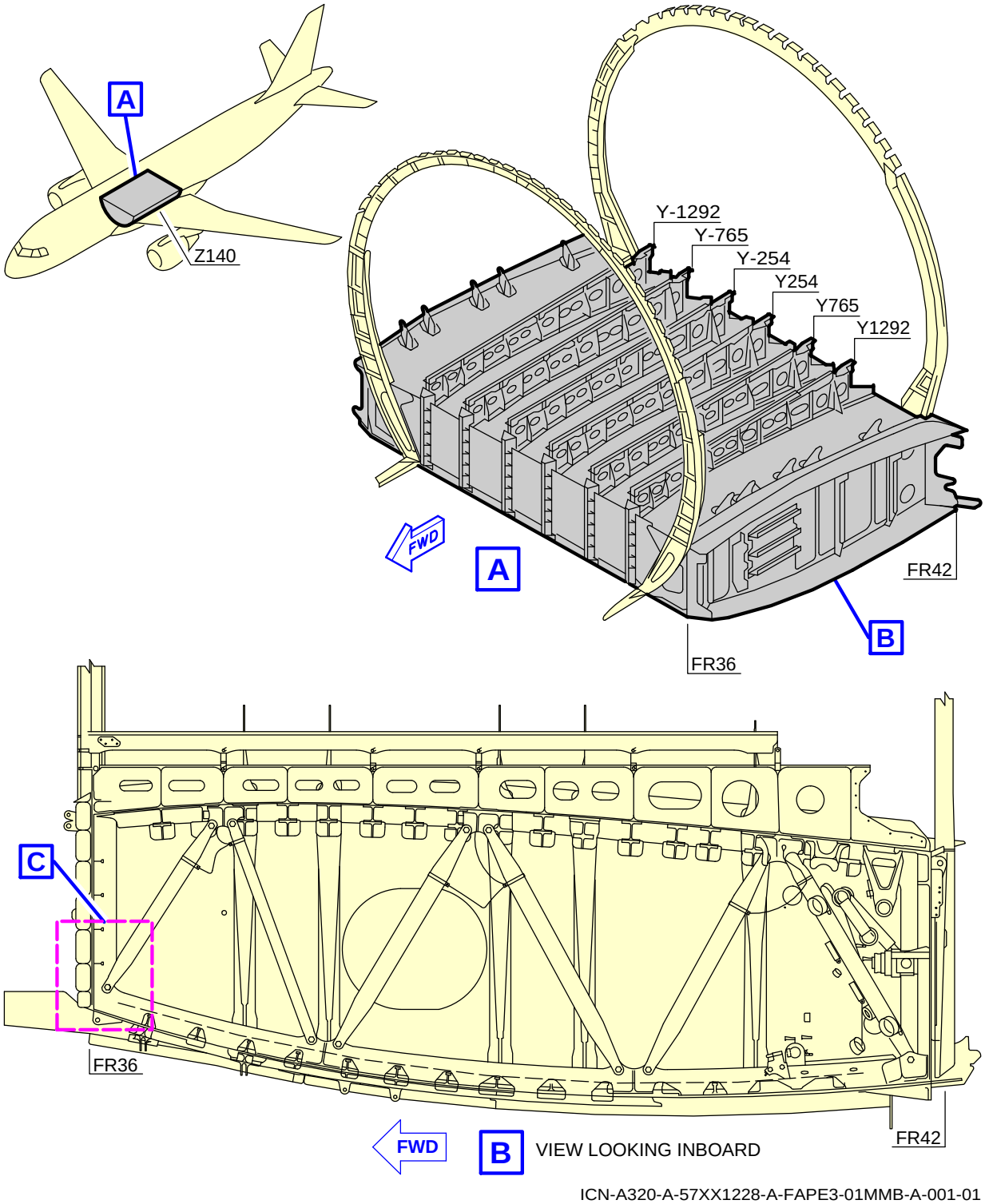
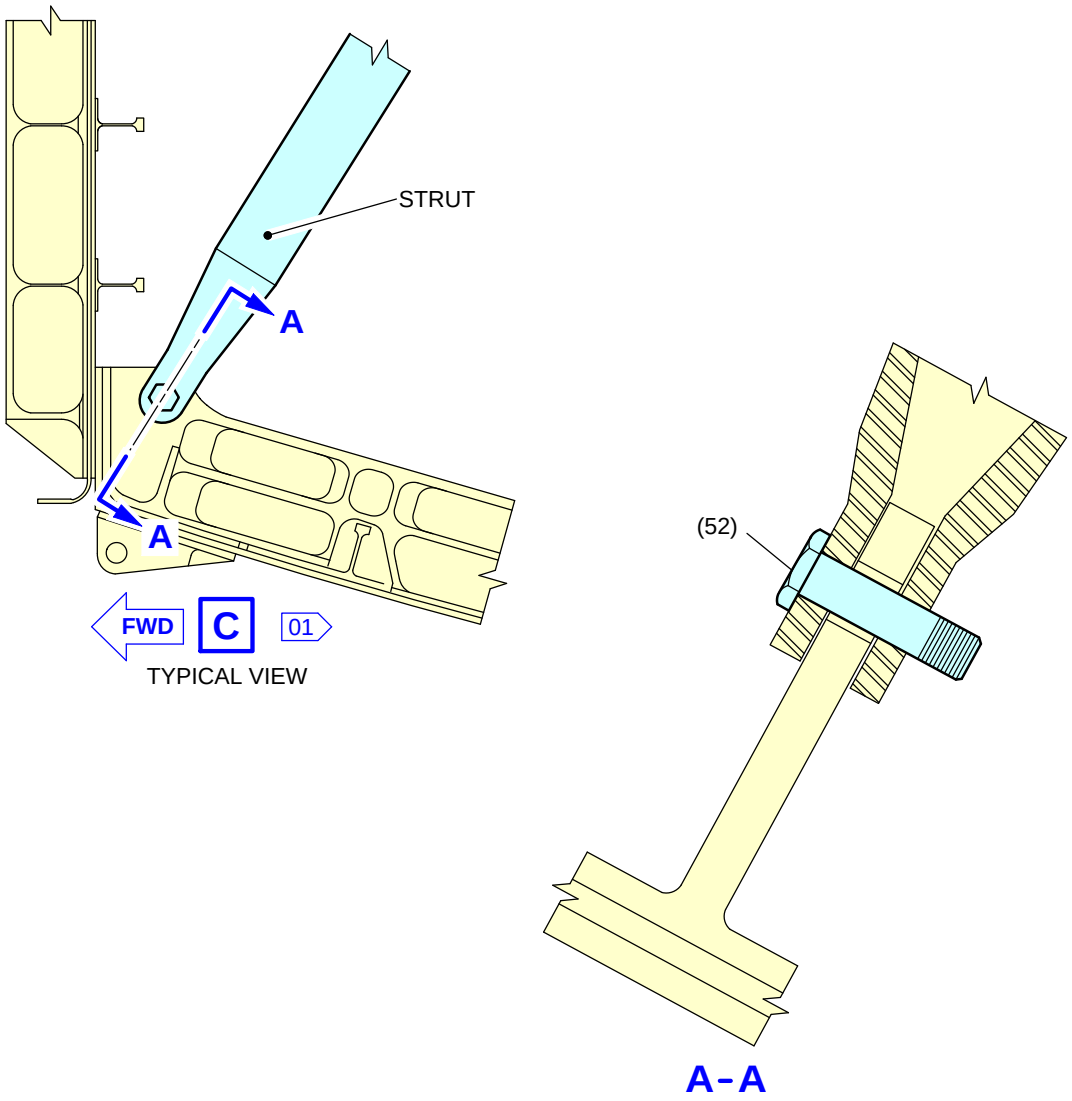


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



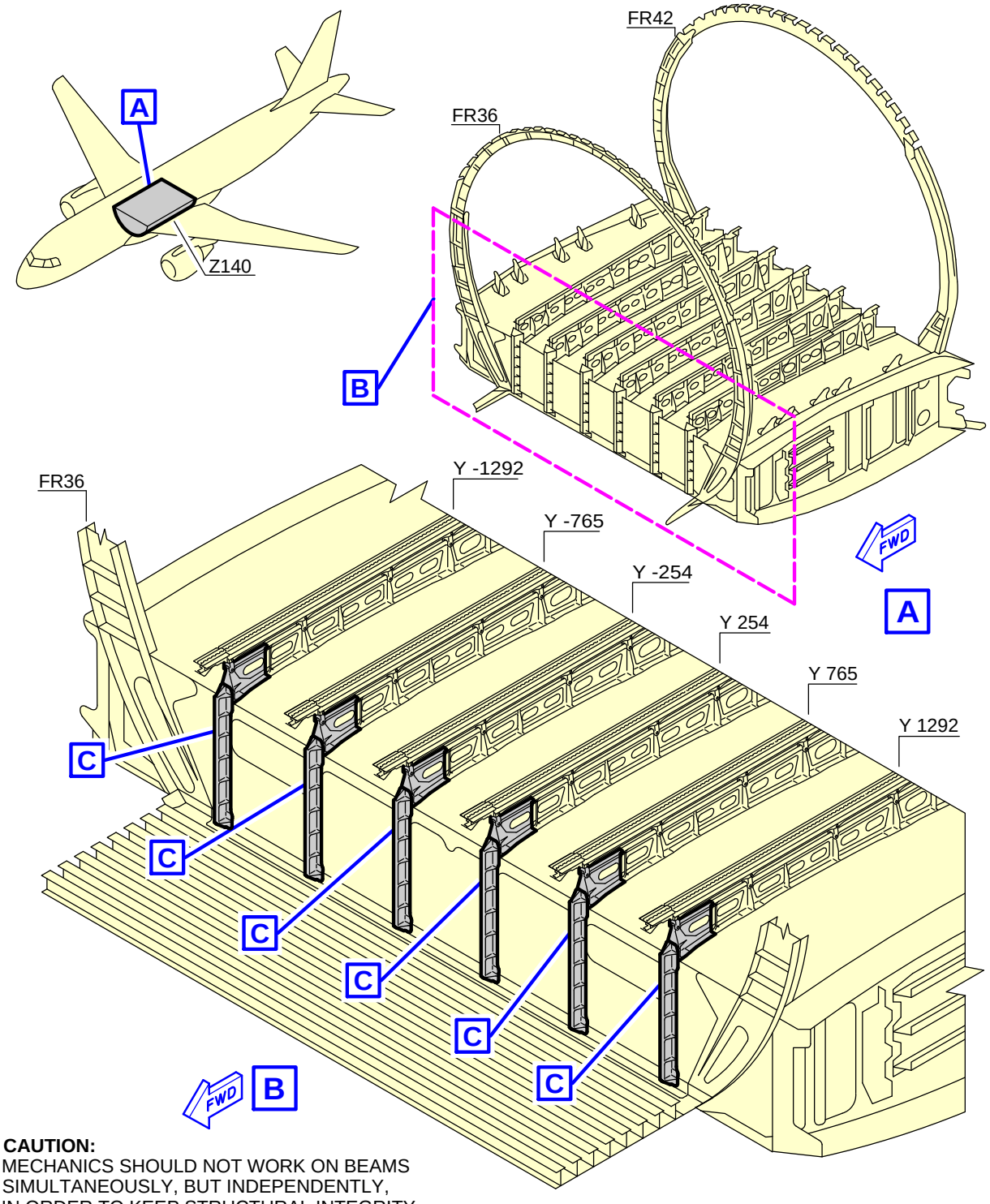
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

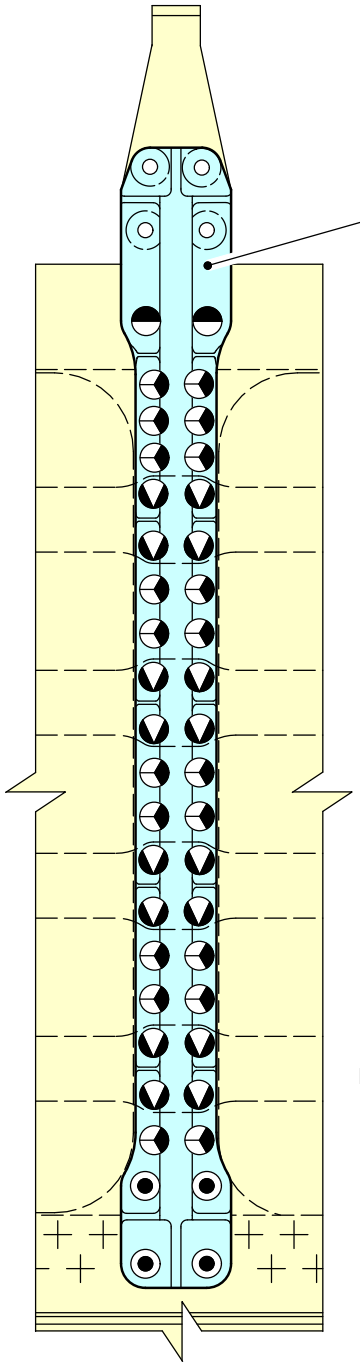


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(33) Task A320-A-57-XX-1228-13002-720A-A - Install the New Vertical Stringer on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

	Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
	Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

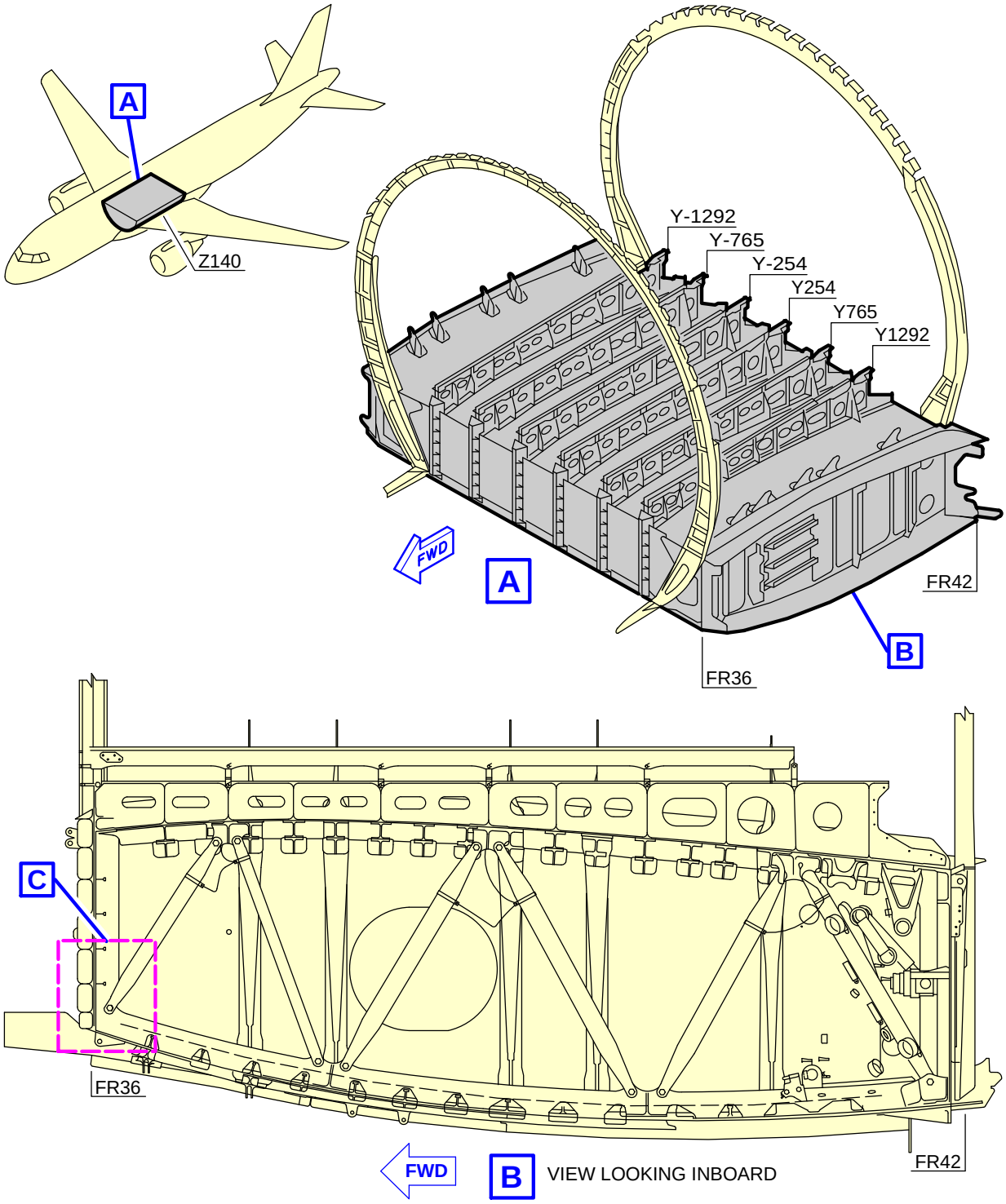
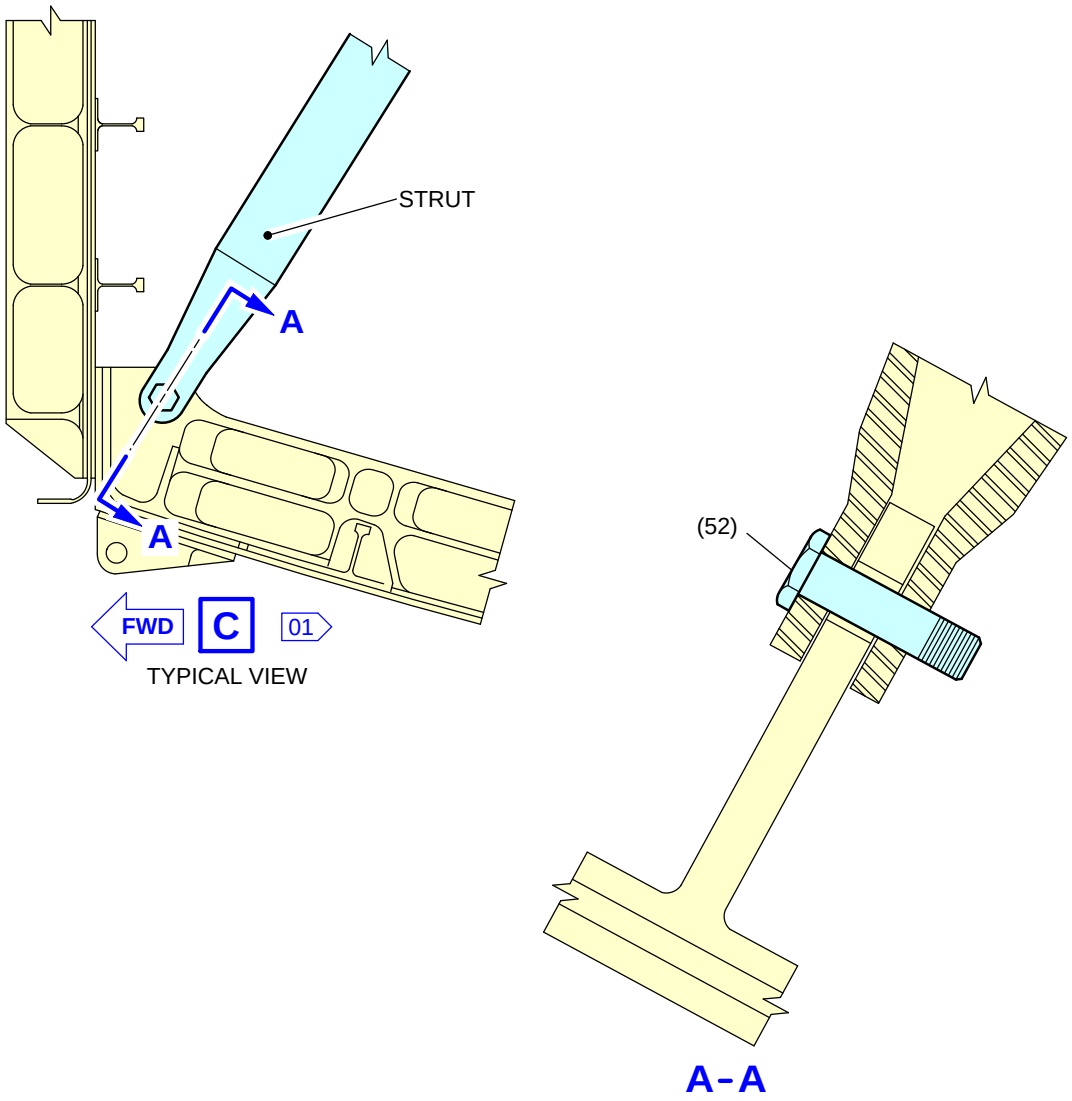


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



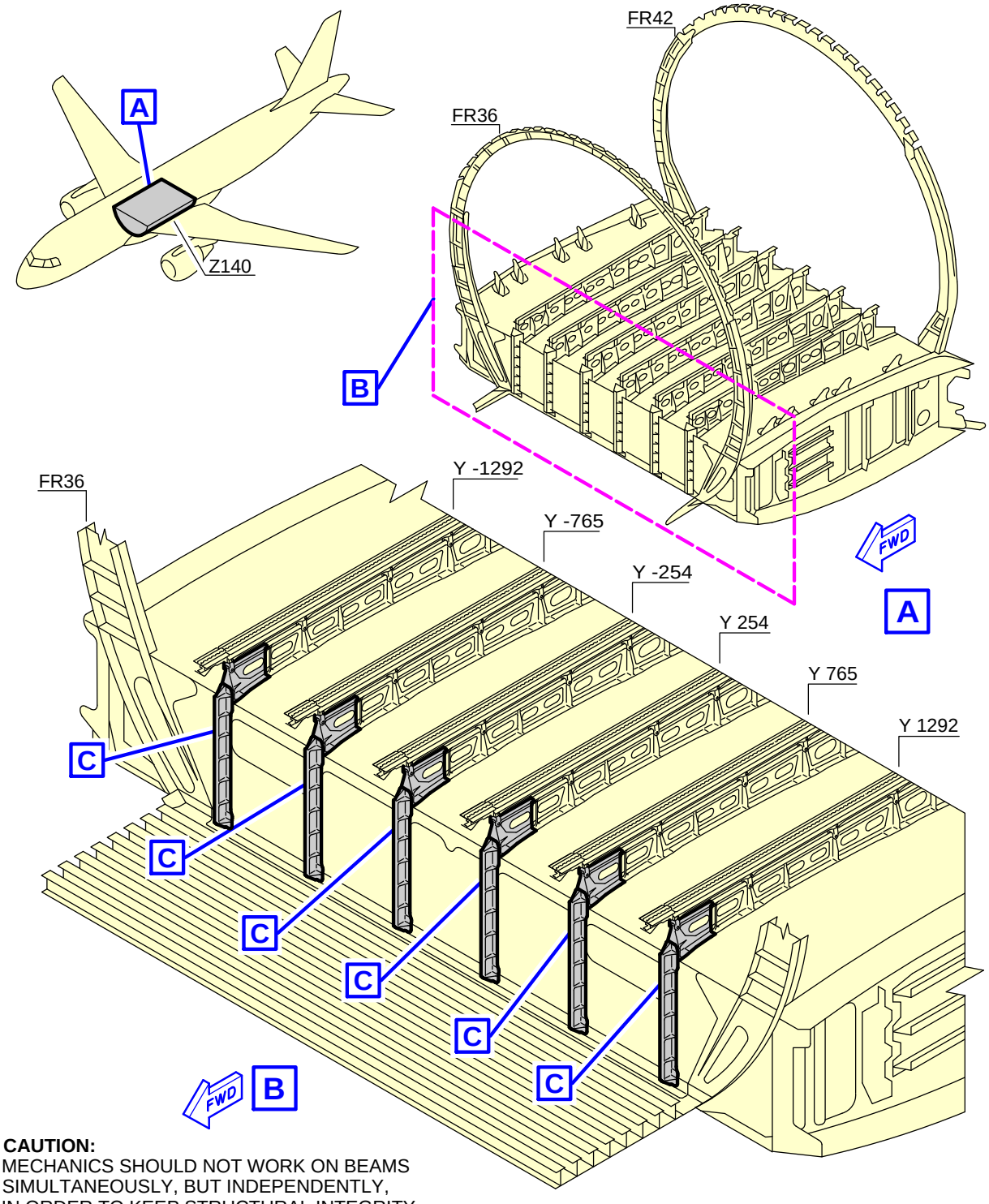
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

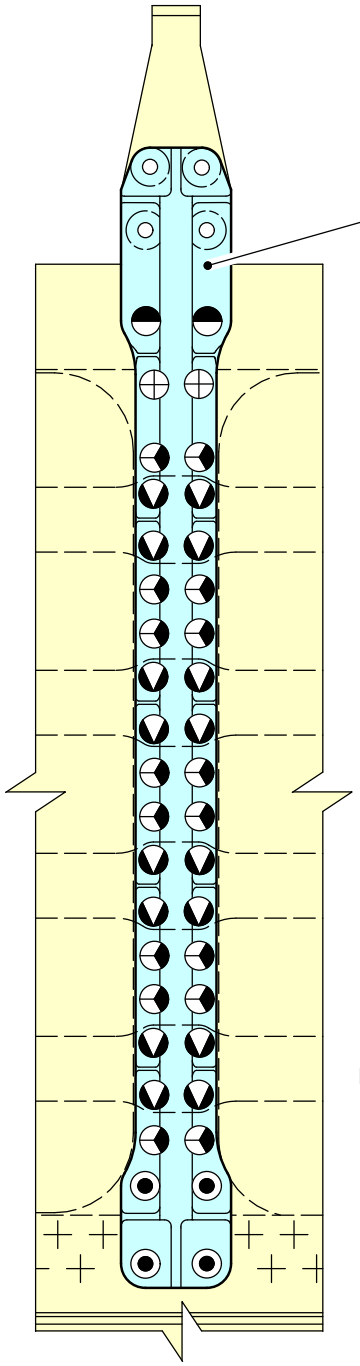


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(34) Task A320-A-57-XX-1228-14001-720A-A - Install the Strut Lower Attachment on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

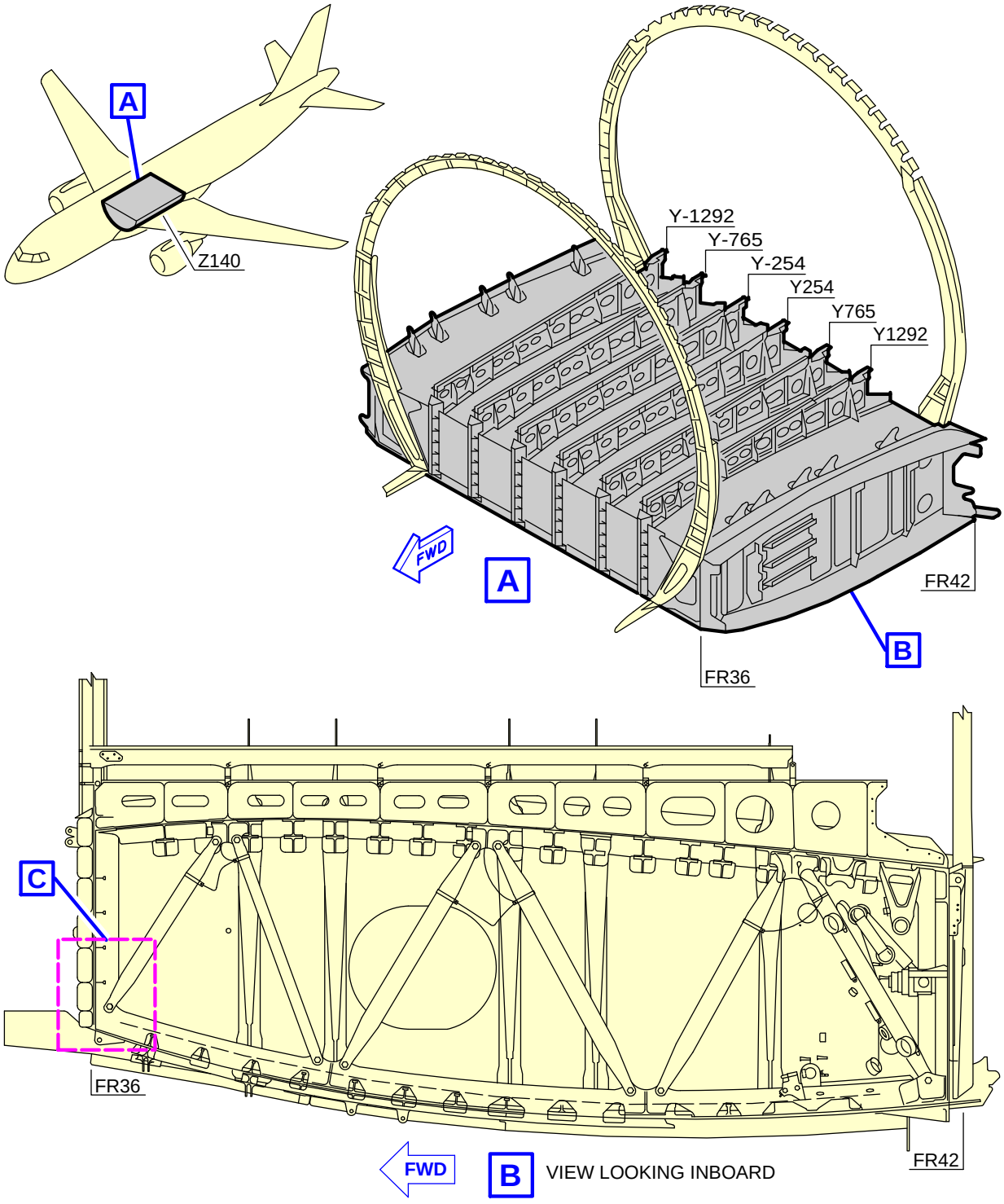
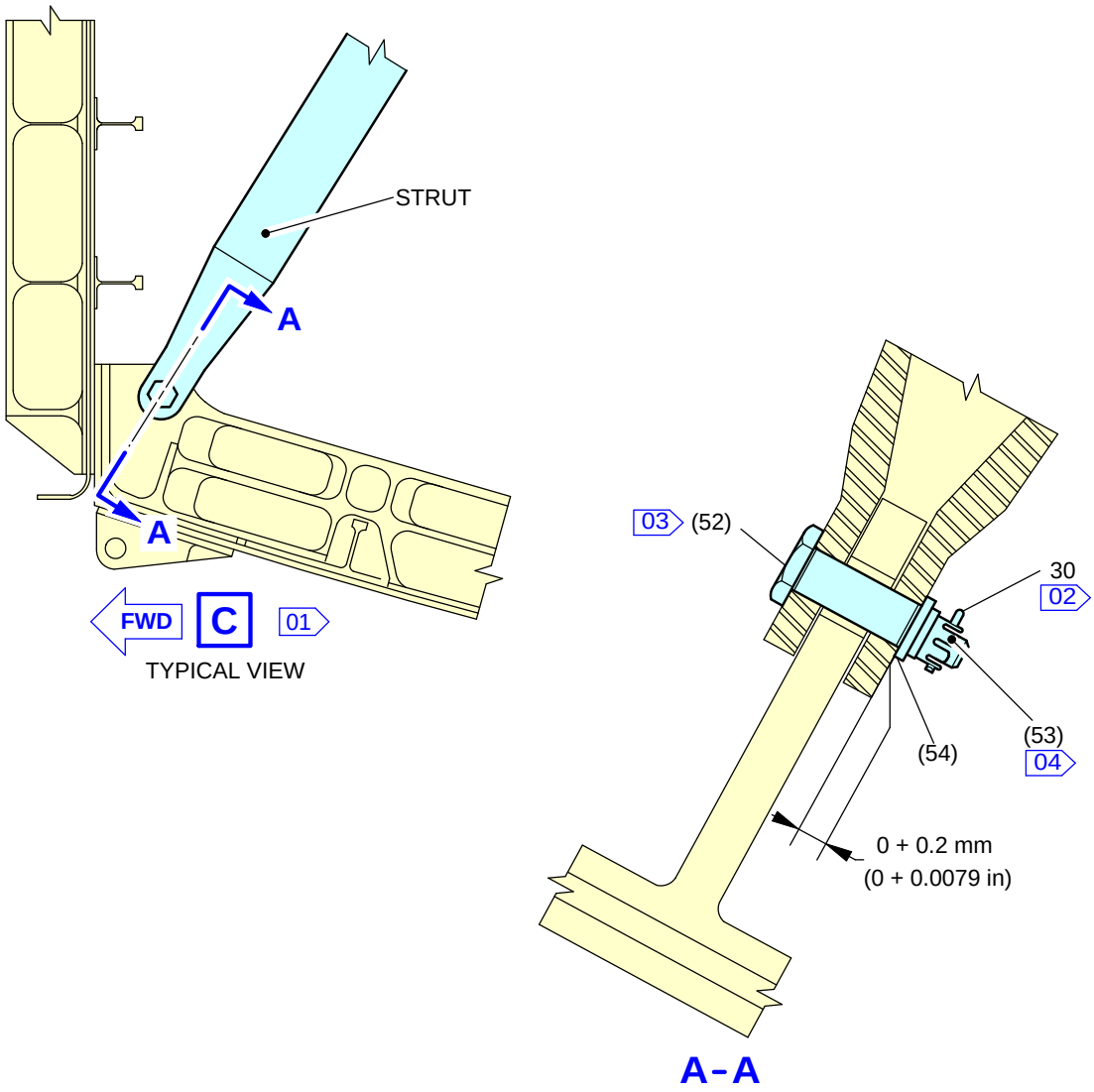


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(34) Task A320-A-57-XX-1228-14002-720A-A - Install the Strut Lower Attachment on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 002

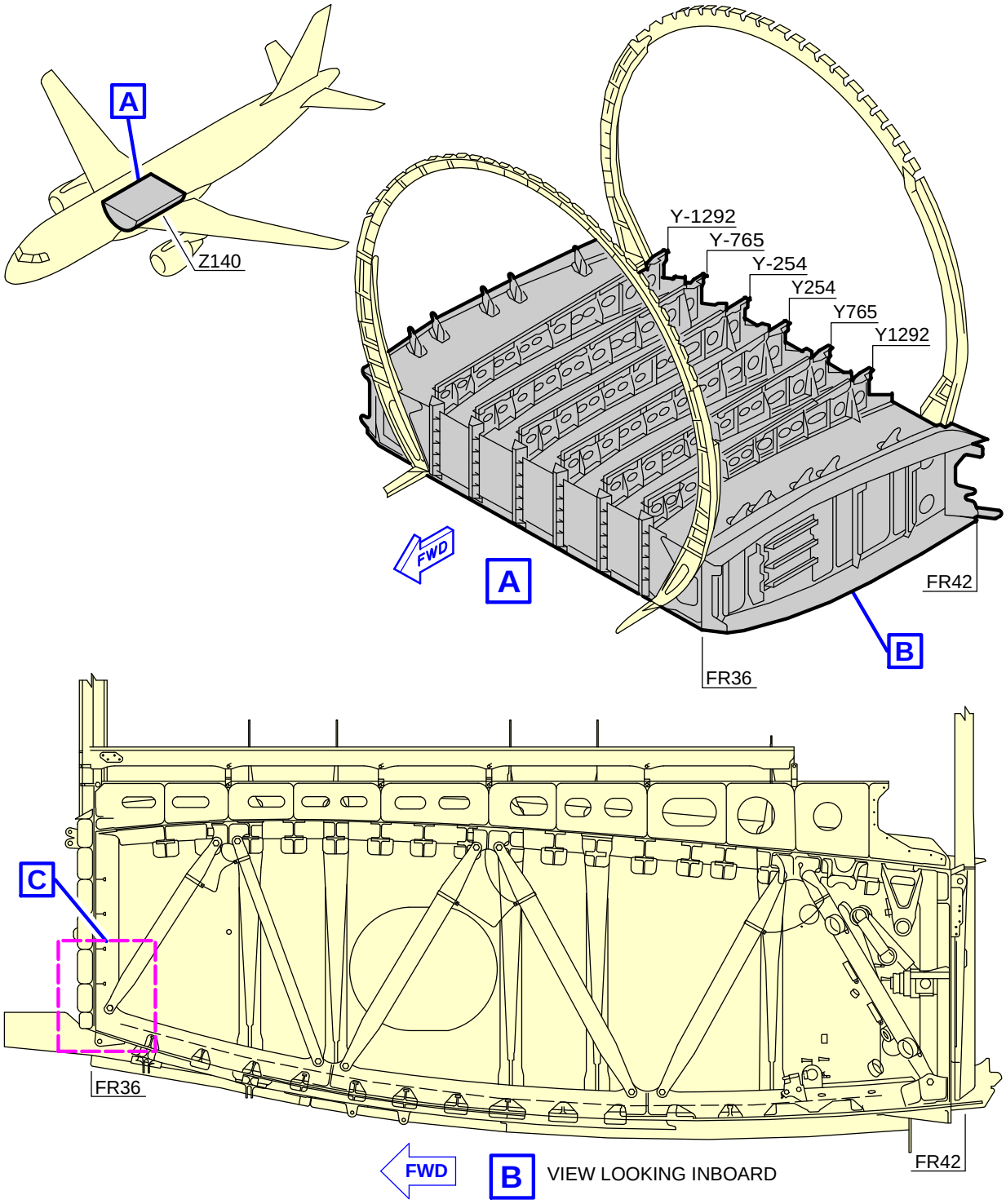
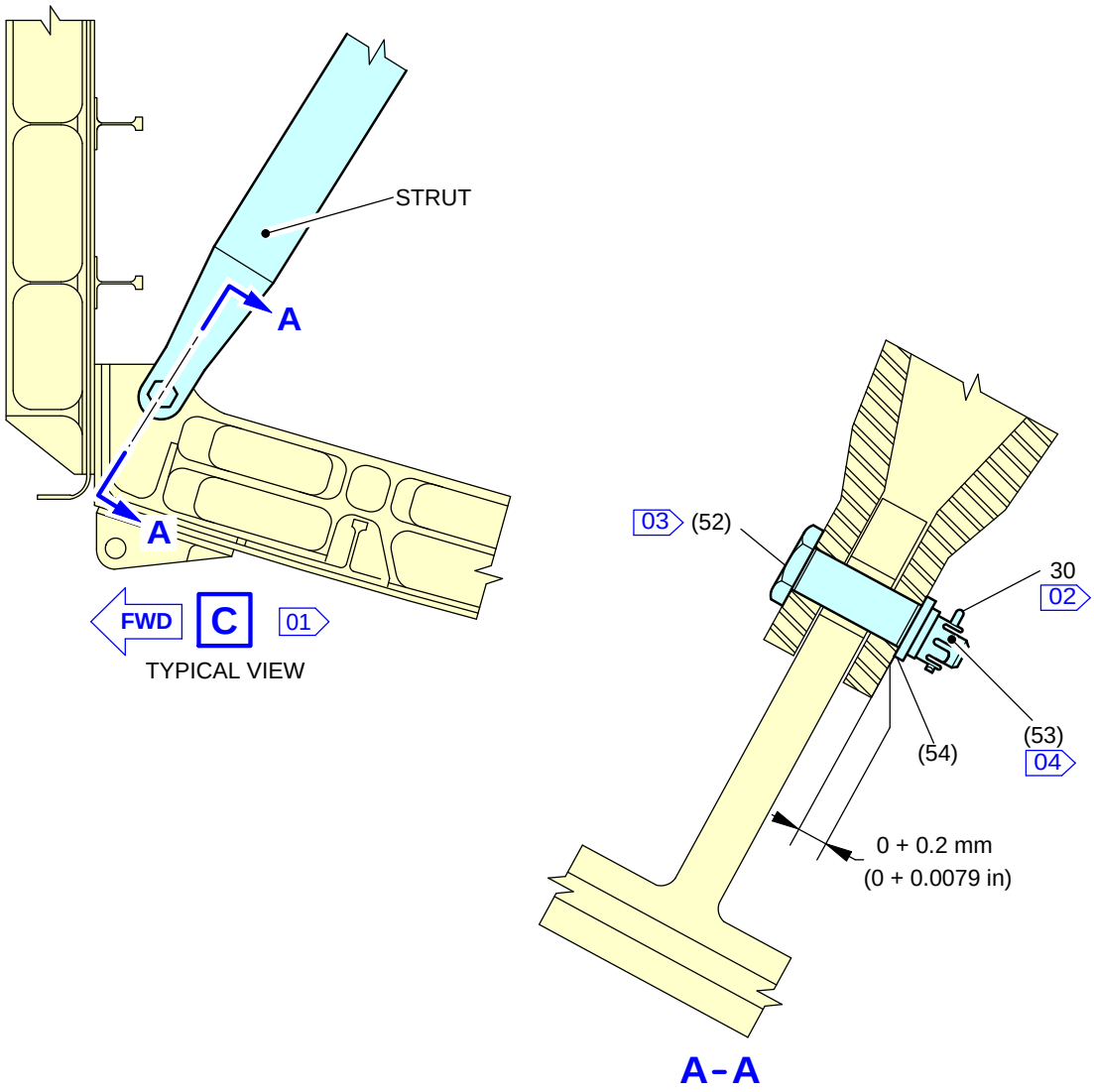


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(35) Task A320-A-57-XX-1228-12001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

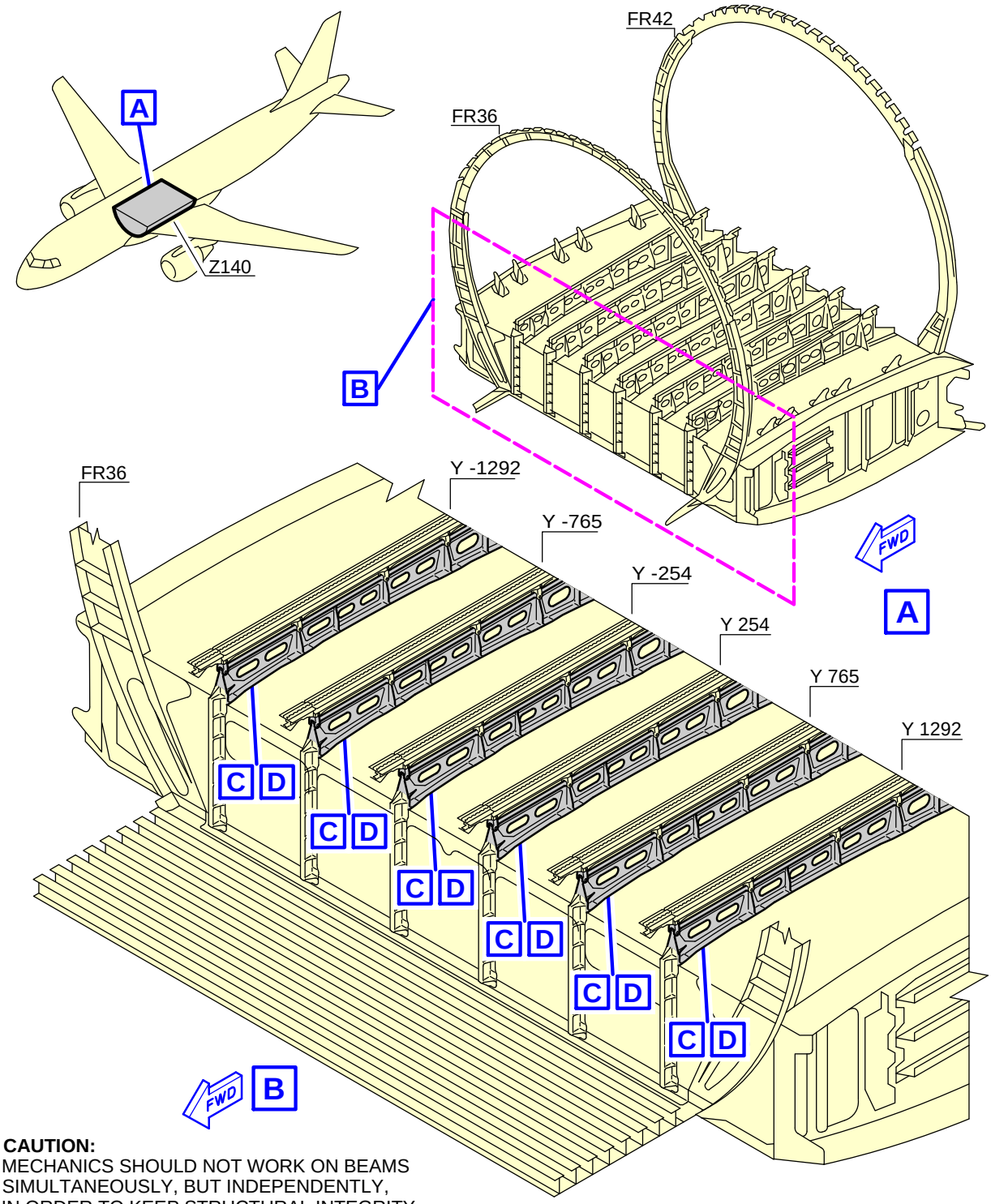
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-16ZZZ-720Z-A.

CONF ALL

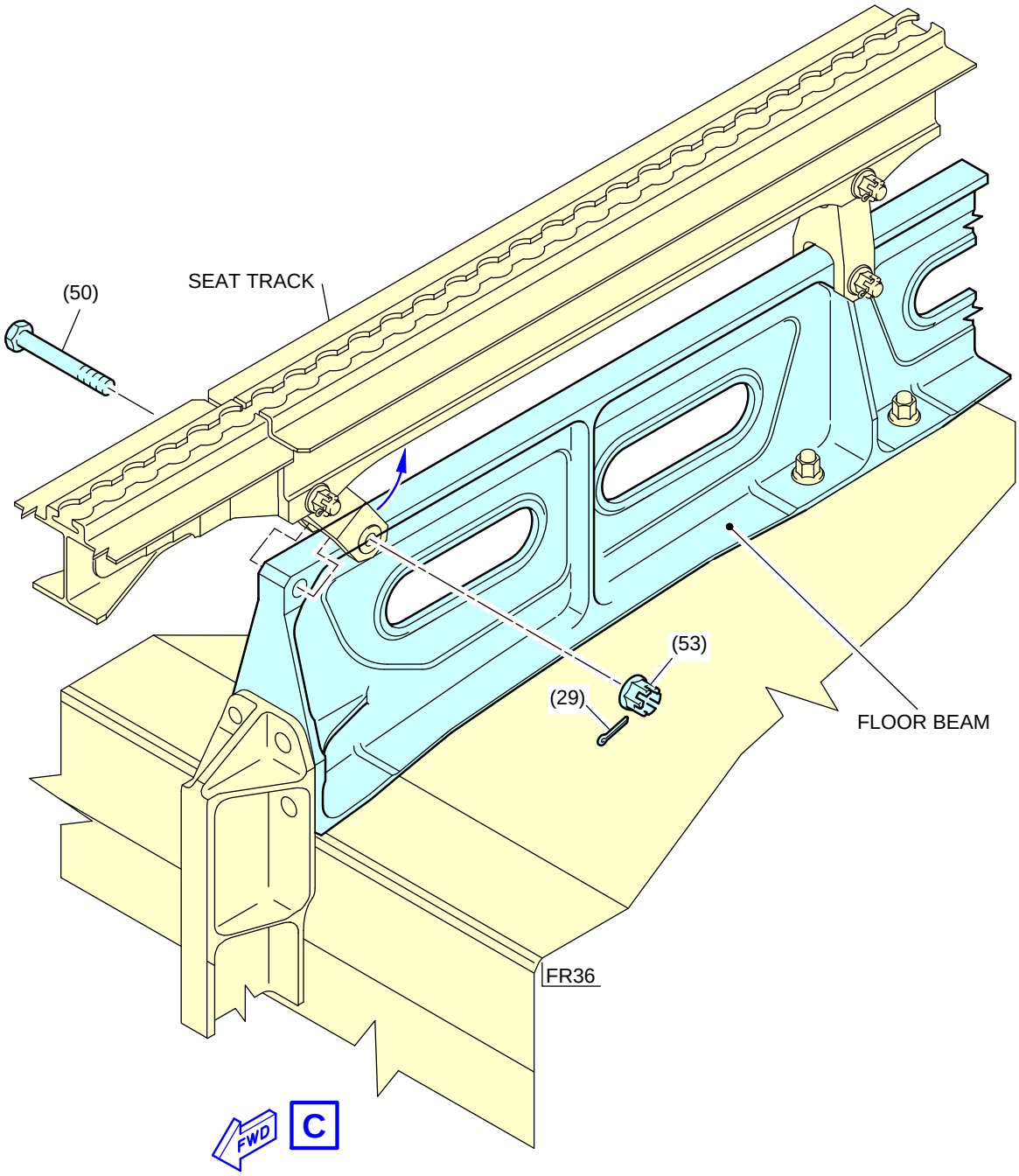


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

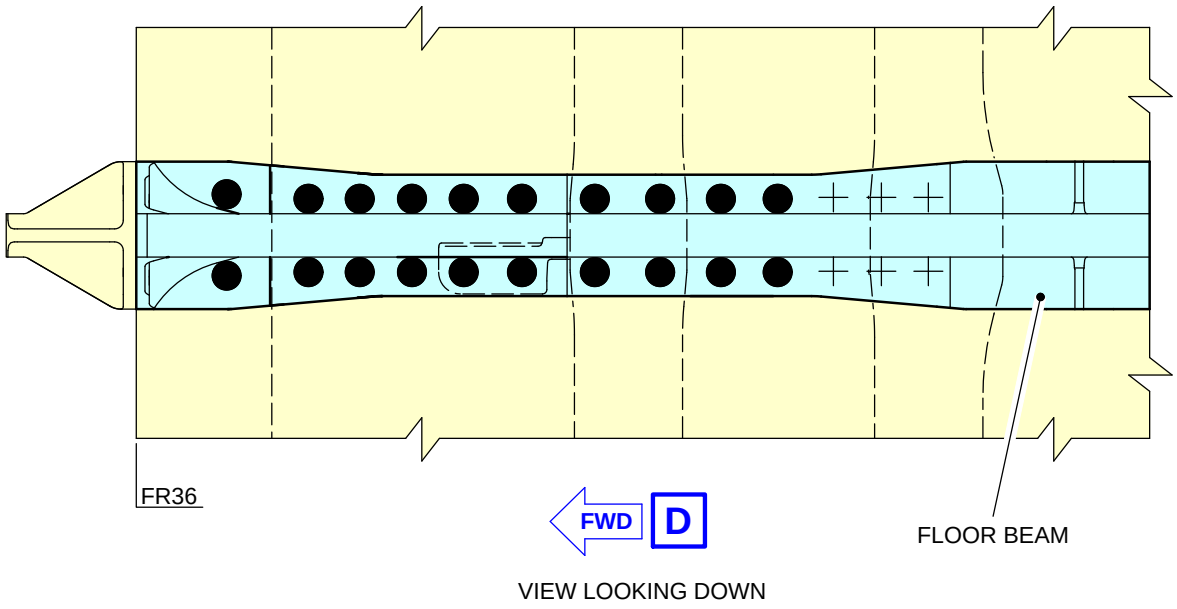
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(36) Task A320-A-57-XX-1228-03001-650A-A - Cut out the Forward End Floor Beam on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

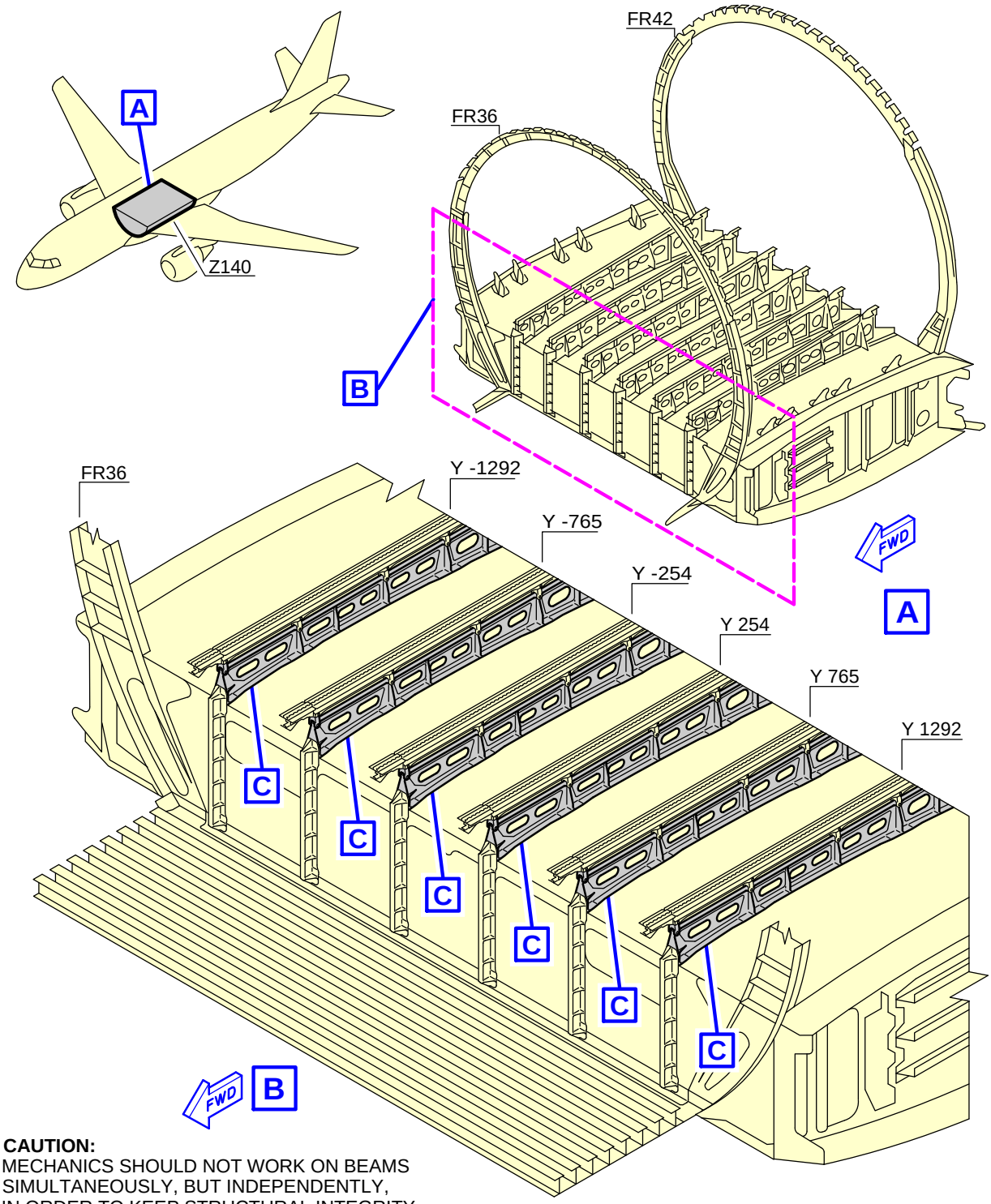
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

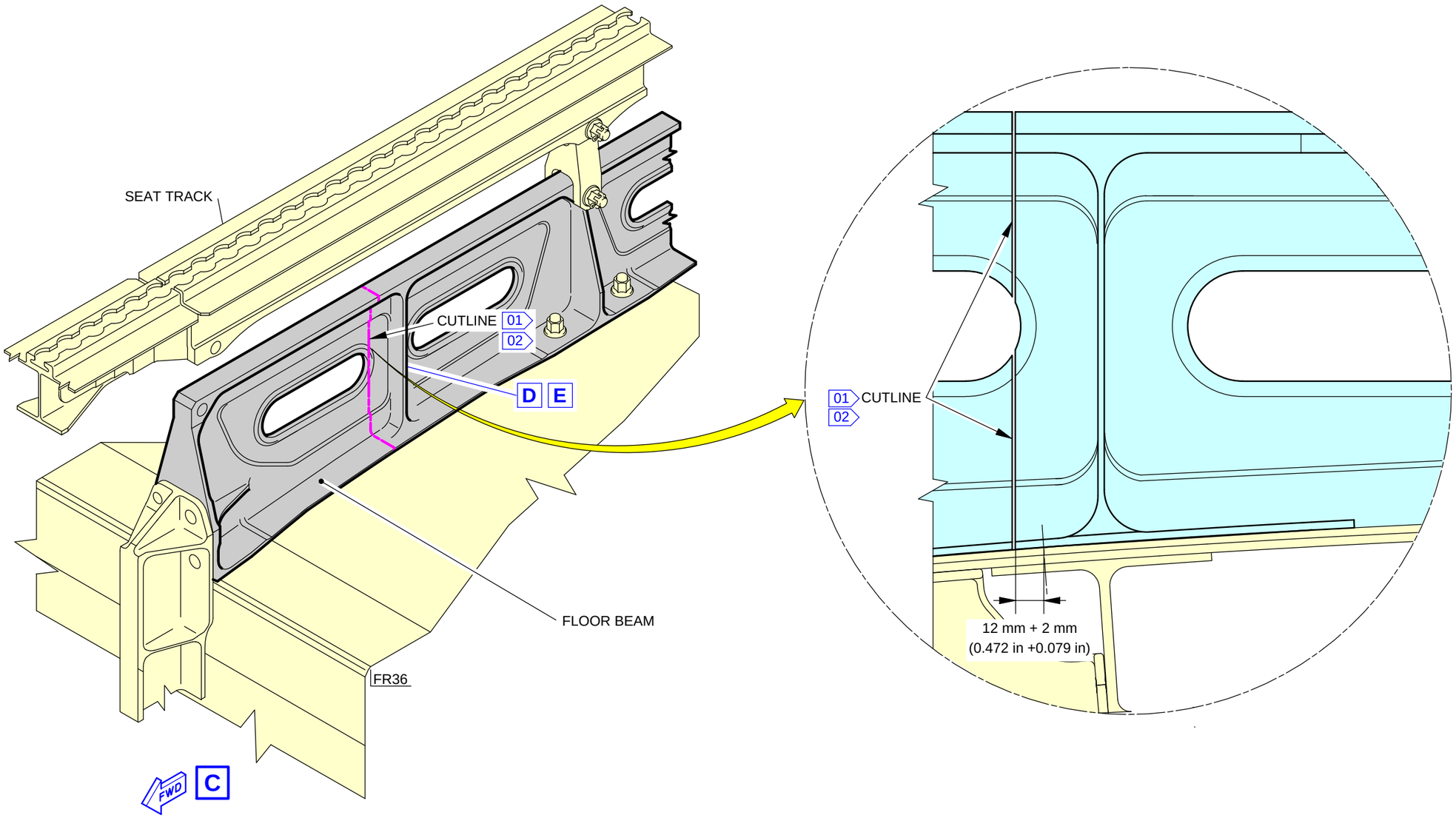


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

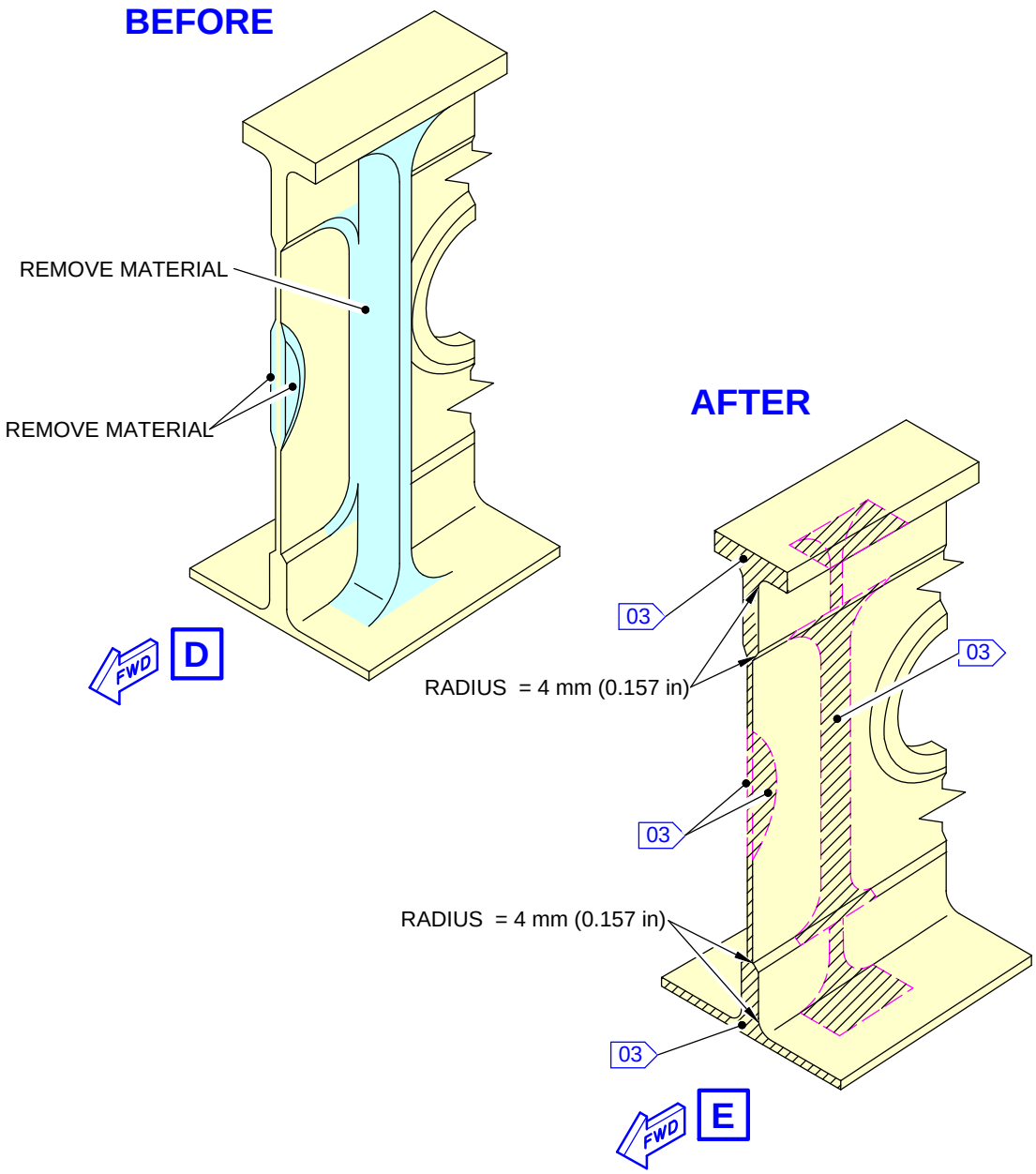
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(37) Task A320-A-57-XX-1228-06001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-15ZZZ-720Z-C.

CONF 001 003 004

(38) Task A320-A-57-XX-1228-15001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

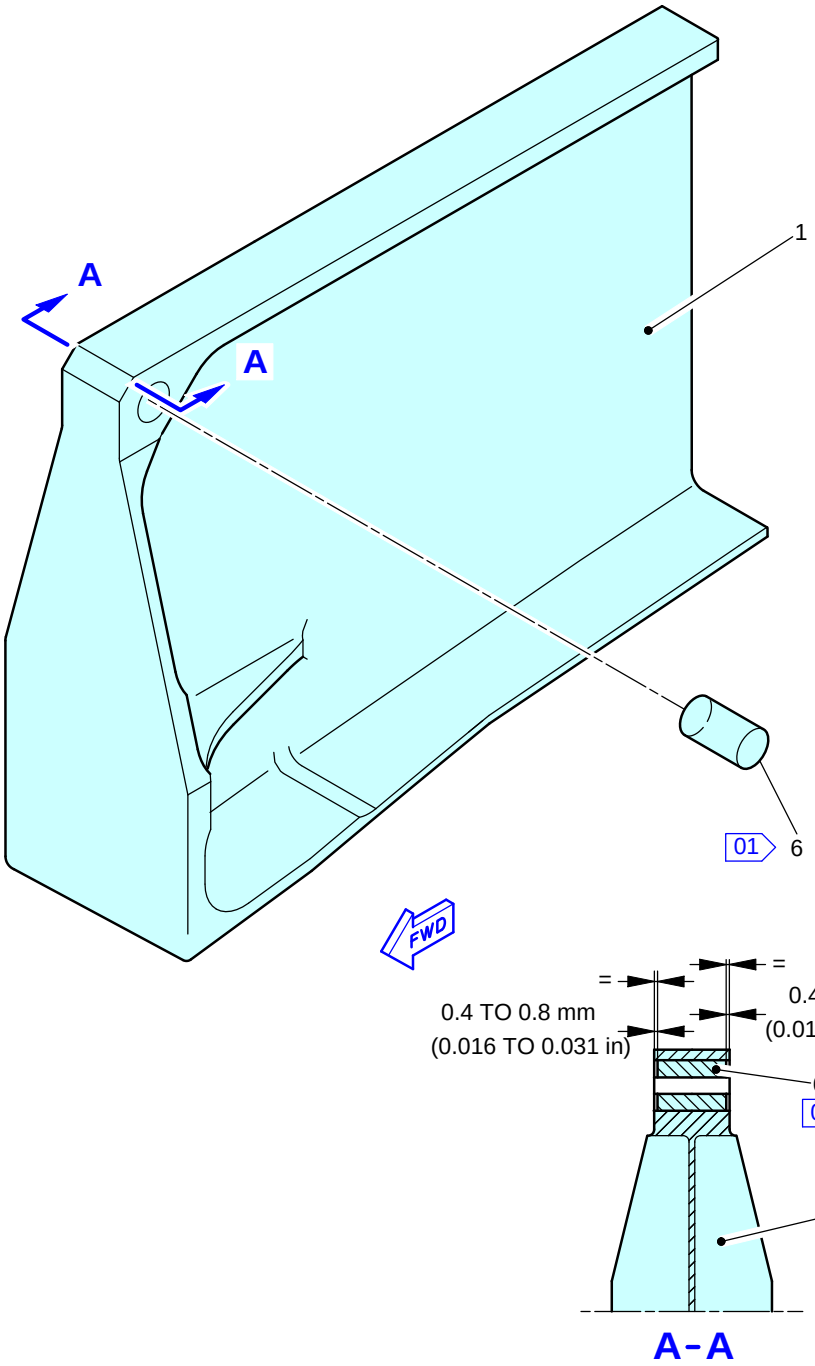
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(38) Task A320-A-57-XX-1228-15002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y254 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

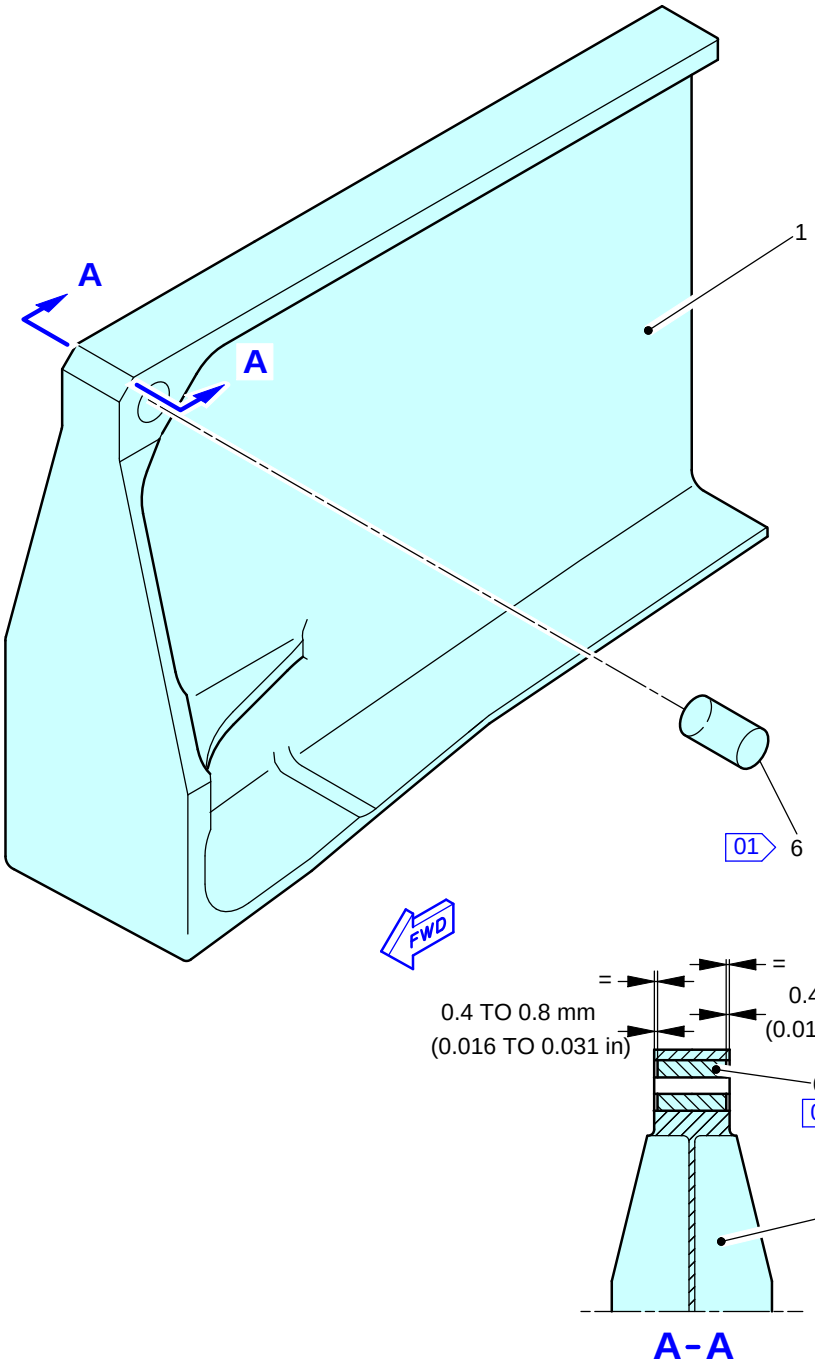
2 Install:

1 BUSHING D5713006420000 Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(39) Task A320-A-57-XX-1228-03001-270A-A - Temporarily, Install the New Parts for Adjustment on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

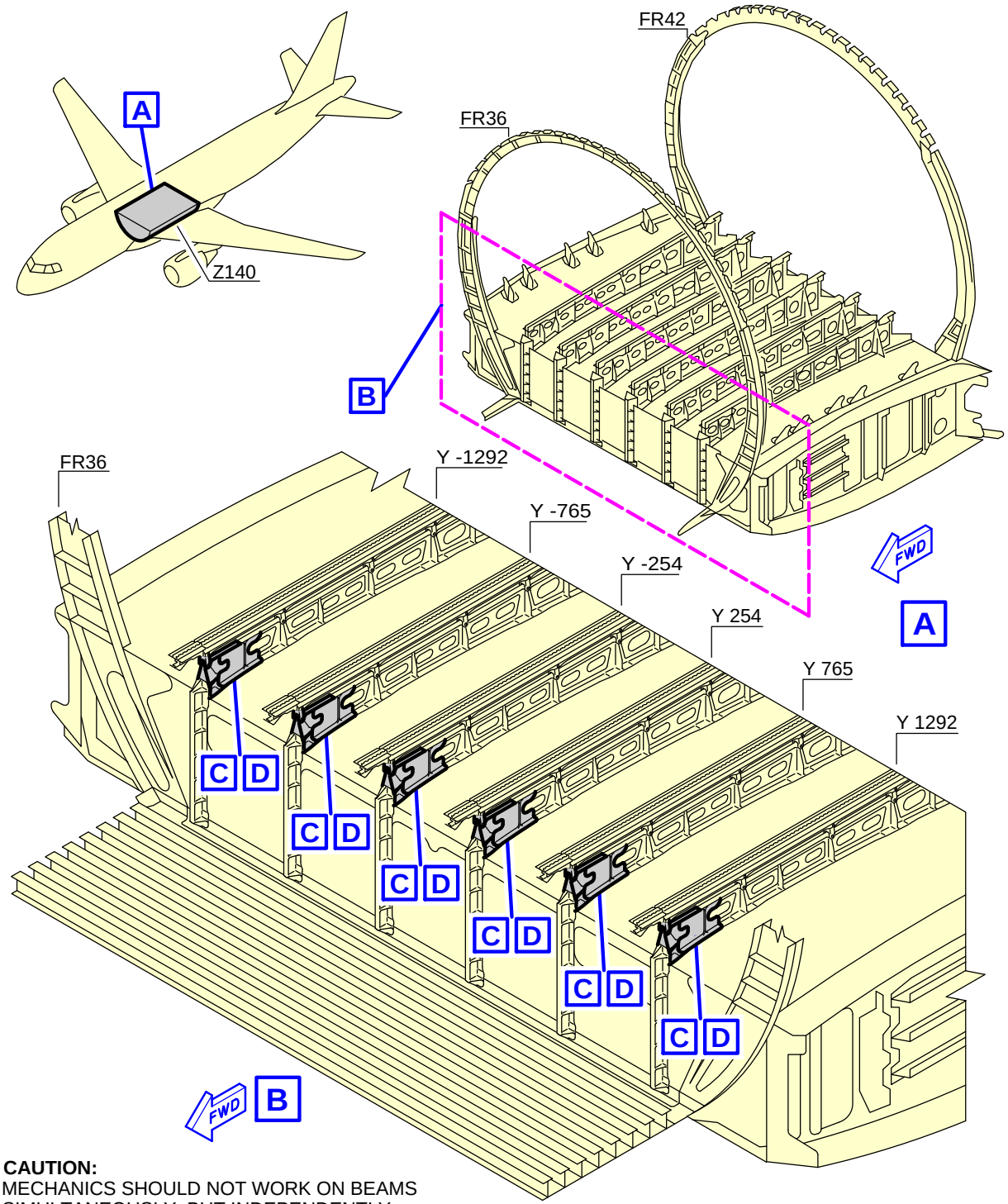
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

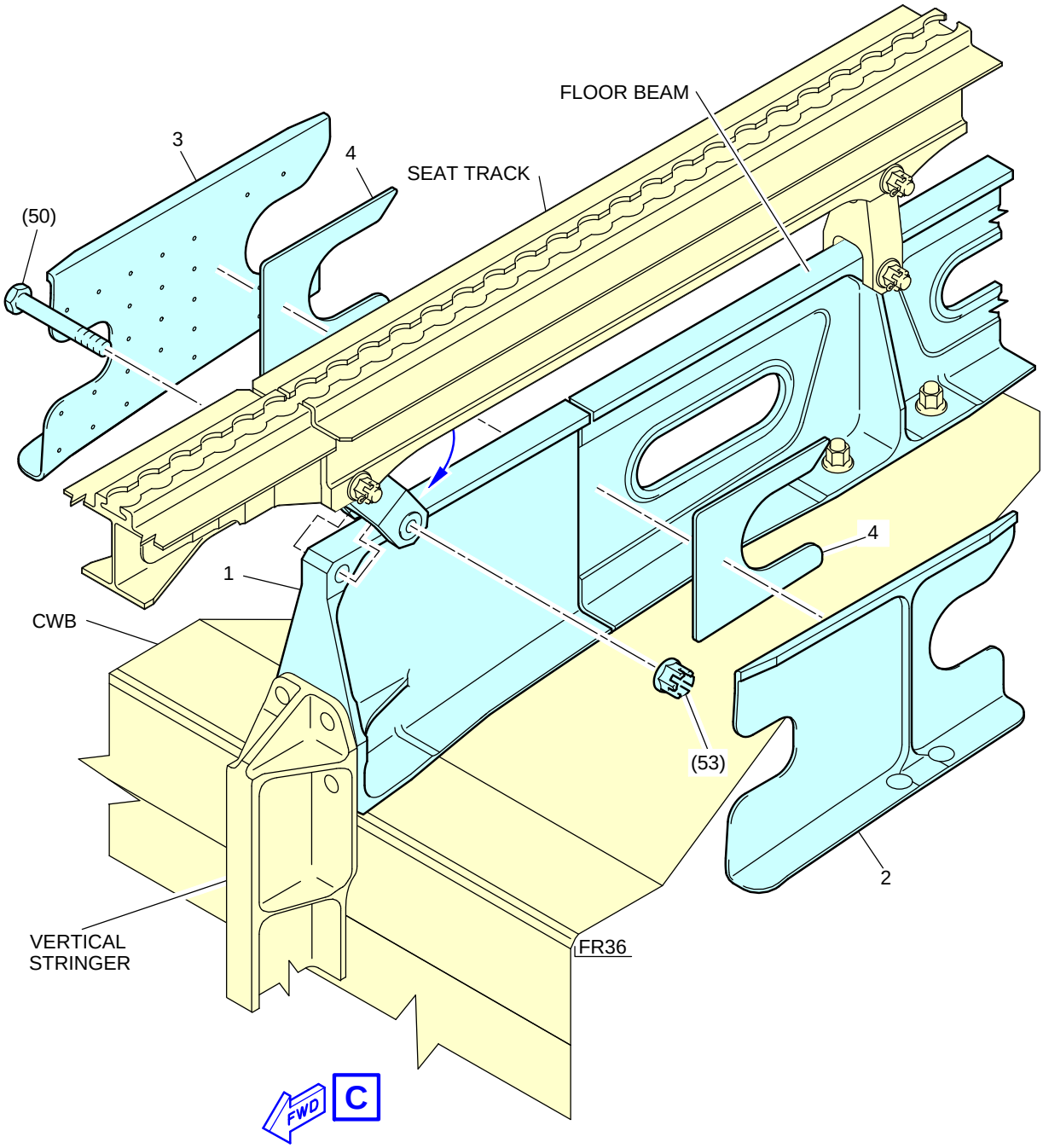


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

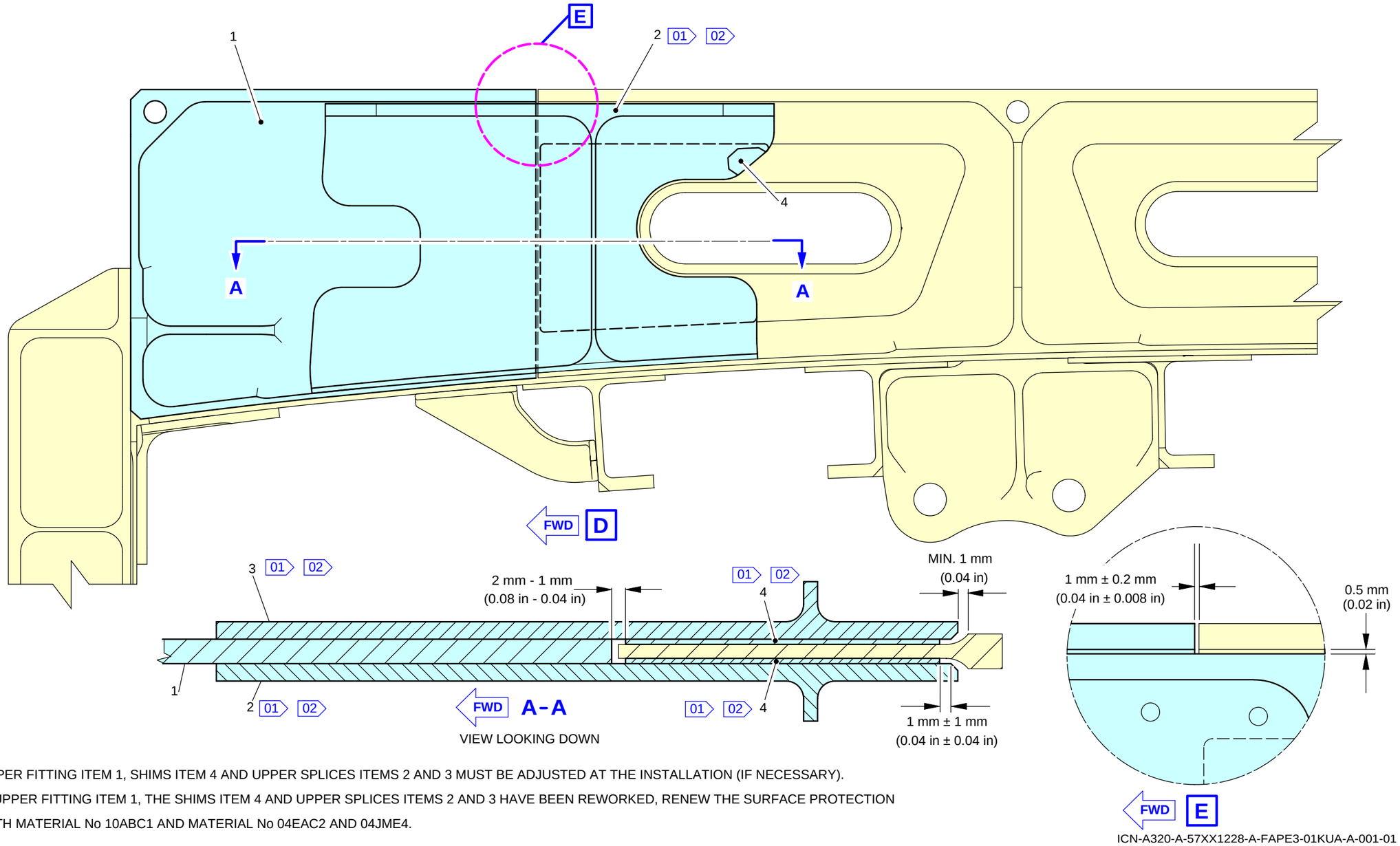
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(39) Task A320-A-57-XX-1228-03002-270A-A - Temporarily, Install the New Parts for Adjustment on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

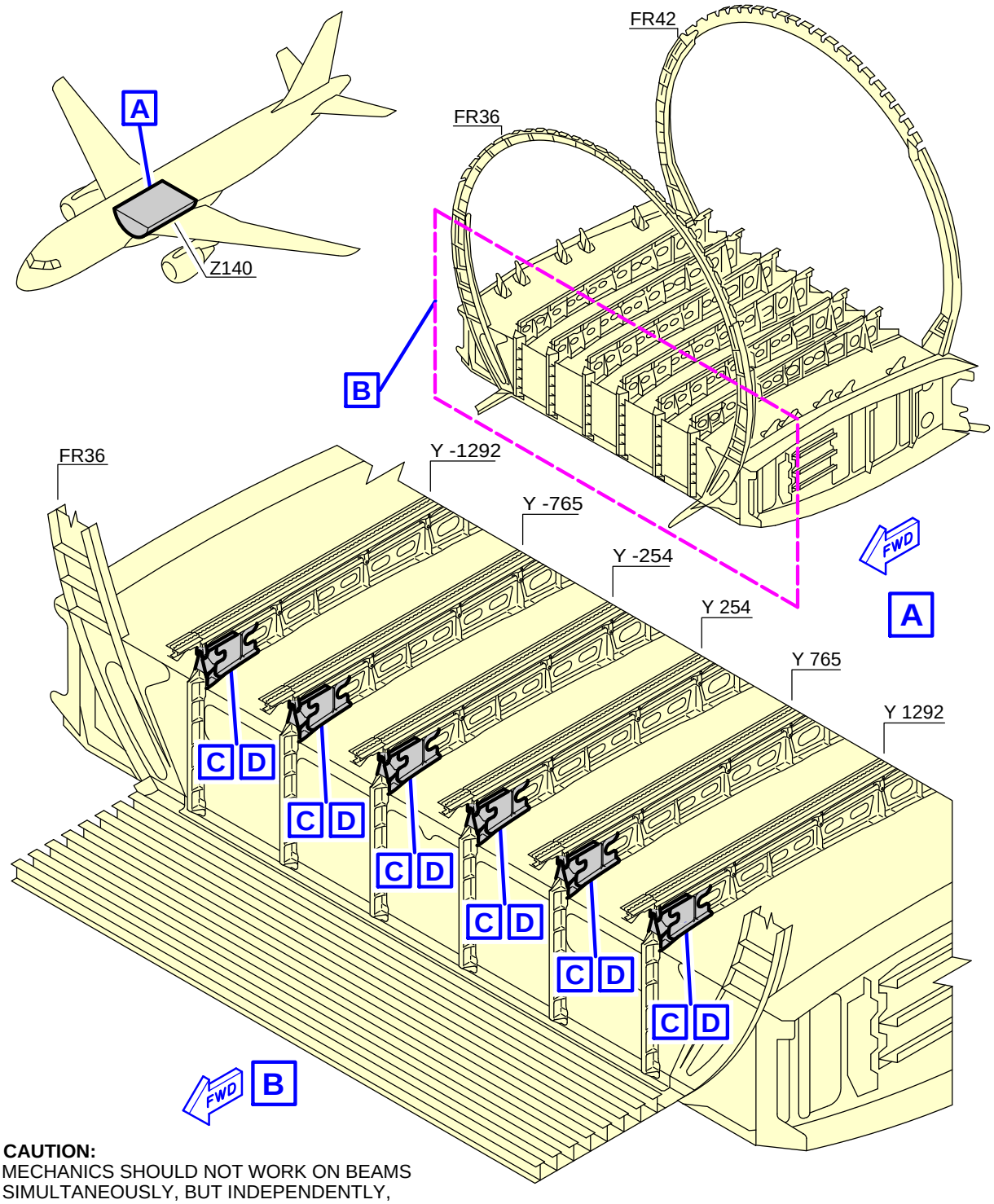
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

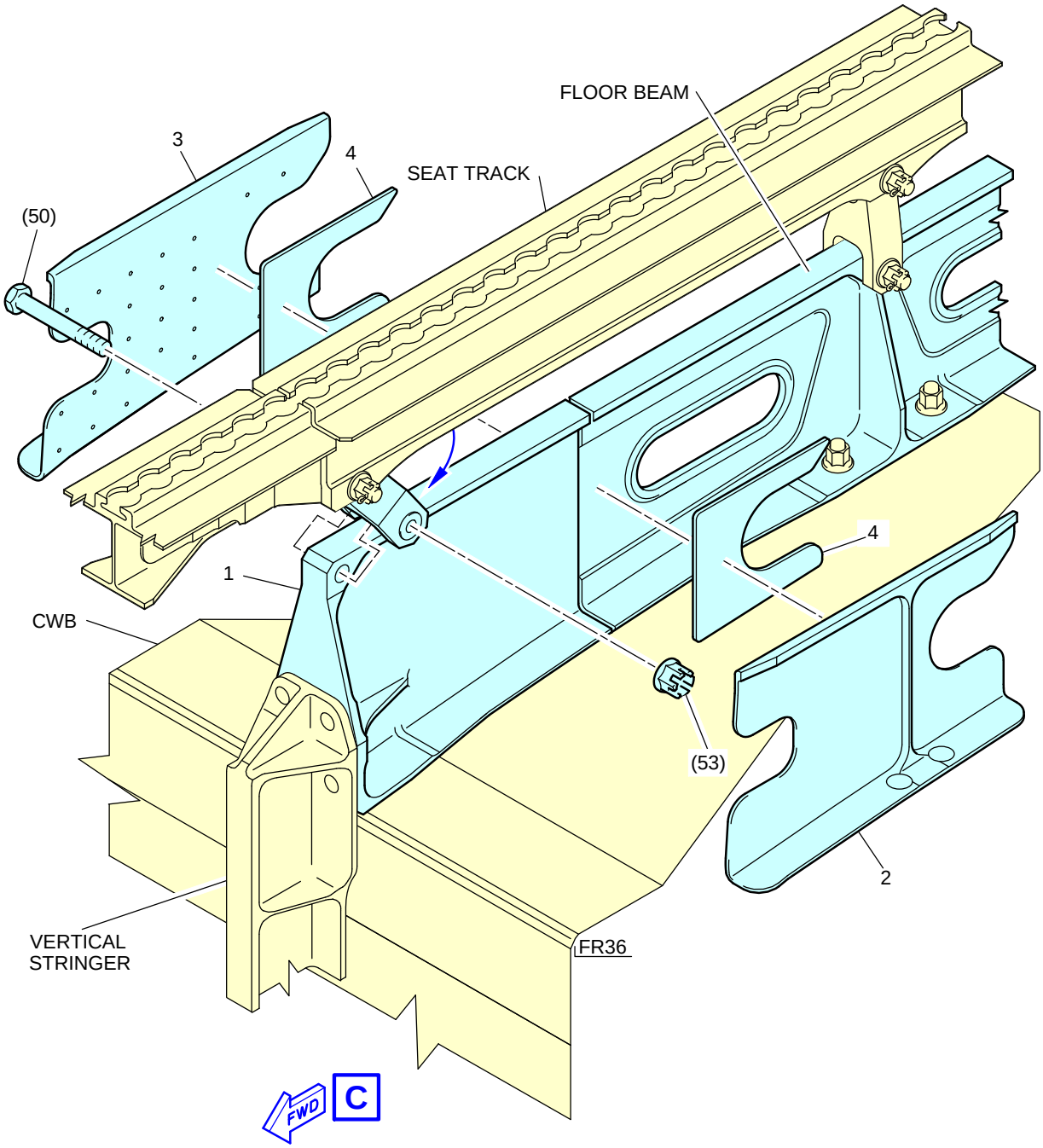


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

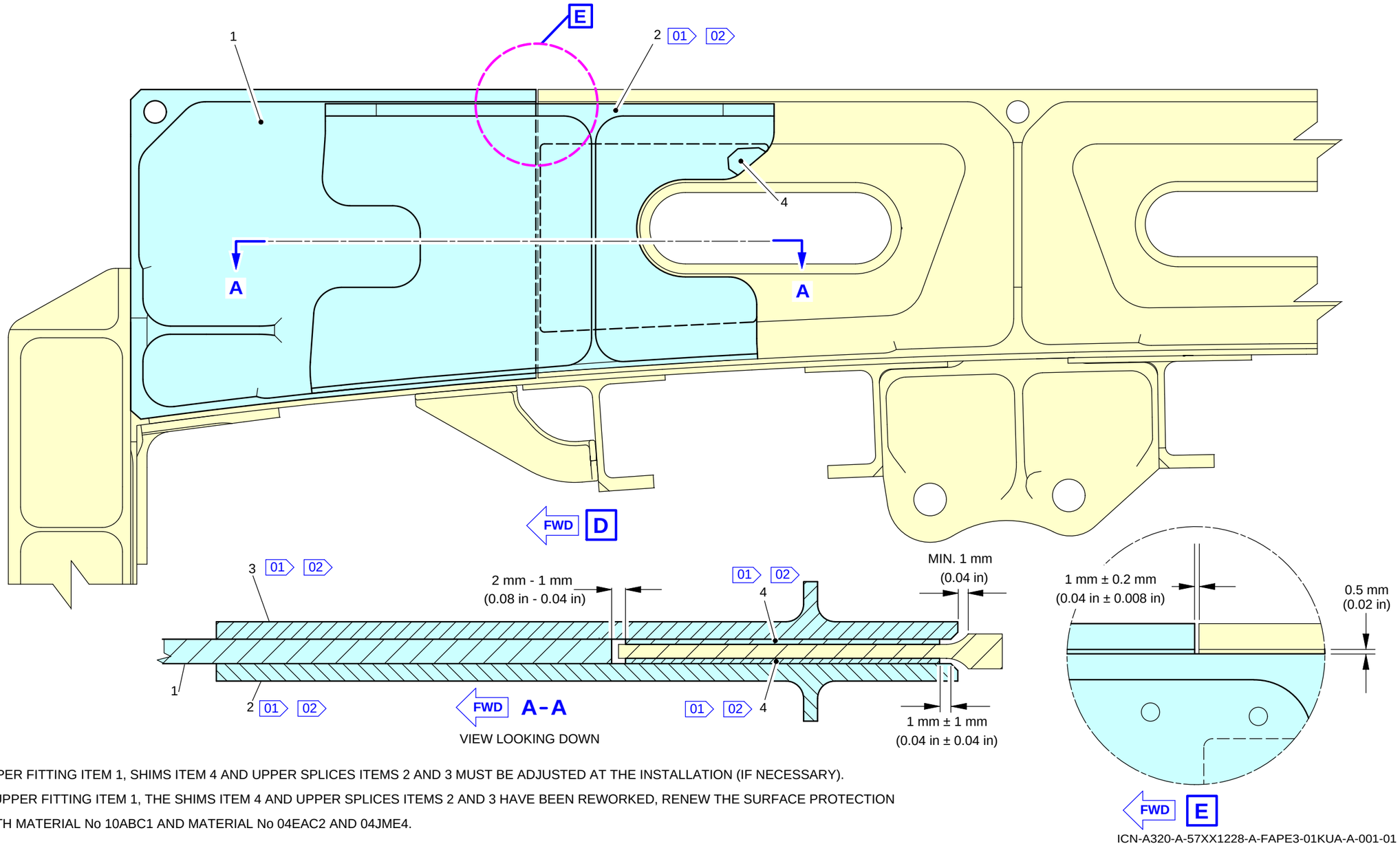
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(40) Task A320-A-57-XX-1228-06001-900A-A - Drill the New Parts on Y254 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

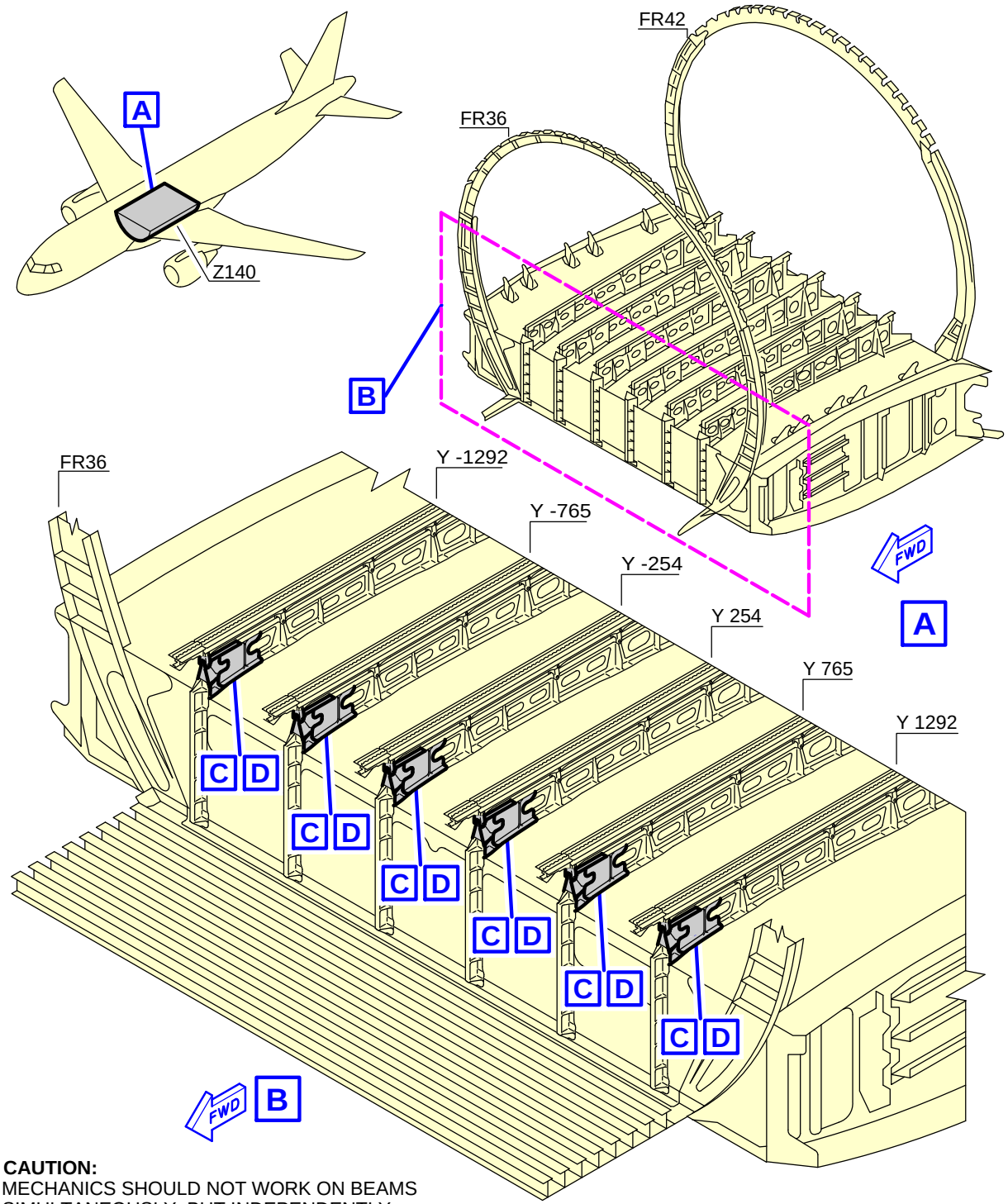
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

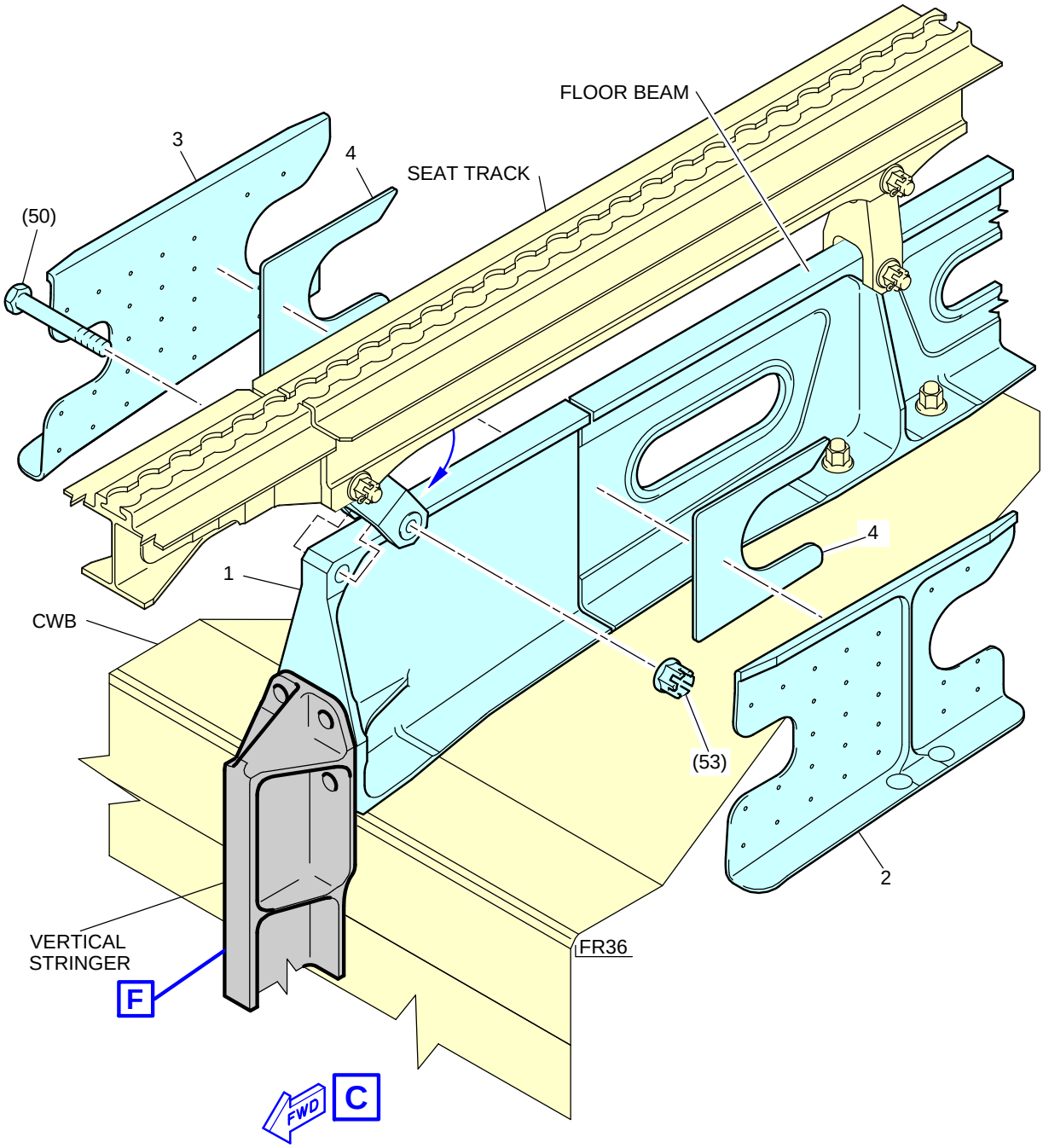


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

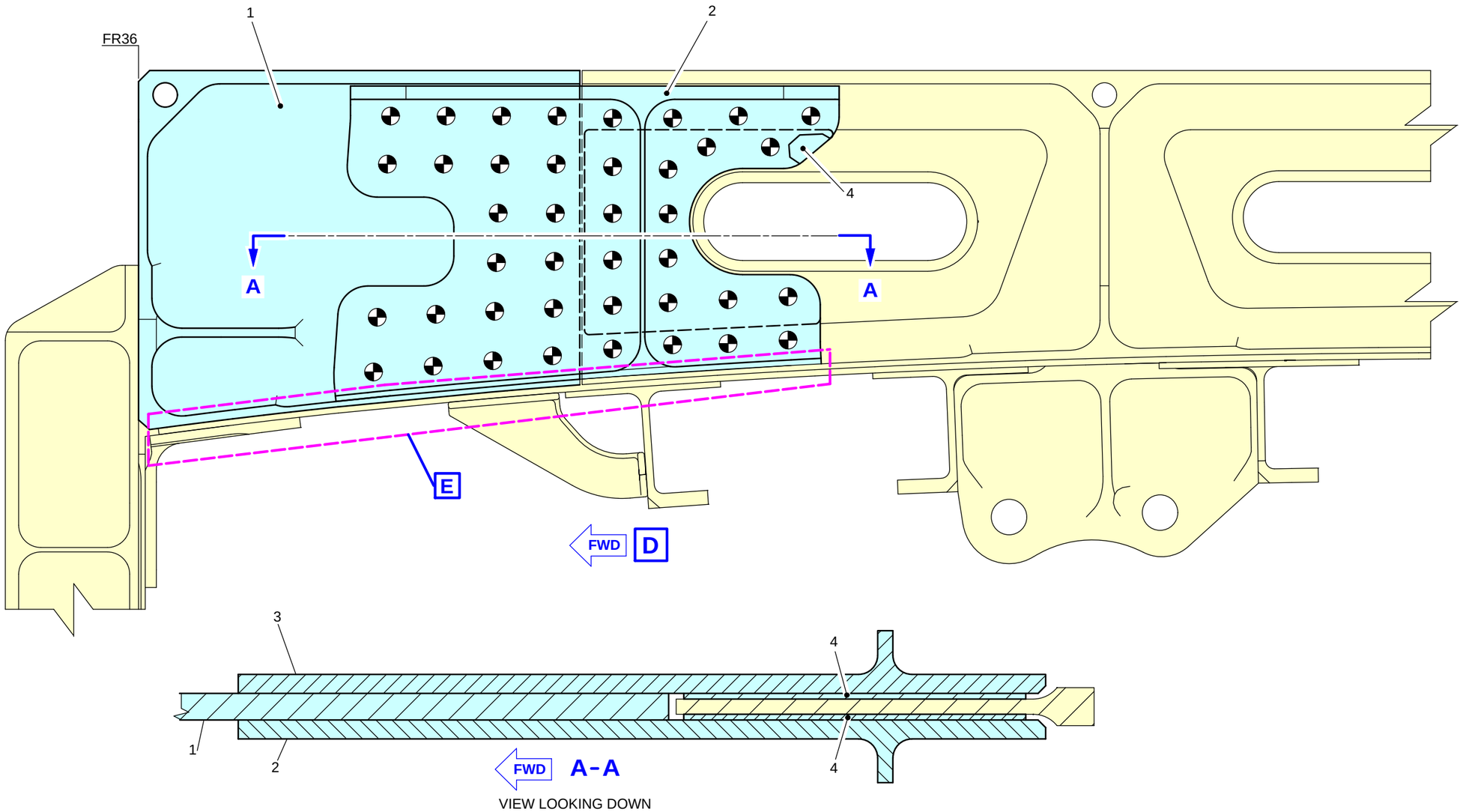
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

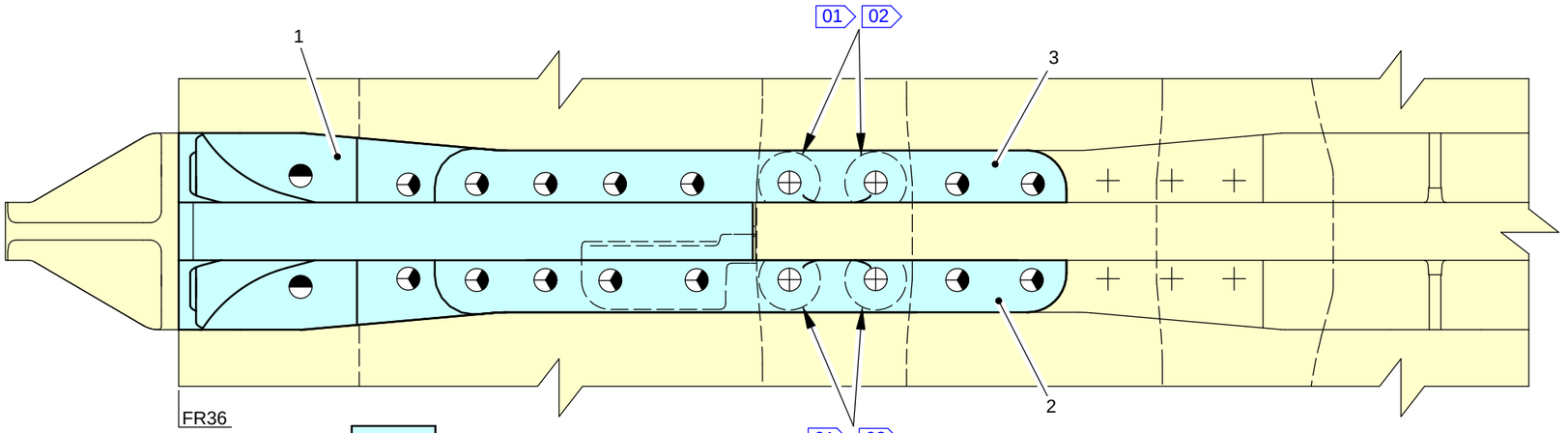


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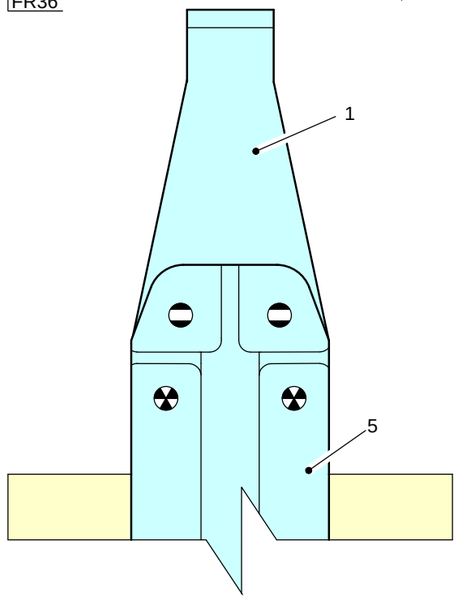
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◒	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(40) Task A320-A-57-XX-1228-06002-900A-A - Drill the New Parts on Y254 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

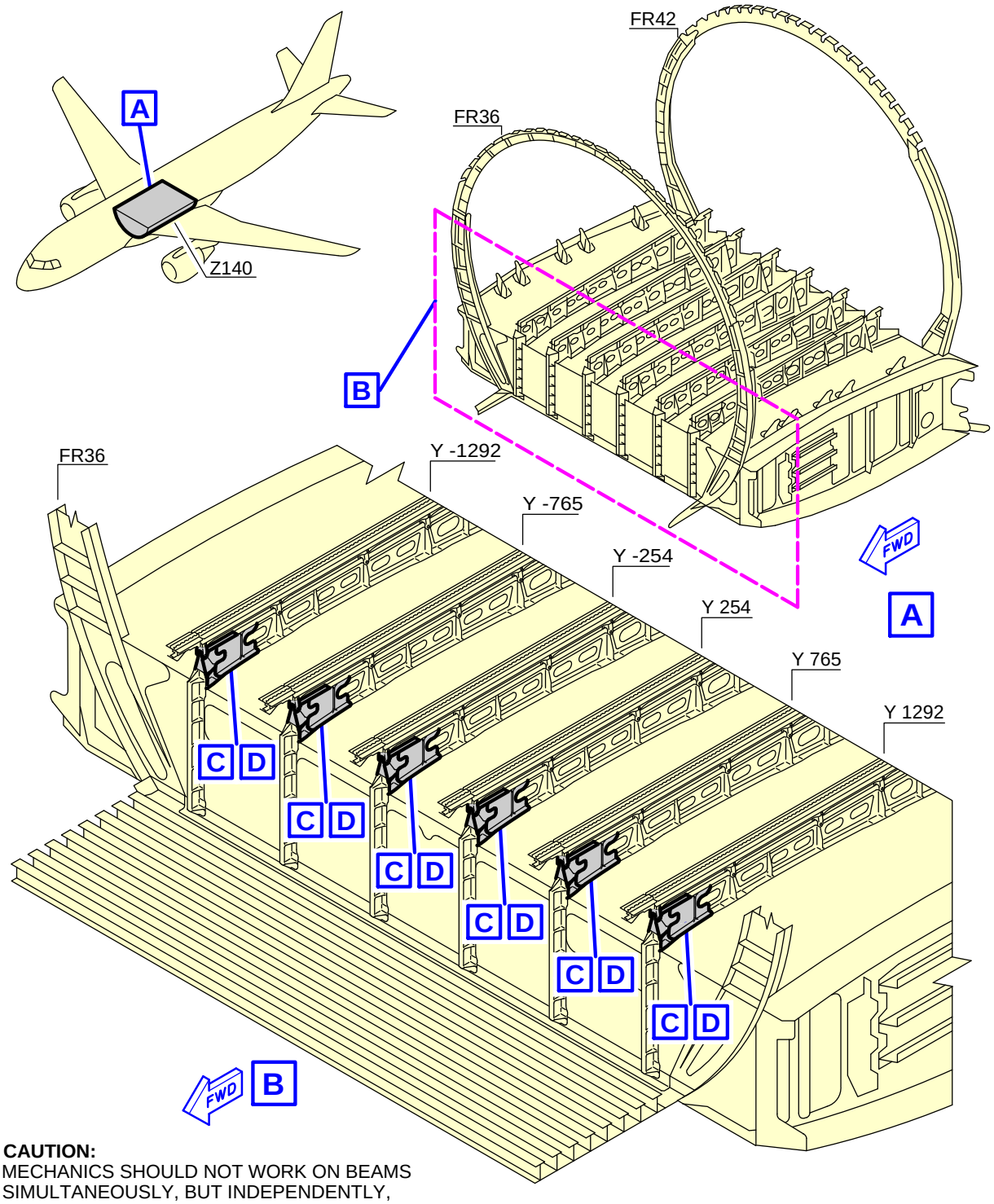
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

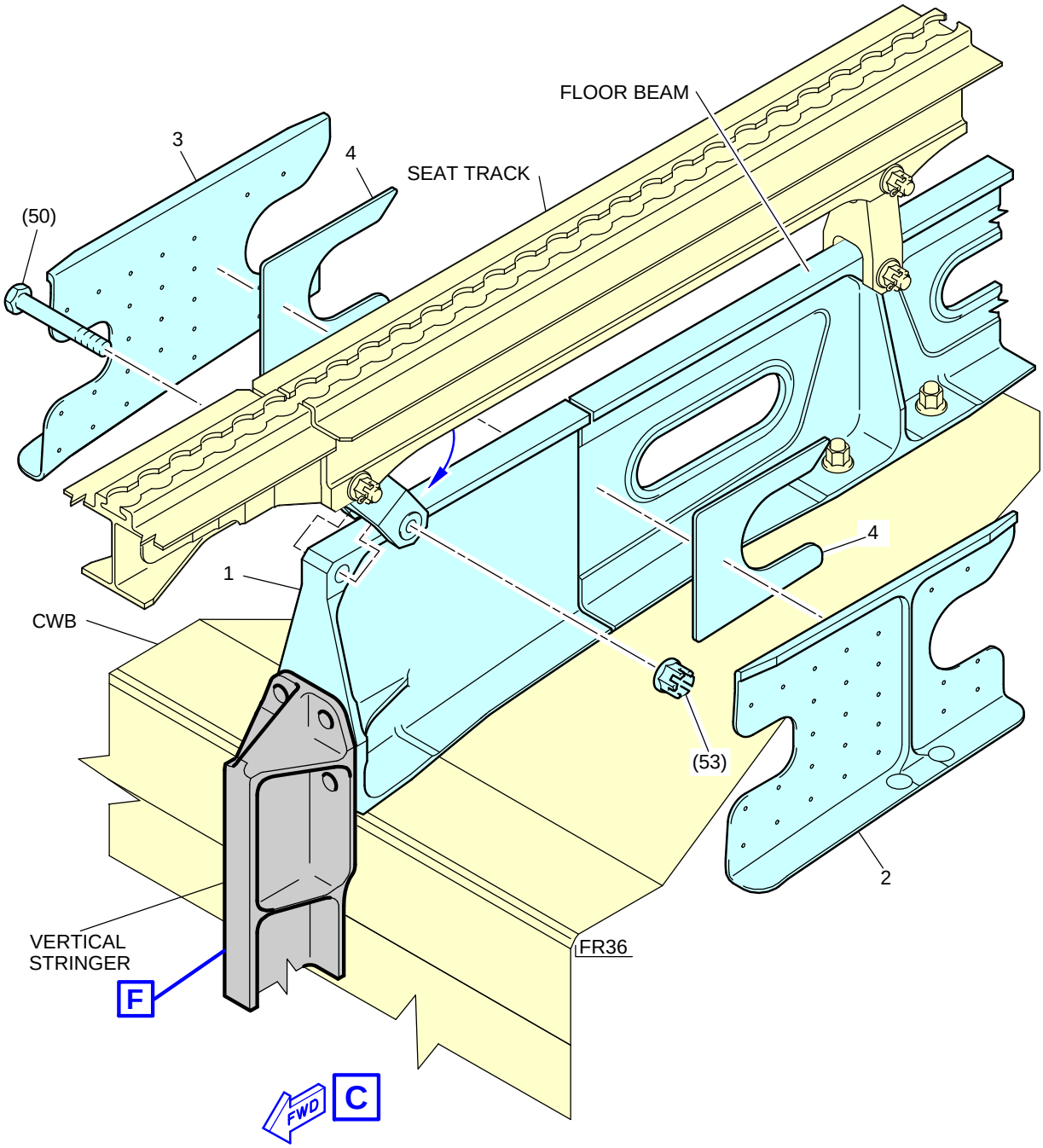


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

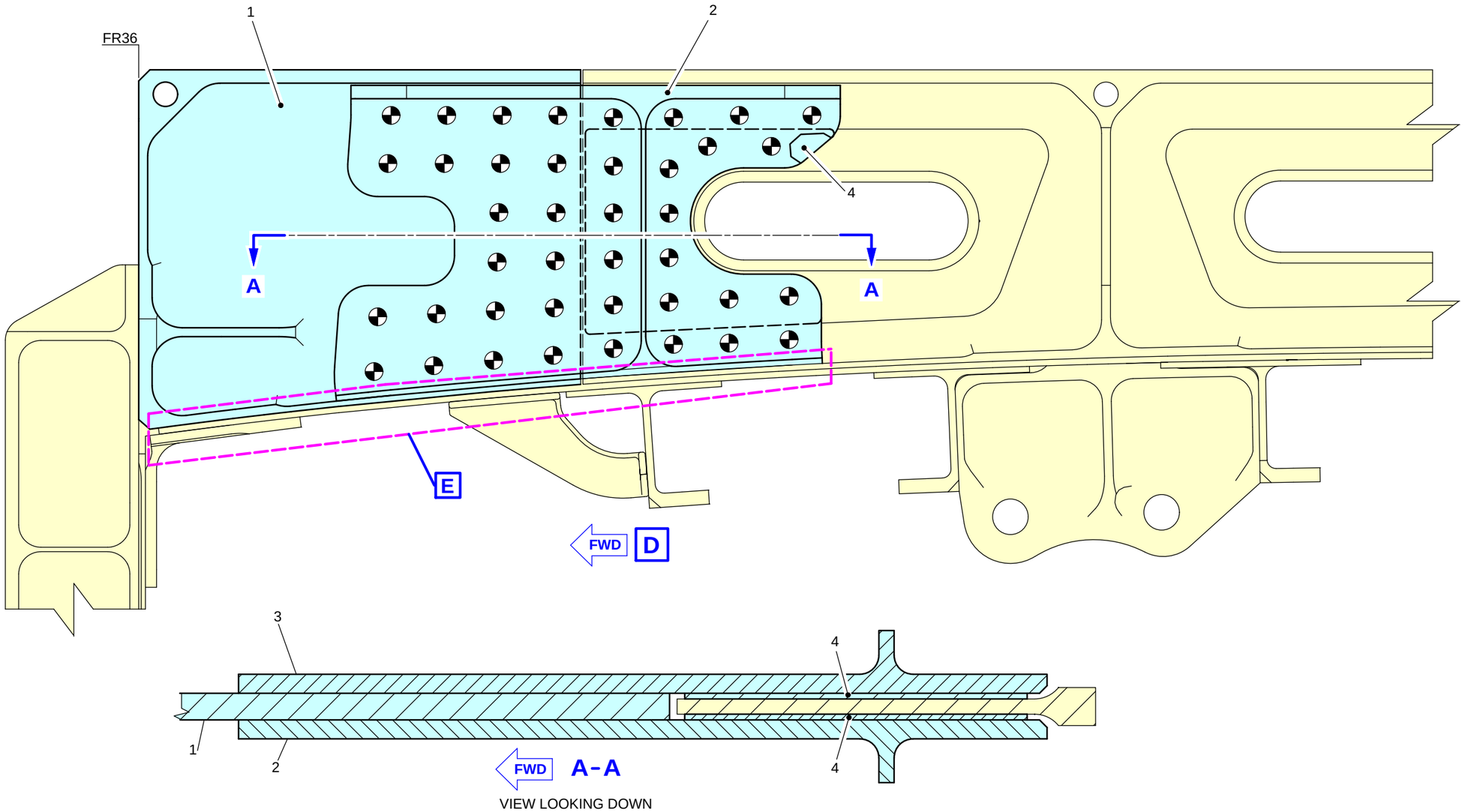
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ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

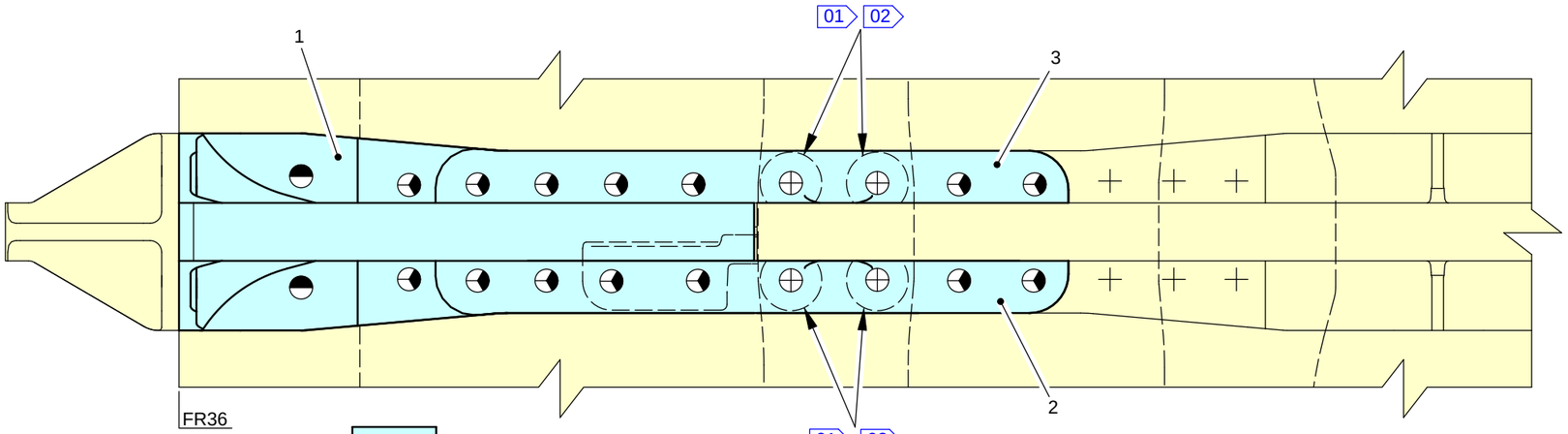


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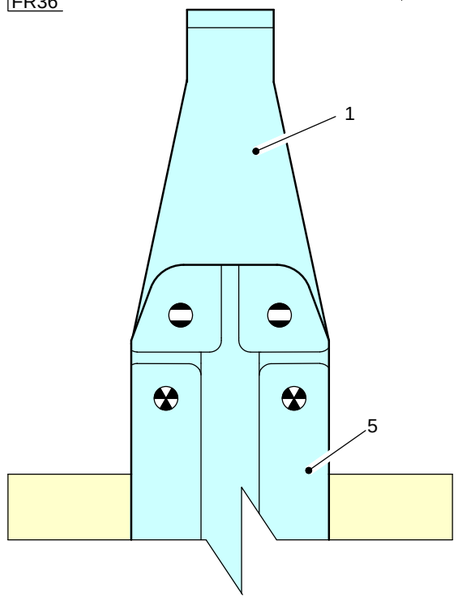
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(41) Task A320-A-57-XX-1228-16001-720A-A - Install the New Parts on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

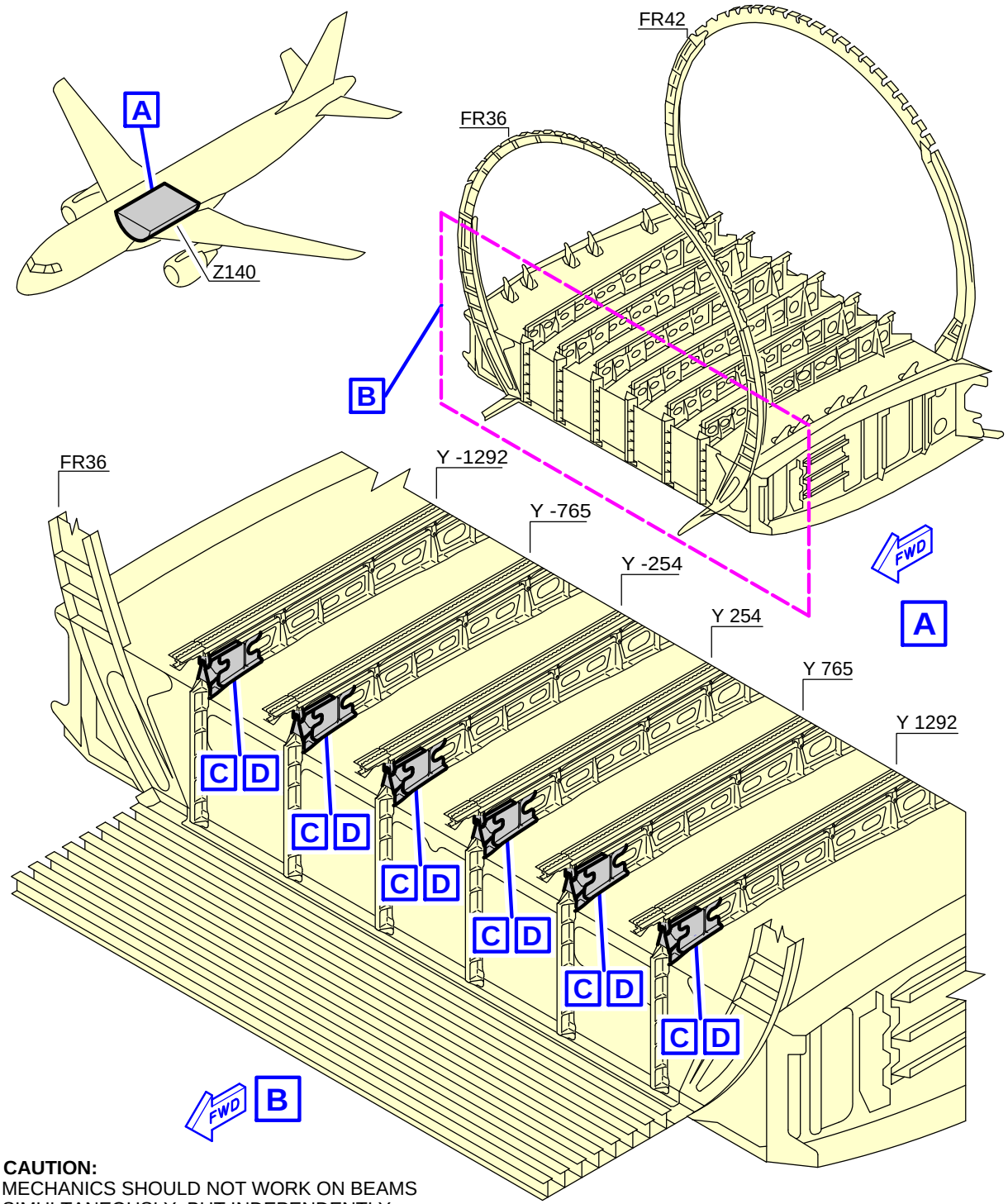
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

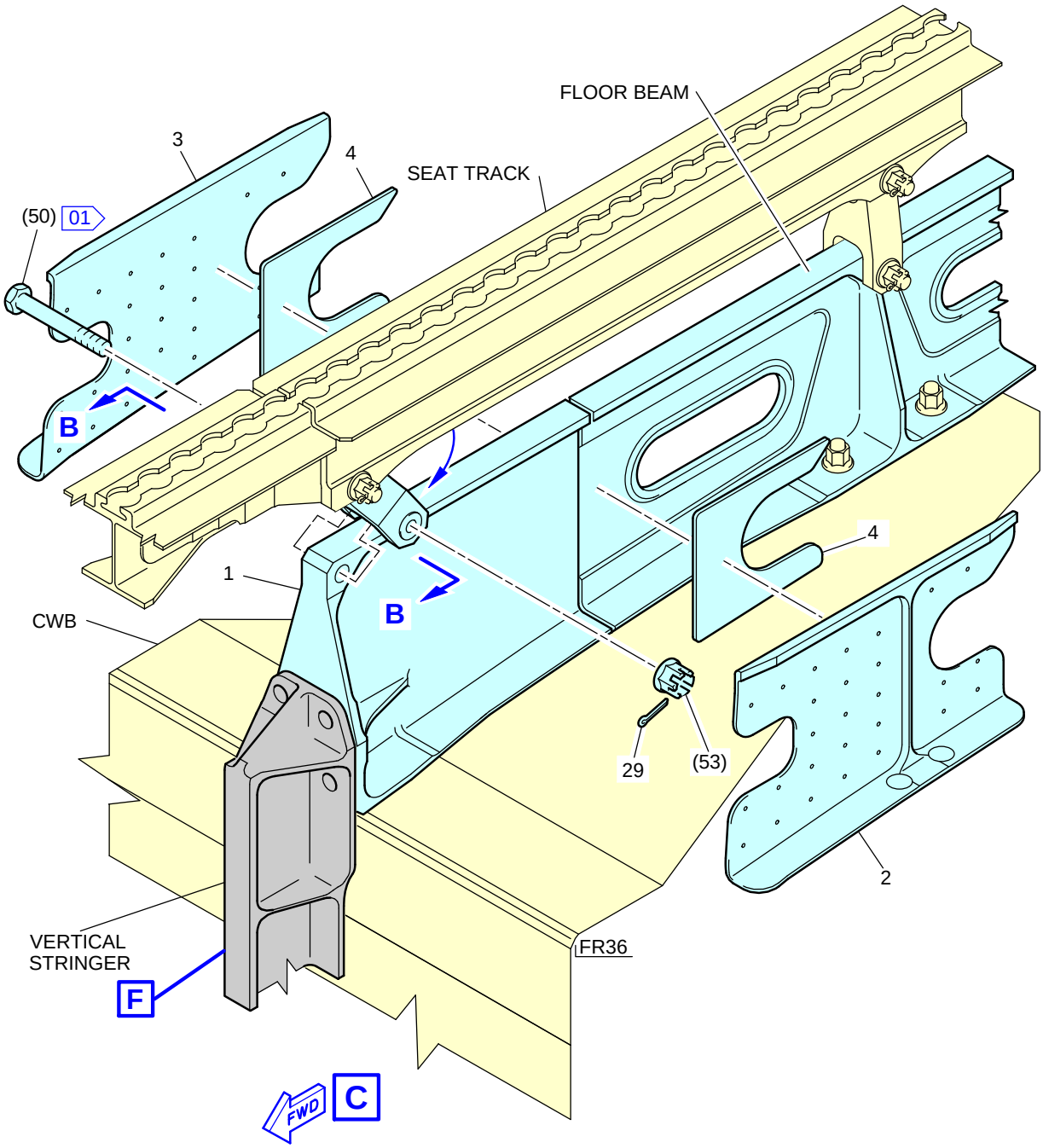


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



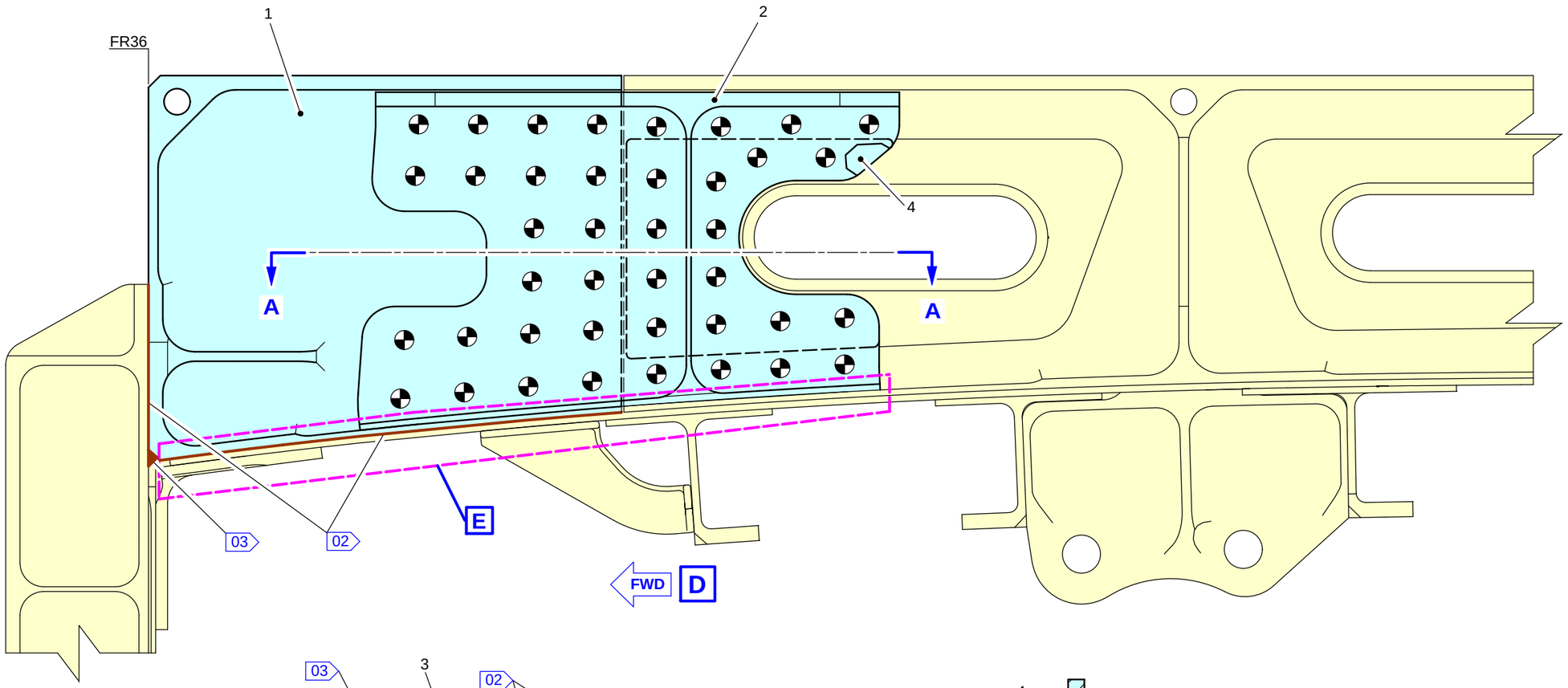
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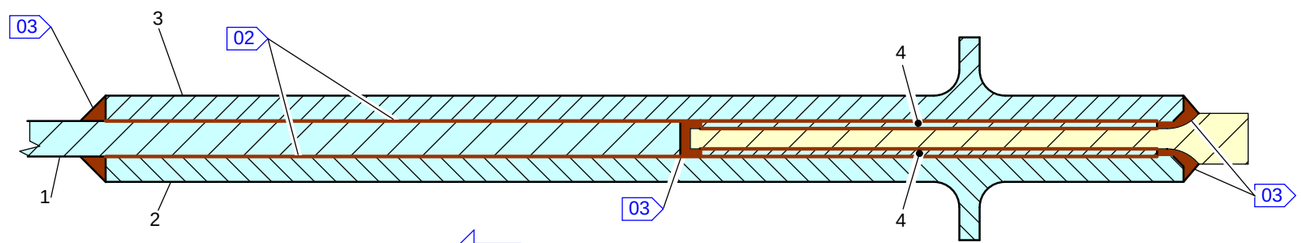
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

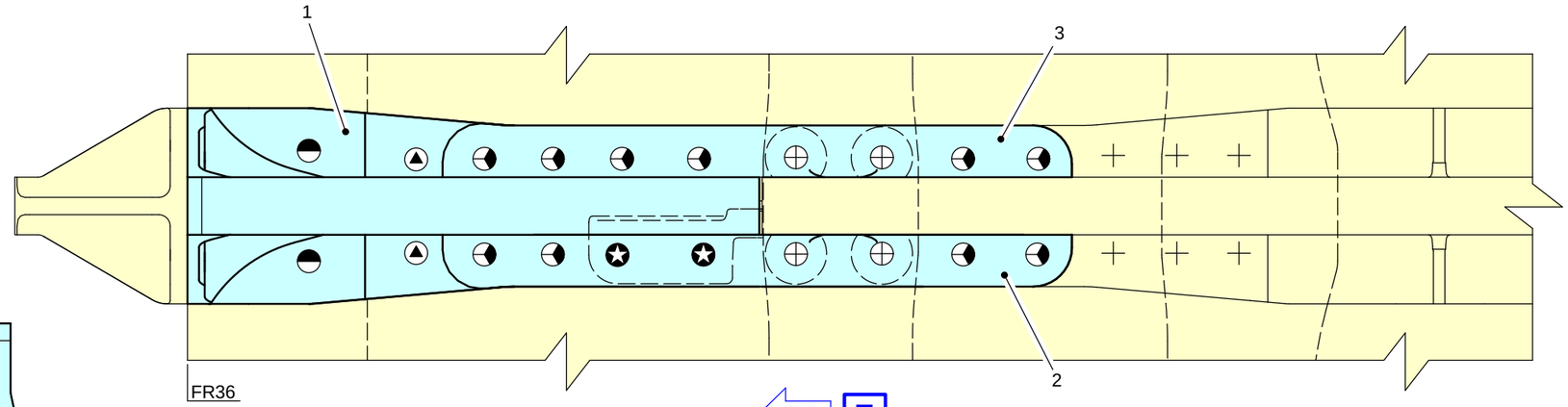
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

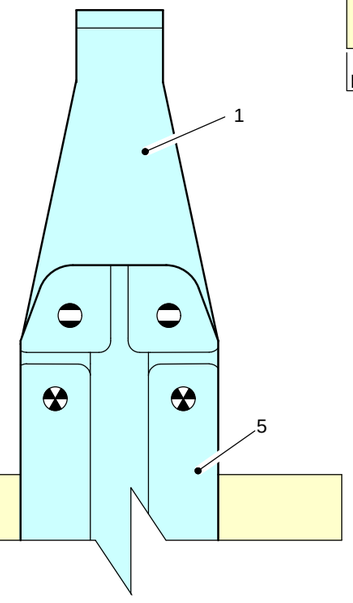
ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

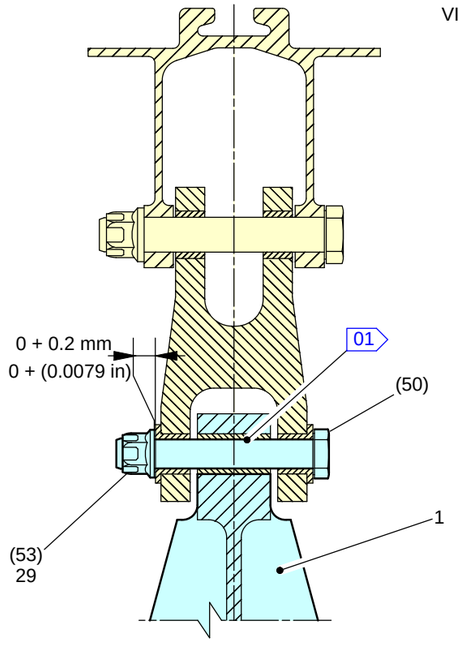
CONF 001 003 004





F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD



VIEW LOOKING DOWN

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 002

(41) Task A320-A-57-XX-1228-16002-720A-A - Install the New Parts on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

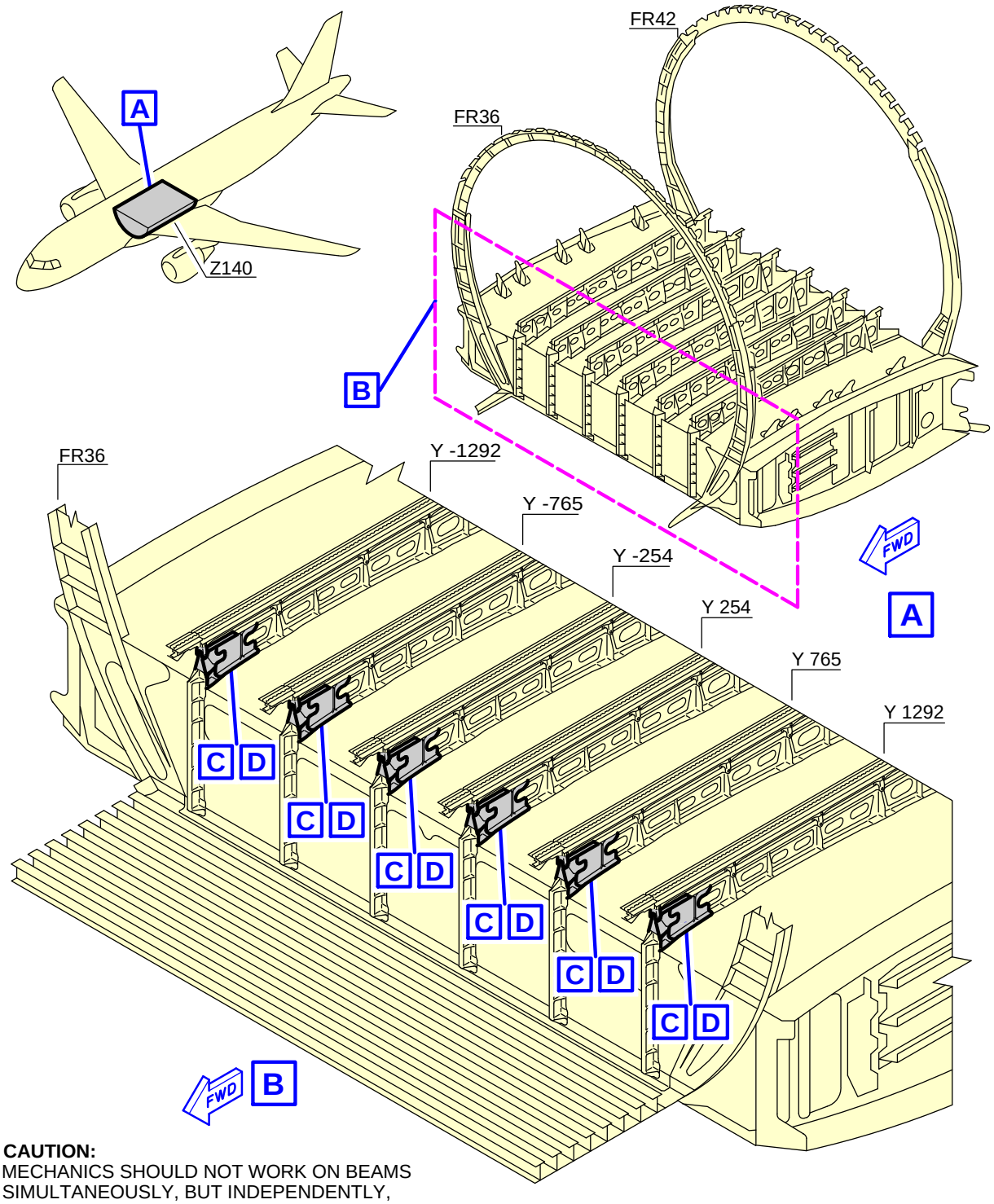
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

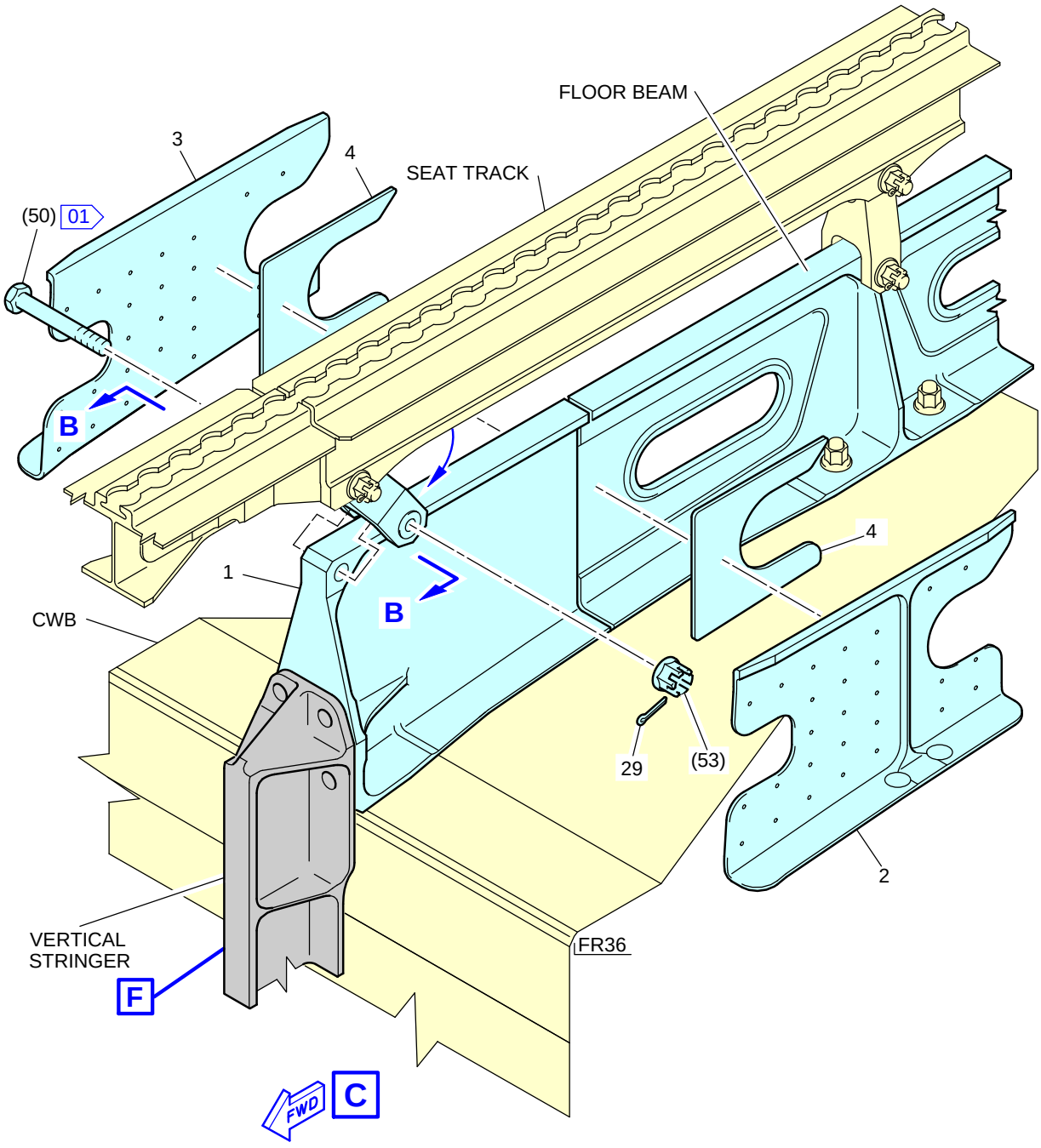


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



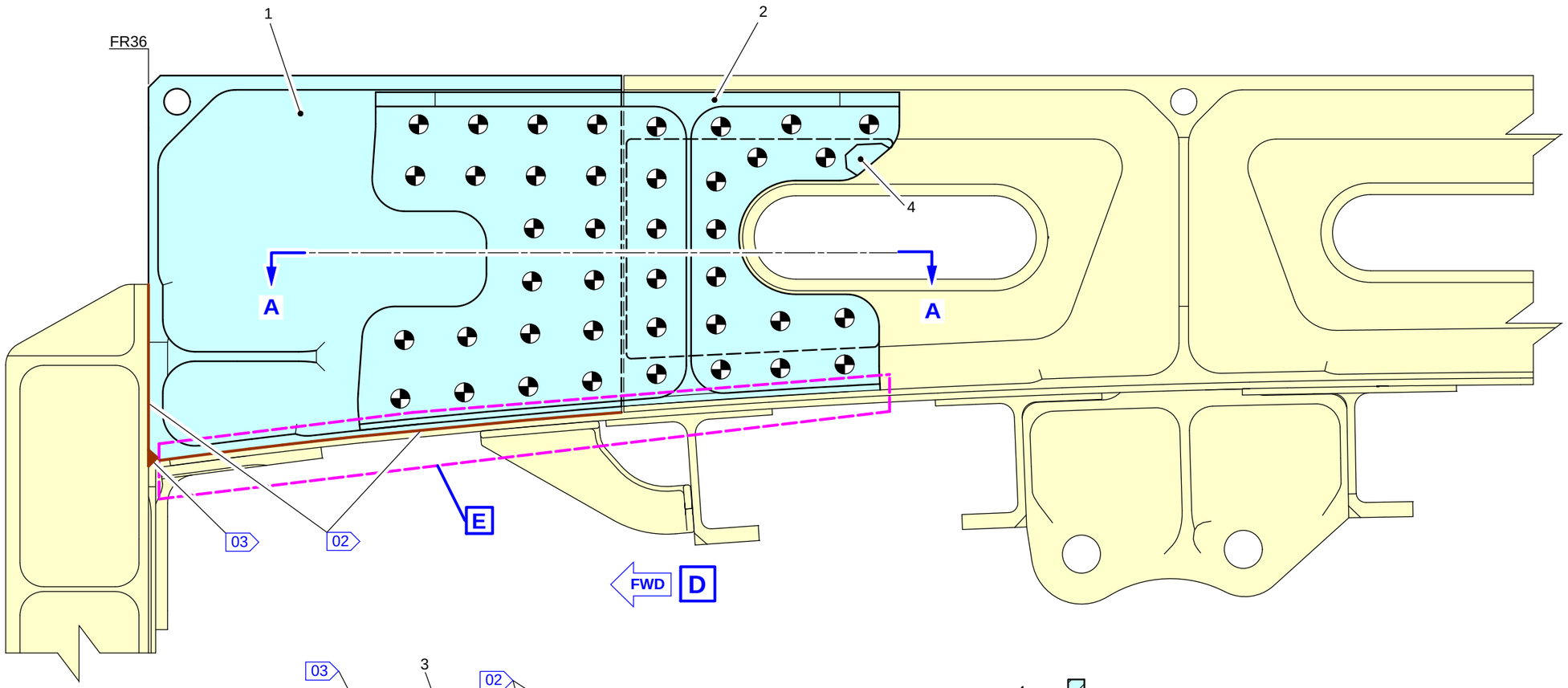
NOTE:

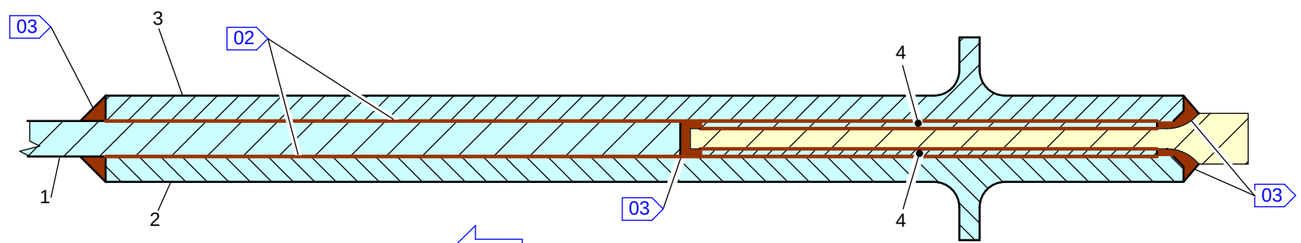
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

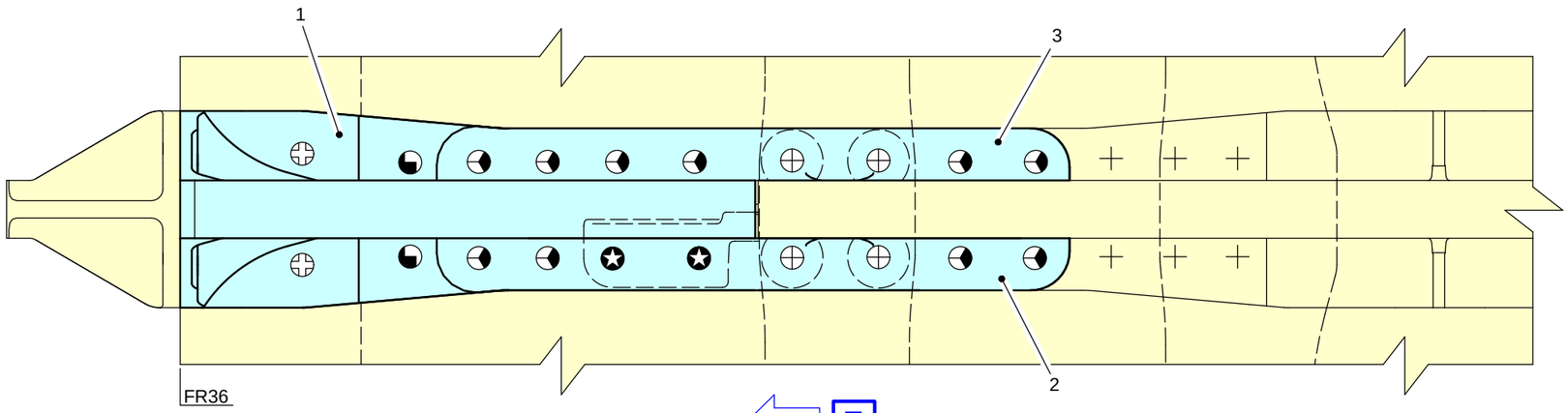
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

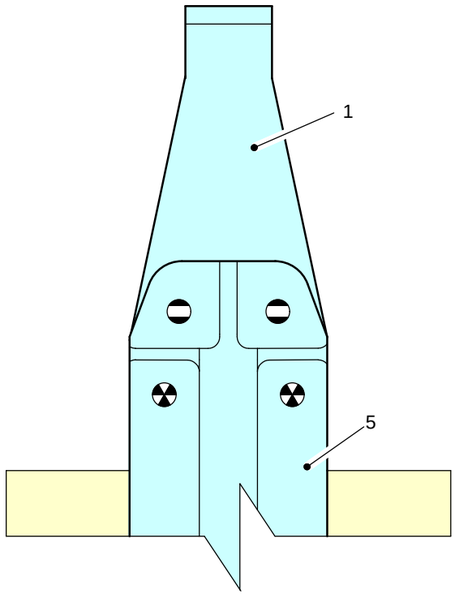
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

CONF 002

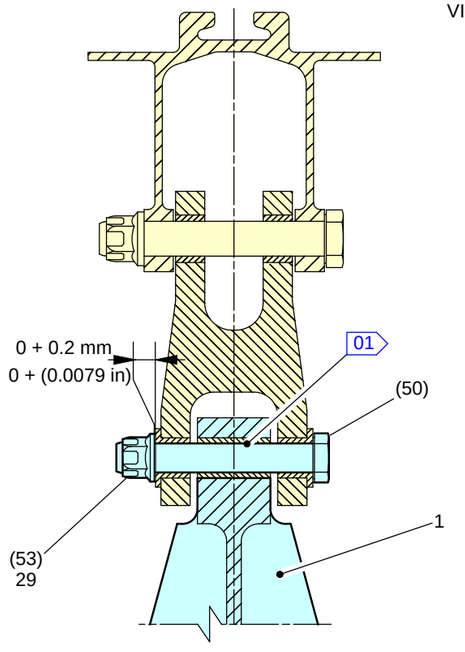


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(42) Task A320-A-57-XX-1228-03001-250A-A - Protect the Fasteners and the New Parts on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

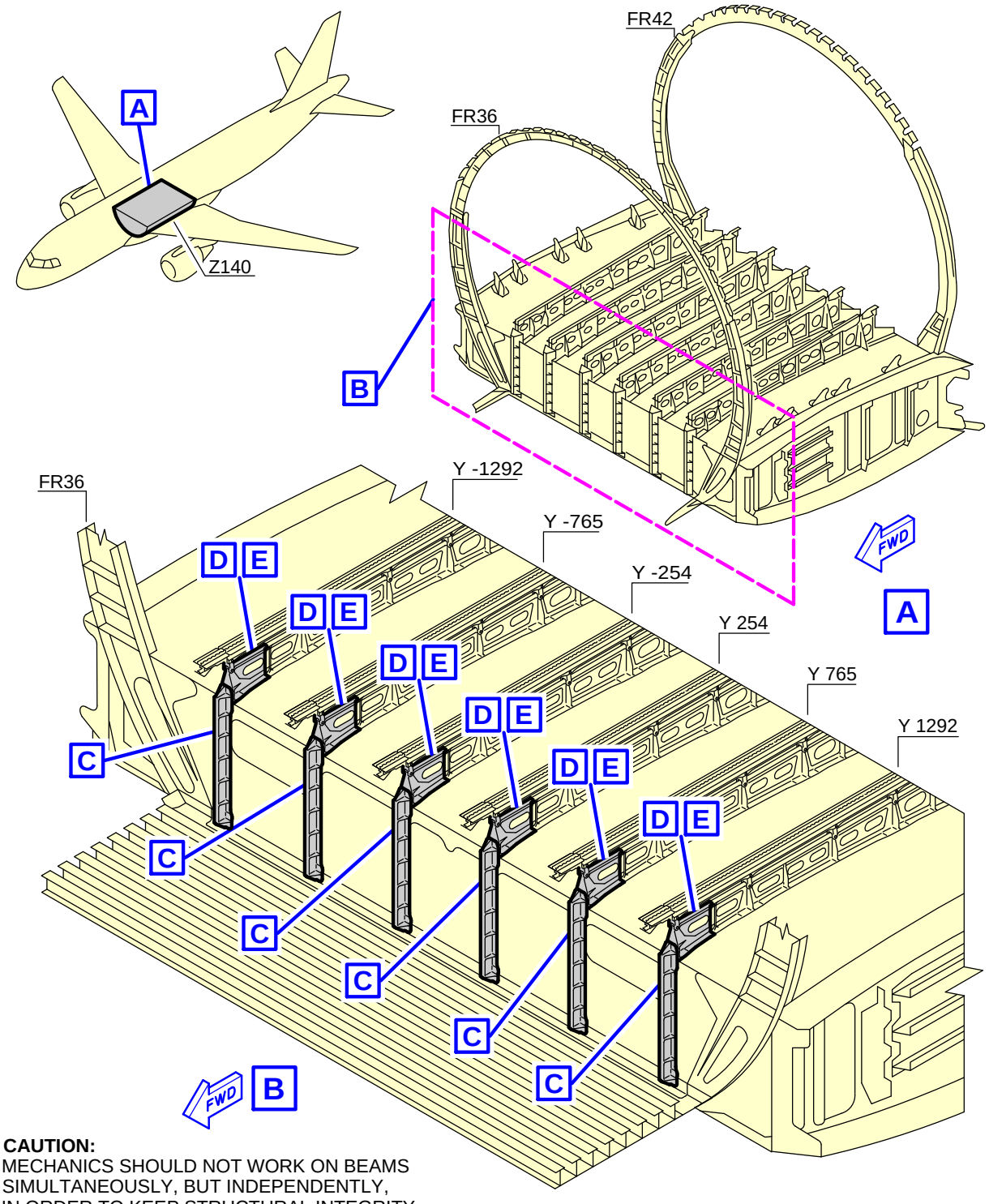
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

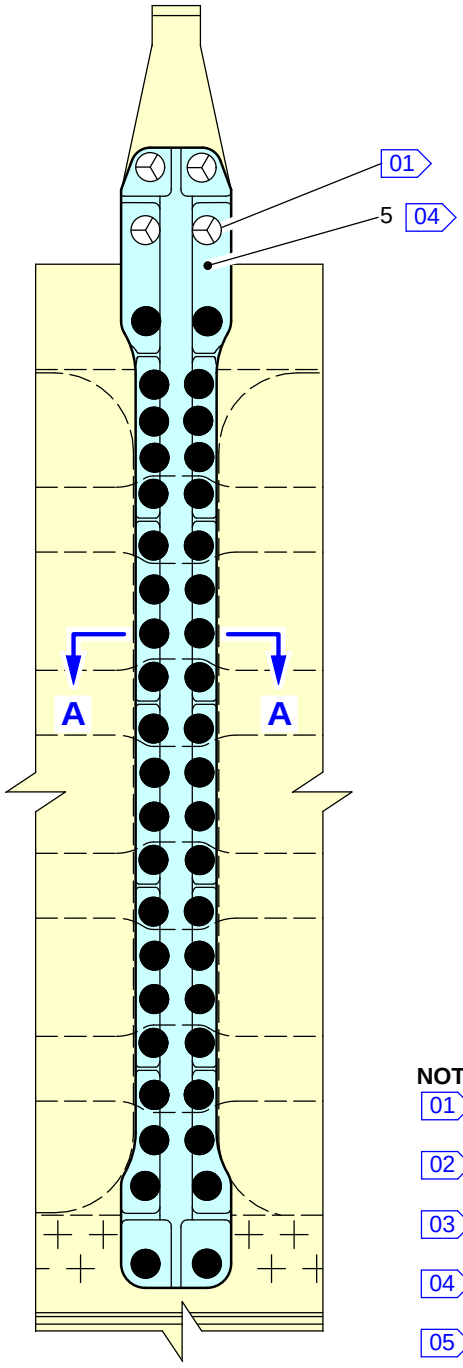


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

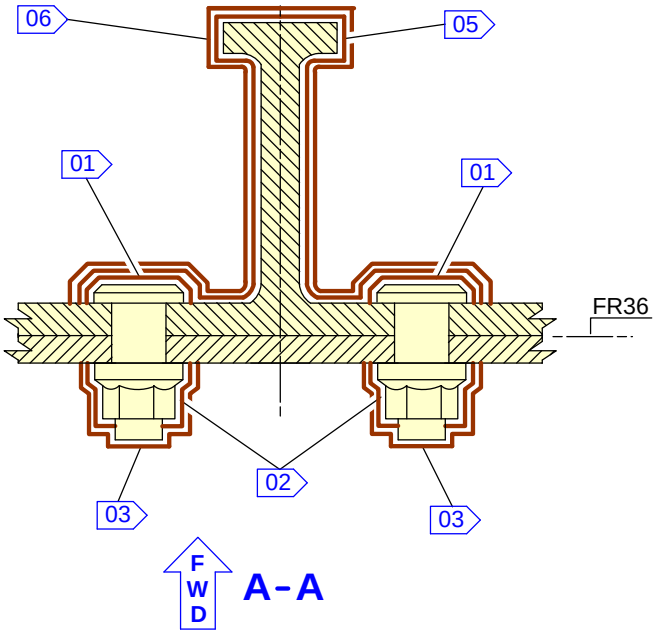
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊘	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

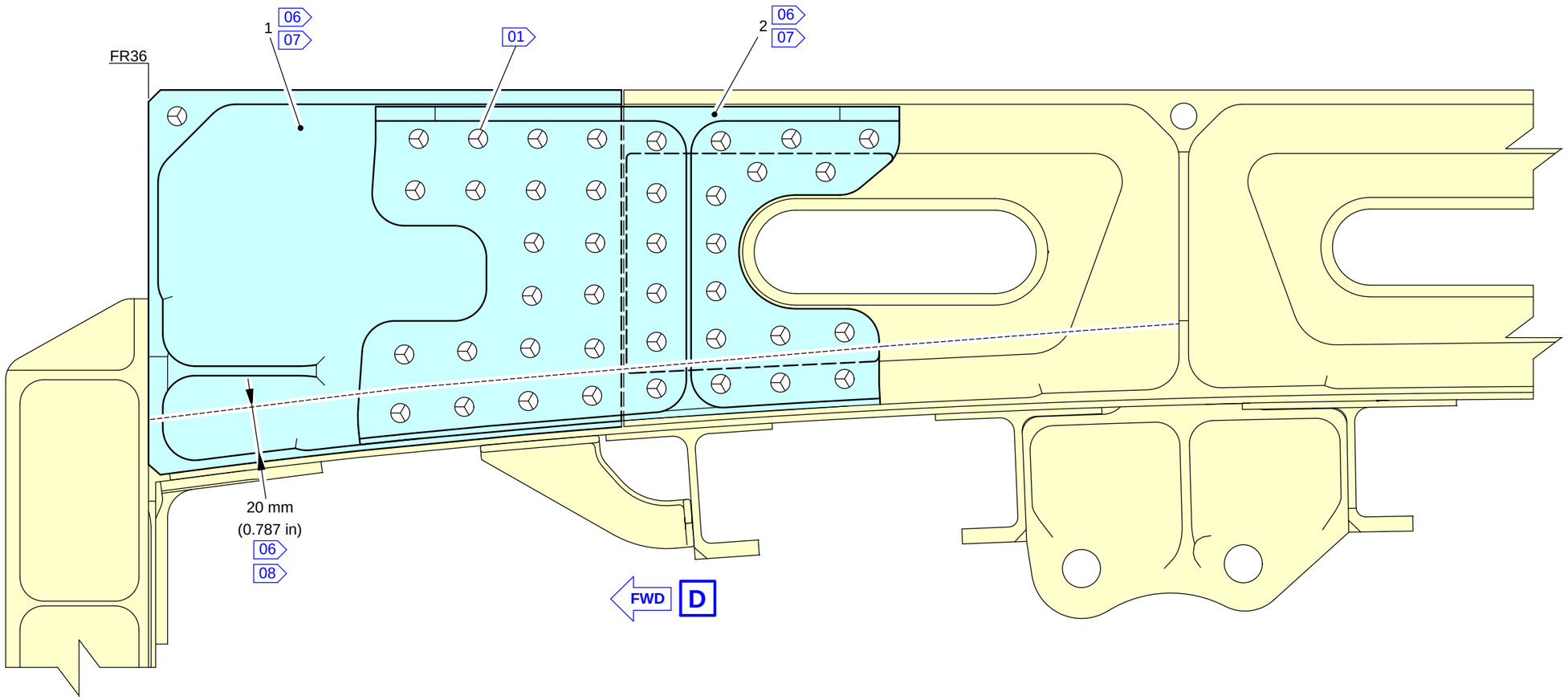
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

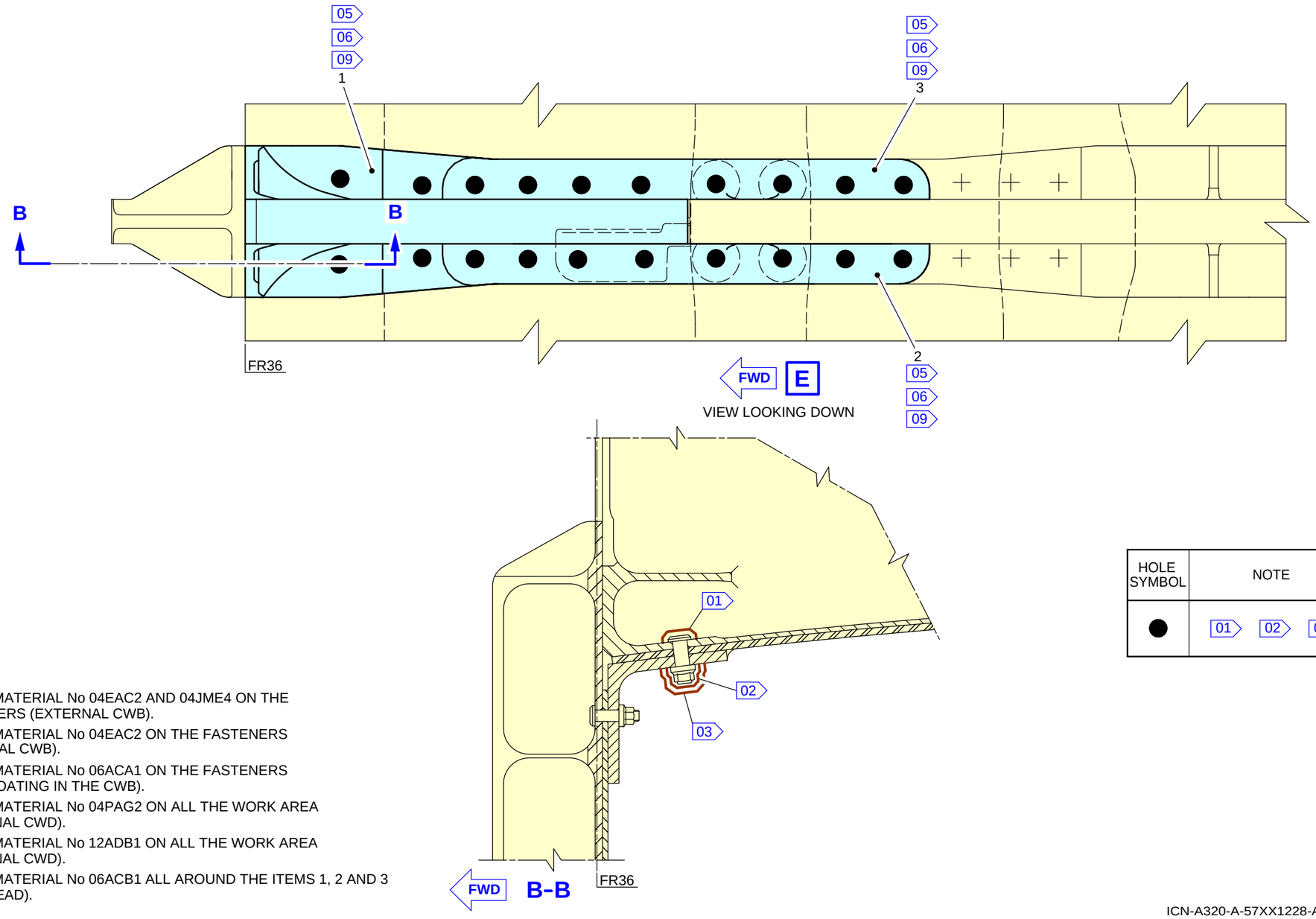
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(42) Task A320-A-57-XX-1228-03002-250A-A - Protect the Fasteners and the New Parts on Y254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

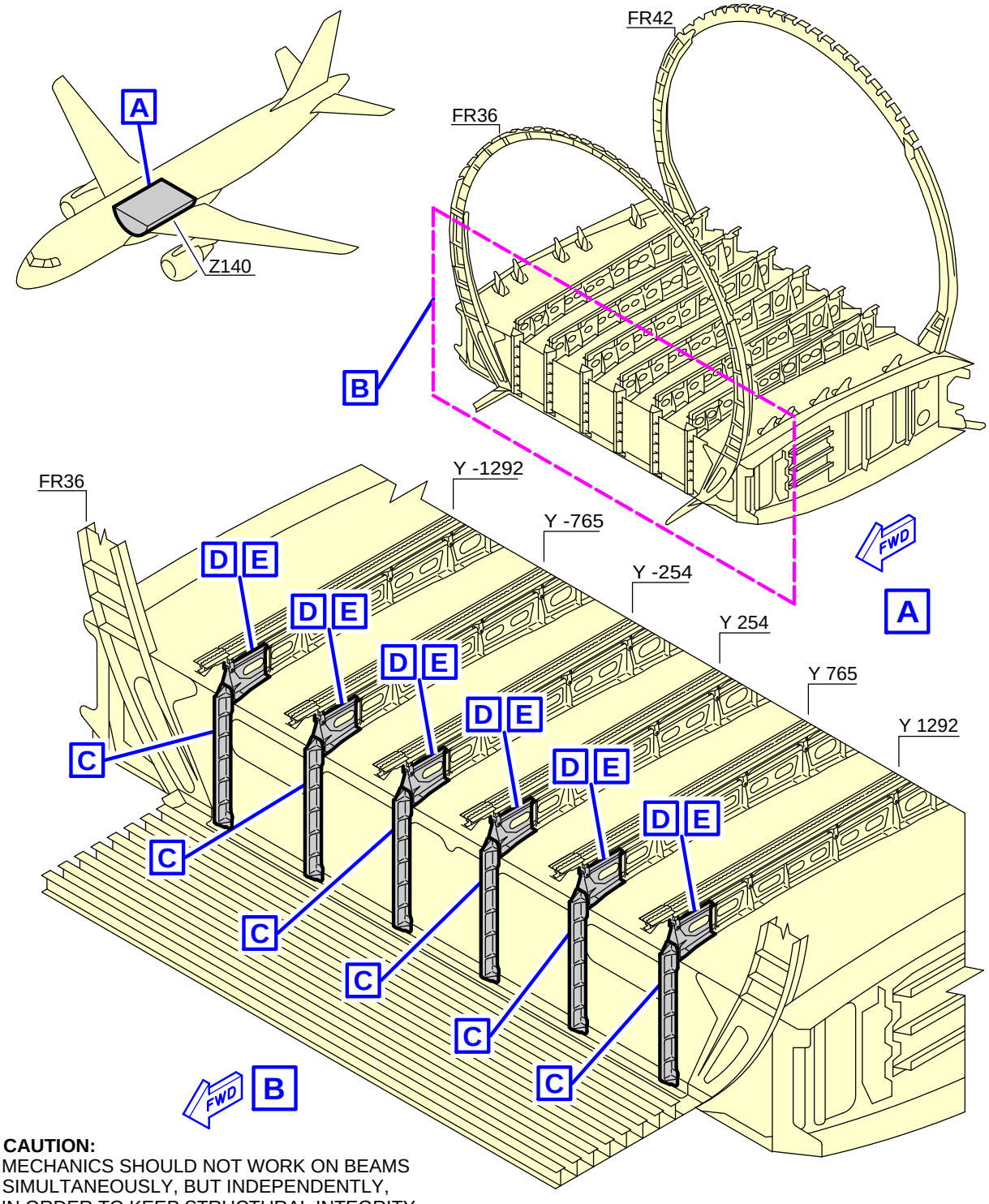
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

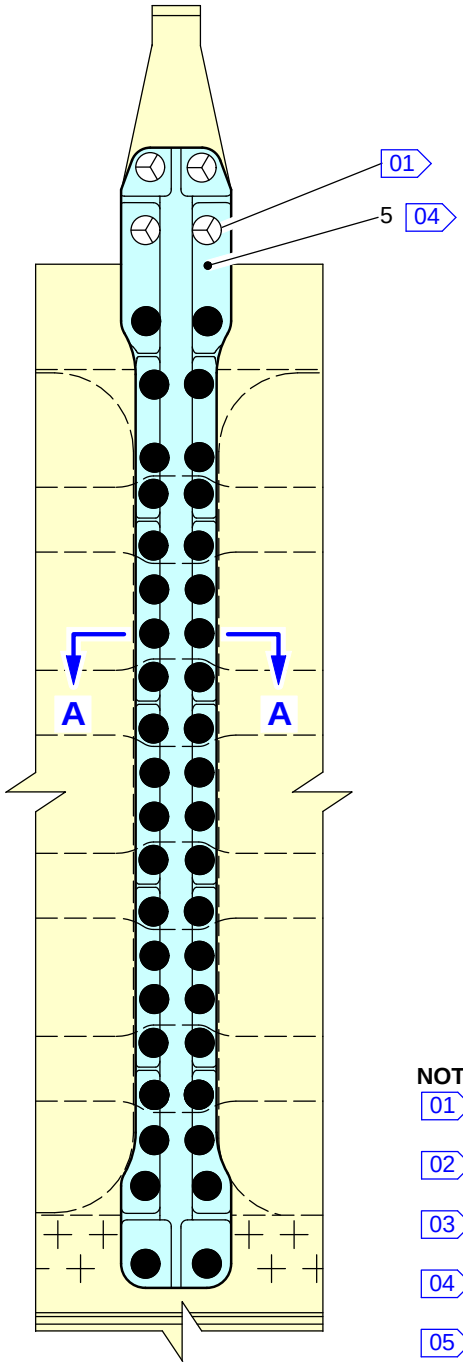


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

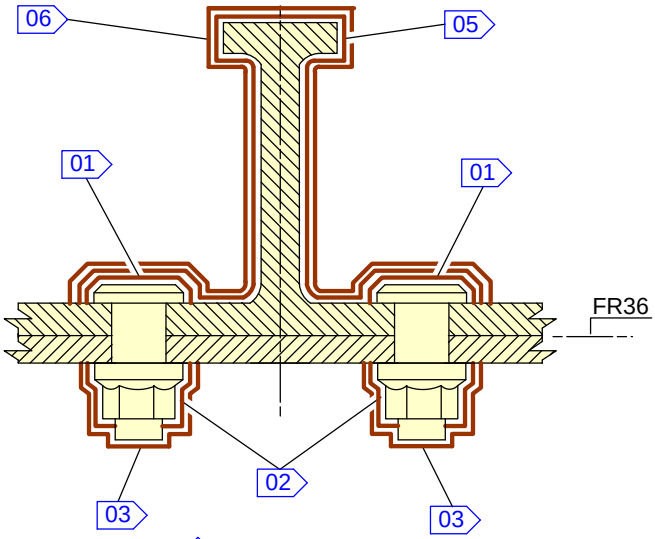
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

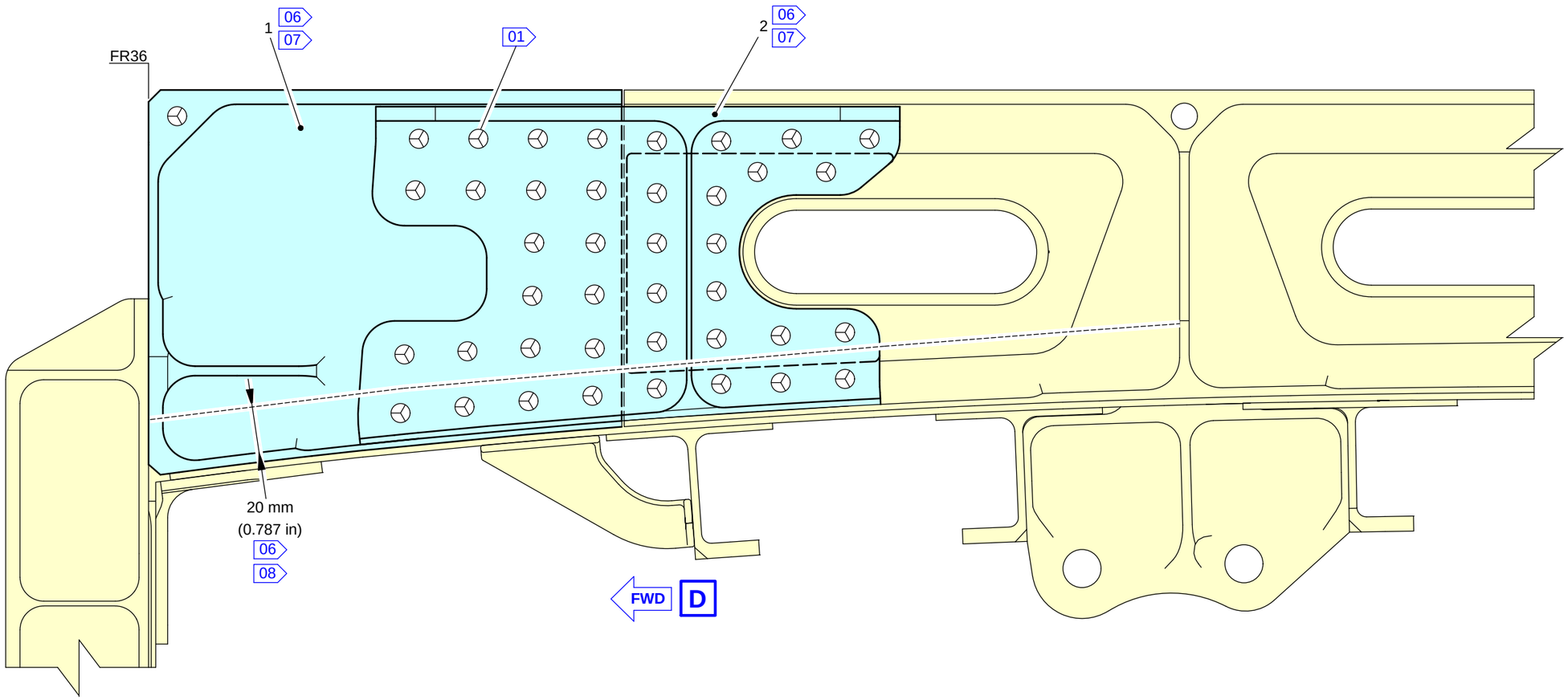
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



HOLE SYMBOL	NOTE
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

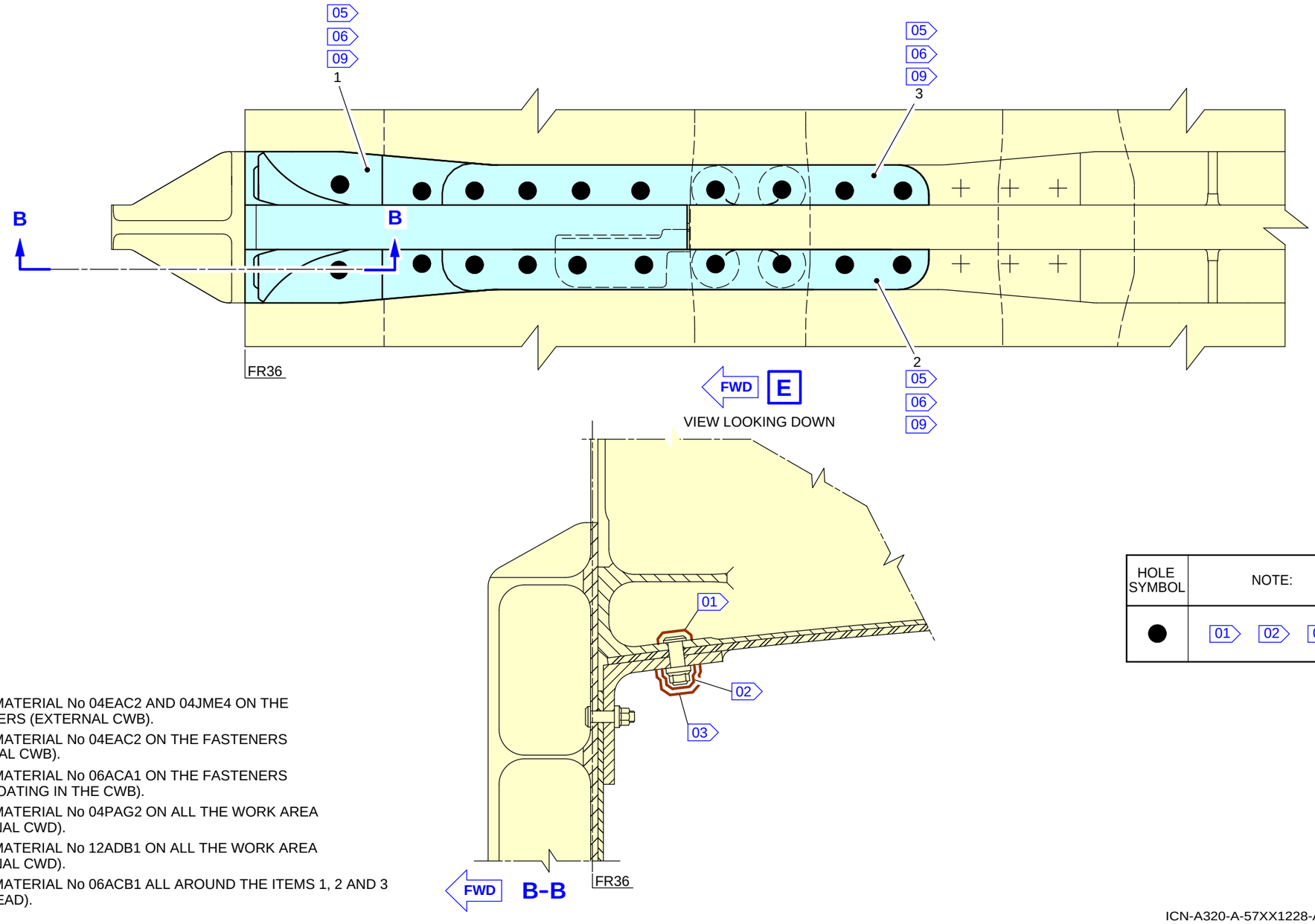
08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

(43) Task A320-A-57-XX-1228-13001-520A-A - Remove the Strut Lower Attachment on Y-254 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

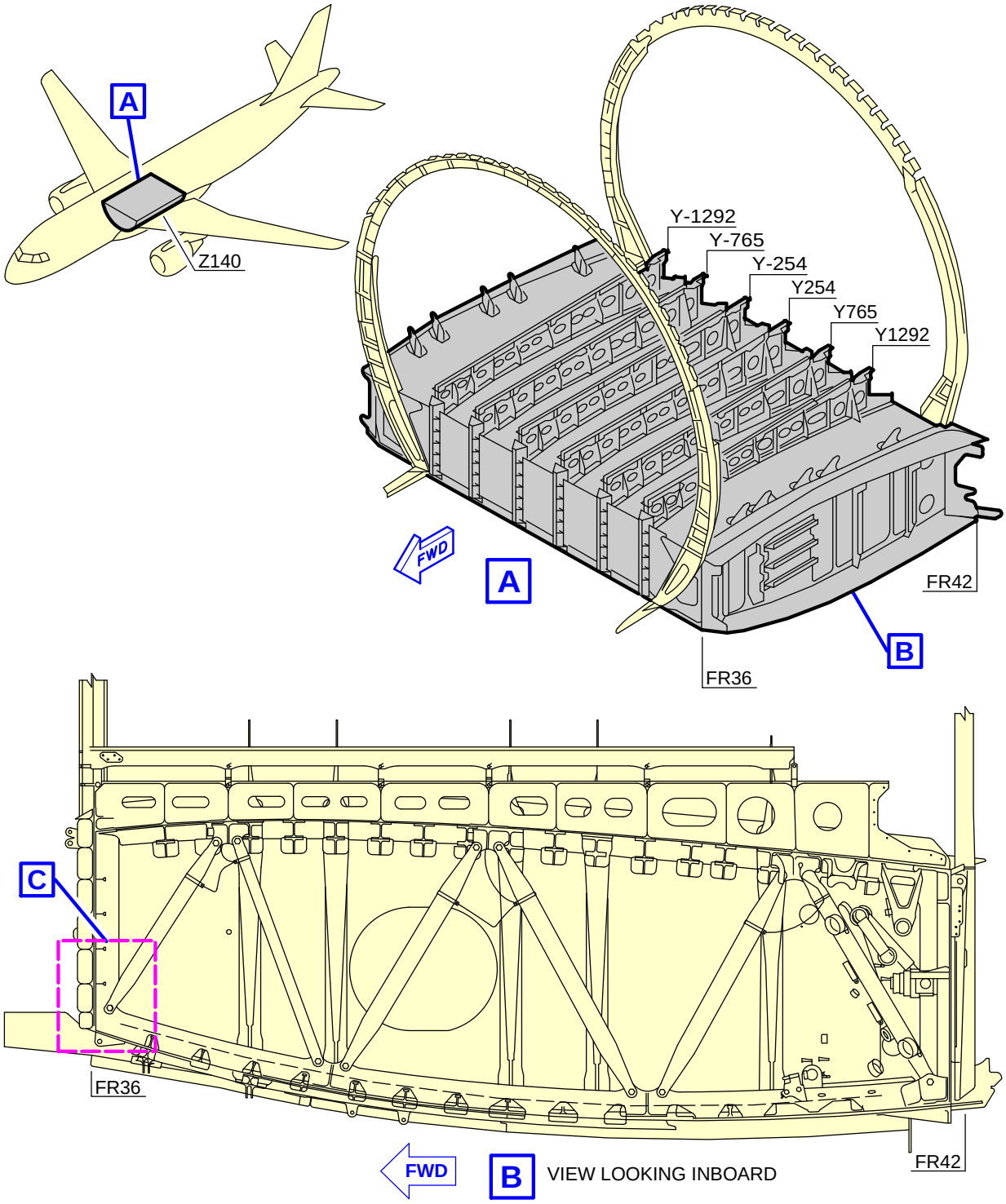
1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain

1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

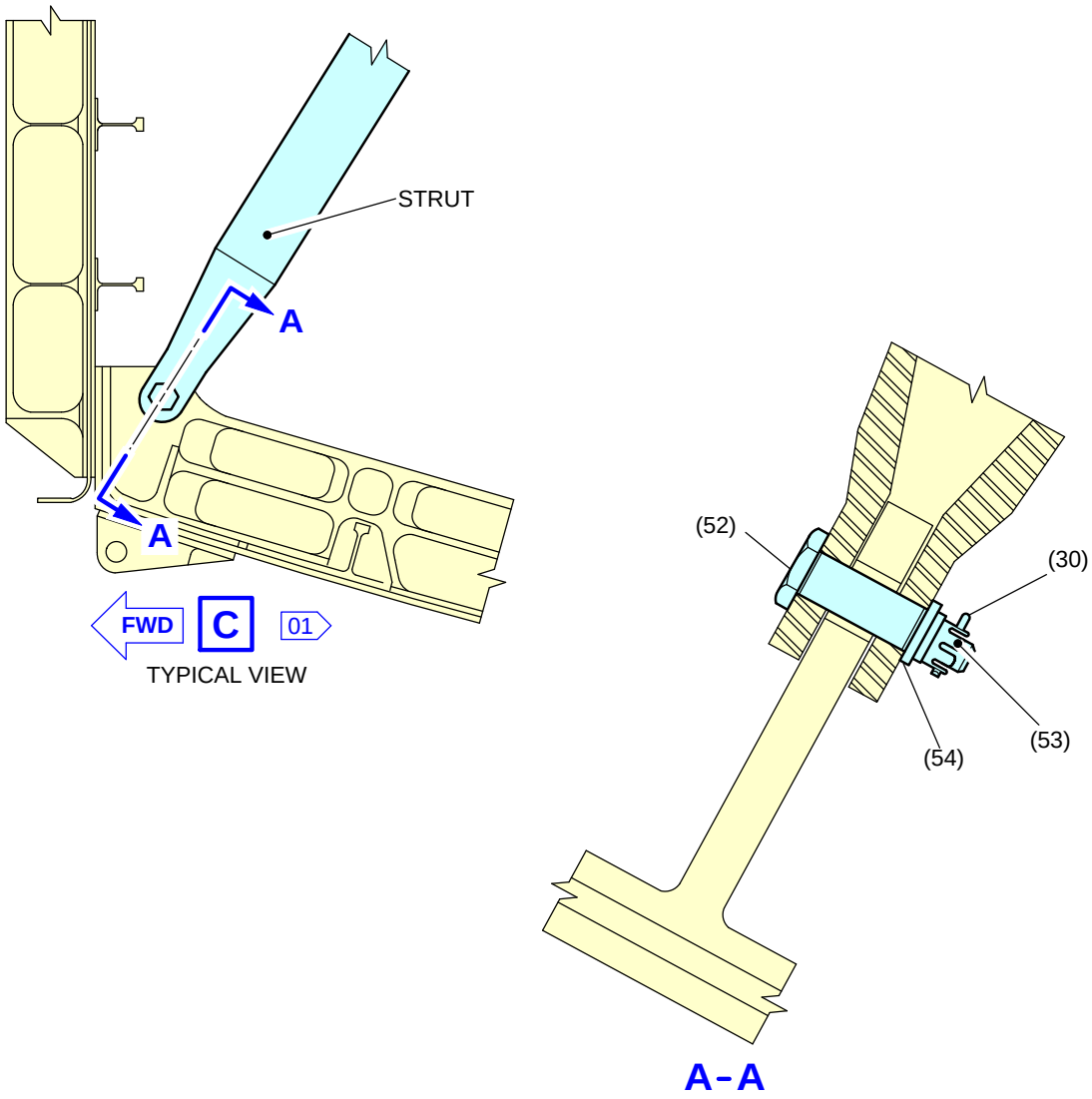
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(44) Task A320-A-57-XX-1228-14001-520A-A - Remove the Vertical Stringer on Y-254 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

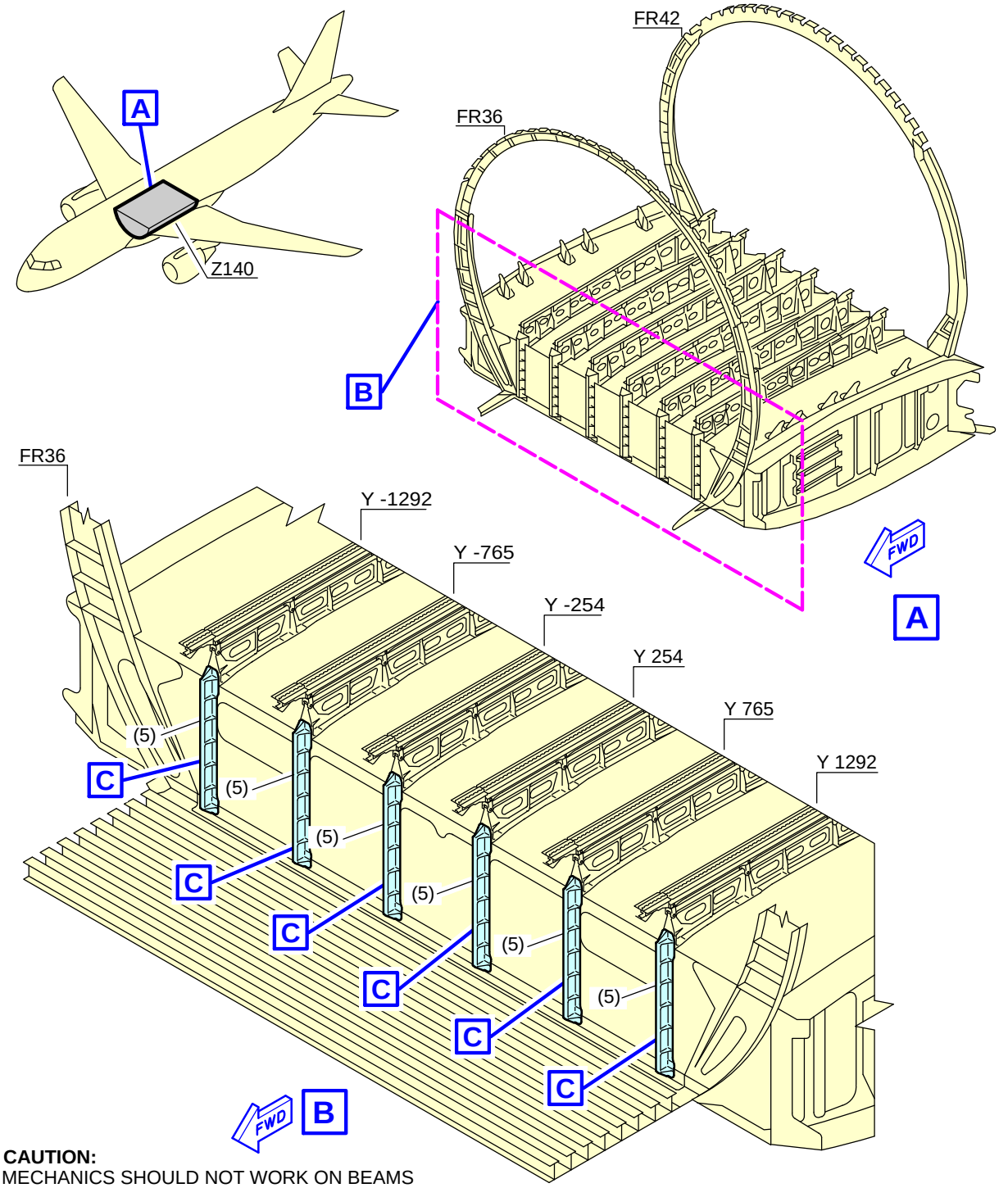
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-17ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

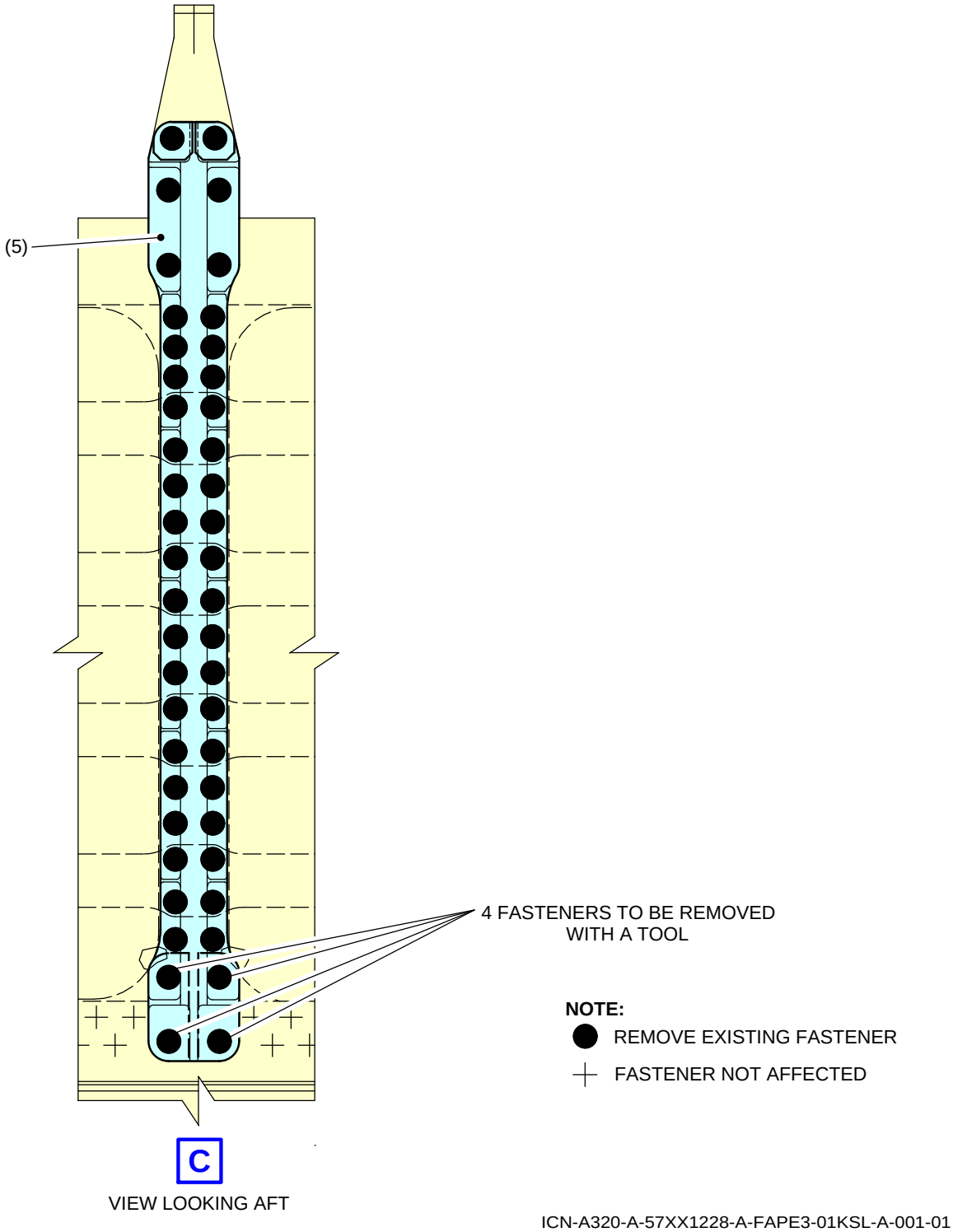


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

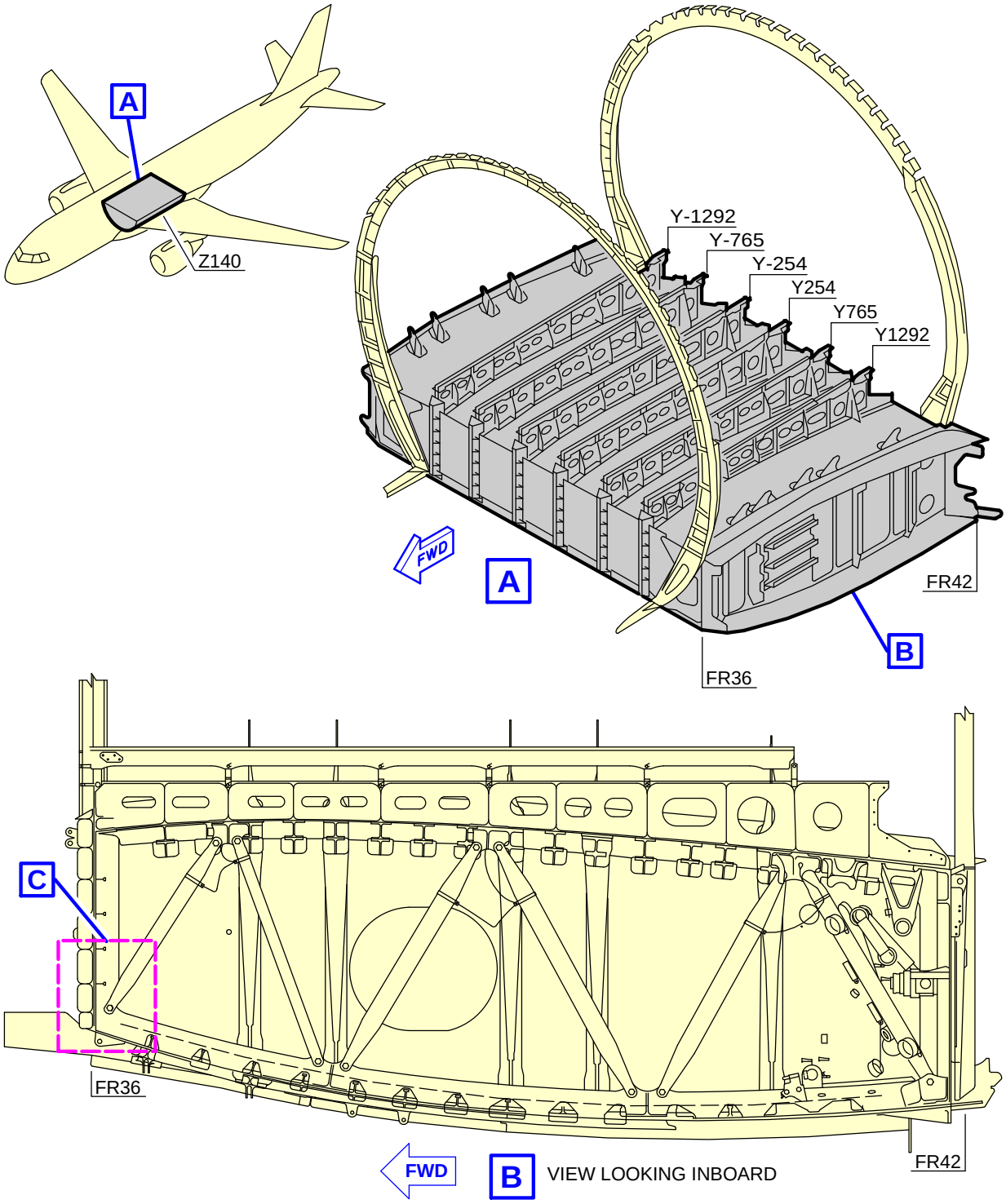
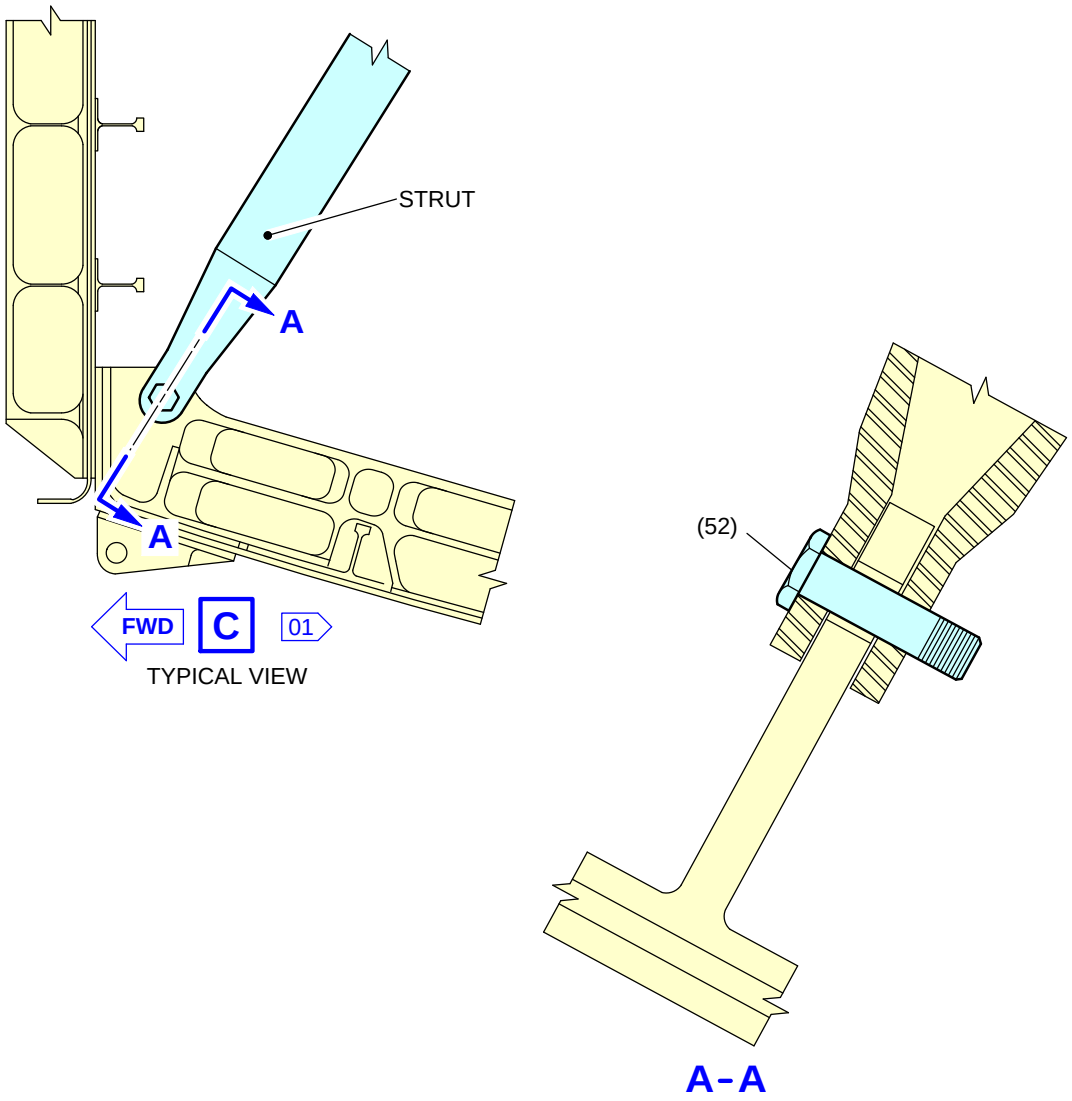


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(44) Task A320-A-57-XX-1228-14002-520A-A - Remove the Vertical Stringer on Y-254 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

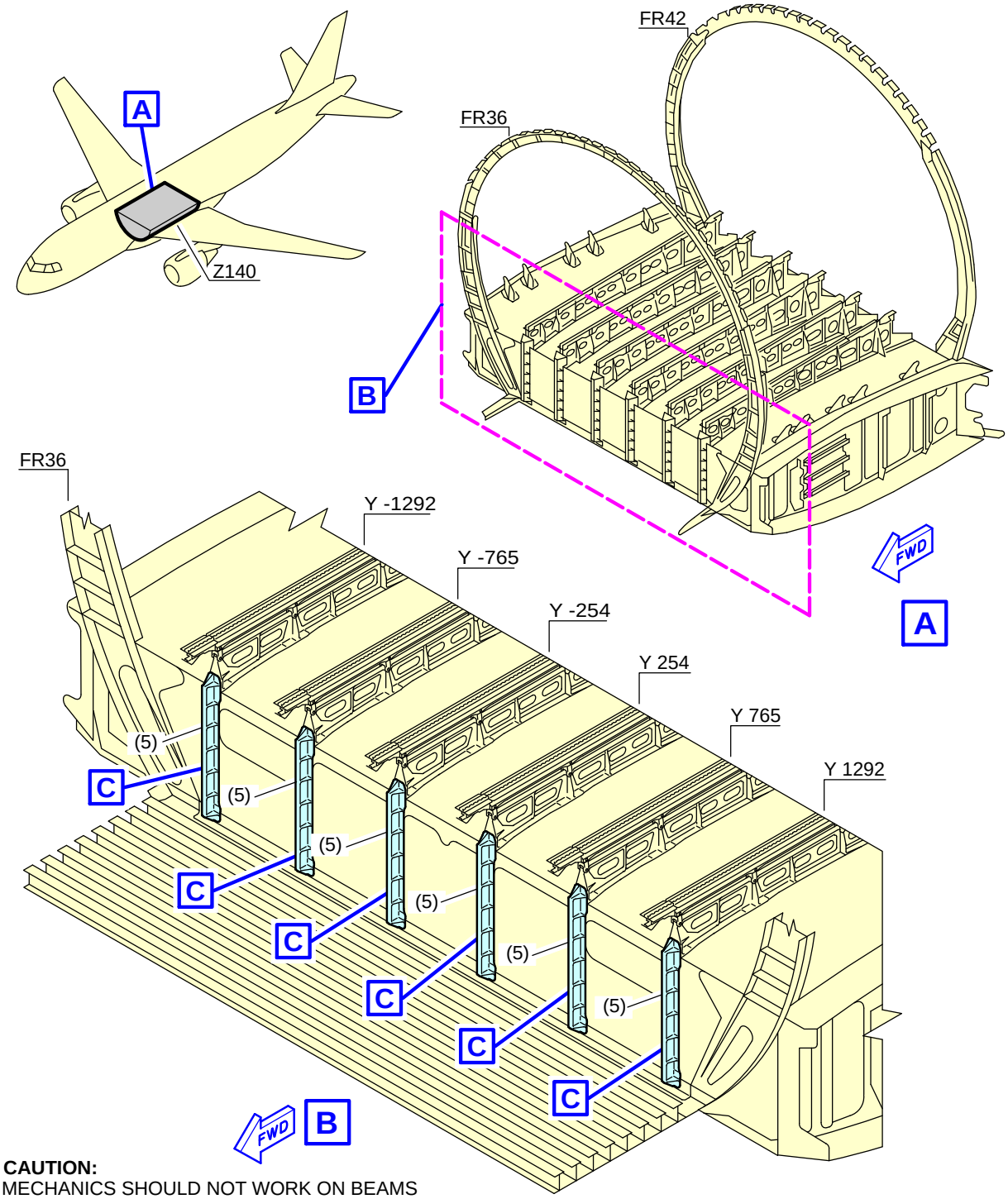
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-17ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

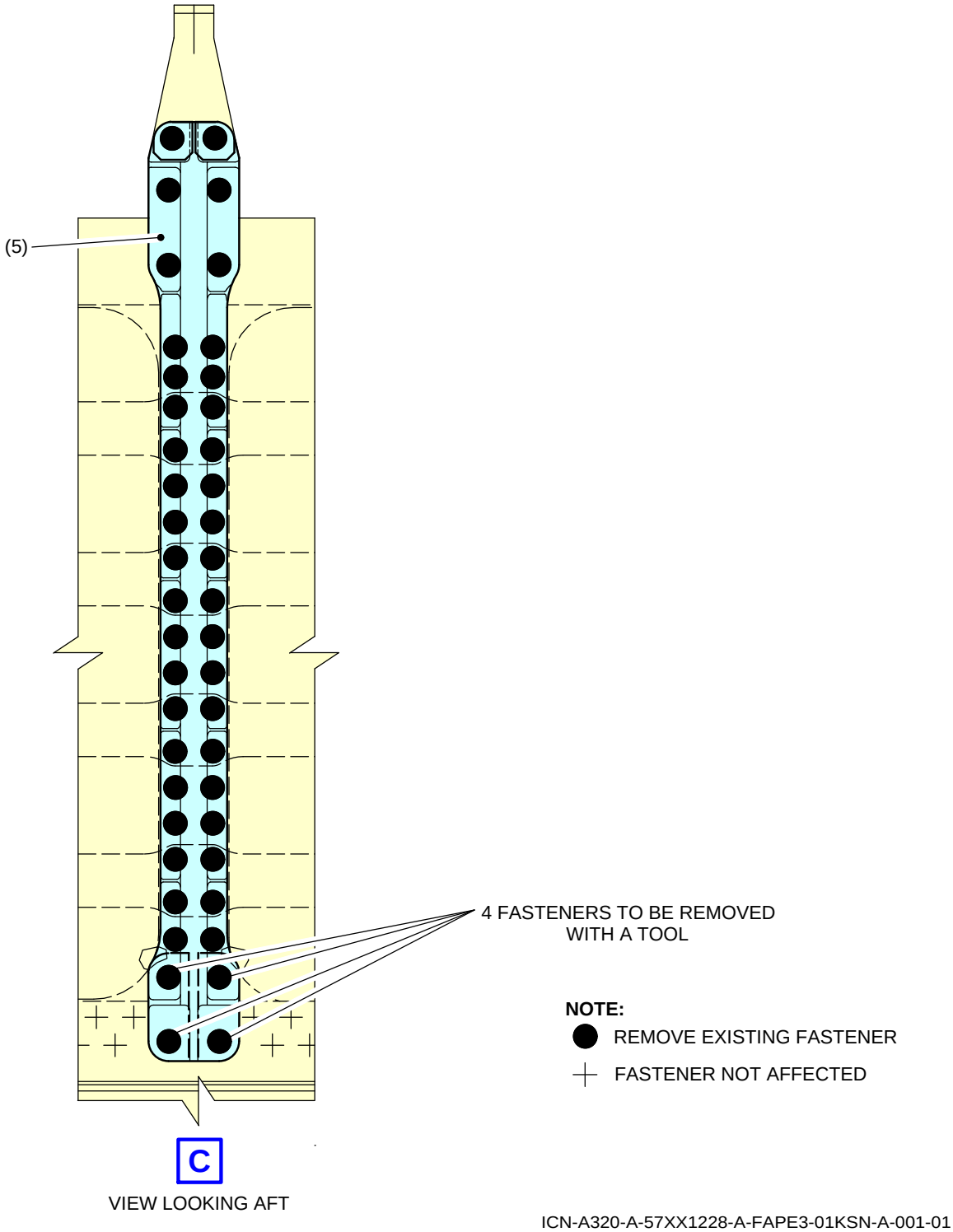


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

CONF 002

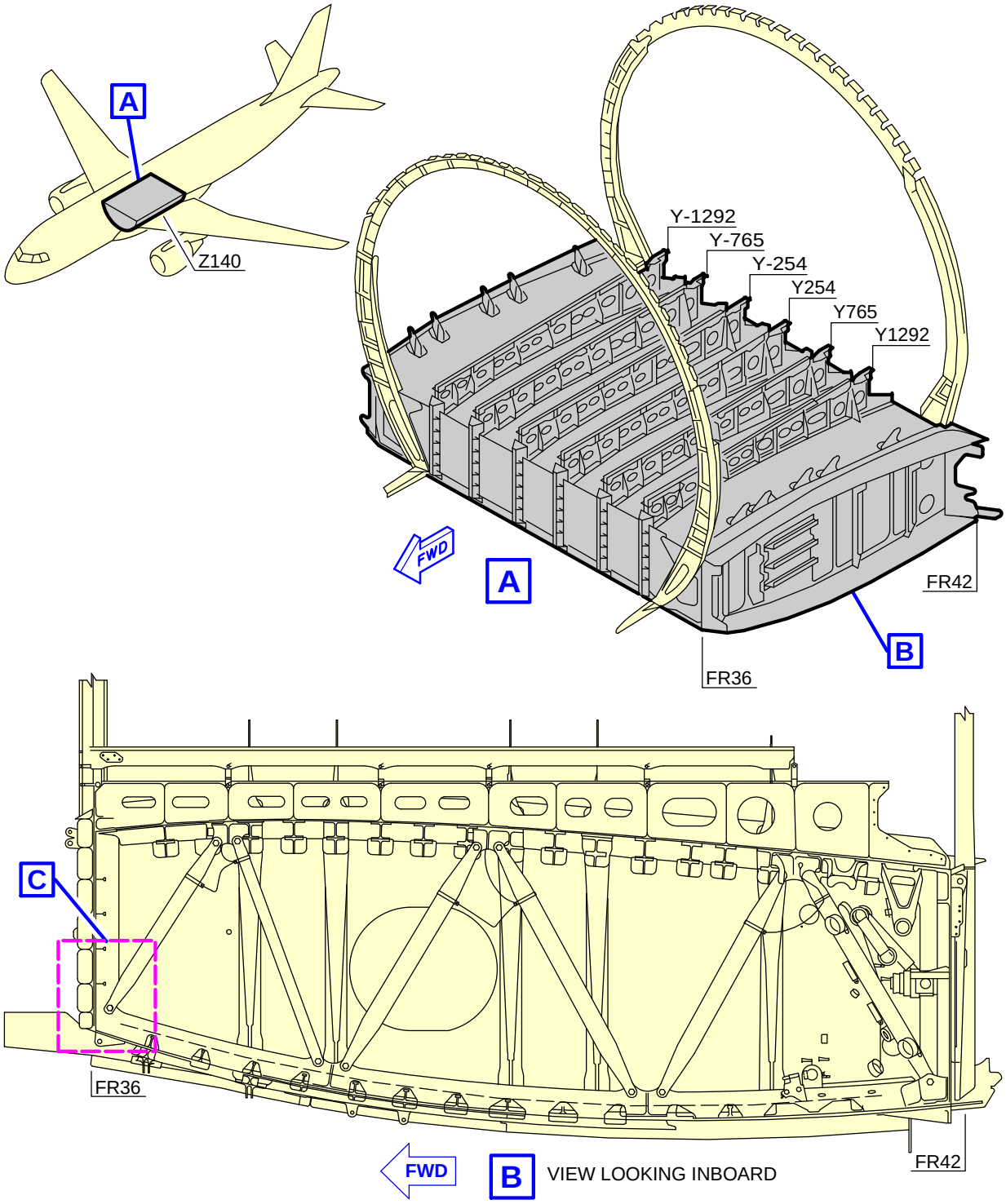
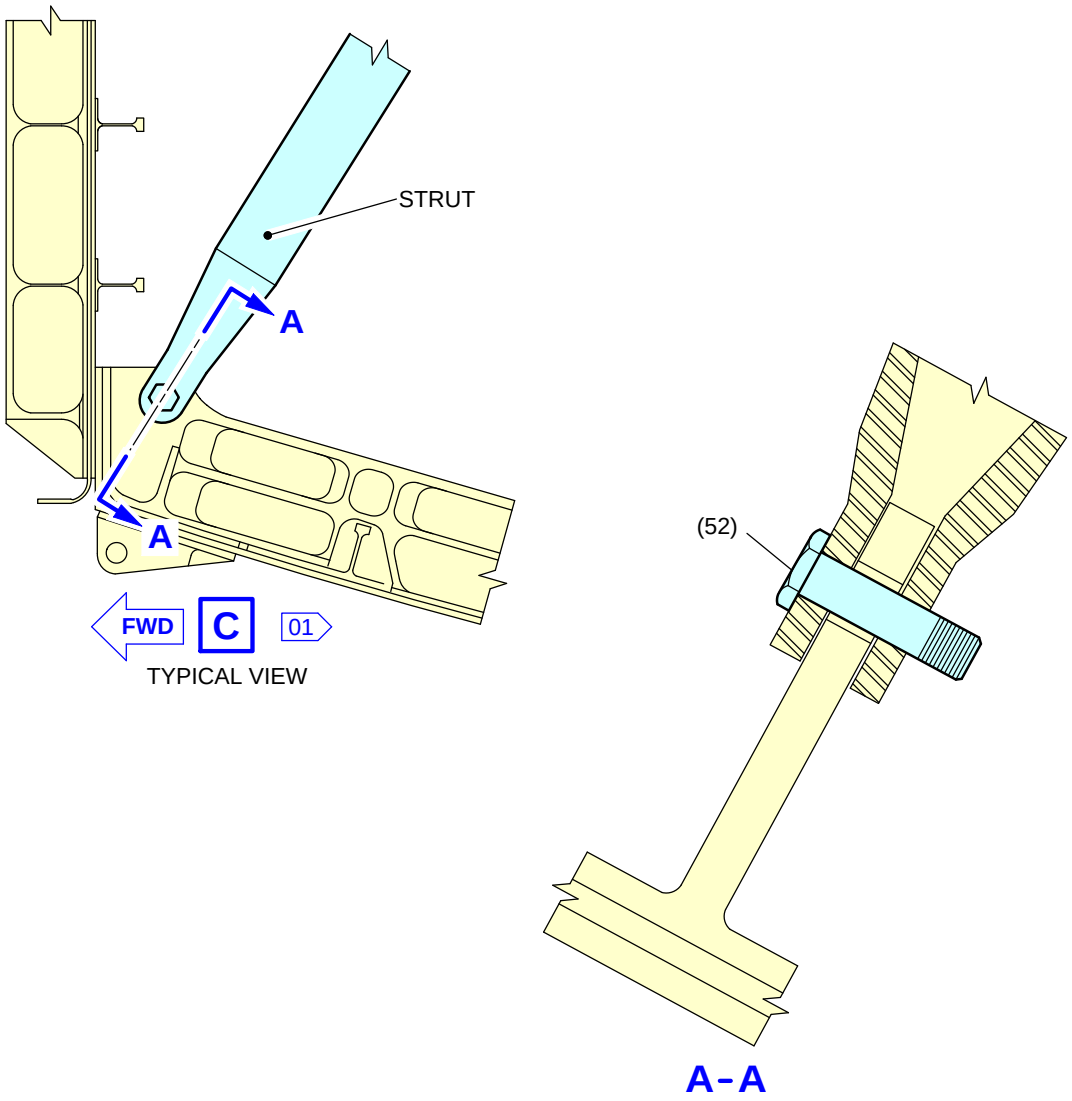


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(45) Task A320-A-57-XX-1228-07001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - 08BAA9
General

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-07ZZZ-900Z-A.

CONF 001 003 004

(46) Task A320-A-57-XX-1228-07001-900A-A - Drill the New Vertical Stringer on Y-254 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER VERTICAL D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

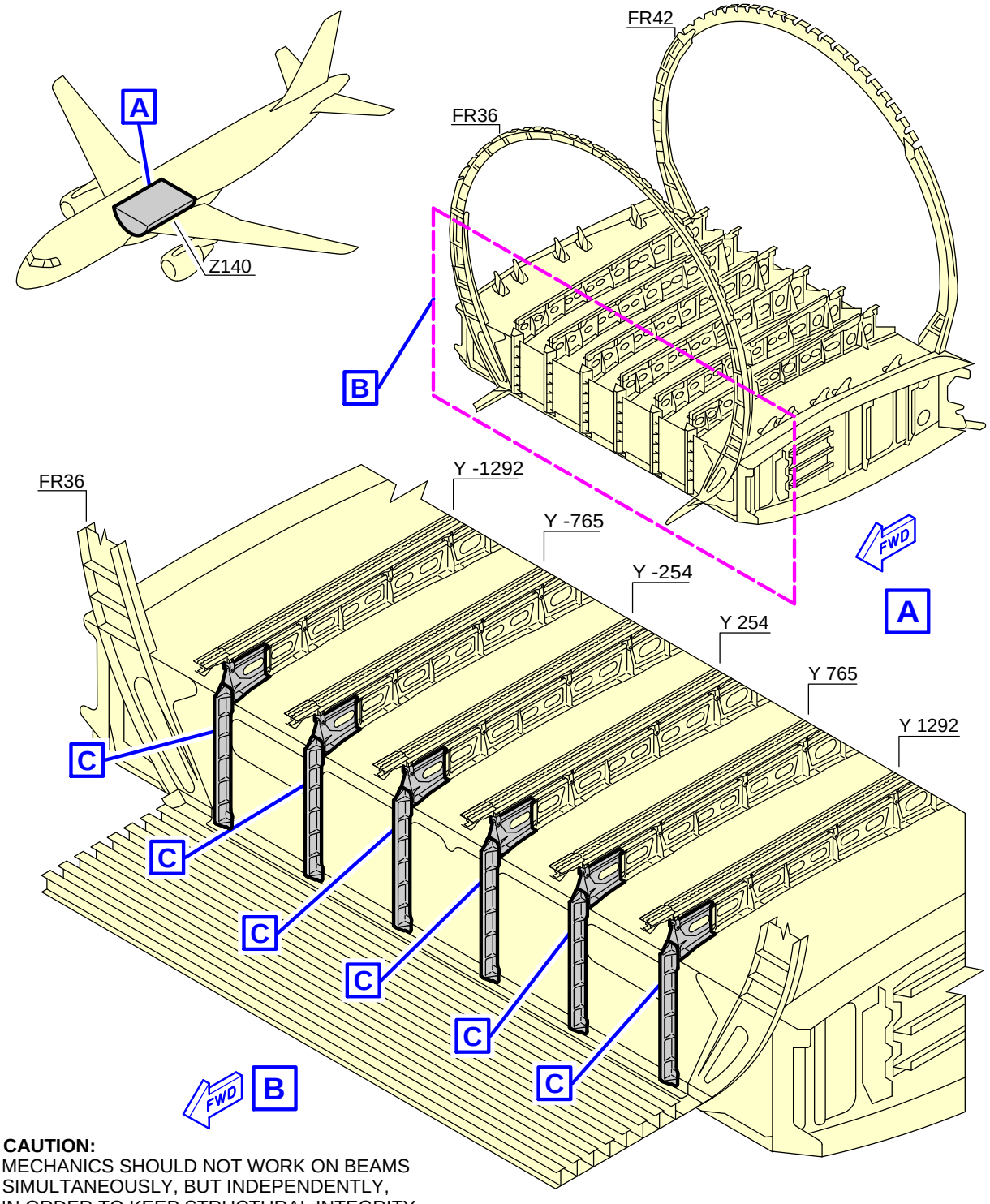
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

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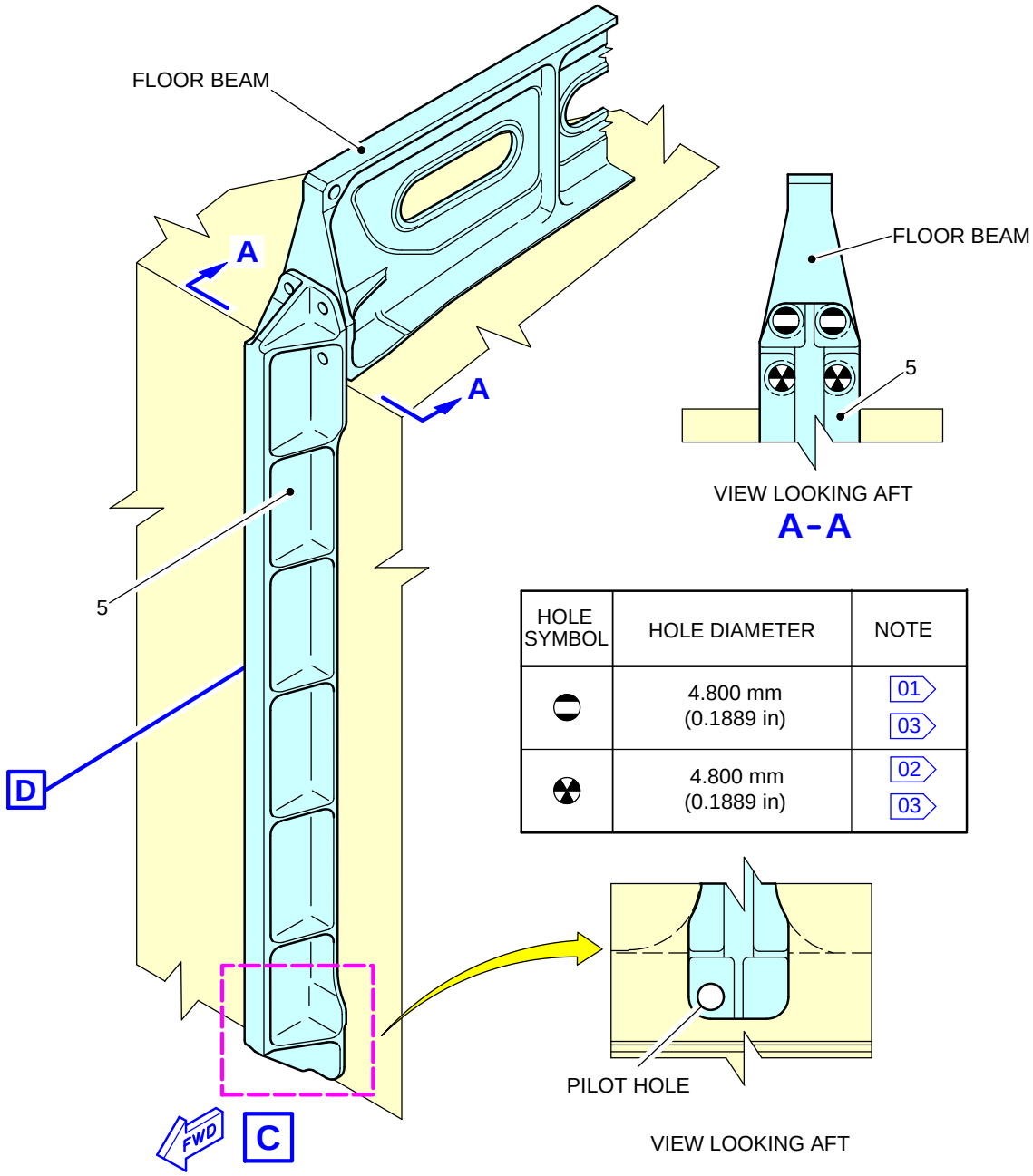


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

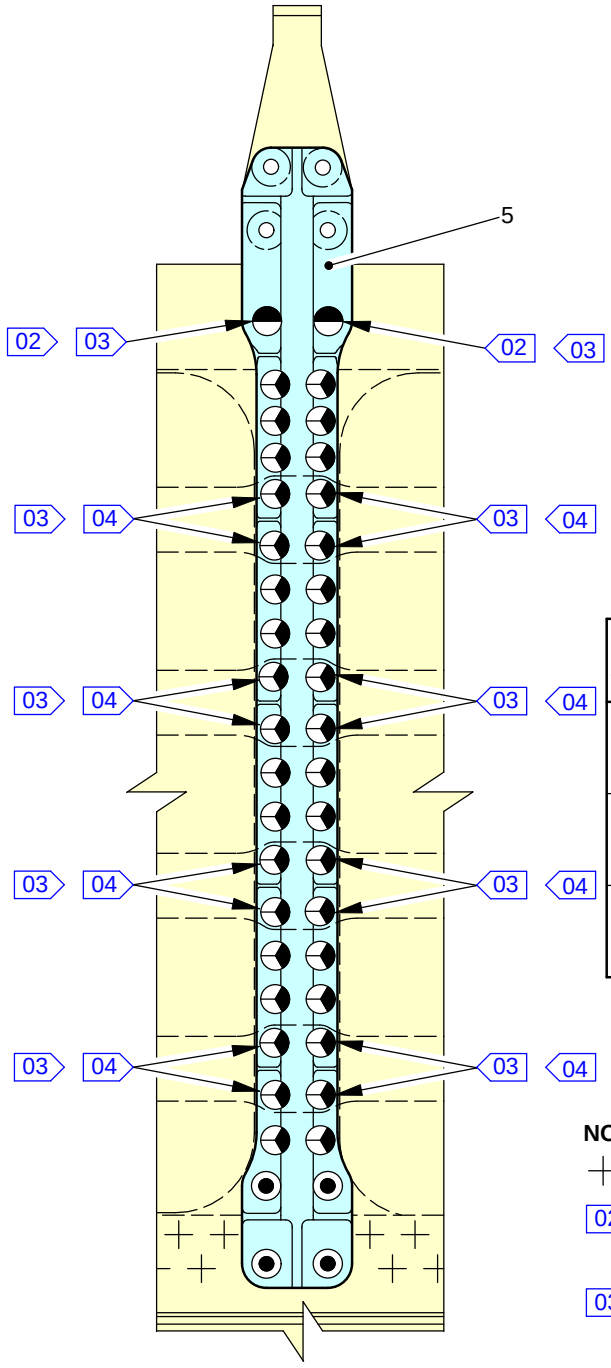
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

+ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

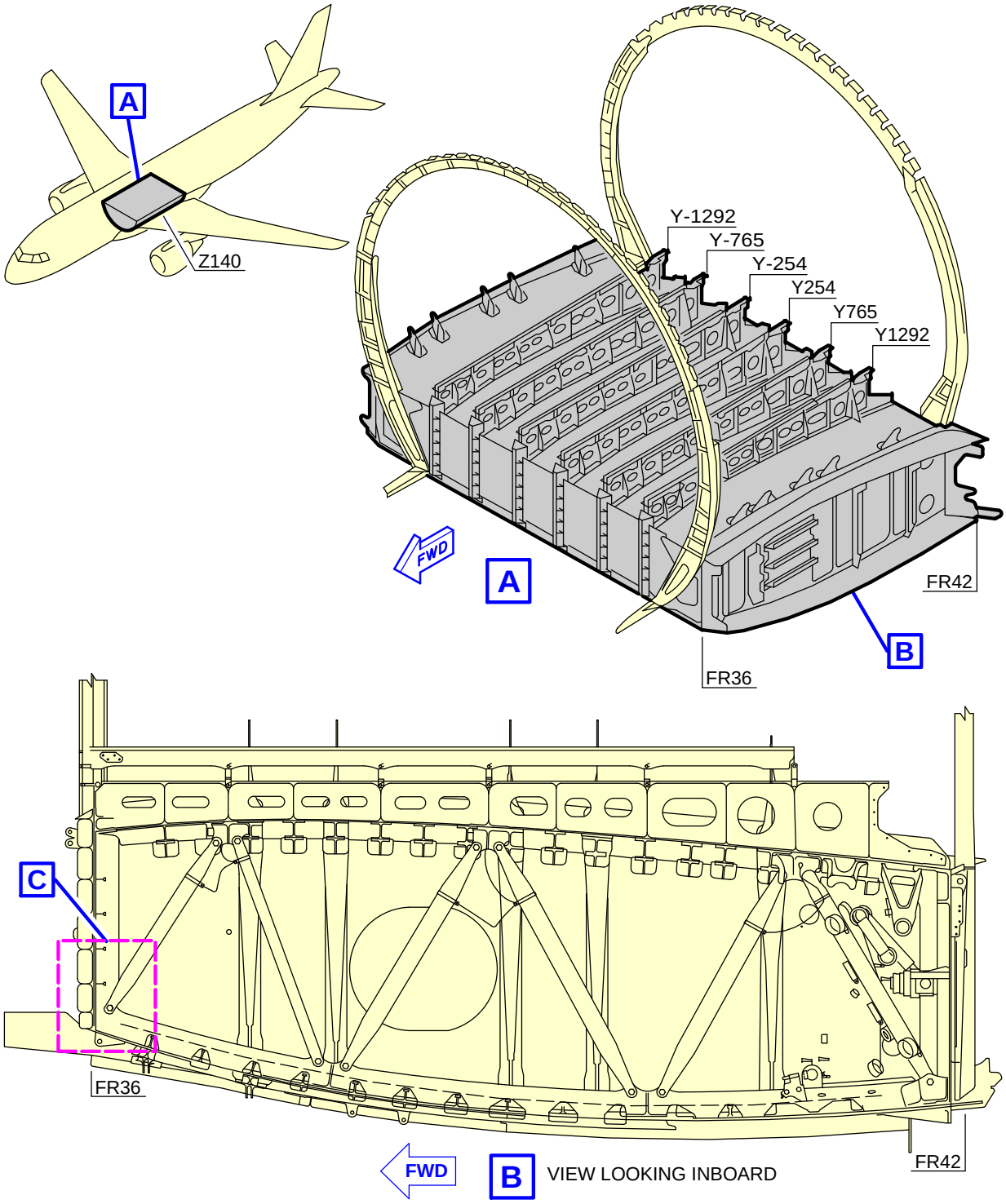
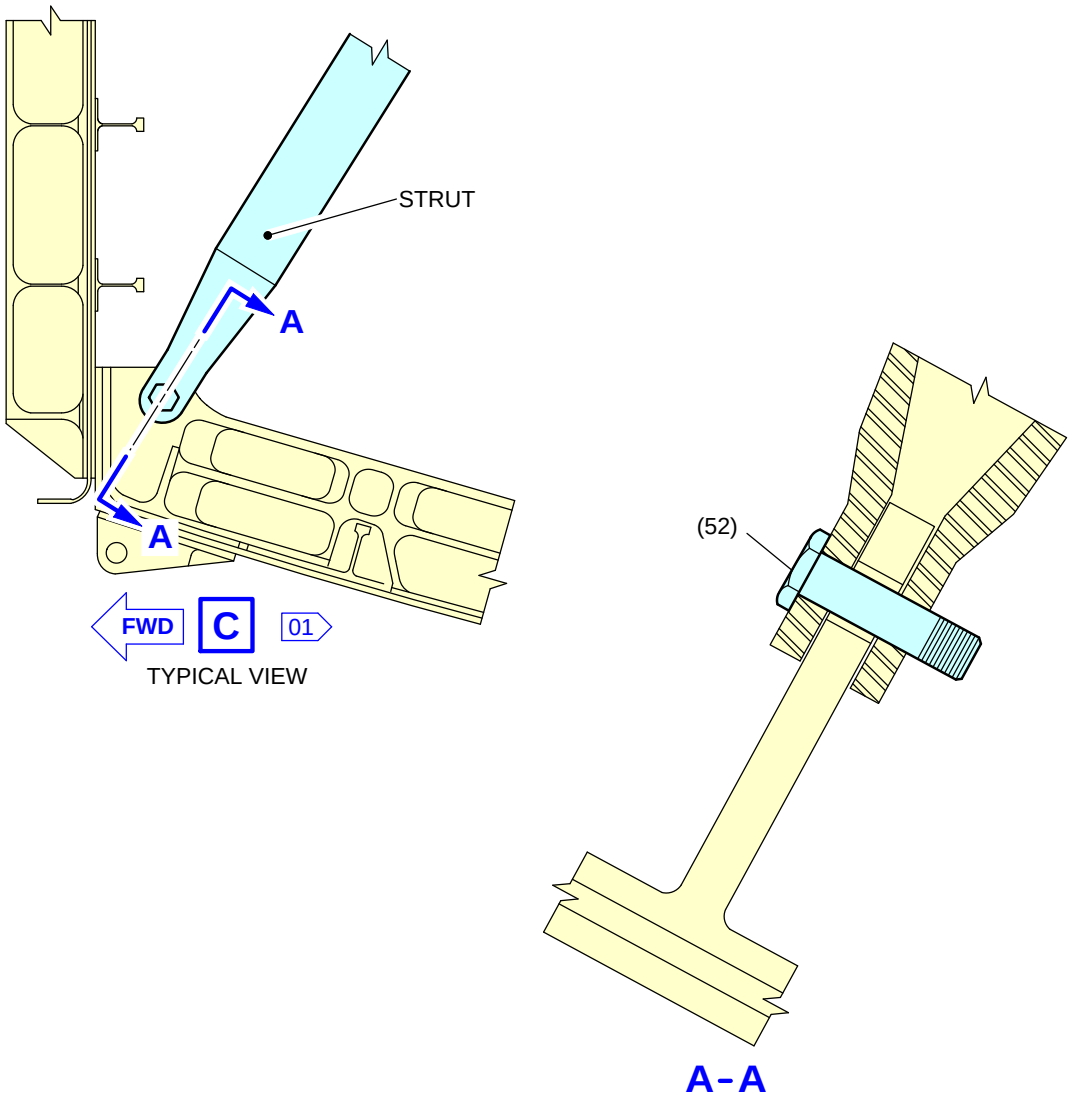


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(46) Task A320-A-57-XX-1228-07002-900A-A - Drill the New Vertical Stringer on Y-254 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER VERTICAL	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

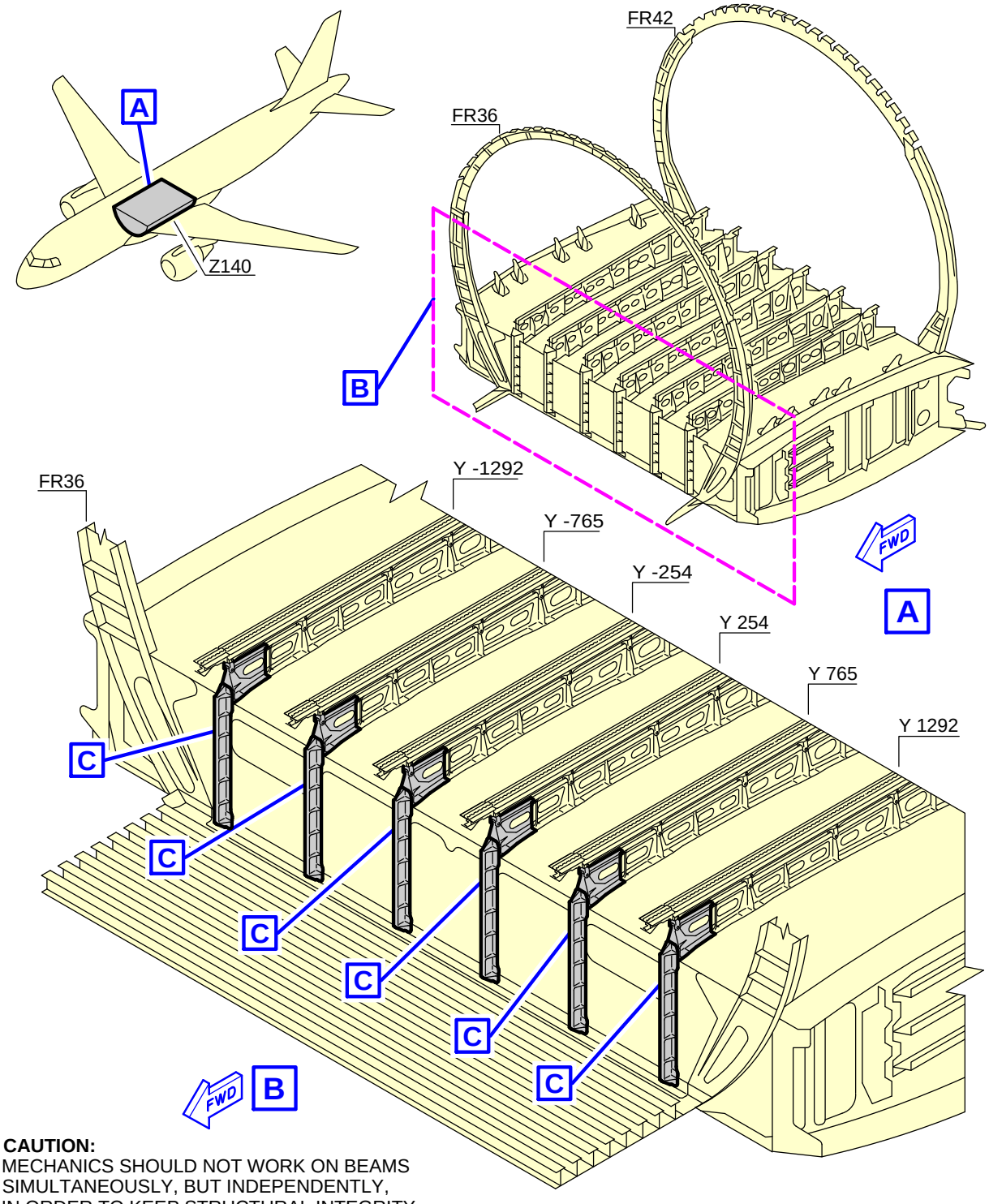
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

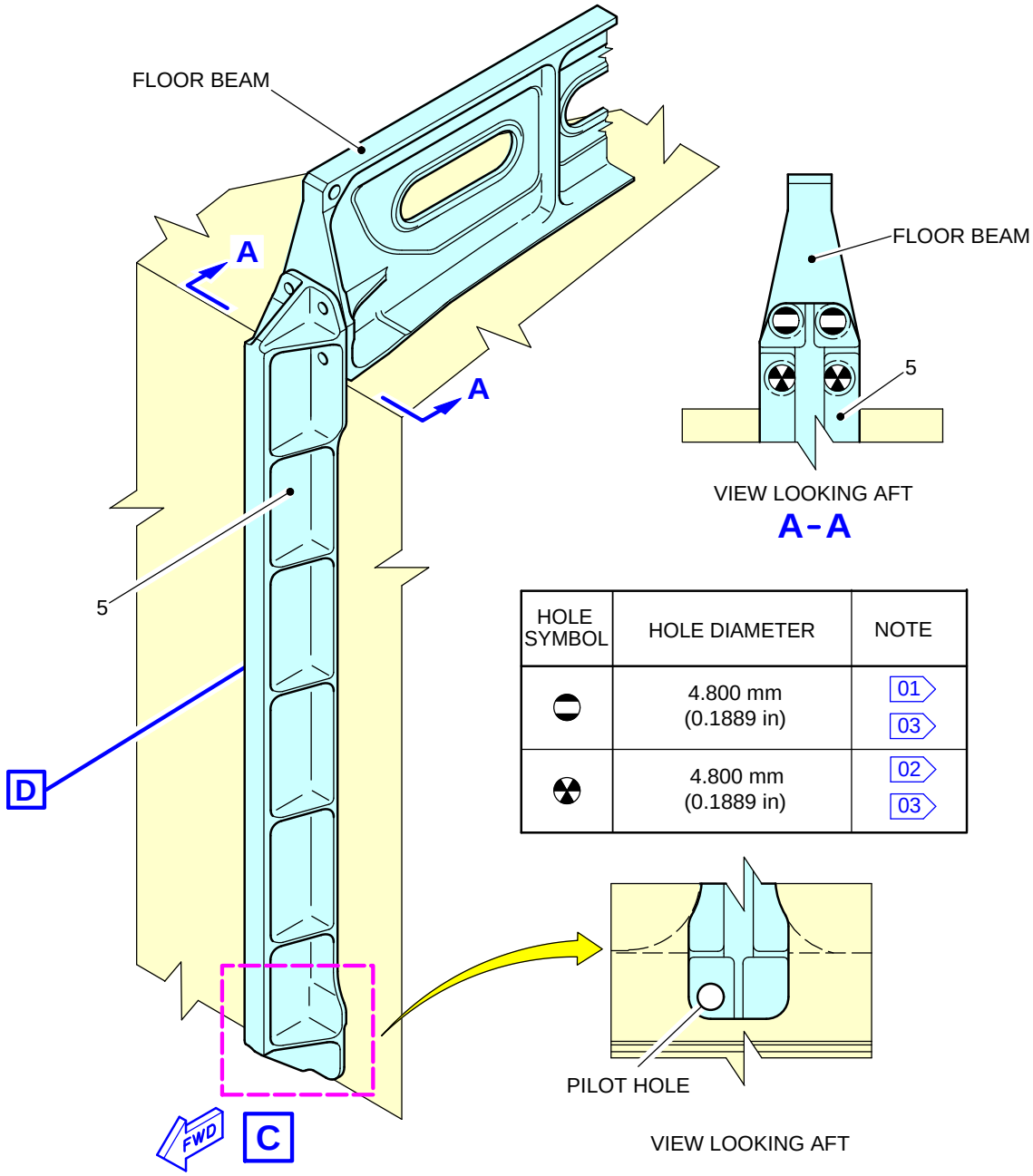


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

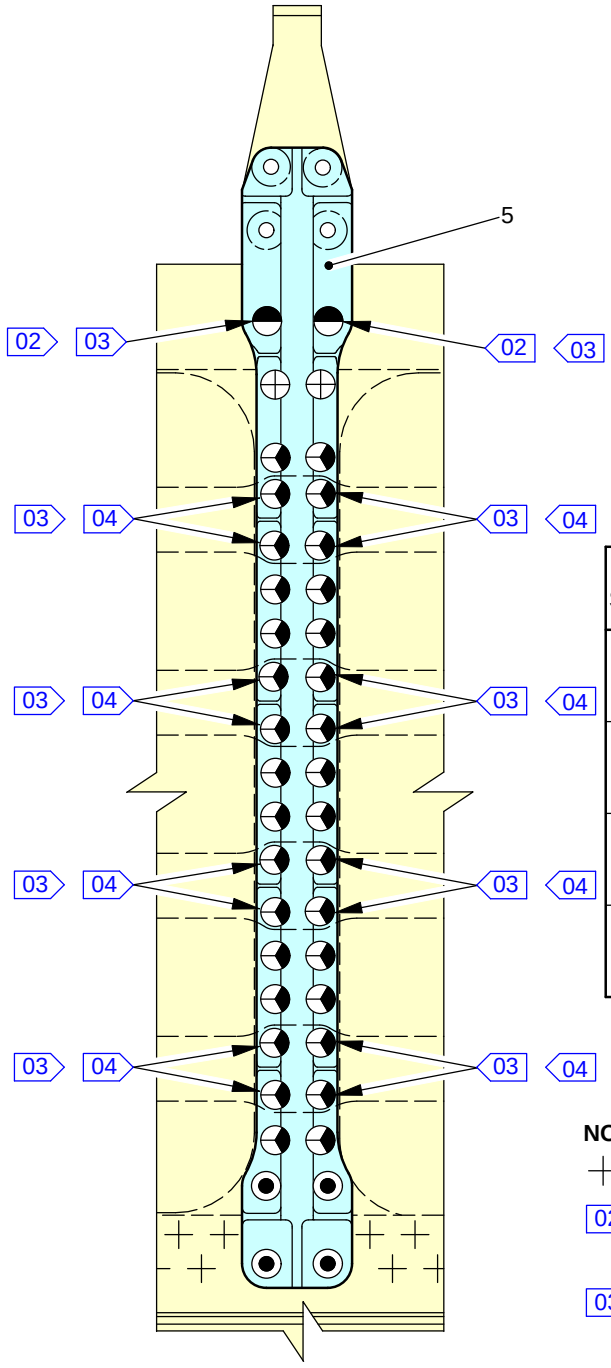
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

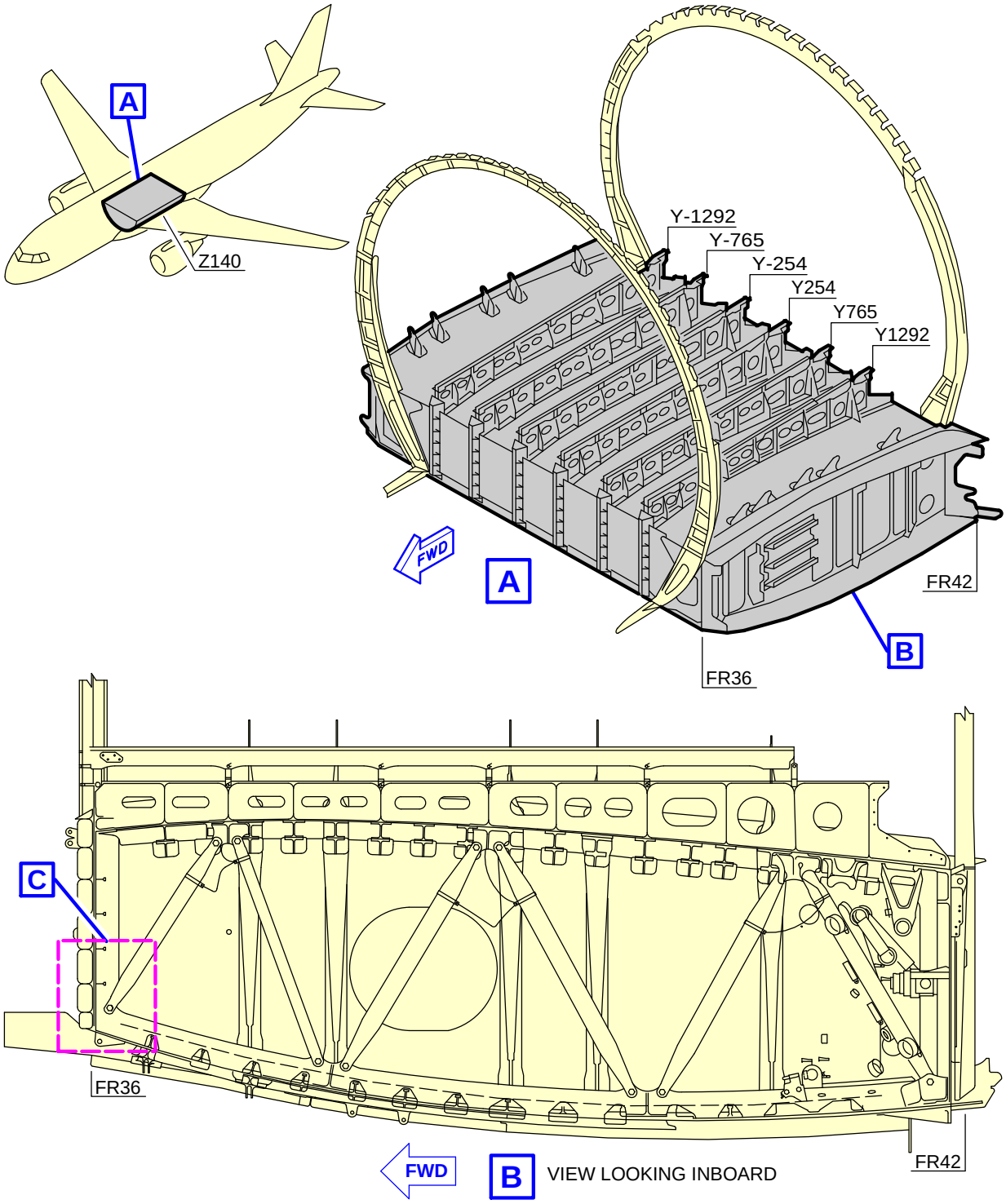
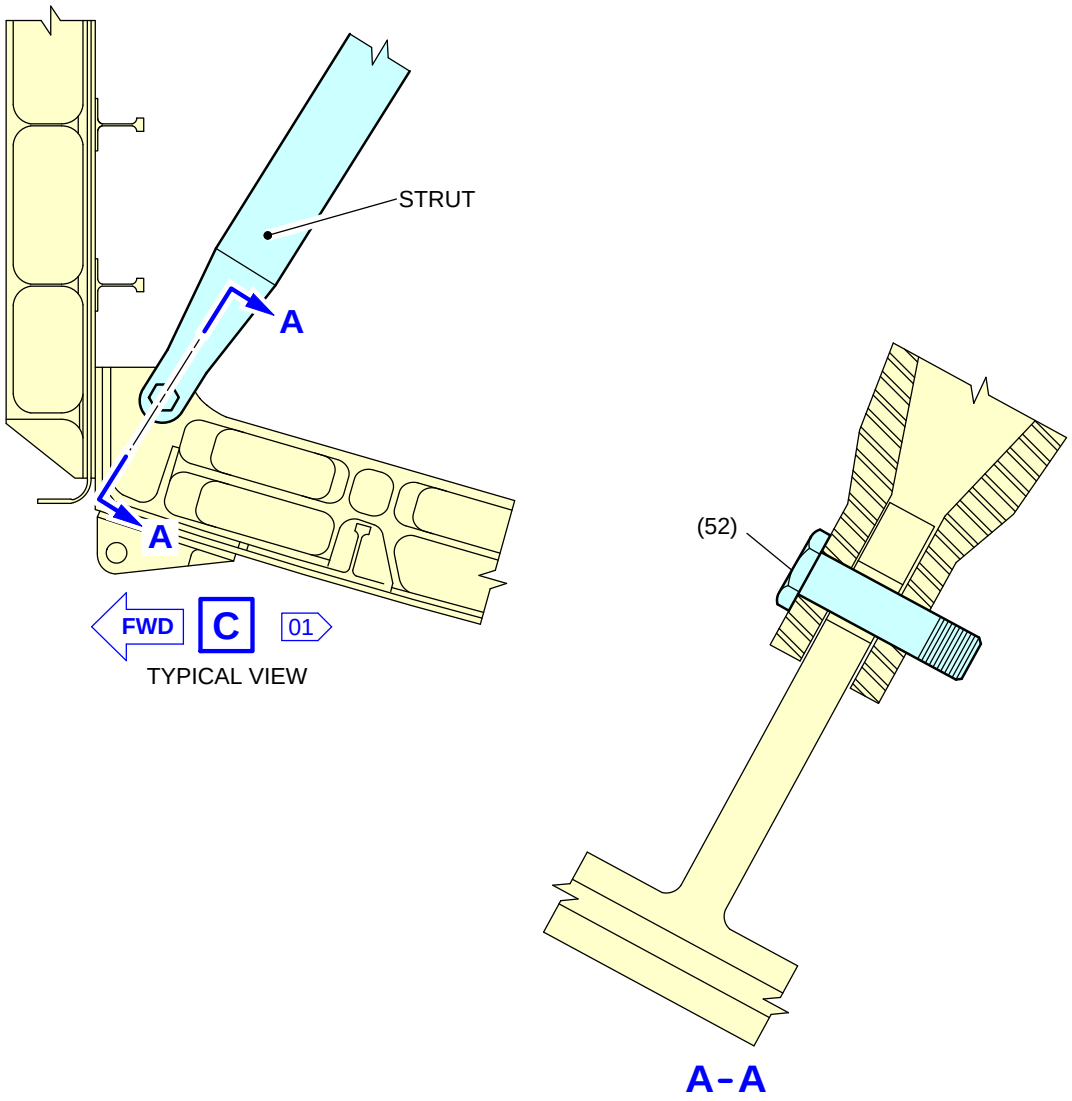


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(47) Task A320-A-57-XX-1228-17001-720A-A - Install the New Vertical Stringer on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001

Manuals/Drawings	References/Sheets
	06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

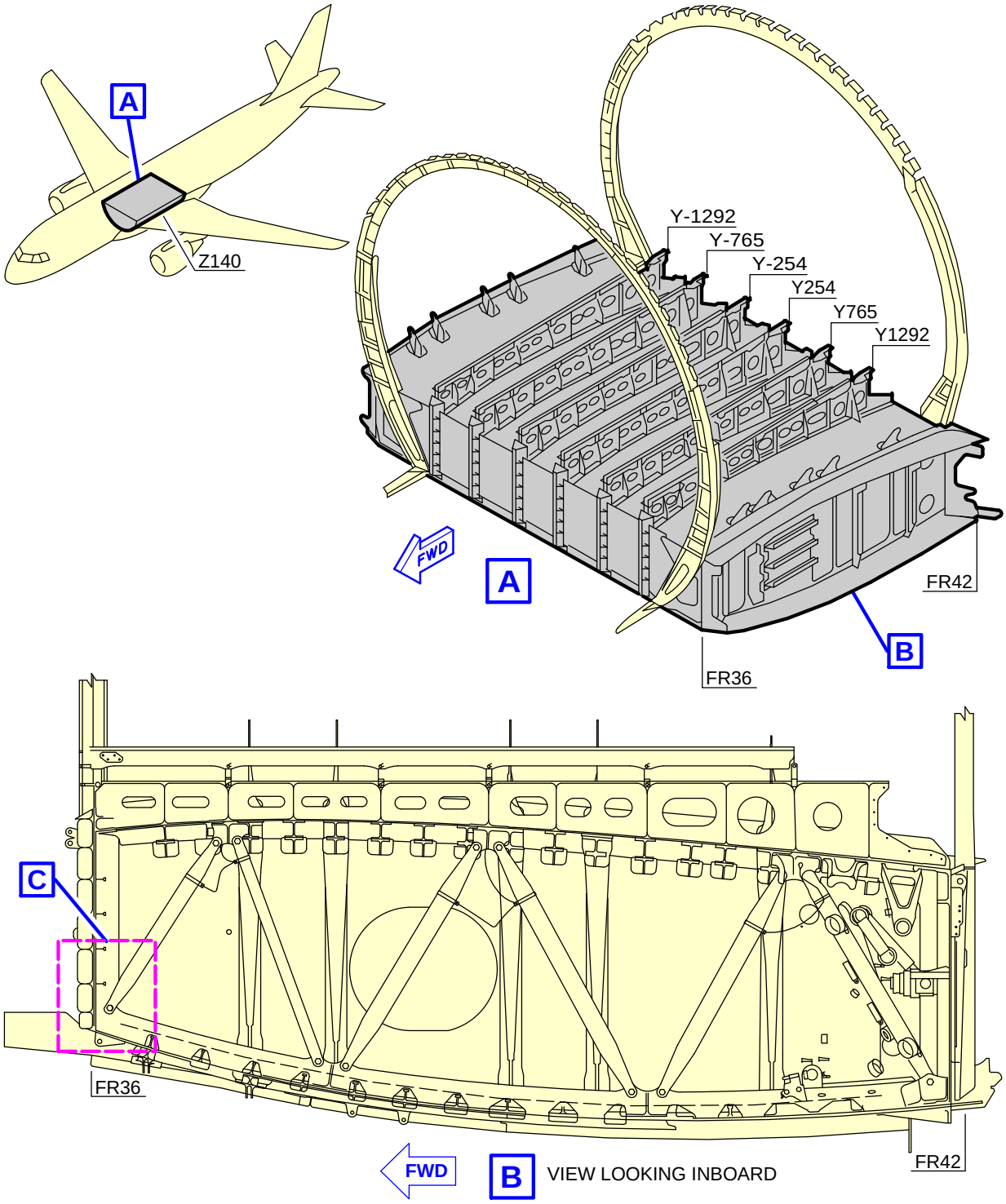
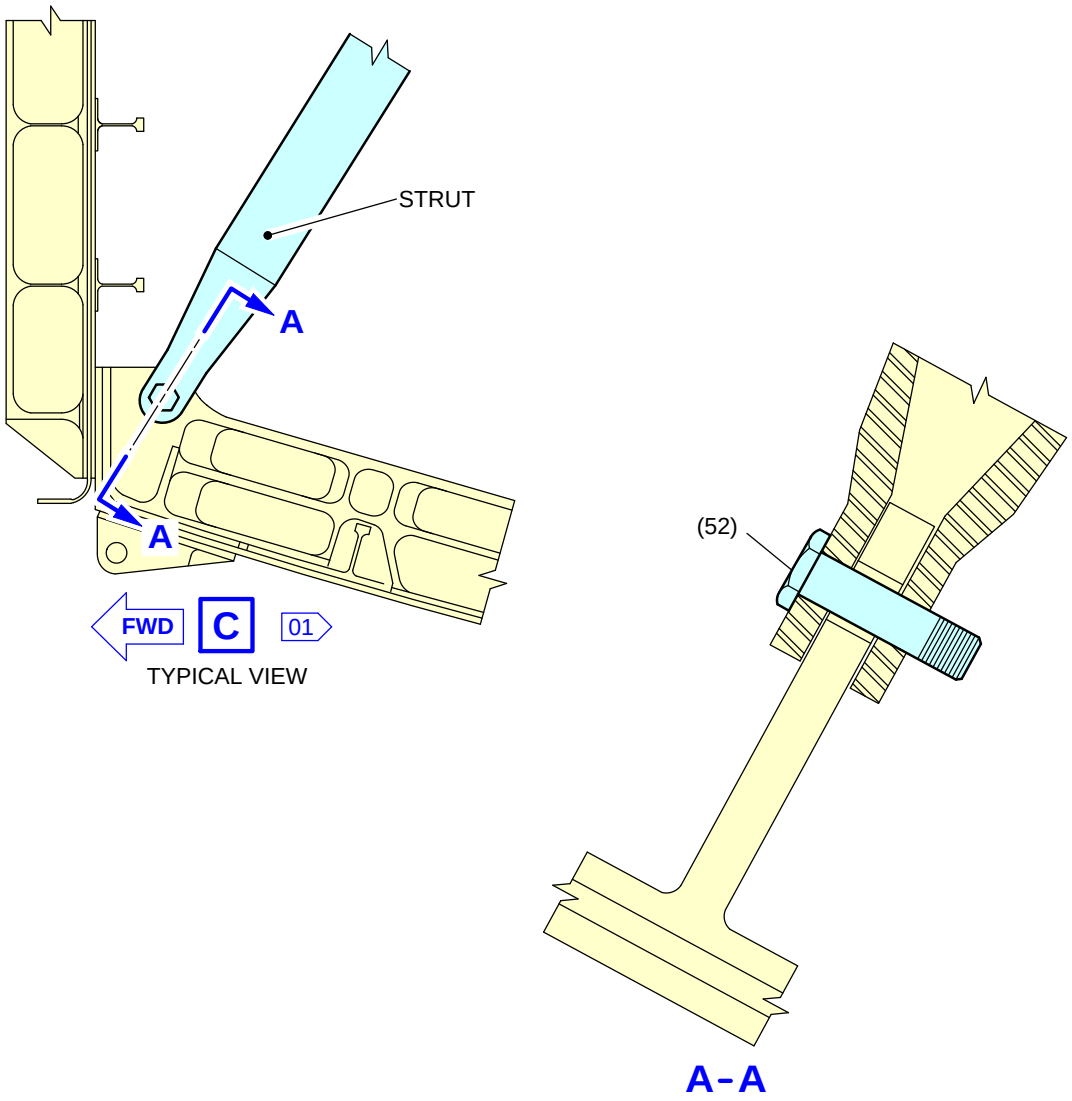


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



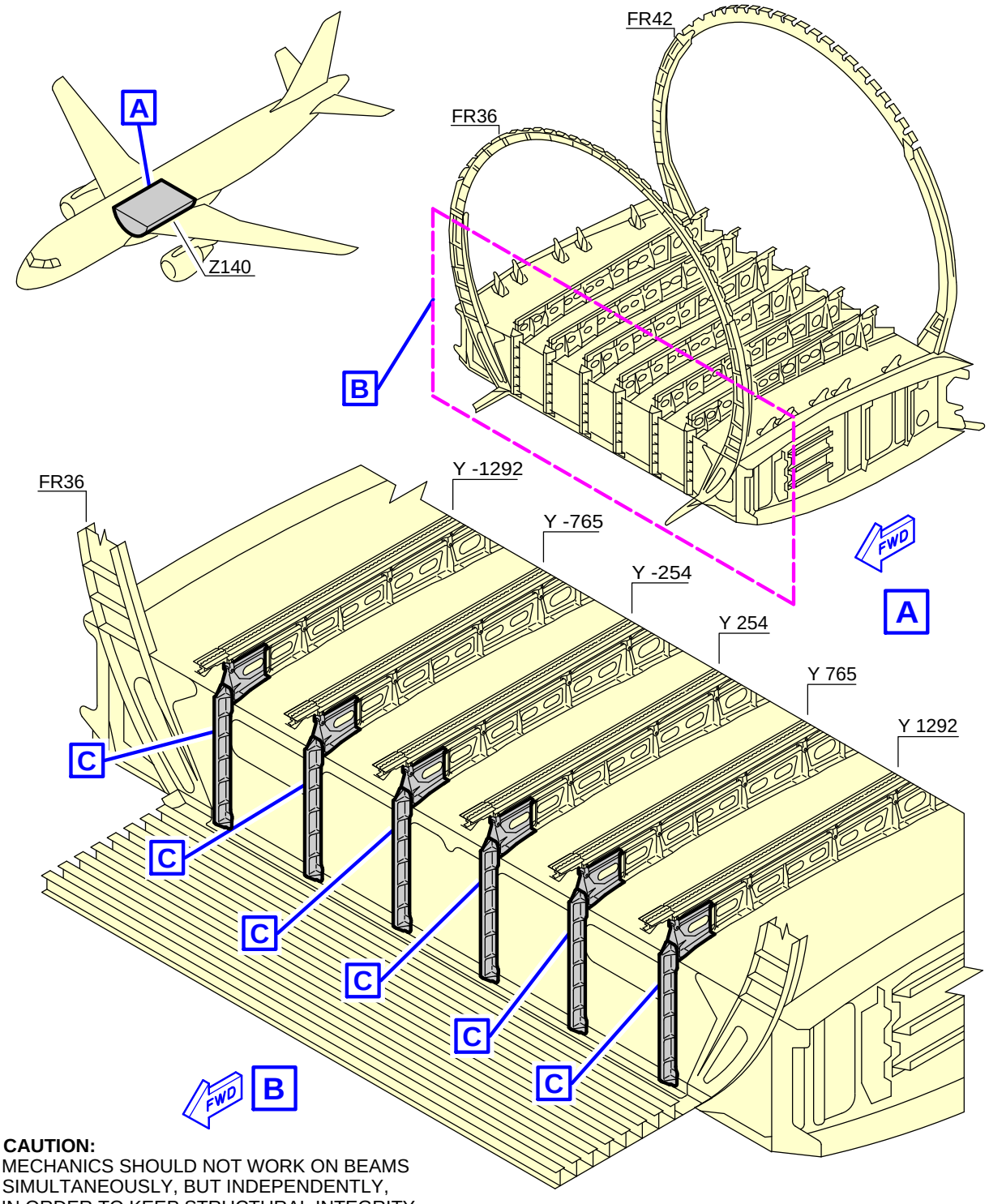
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

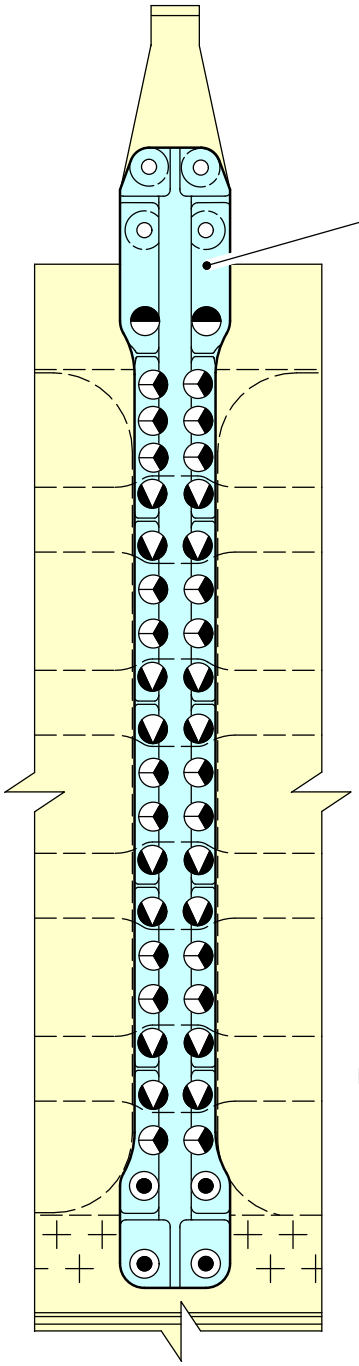


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(47) Task A320-A-57-XX-1228-17002-720A-A - Install the New Vertical Stringer on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

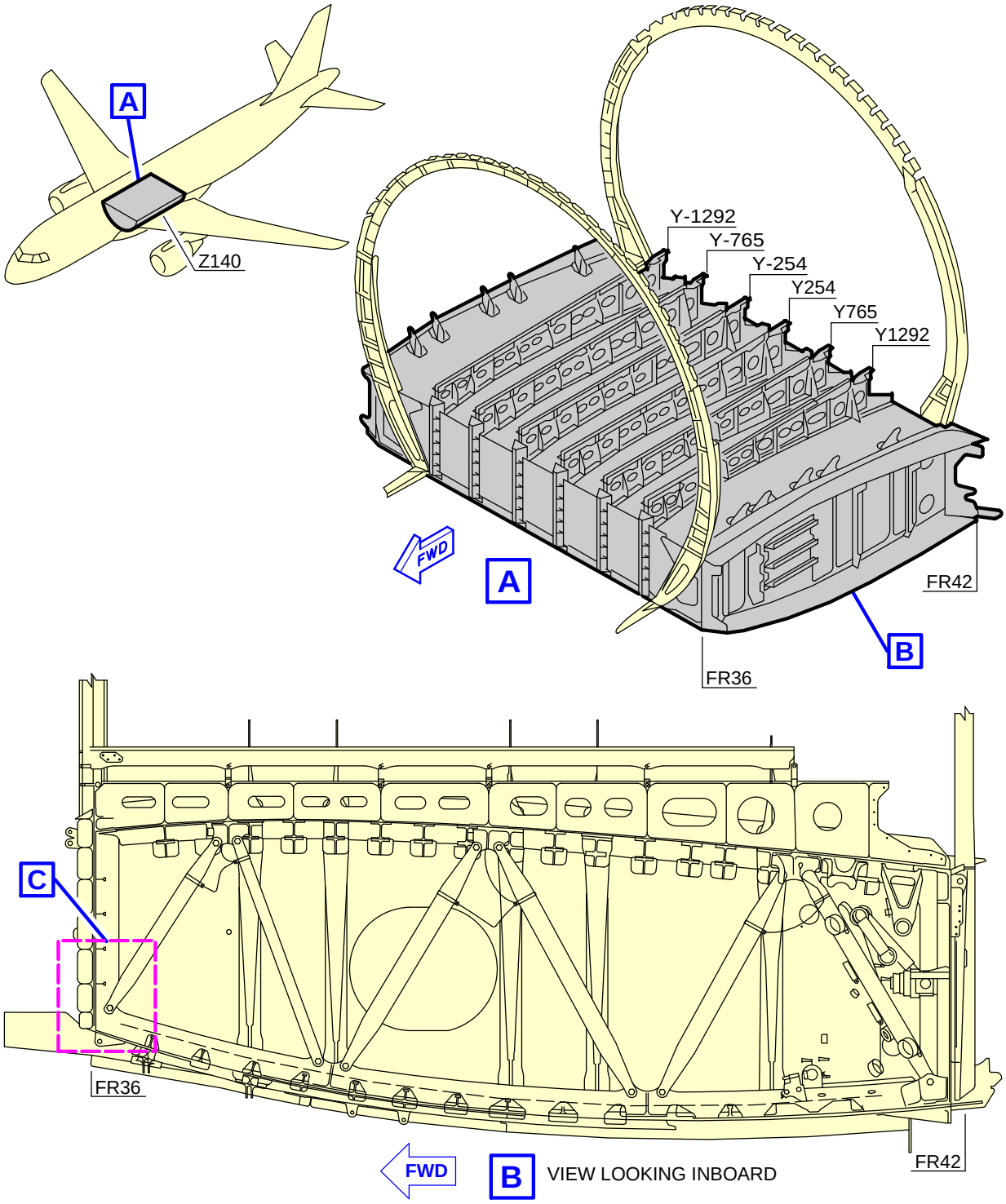
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

	Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
	Top Coat Polyurethane - - Grey InternalStructure	04JME4

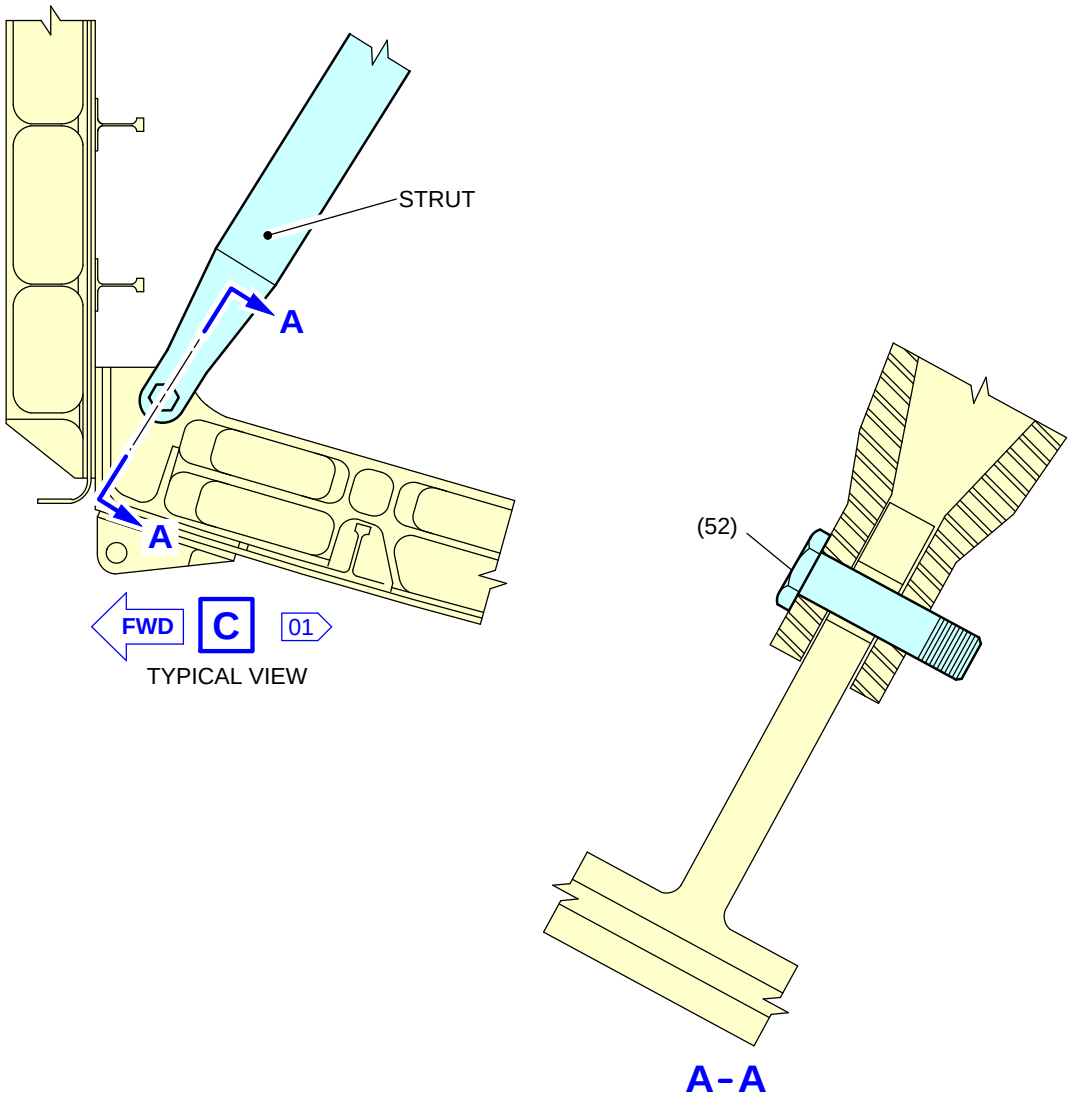
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



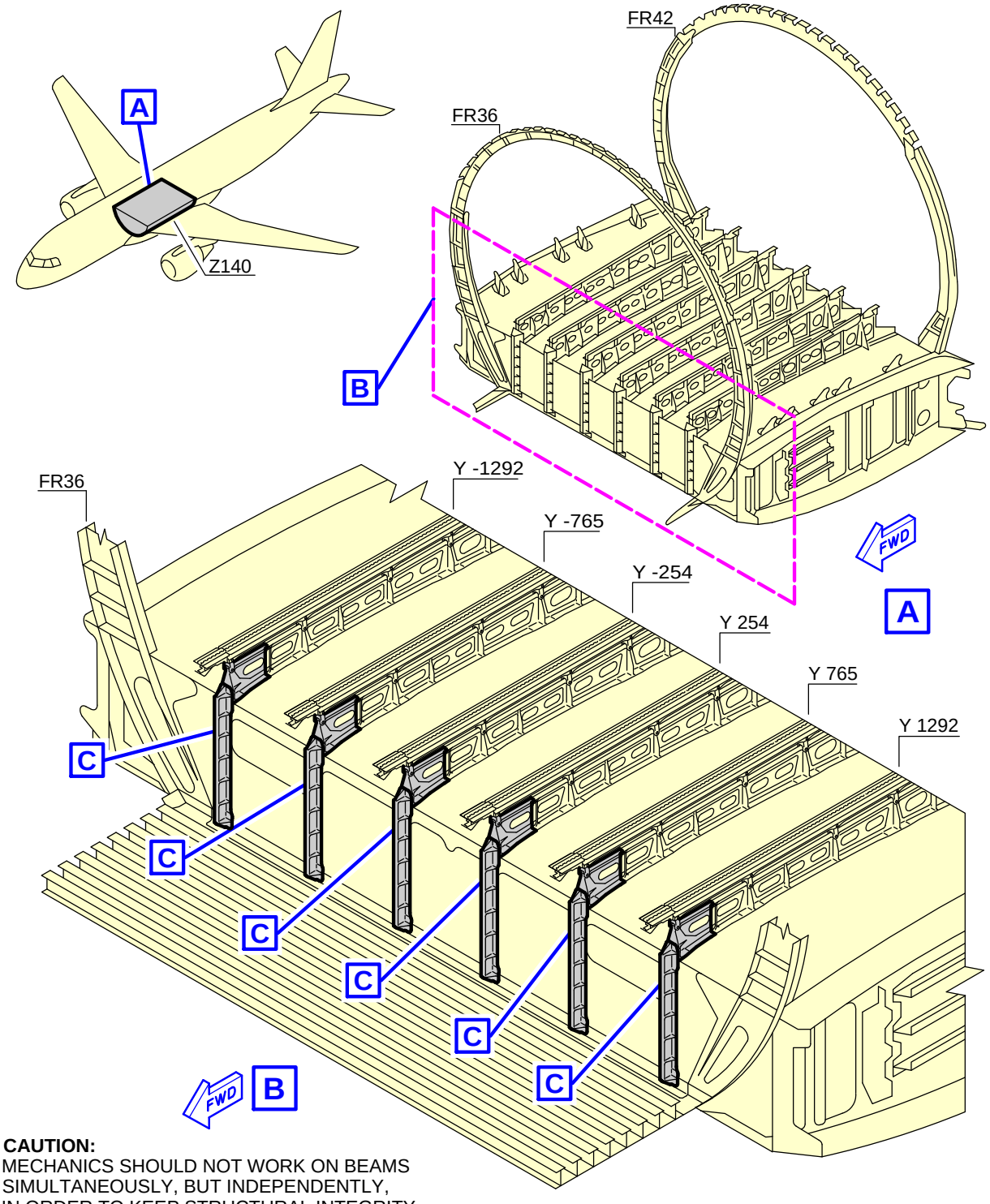
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

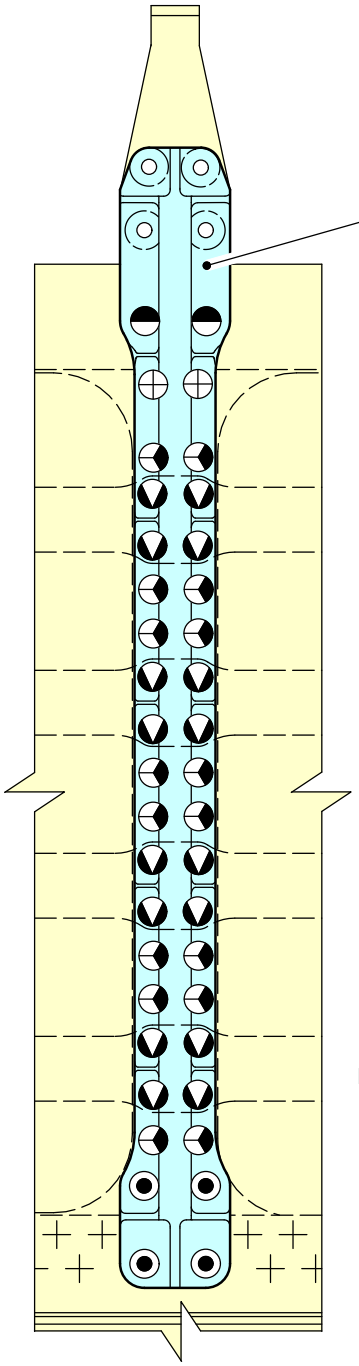


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(48) Task A320-A-57-XX-1228-18001-720A-A - Install the Strut Lower Attachment on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

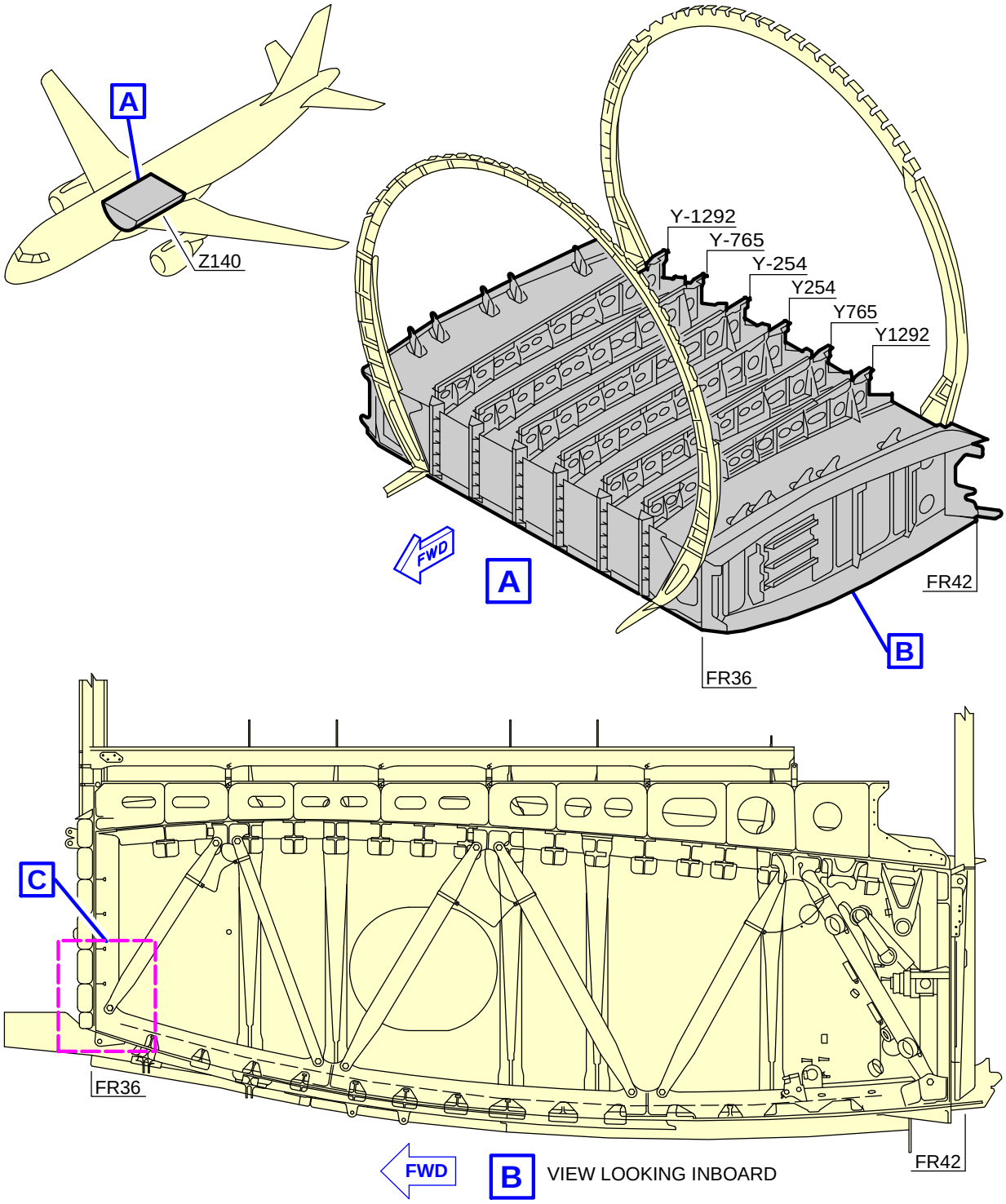
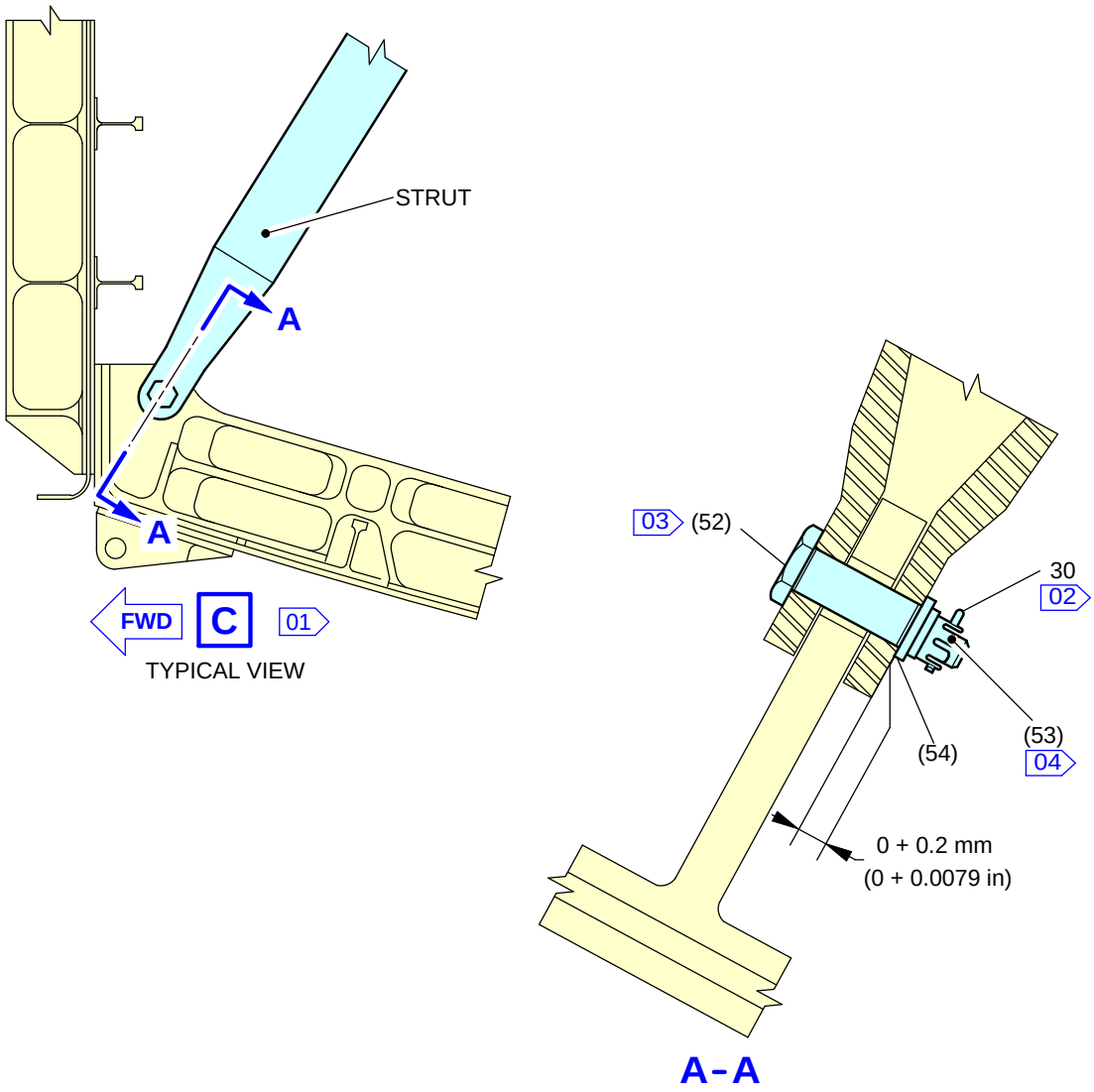


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(48) Task A320-A-57-XX-1228-18002-720A-A - Install the Strut Lower Attachment on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 002

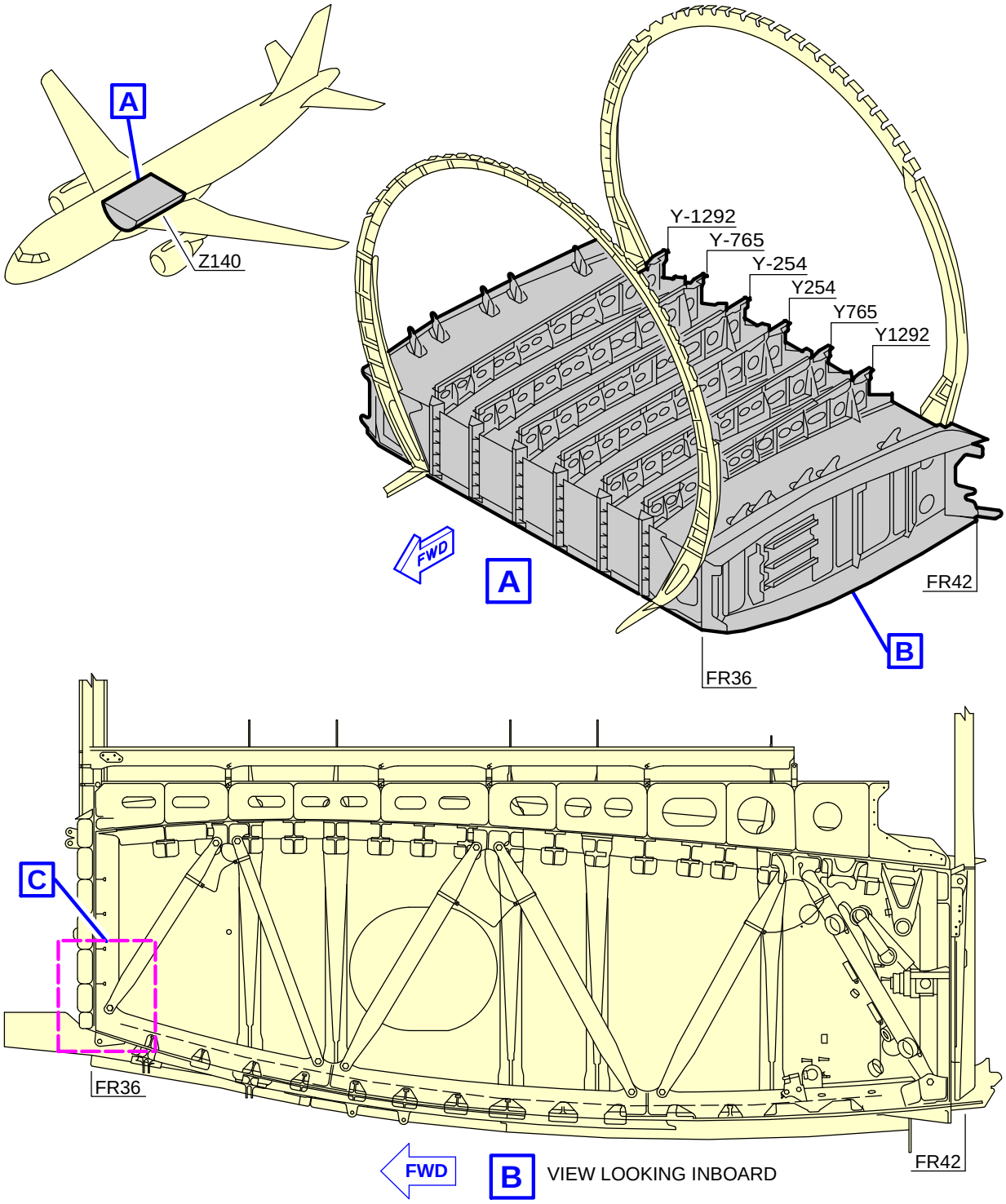
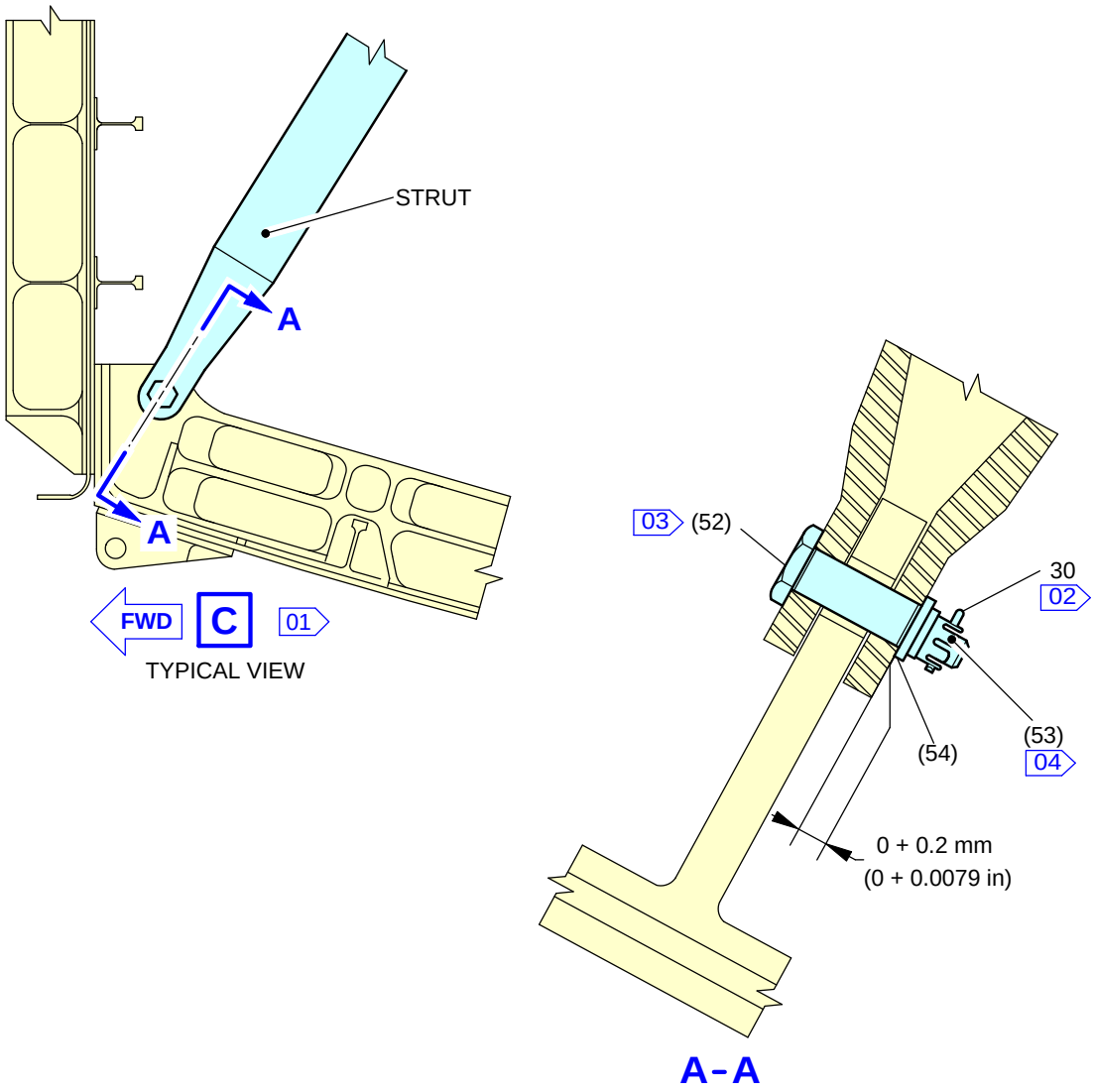


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(49) Task A320-A-57-XX-1228-15001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

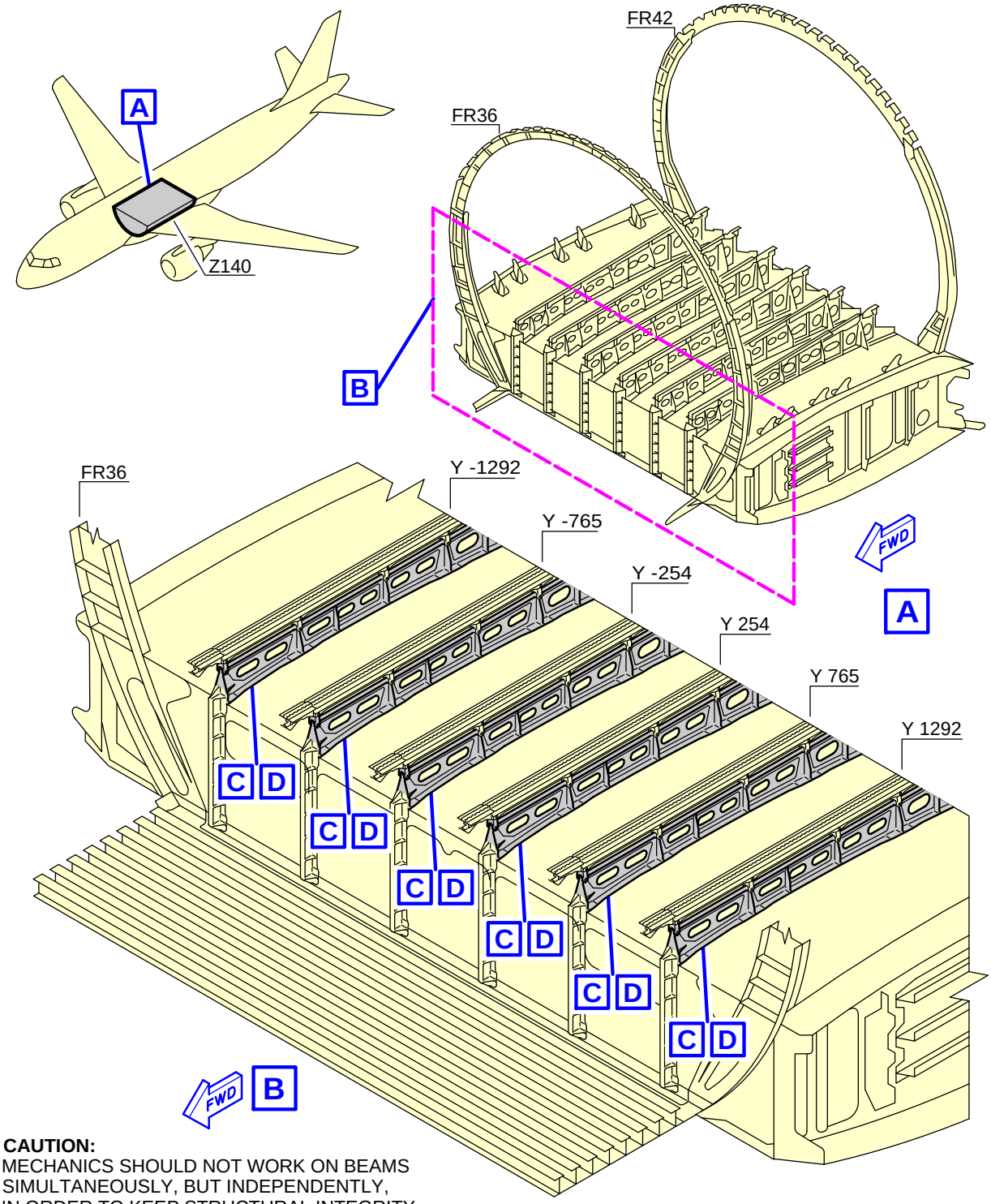
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-20ZZZ-720Z-A.

CONF ALL

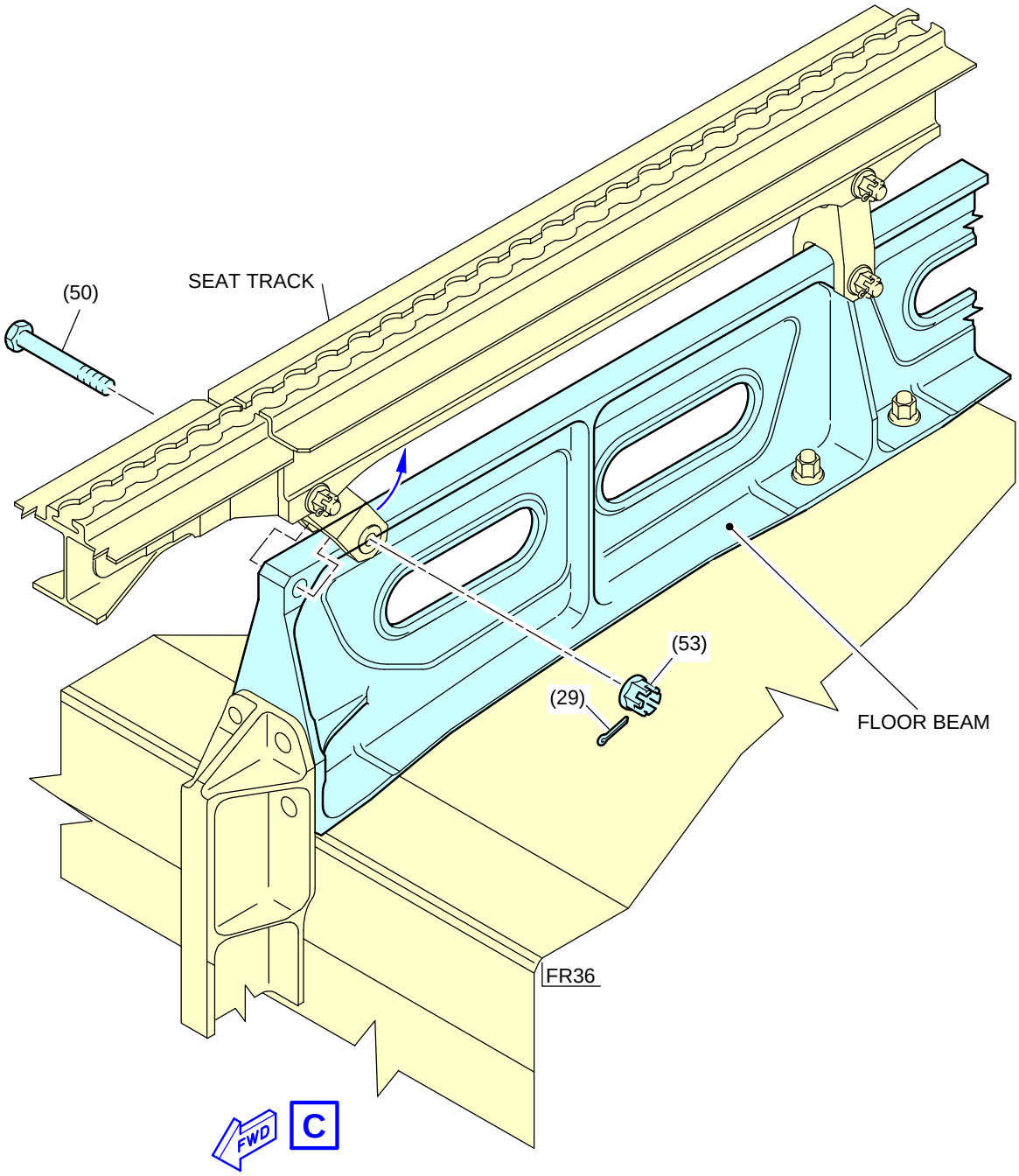


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

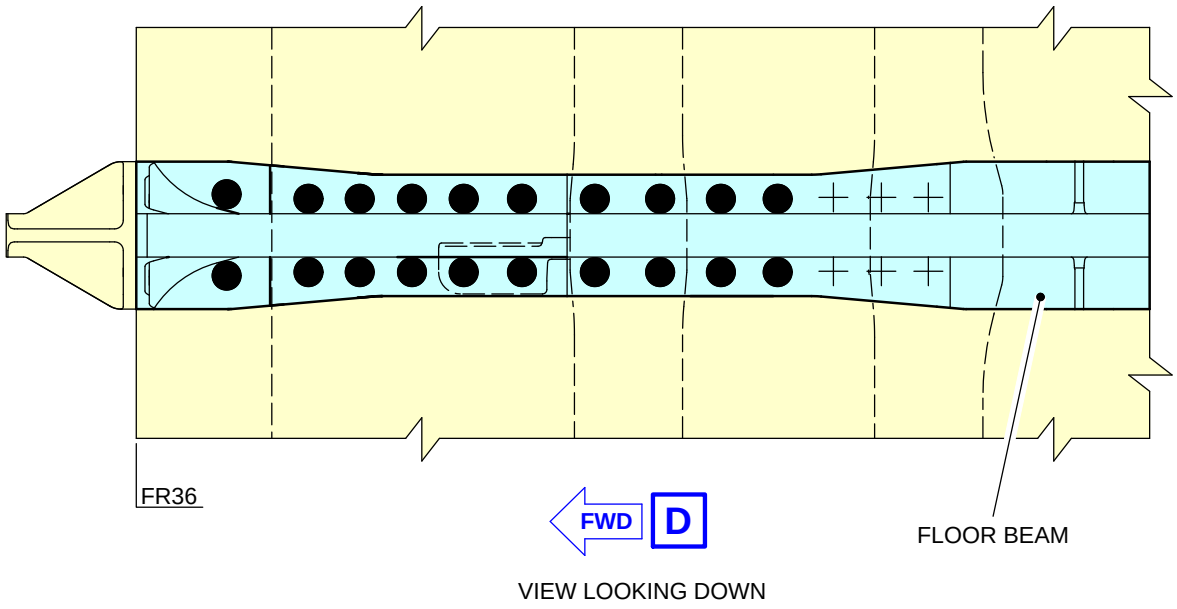
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(50) Task A320-A-57-XX-1228-04001-650A-A - Cut out the Forward End Floor Beam on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

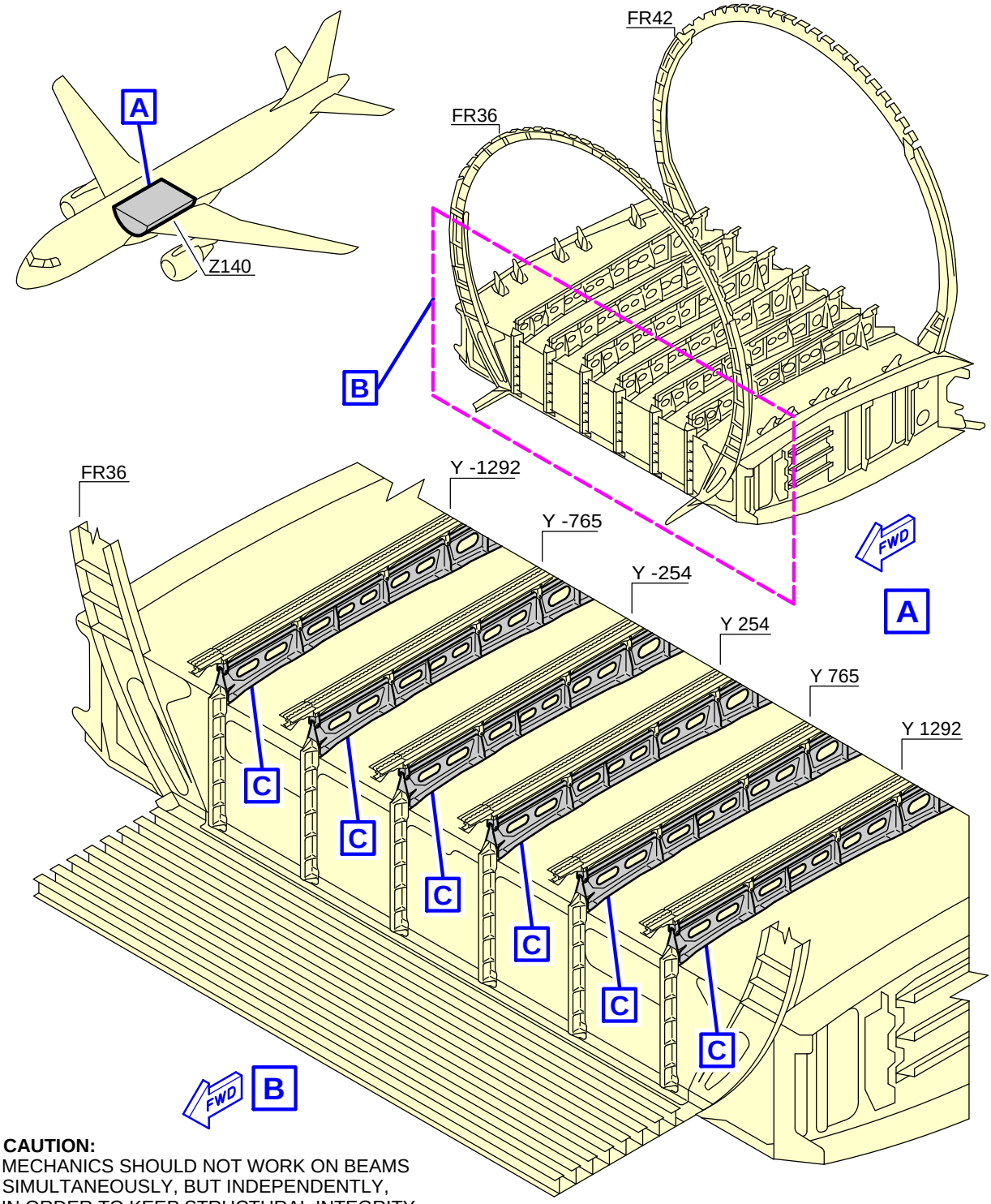
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

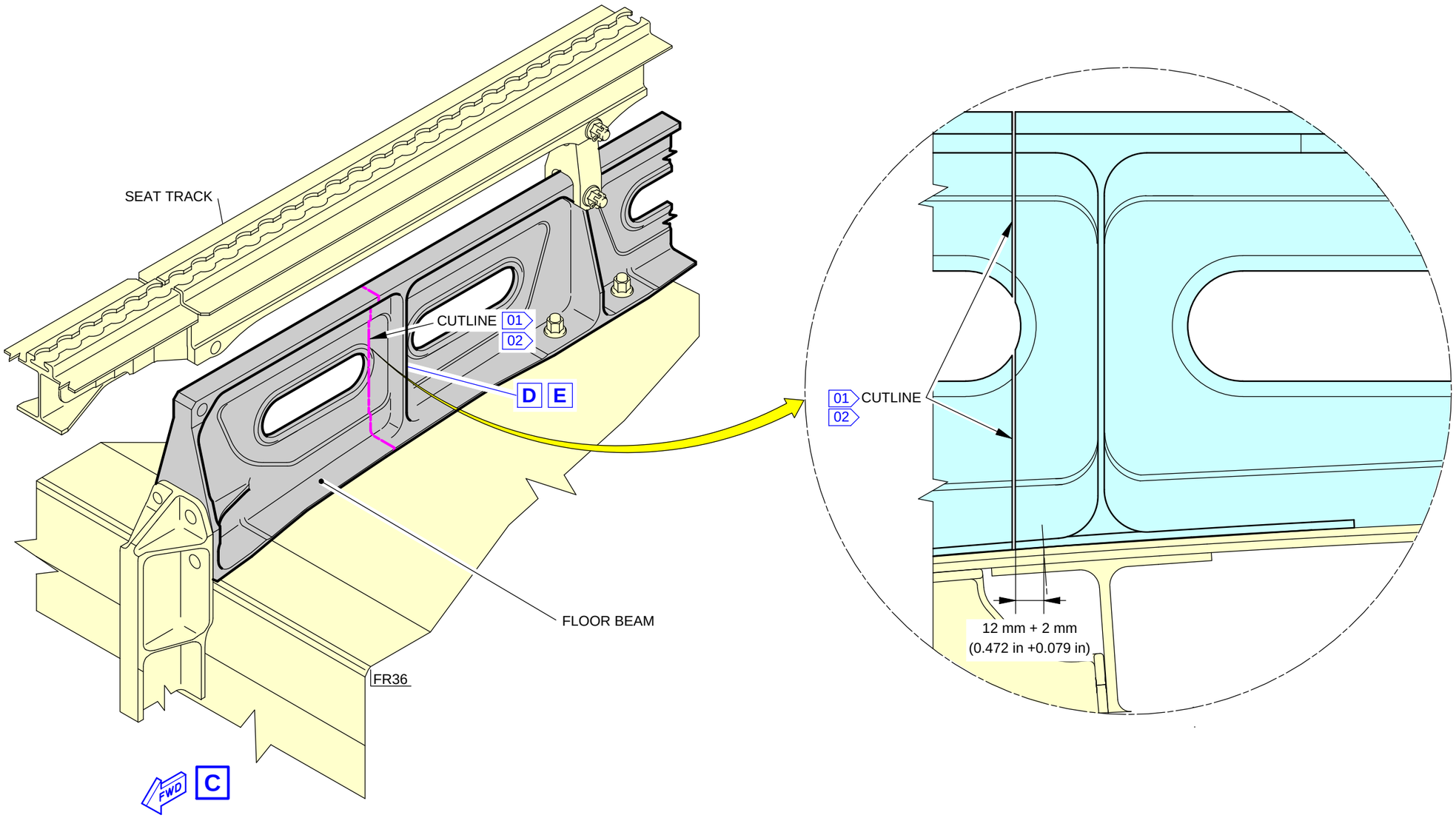


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

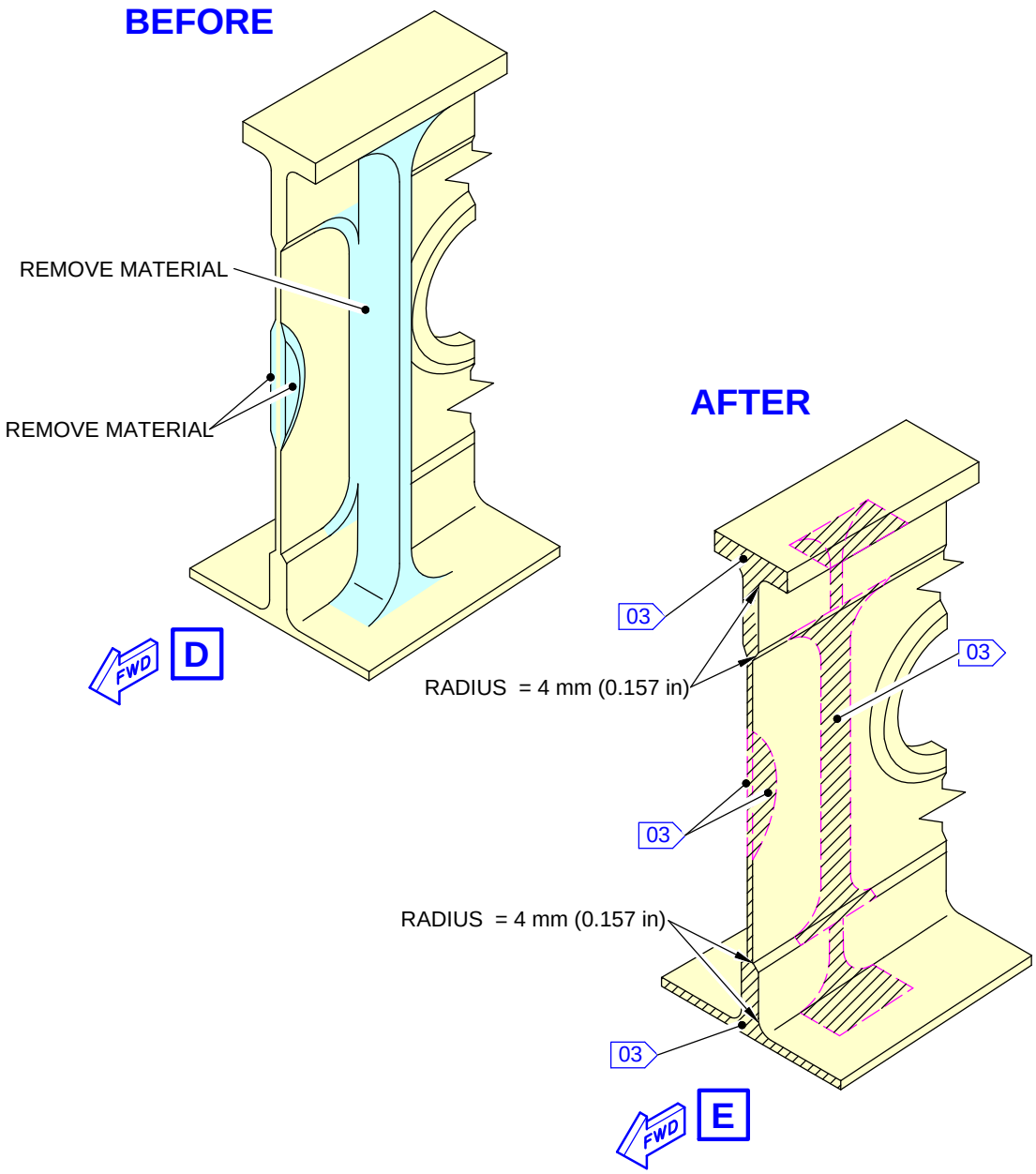
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(51) Task A320-A-57-XX-1228-08001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-19ZZZ-720Z-C.

CONF 001 003 004

(52) Task A320-A-57-XX-1228-19001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

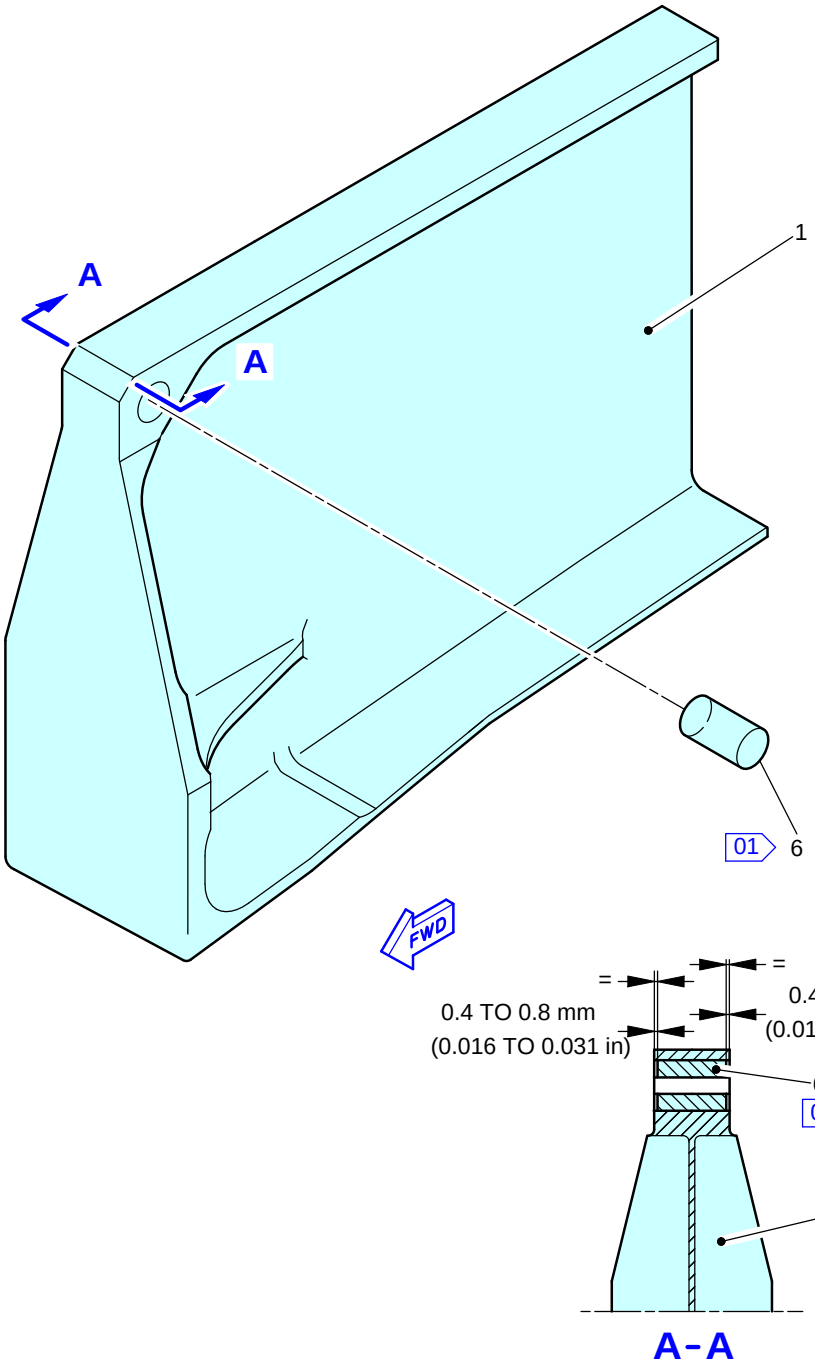
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(52) Task A320-A-57-XX-1228-19002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-254 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

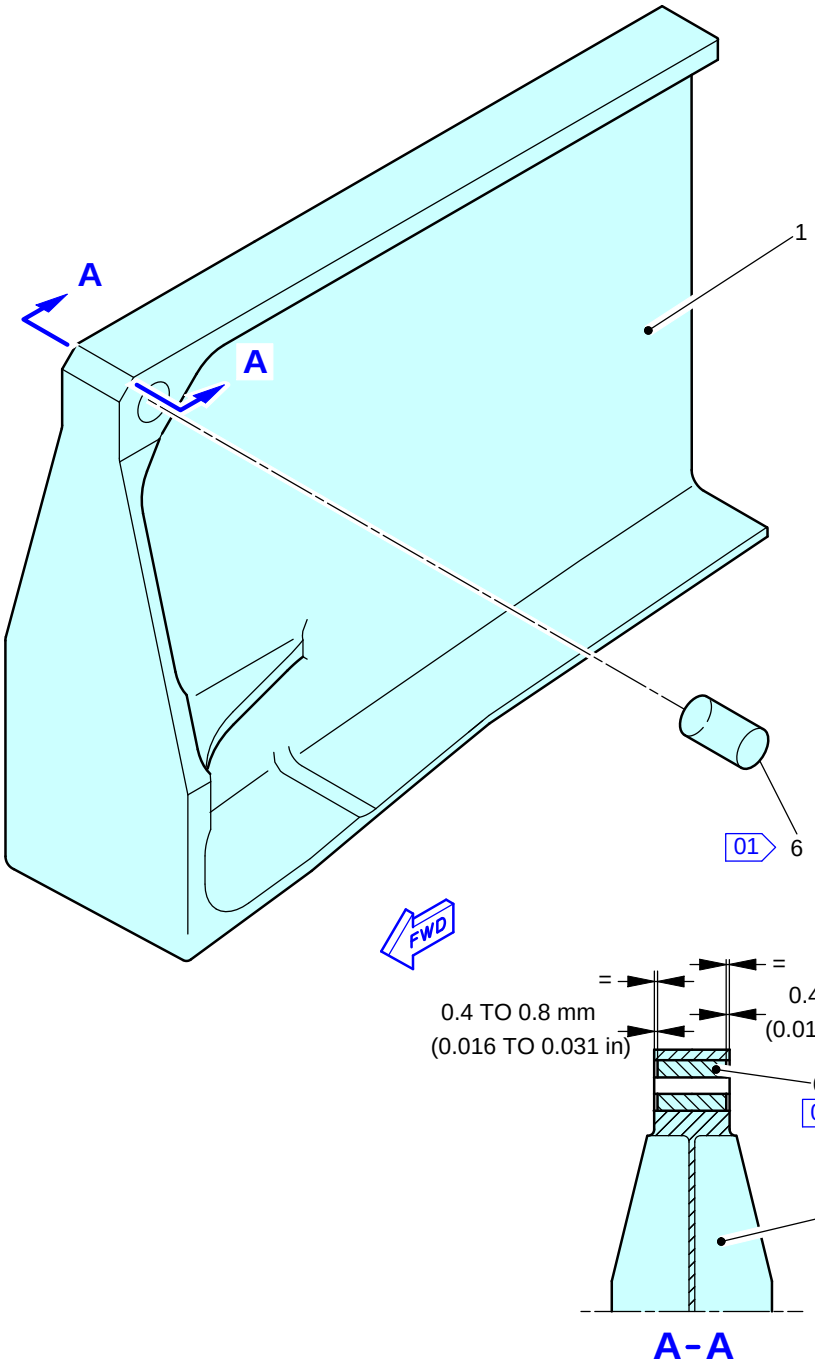
2 Install:

1	BUSHING	D5713006420000	Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(53) Task A320-A-57-XX-1228-04001-270A-A - Temporarily, Install the New Parts for Adjustment on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

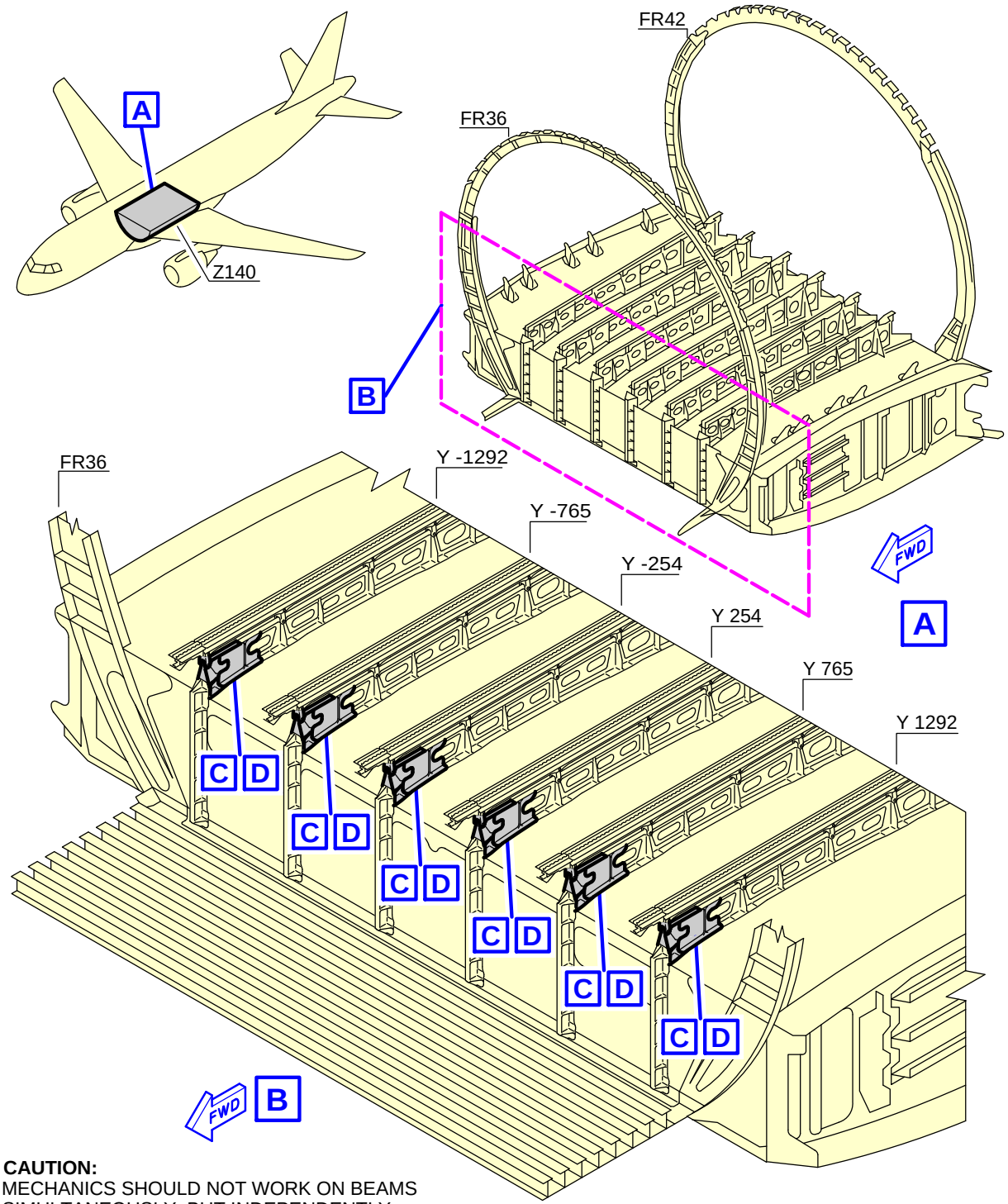
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

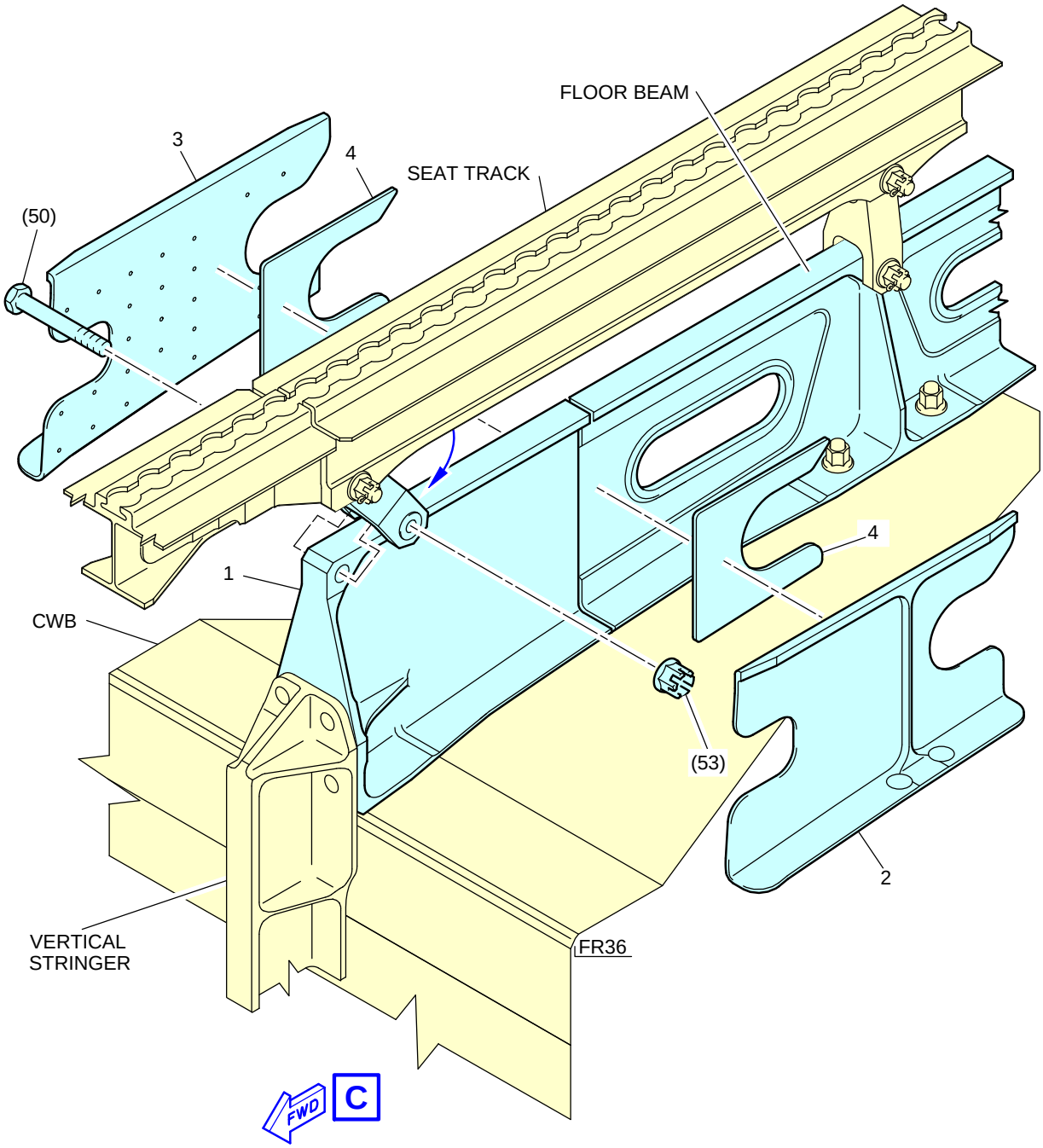


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

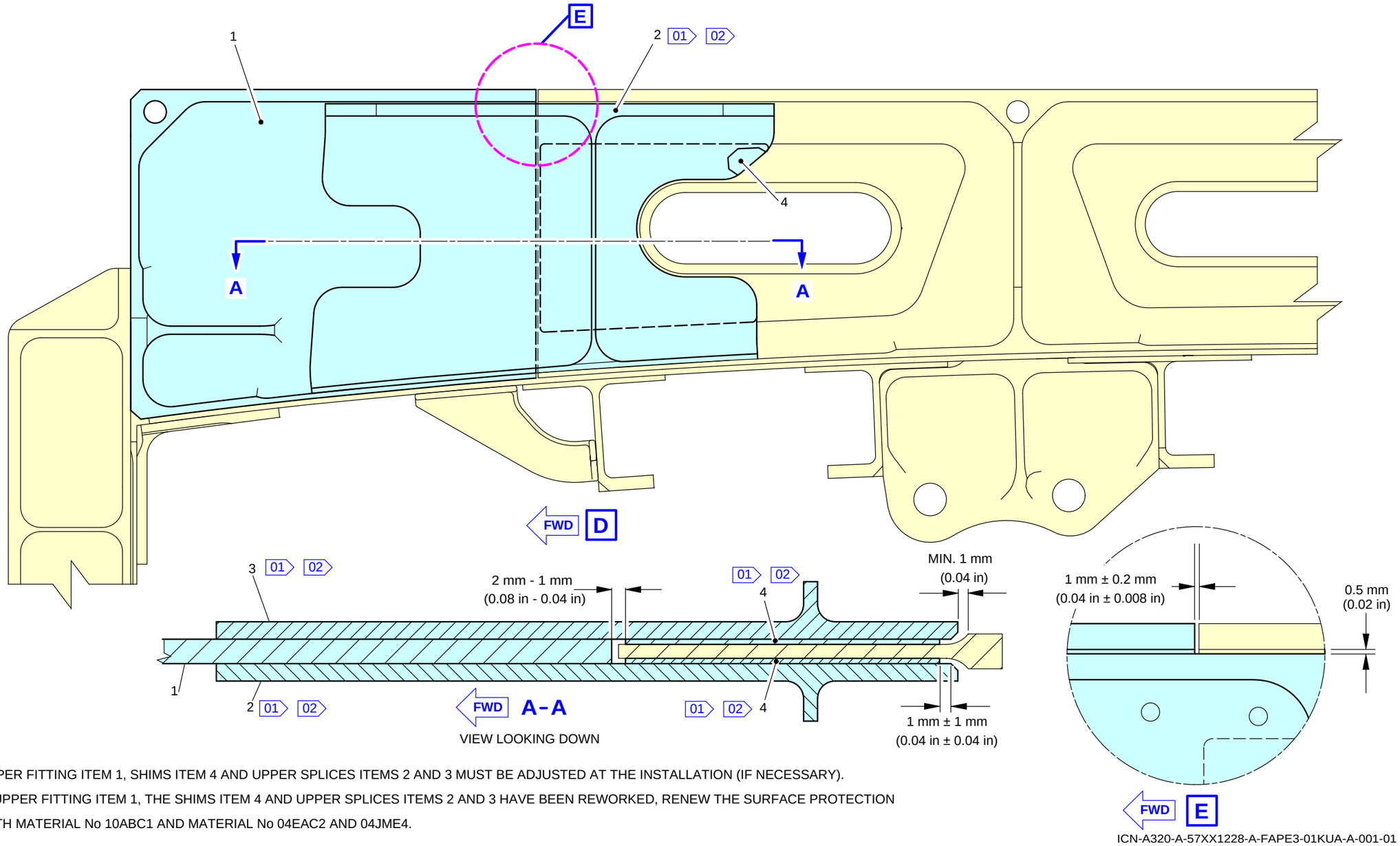
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(53) Task A320-A-57-XX-1228-04002-270A-A - Temporarily, Install the New Parts for Adjustment on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

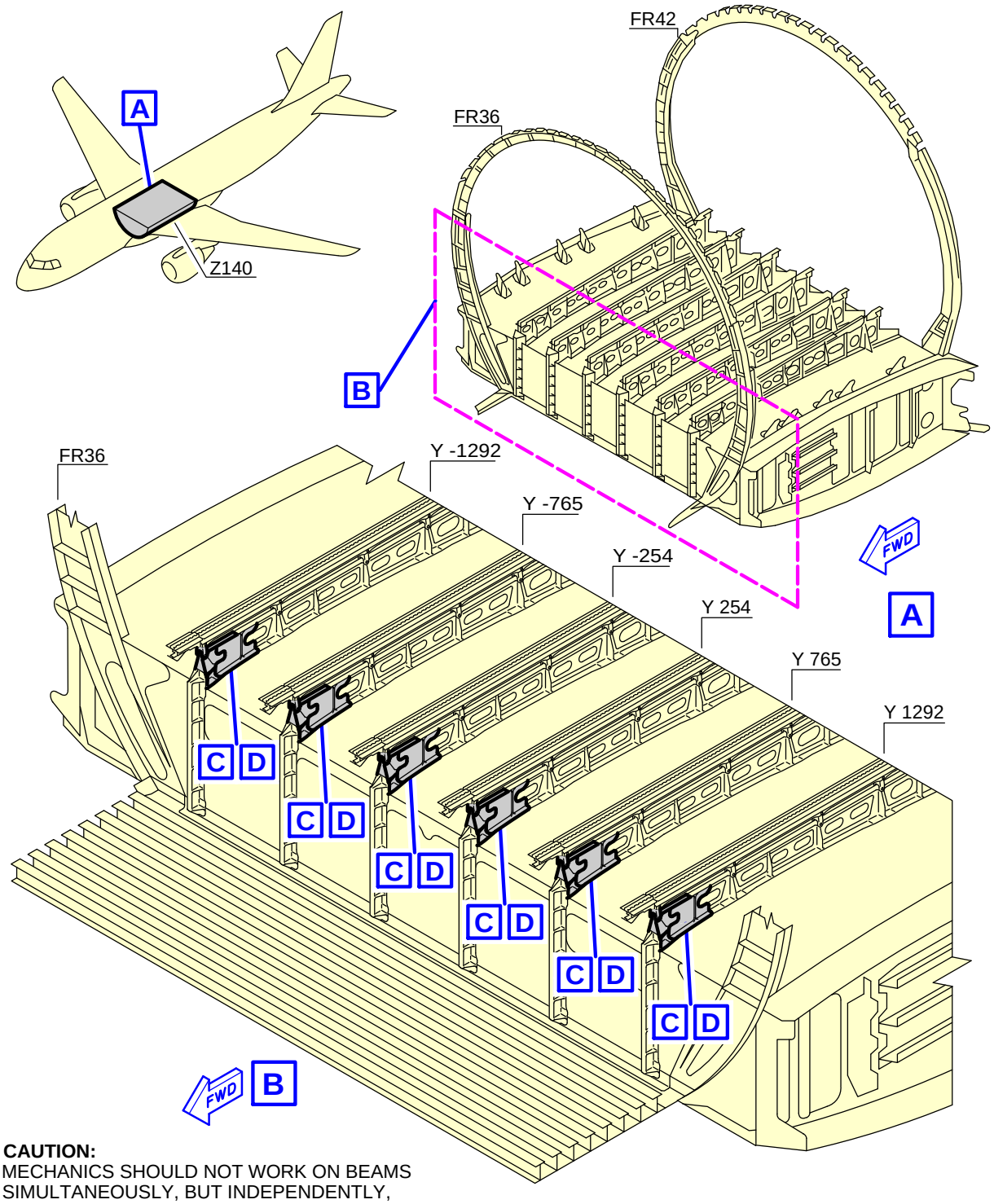
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

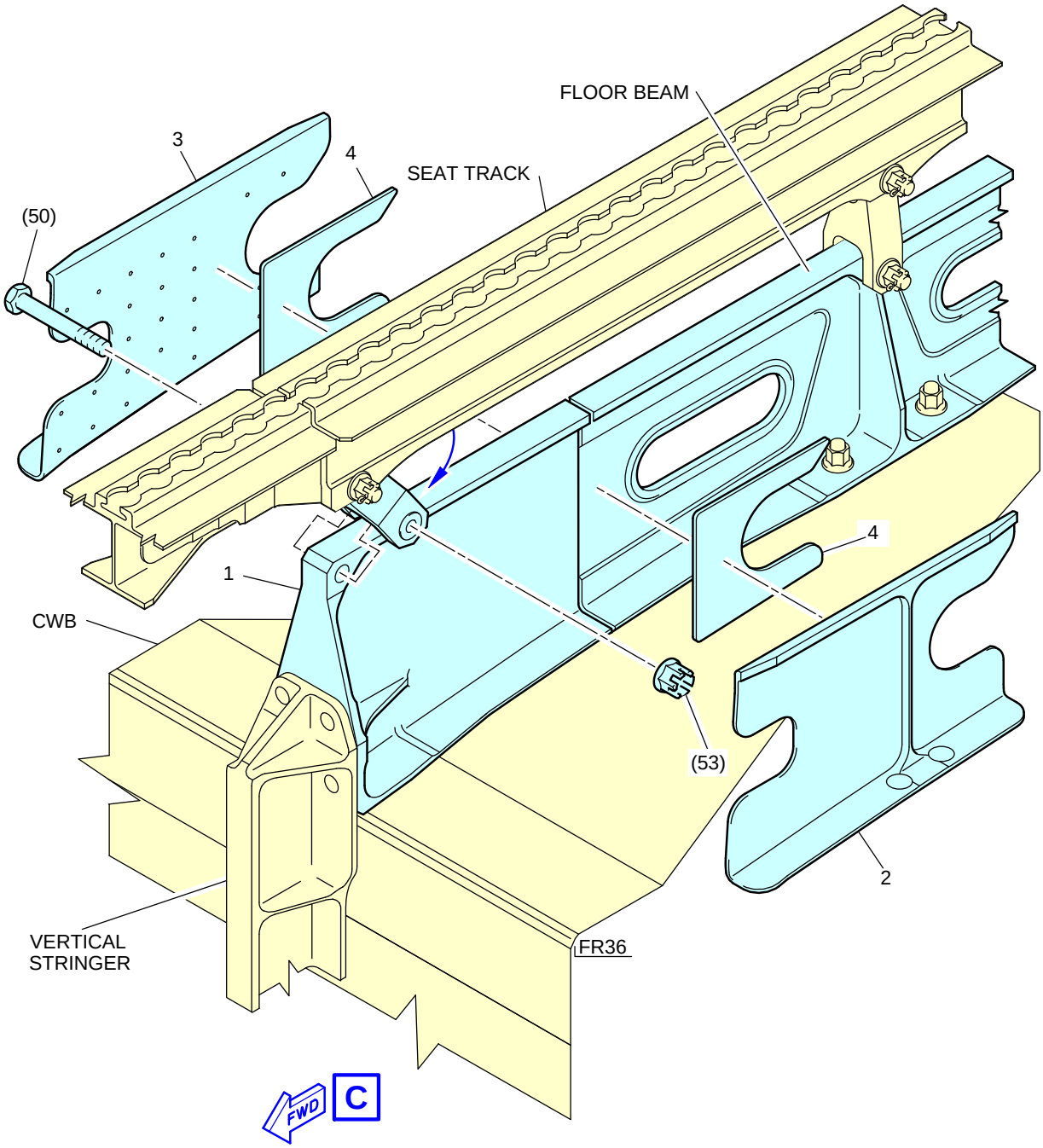


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

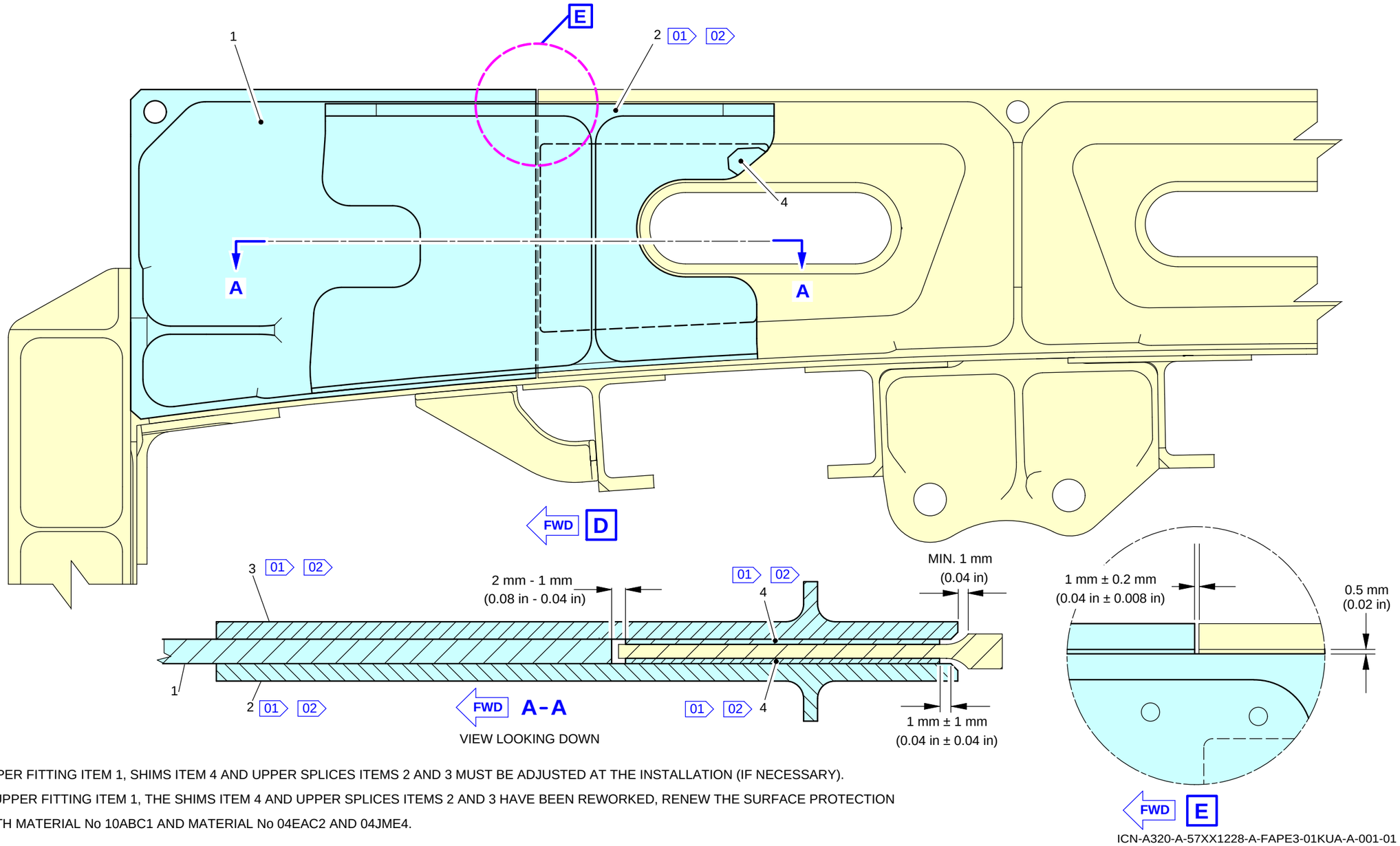
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(54) Task A320-A-57-XX-1228-08001-900A-A - Drill the New Parts on Y-254 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

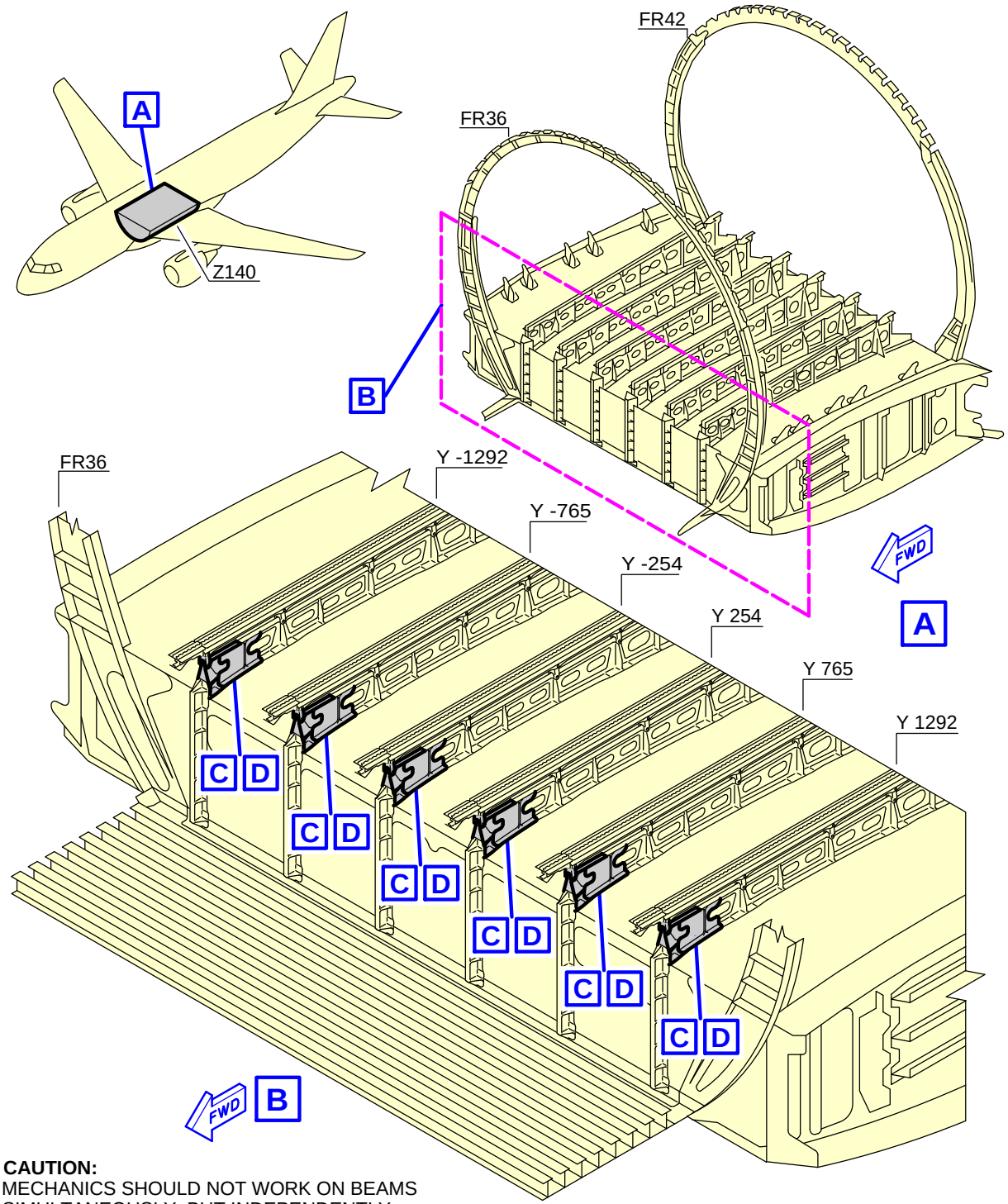
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

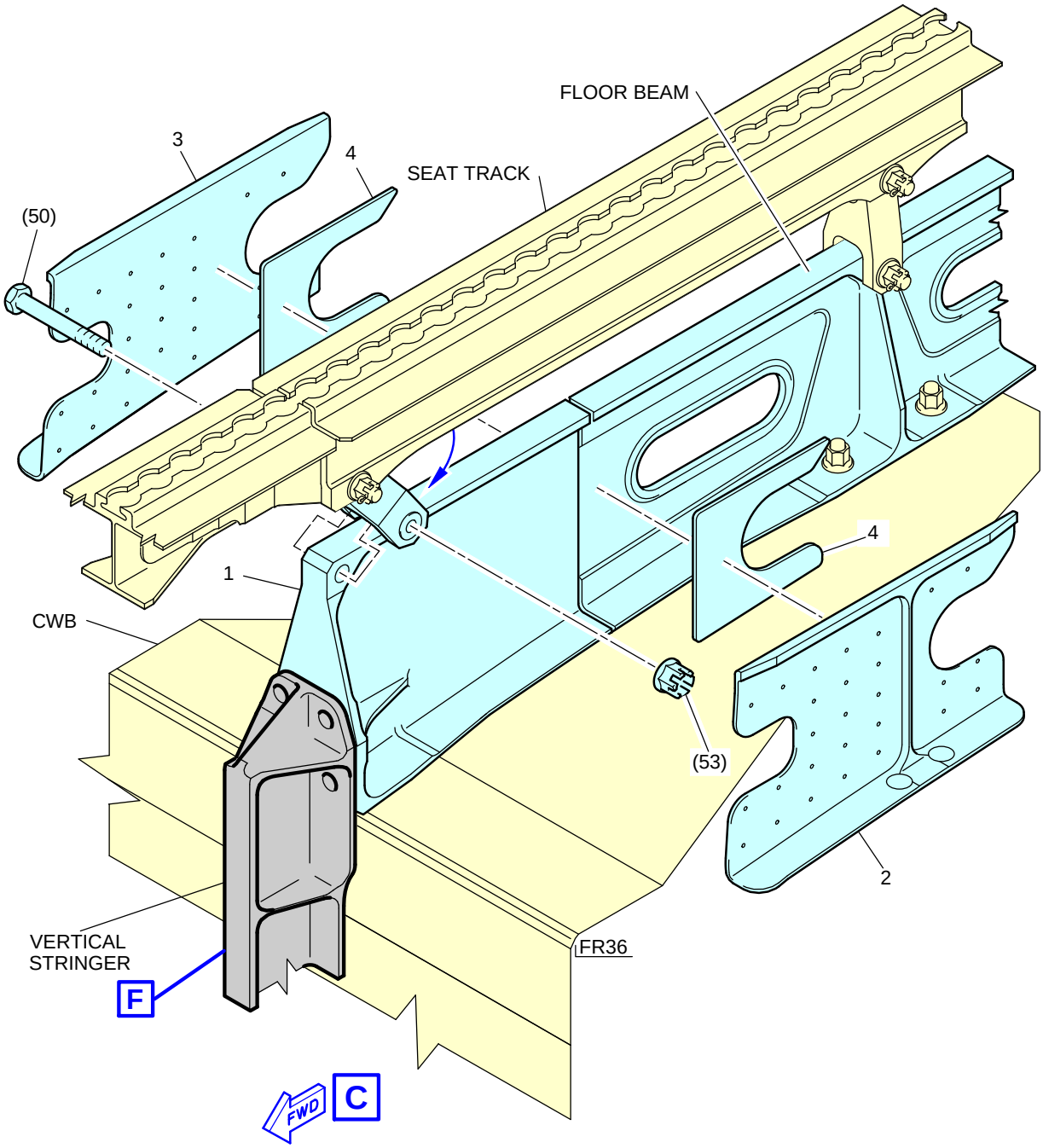


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

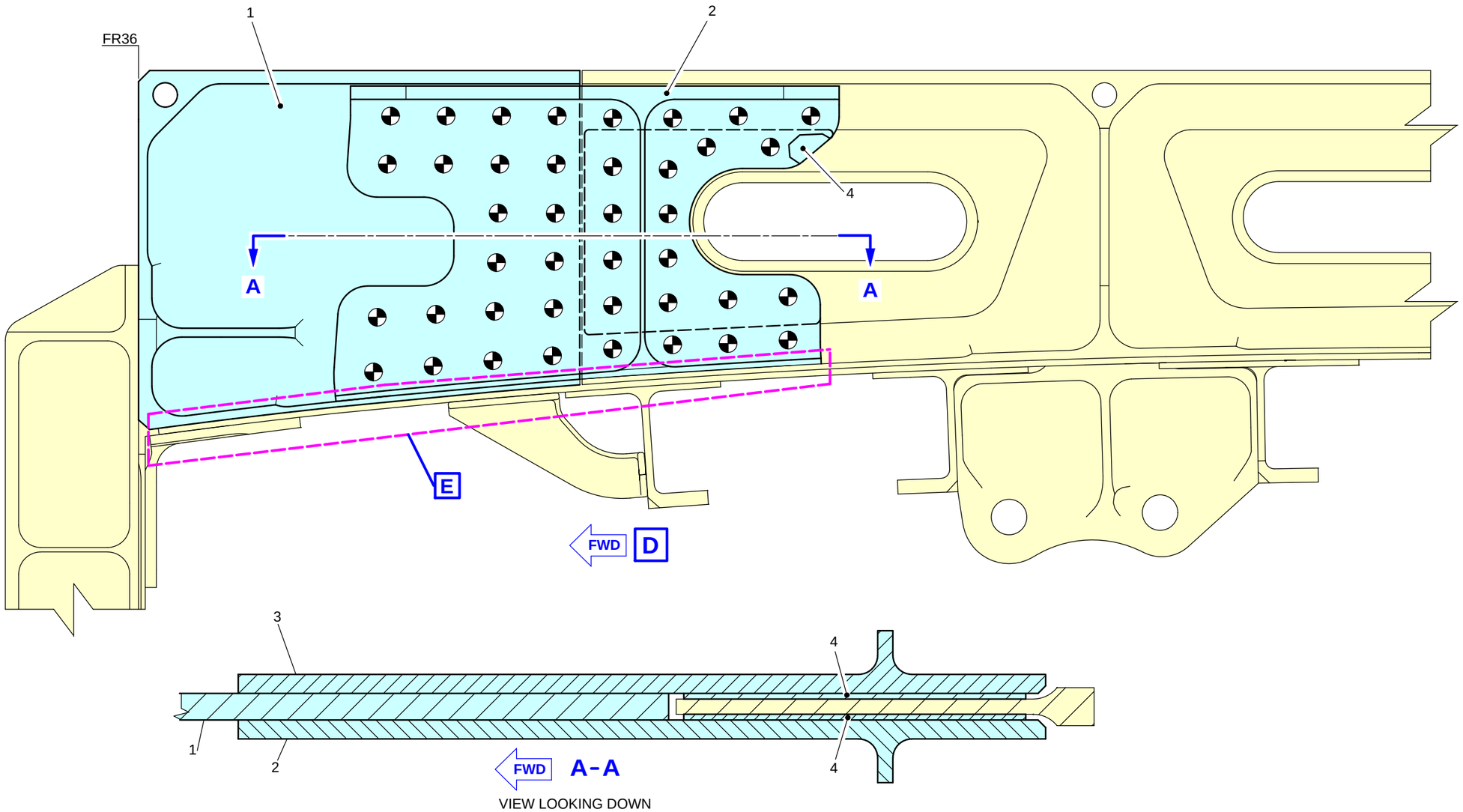
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

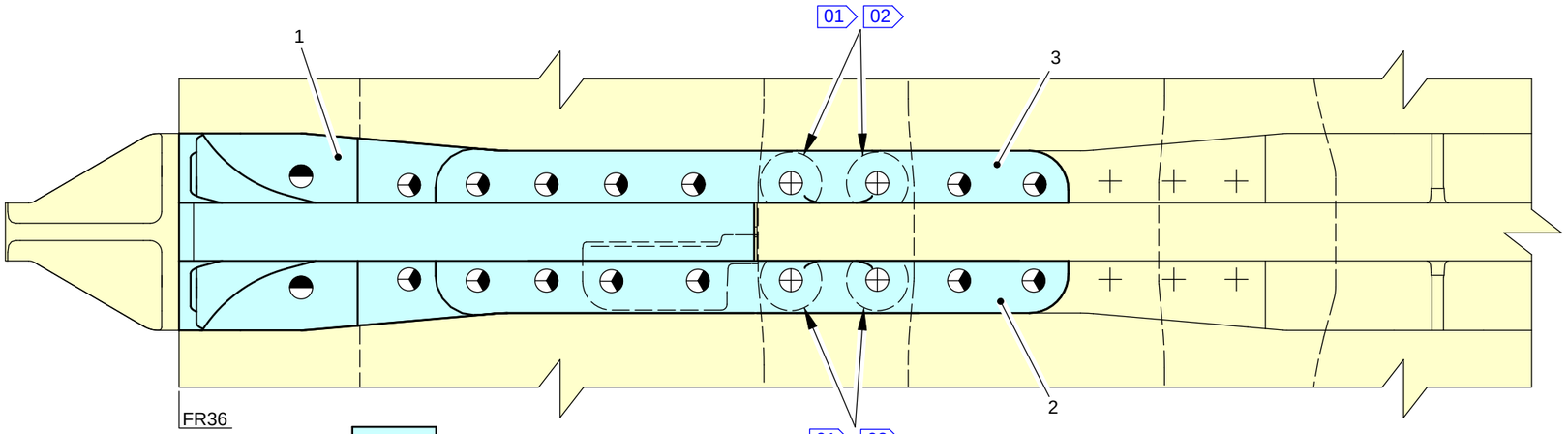


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

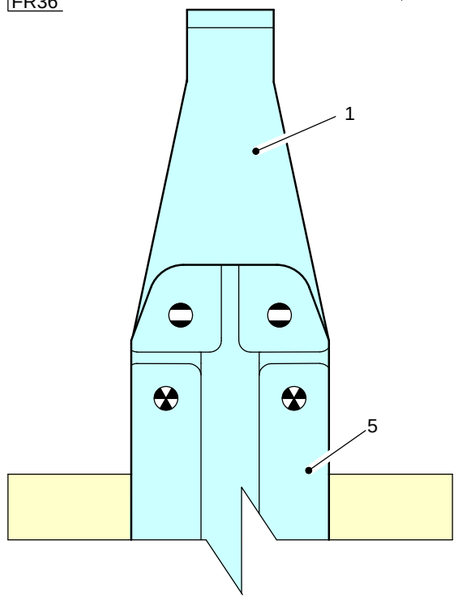
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◒	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(54) Task A320-A-57-XX-1228-08002-900A-A - Drill the New Parts on Y-254 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

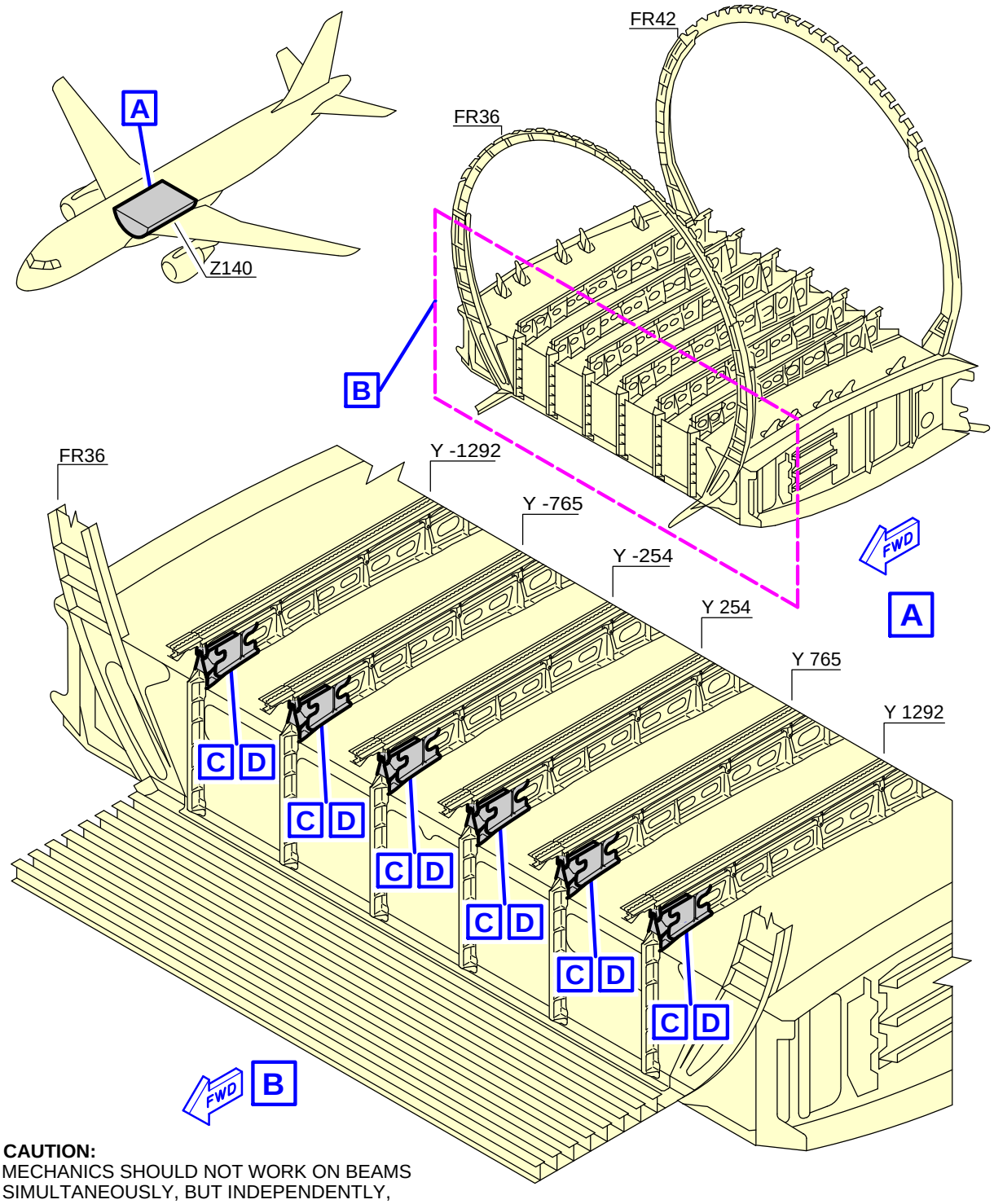
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

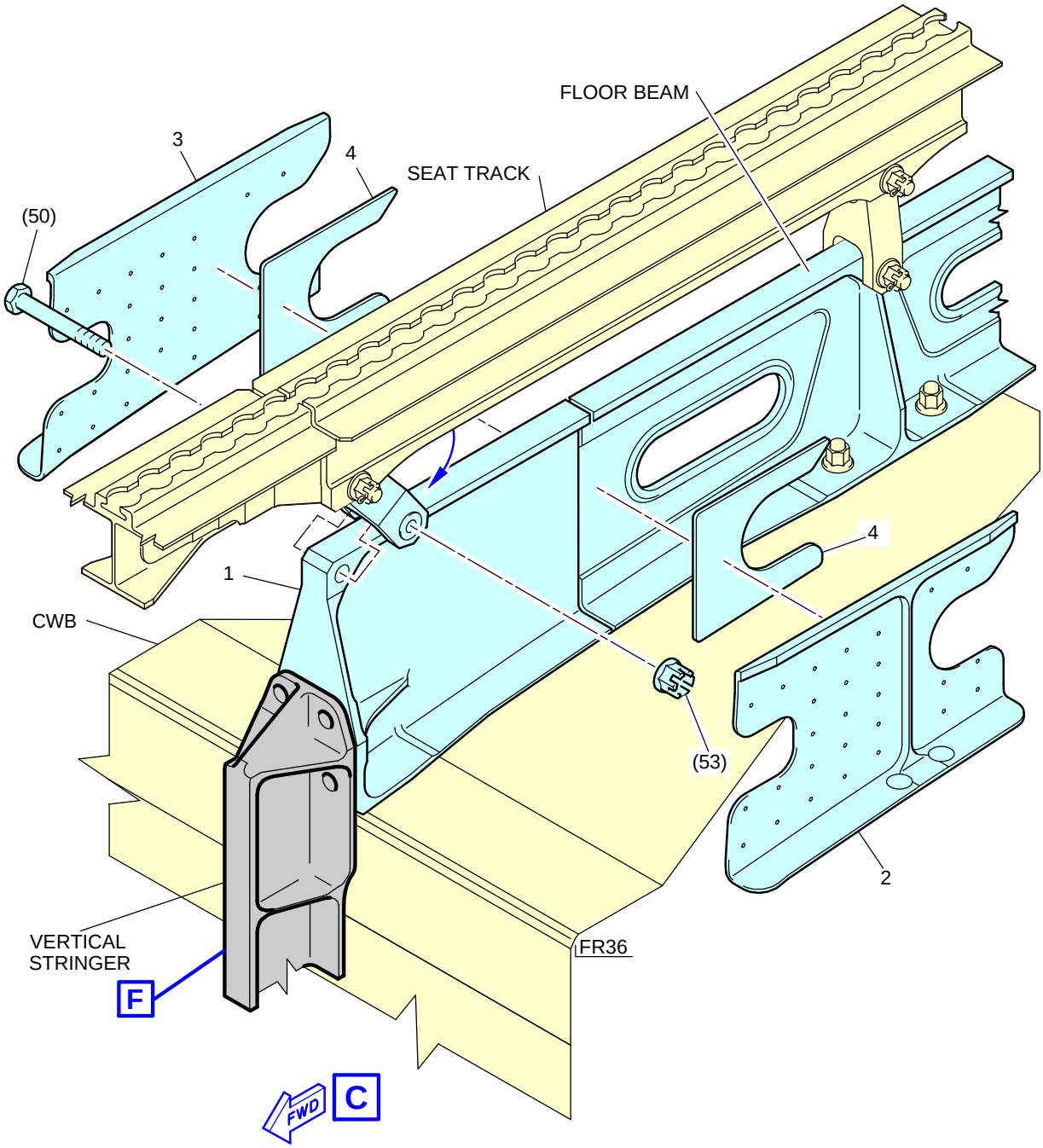


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

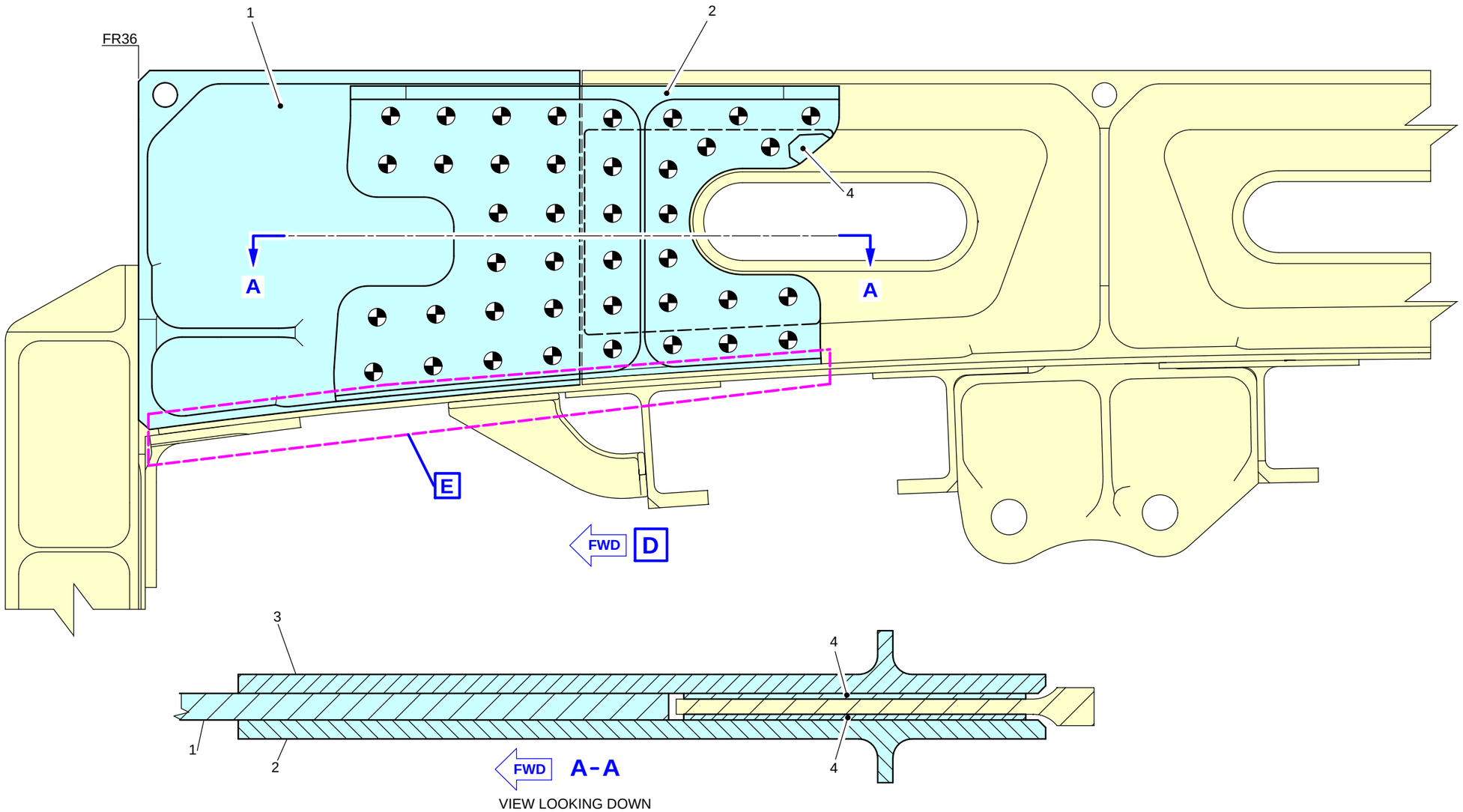
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

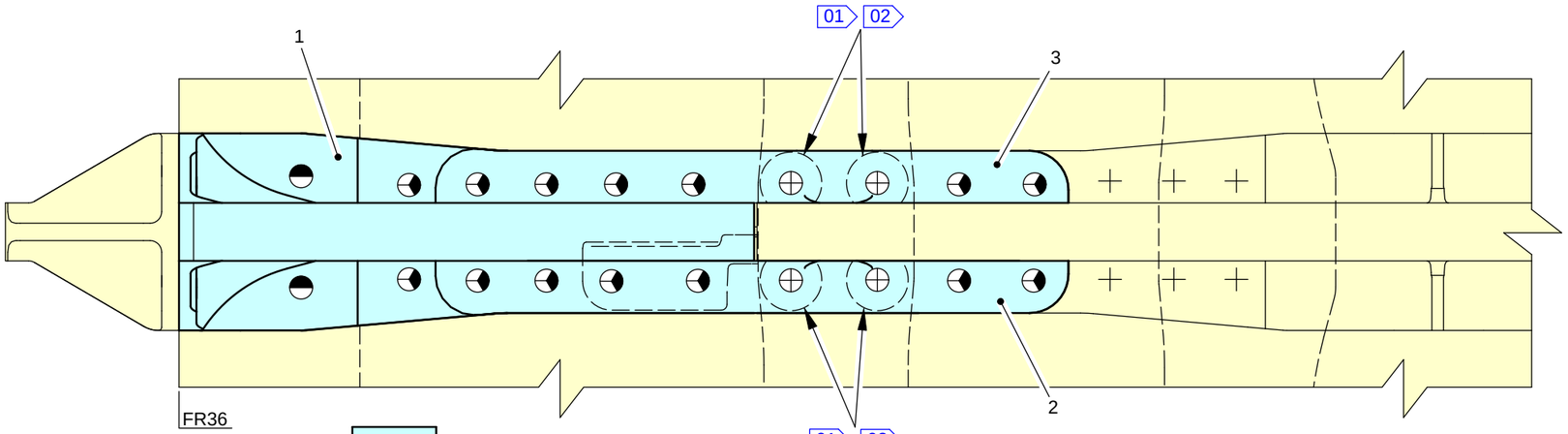


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

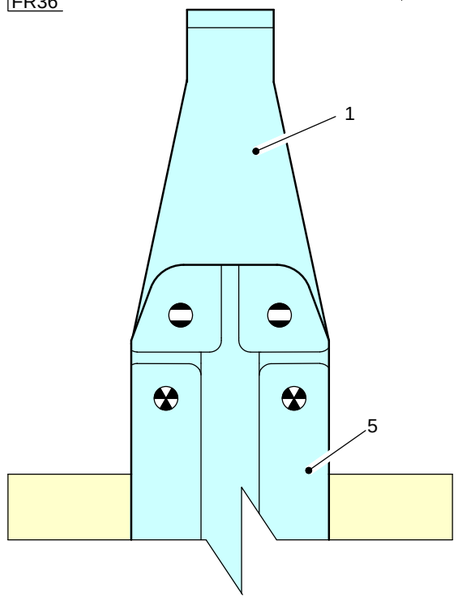
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(55) Task A320-A-57-XX-1228-20001-720A-A - Install the New Parts on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

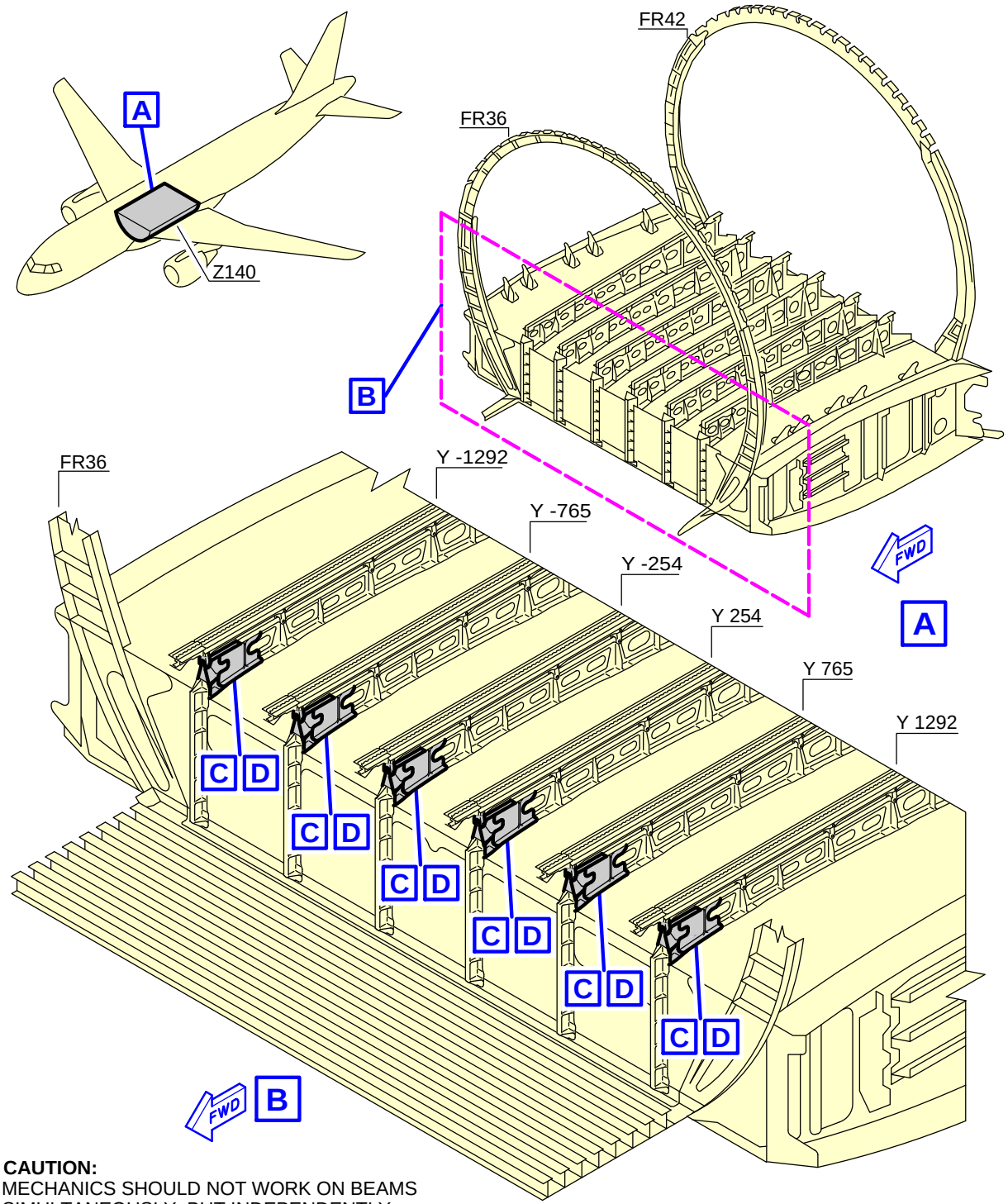
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

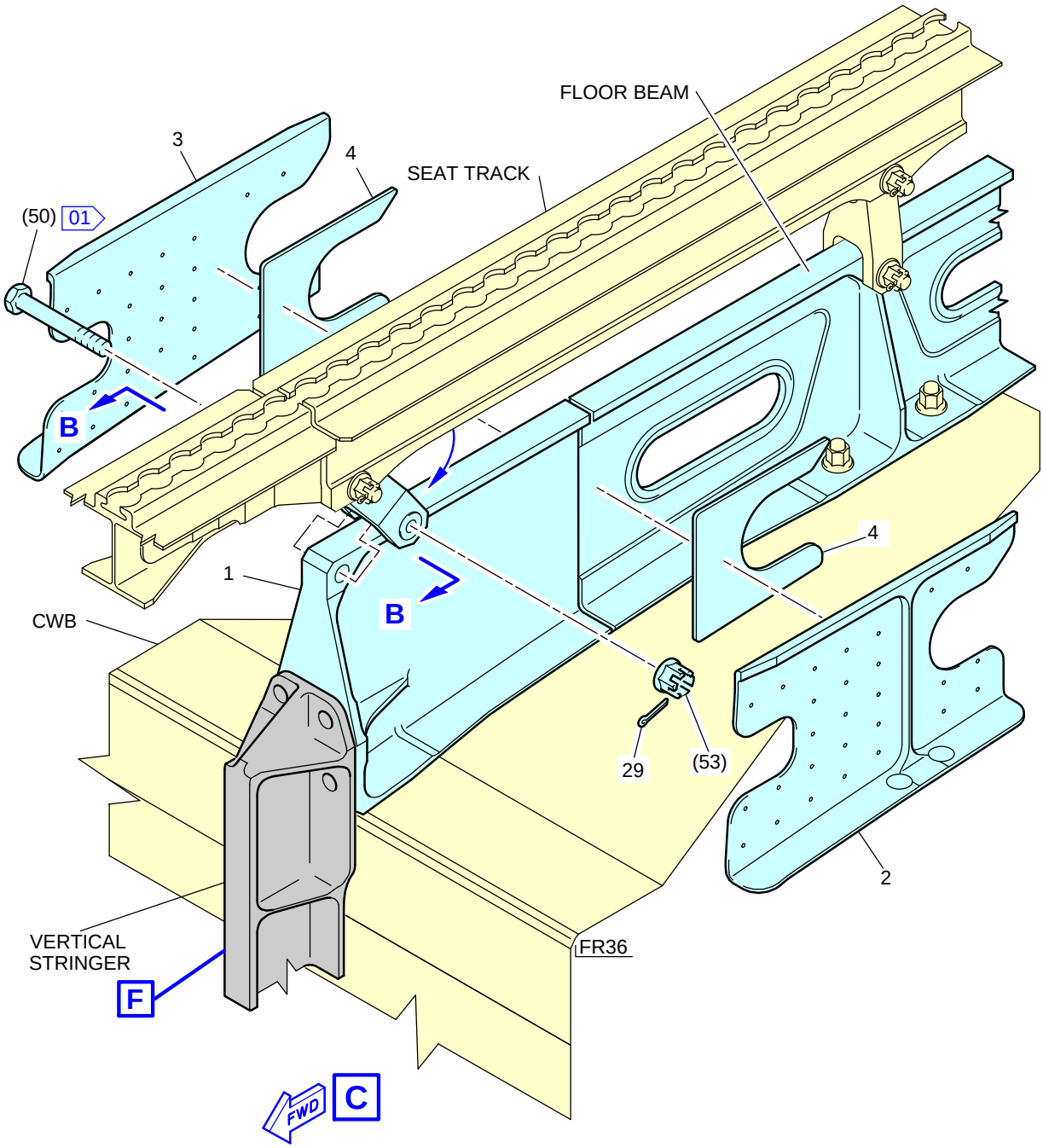


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



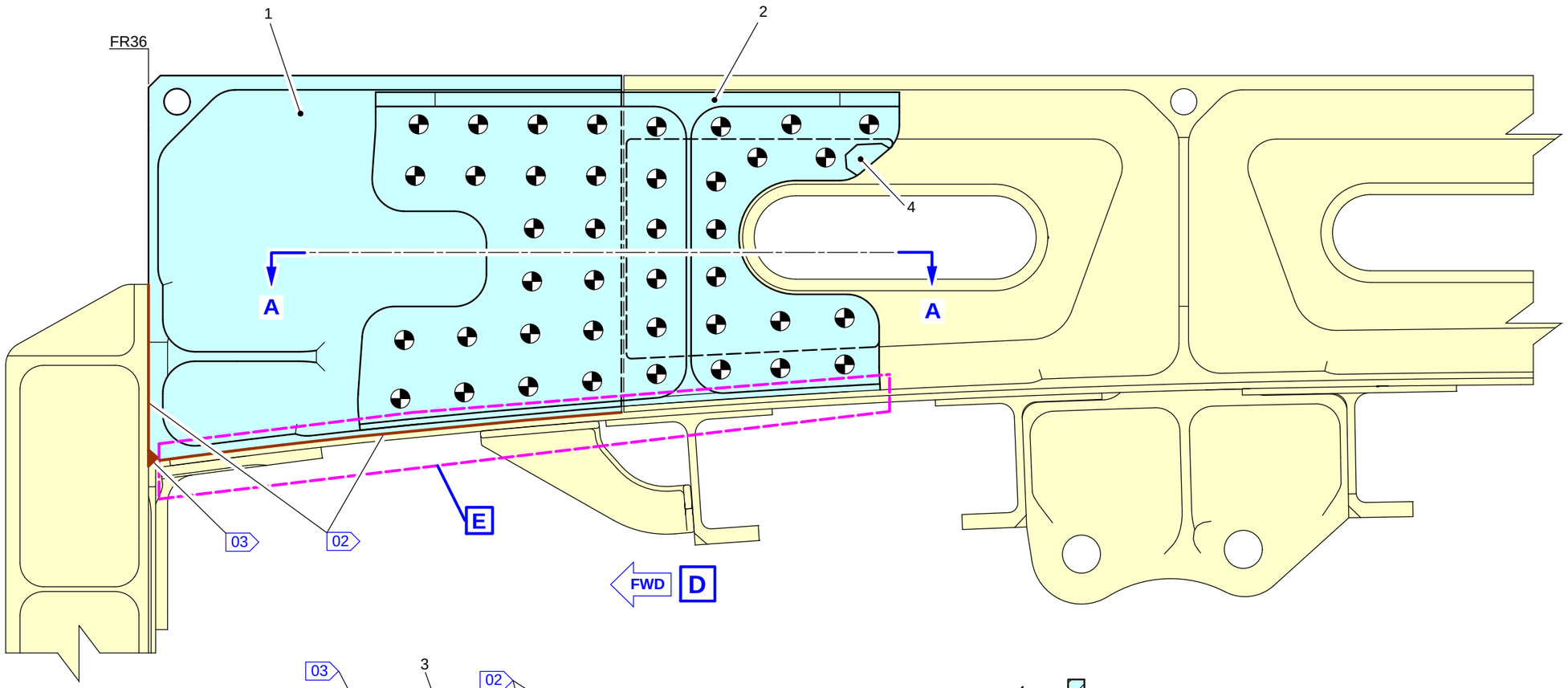
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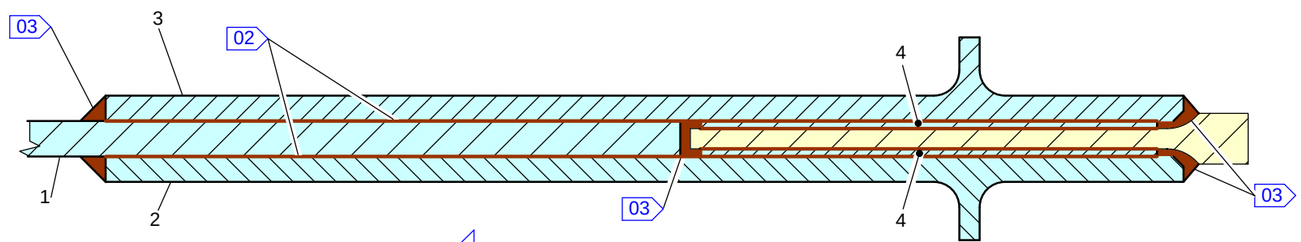
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

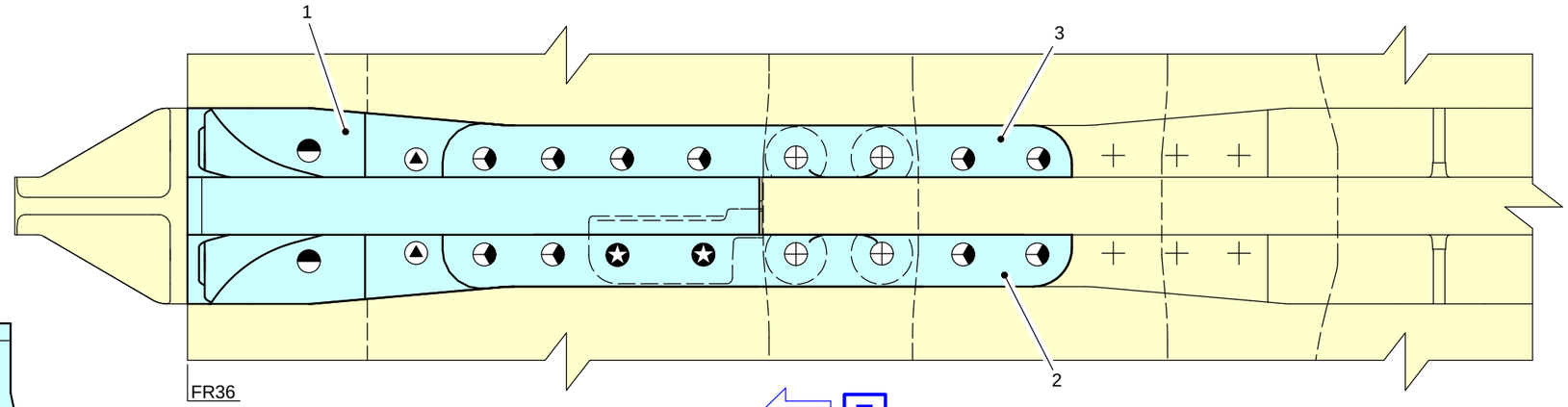
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

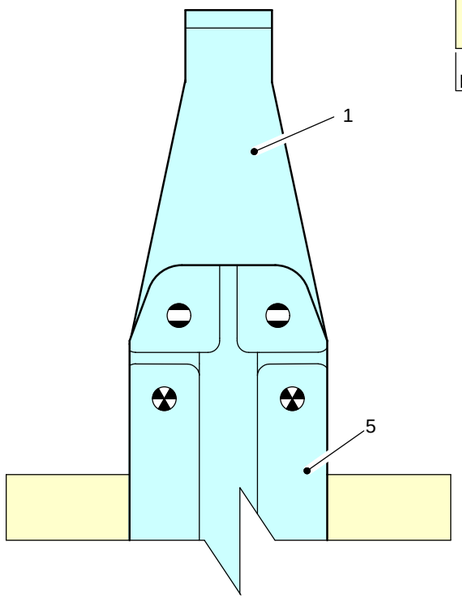
Installation of the New Parts at FR36

CONF 001 003 004



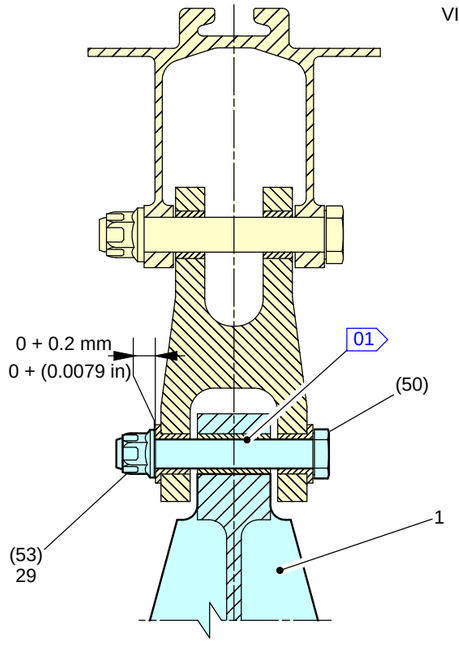


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 002

(55) Task A320-A-57-XX-1228-20002-720A-A - Install the New Parts on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE with:	D0041005420200	Item 3	
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1		

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

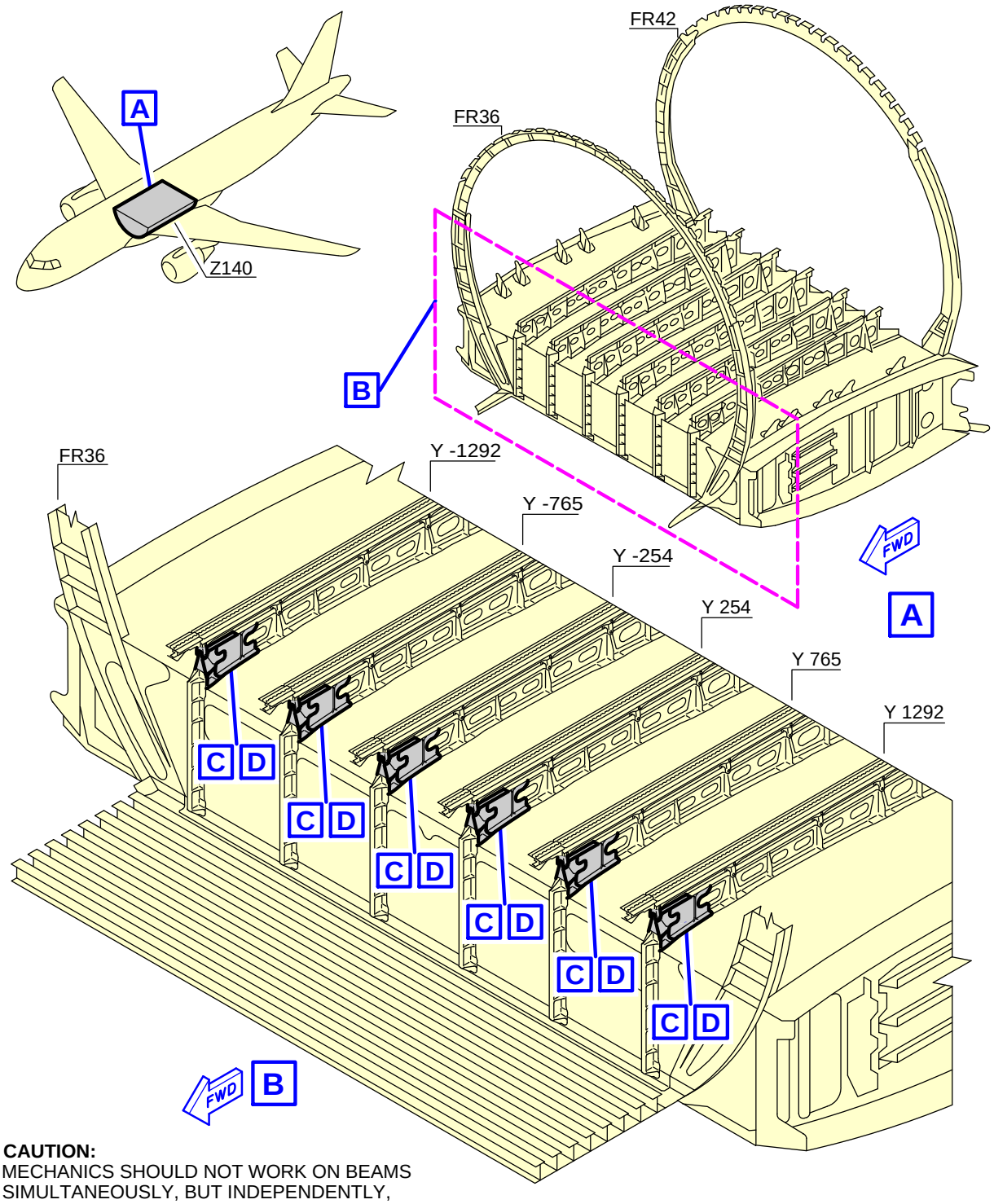
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

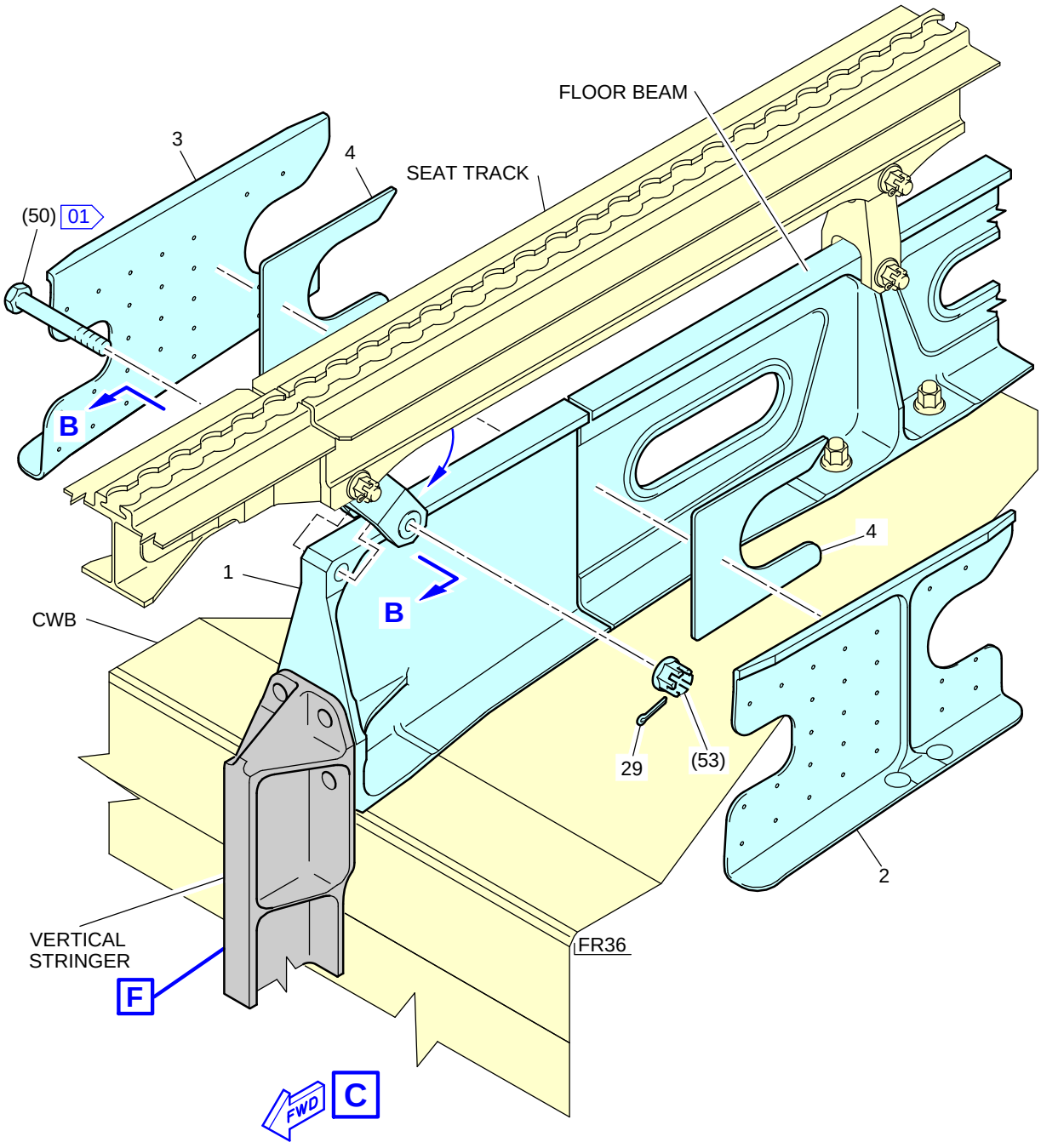


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



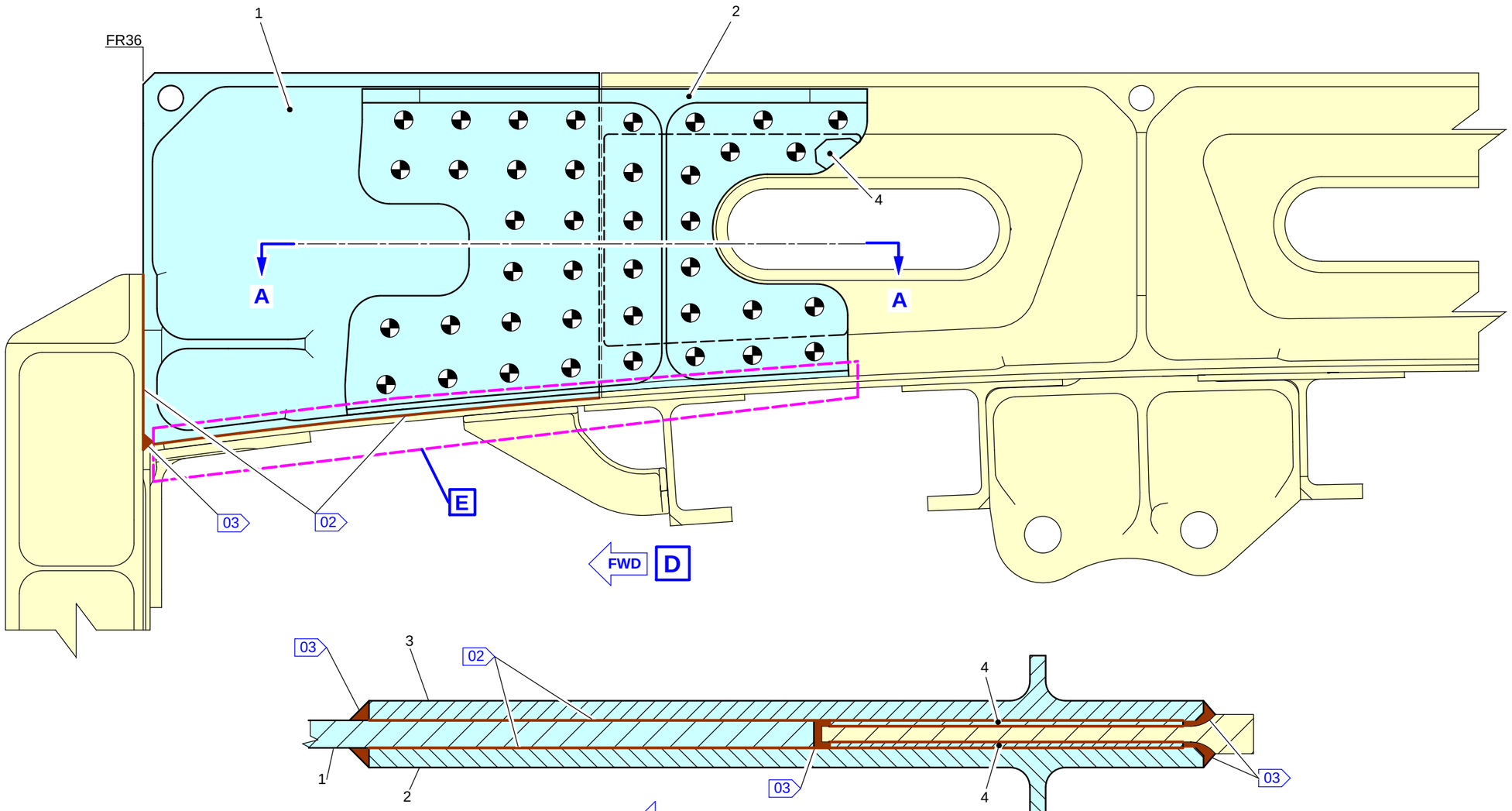
NOTE:

01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002



VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

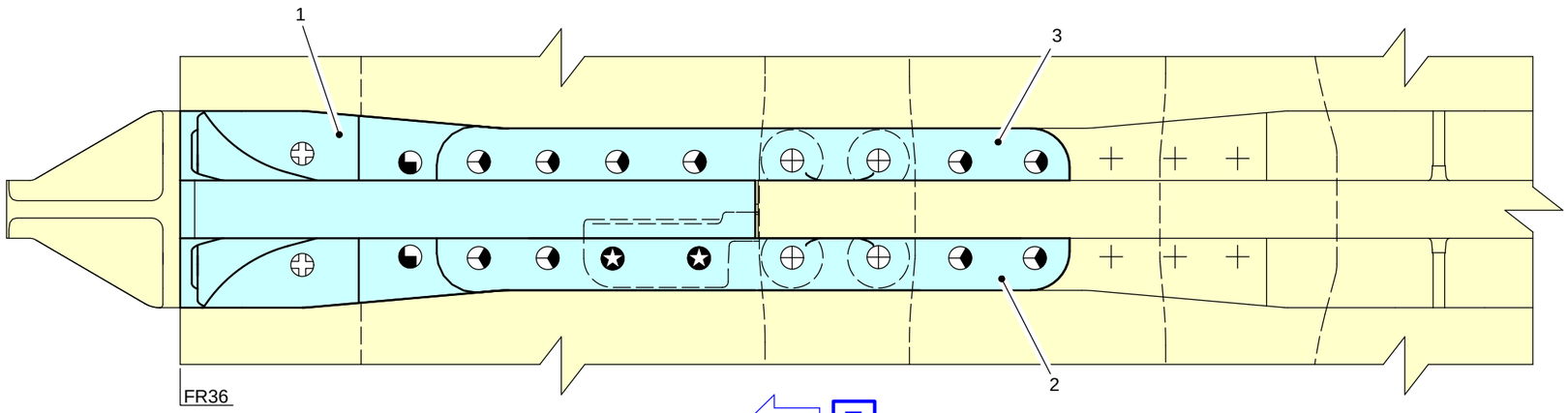
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

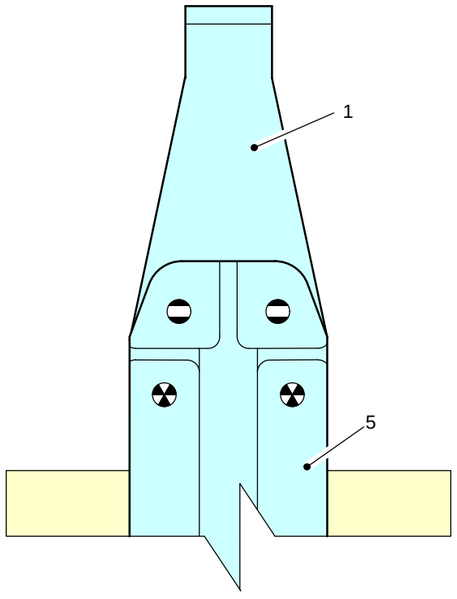
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

CONF 002

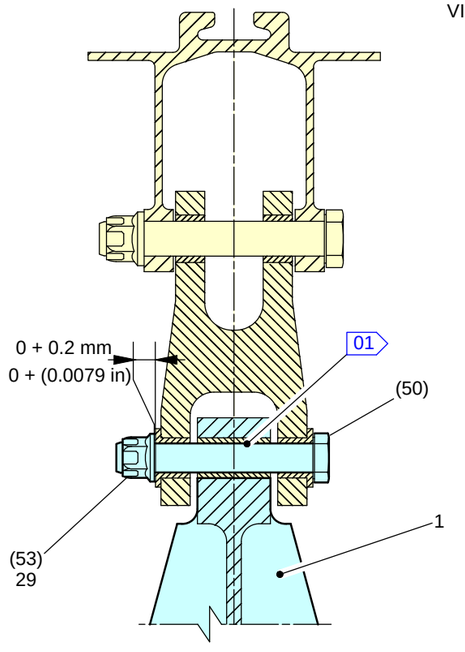


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(56) Task A320-A-57-XX-1228-04001-250A-A - Protect the Fasteners and the New Parts on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

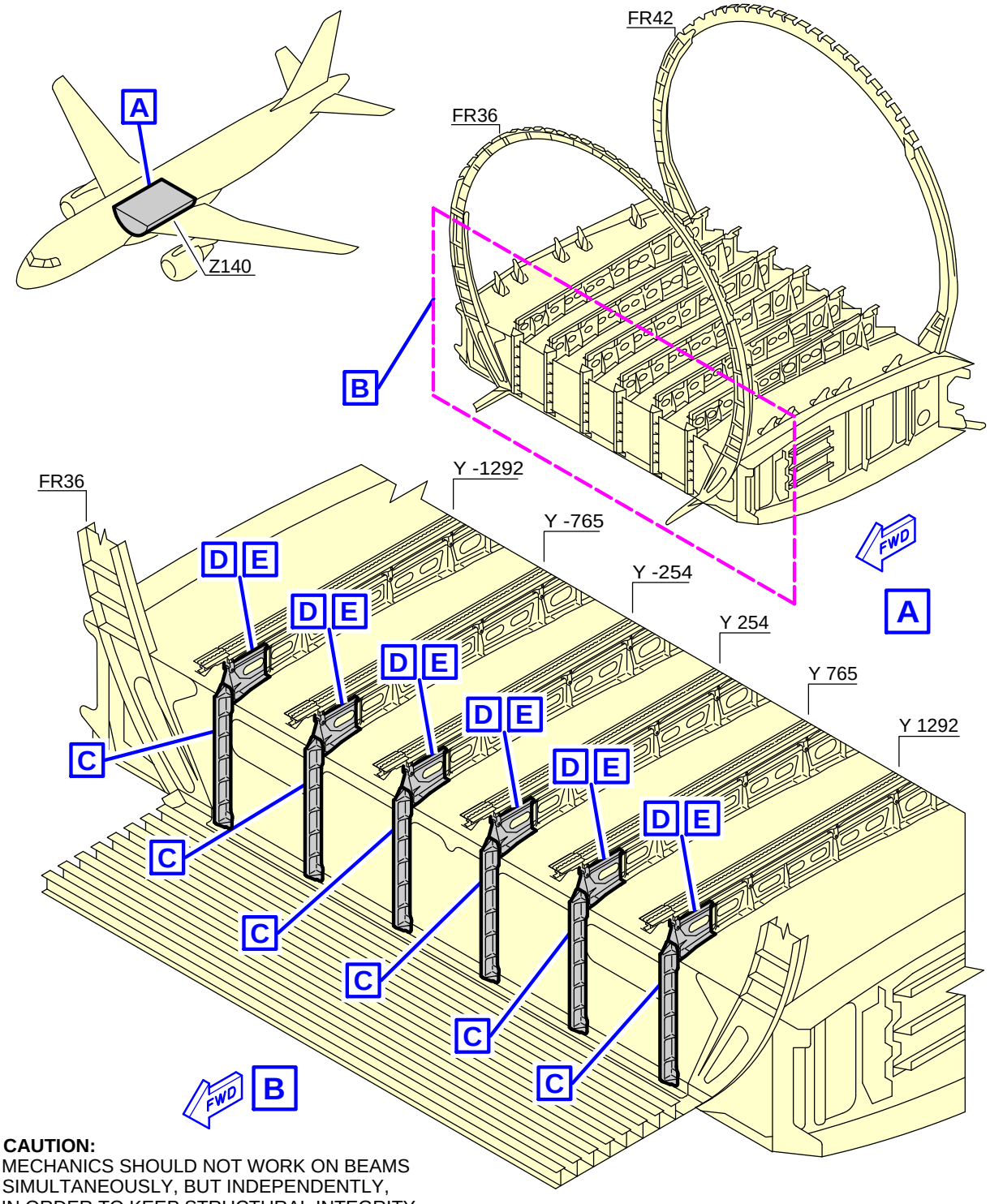
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

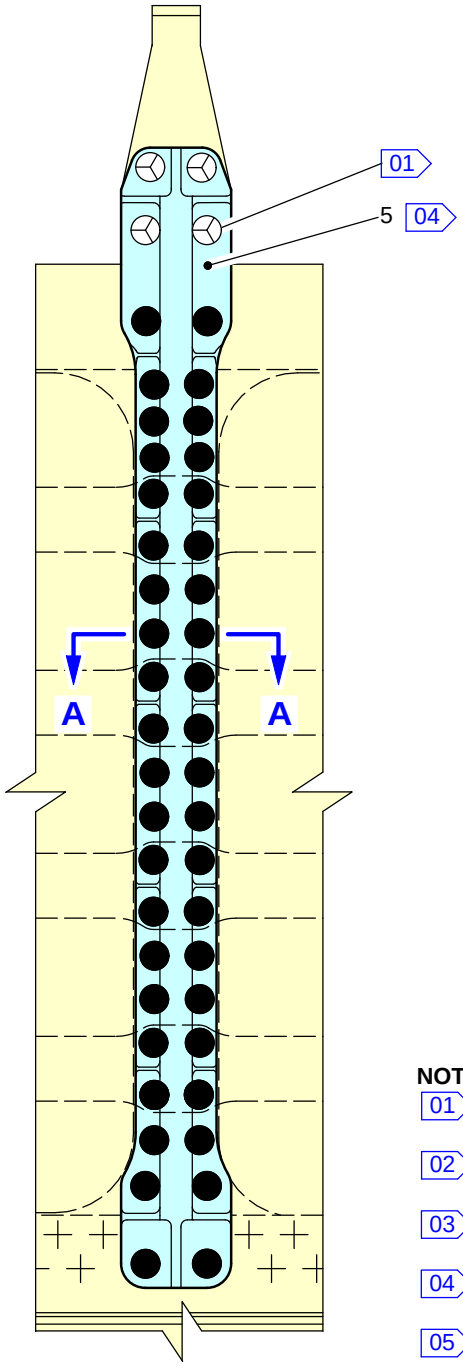


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

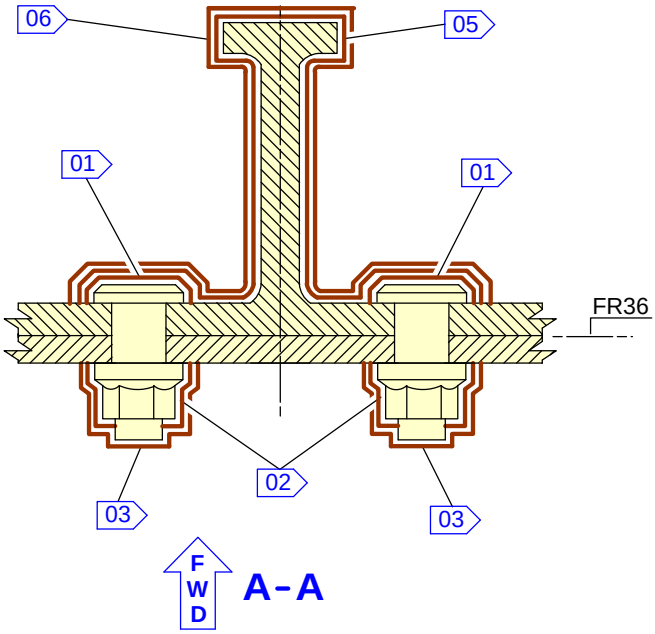
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊘	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

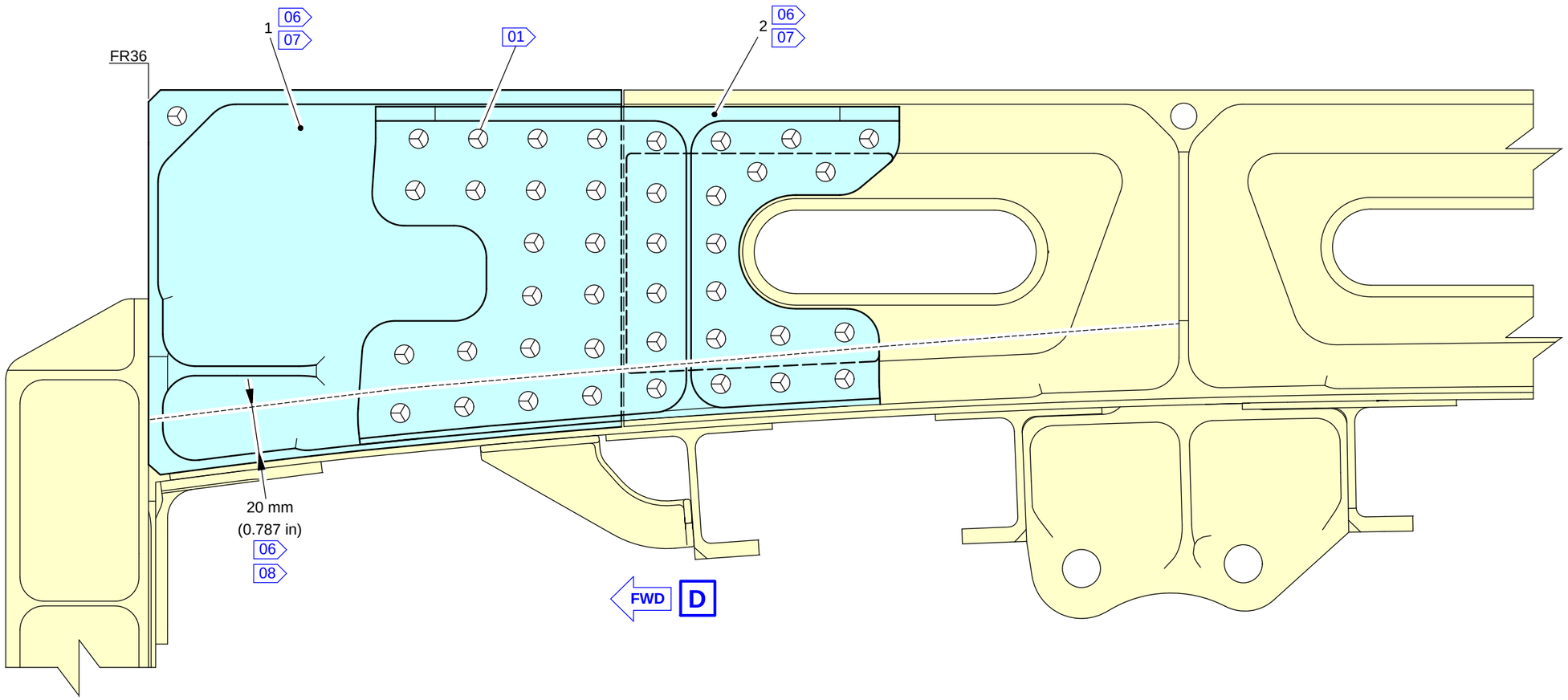
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



HOLE SYMBOL	NOTE
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

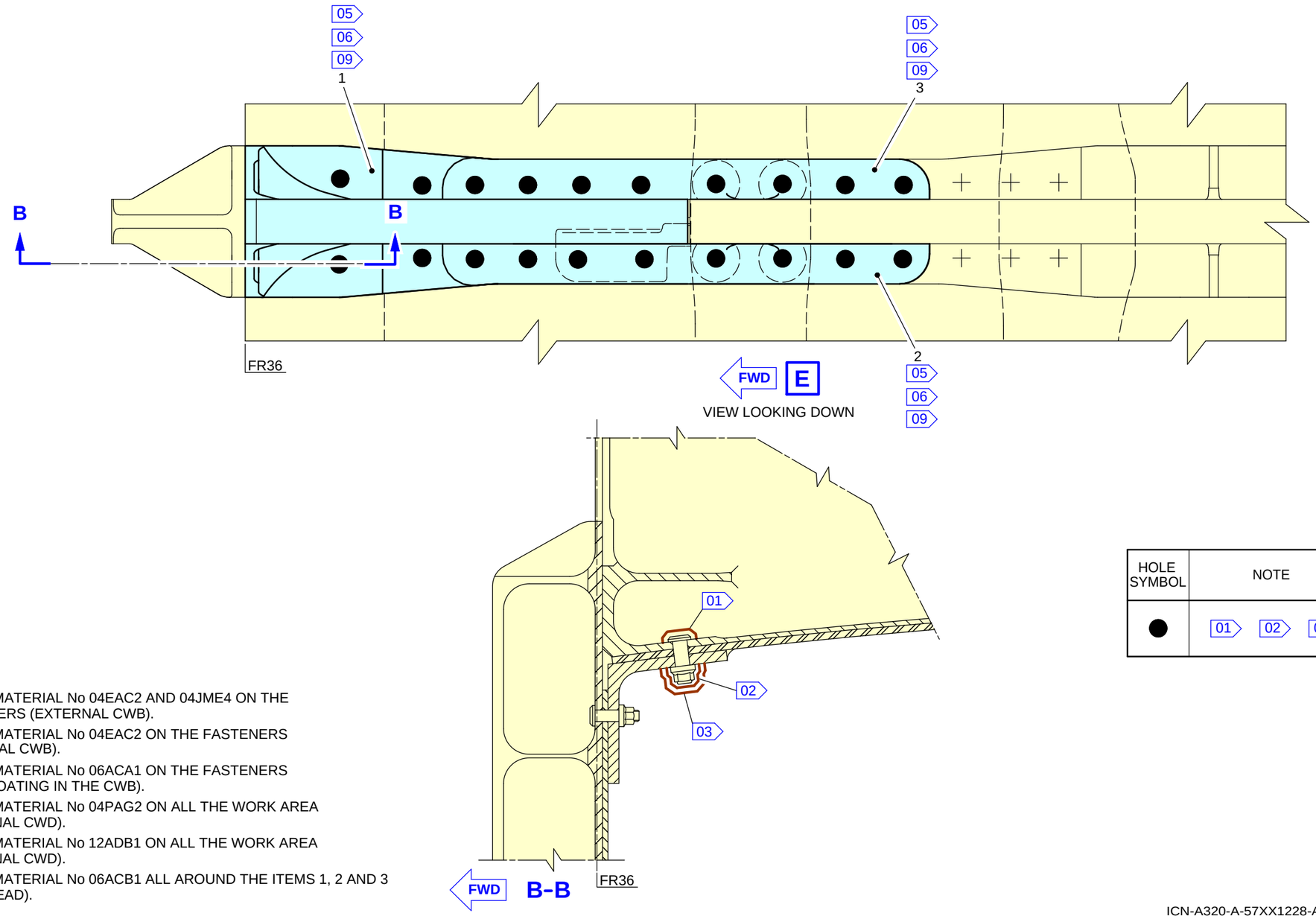
08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(56) Task A320-A-57-XX-1228-04002-250A-A - Protect the Fasteners and the New Parts on Y-254 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

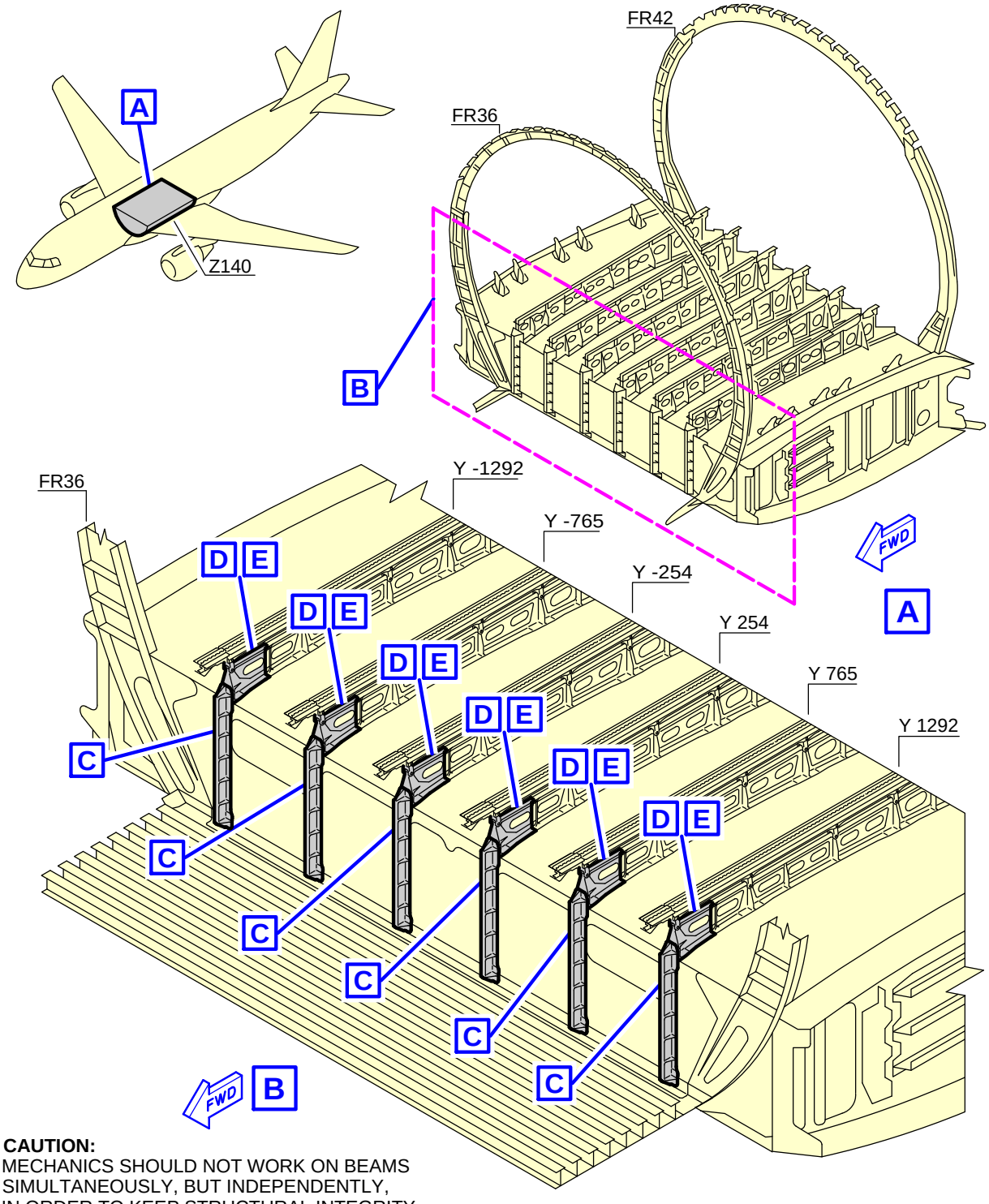
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

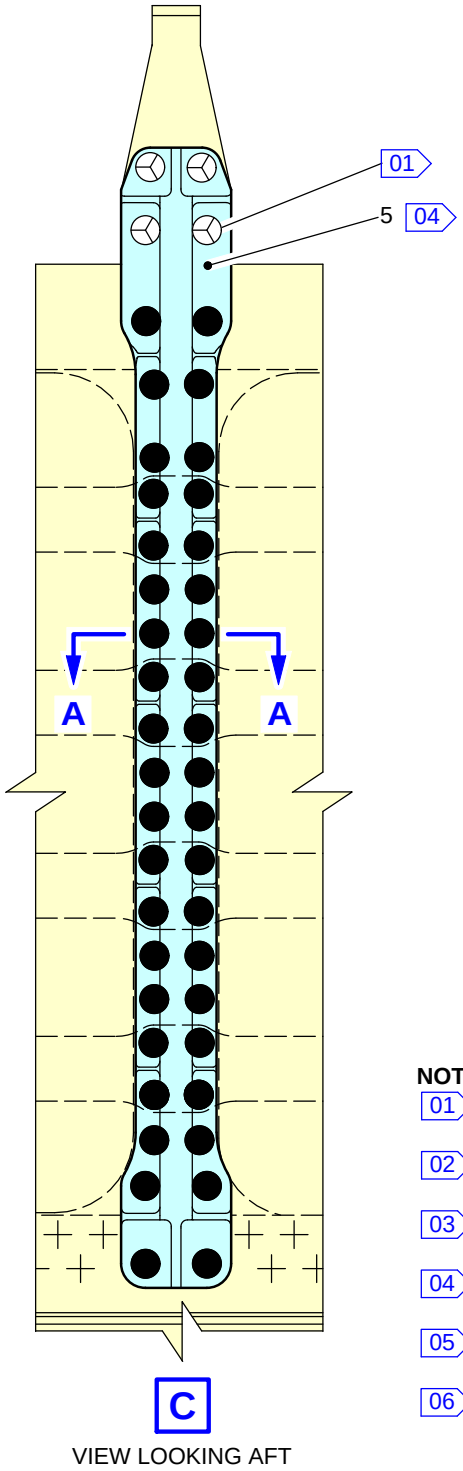


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

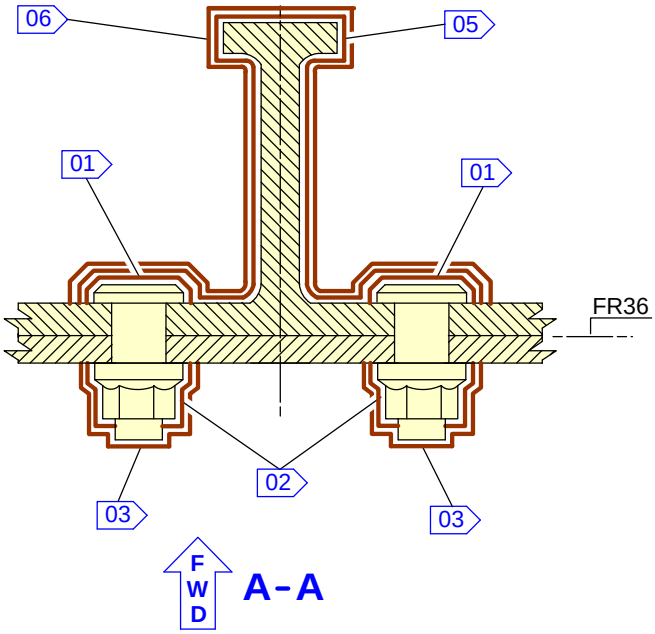
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

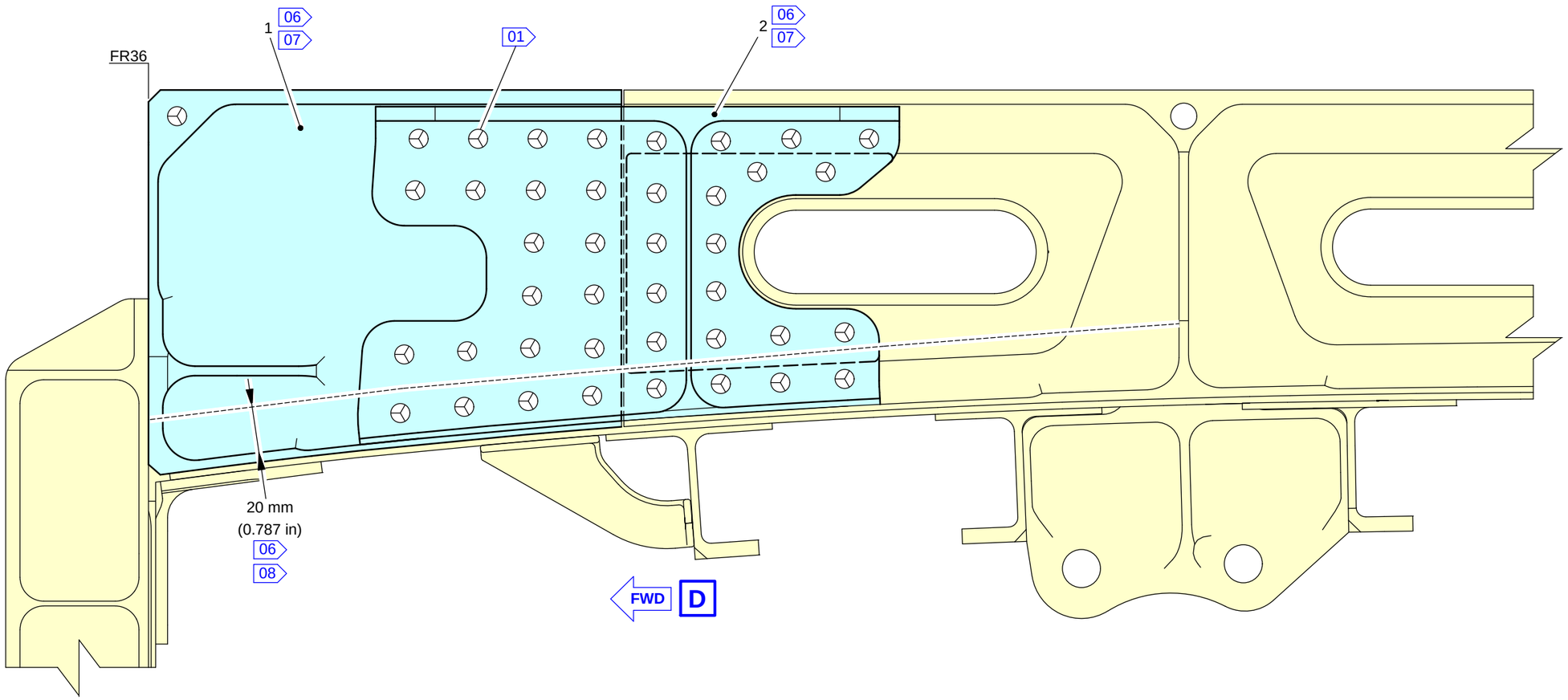
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

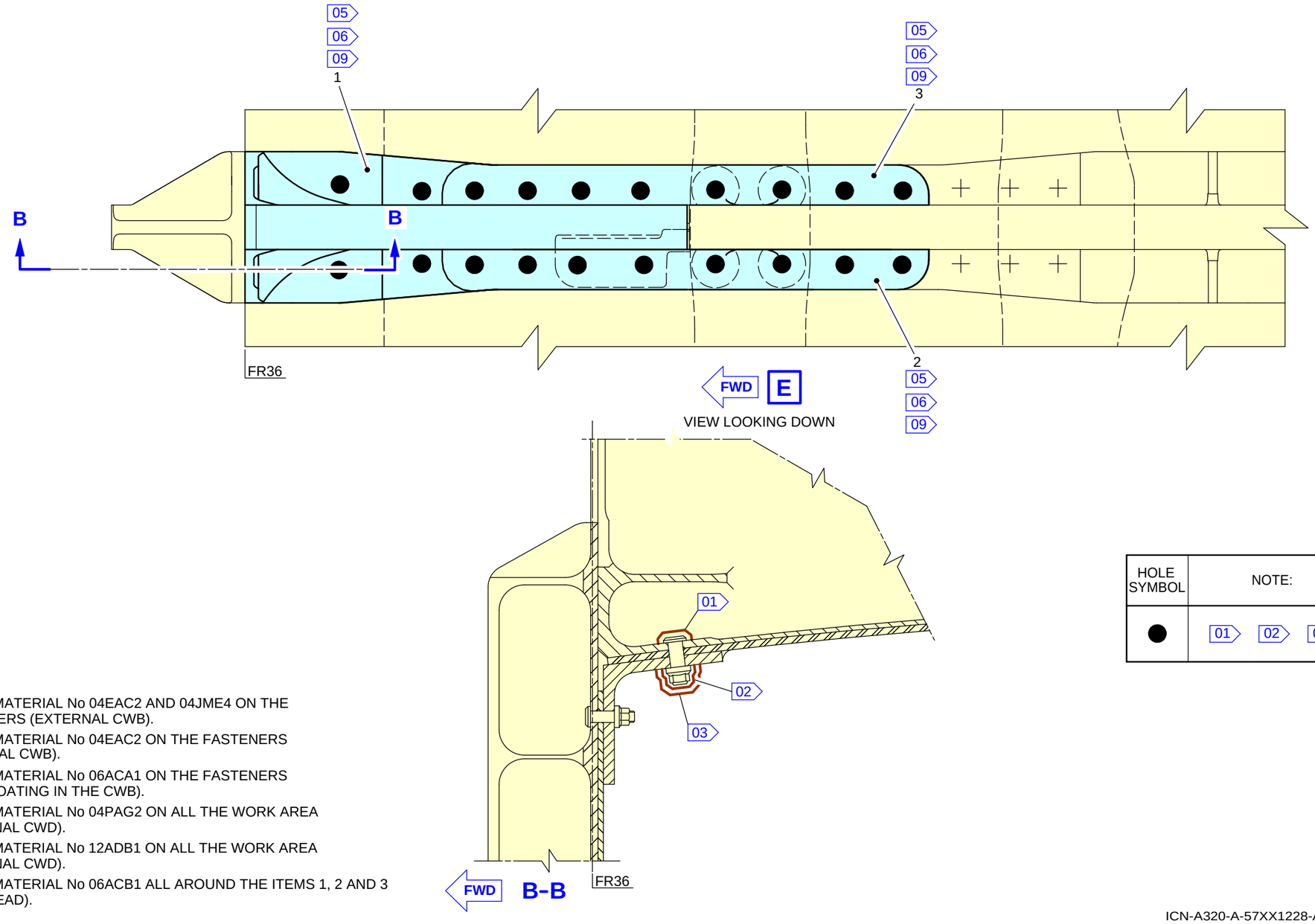
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

(57) Task A320-A-57-XX-1228-16001-520A-A - Remove the Strut Lower Attachment on Y-765 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

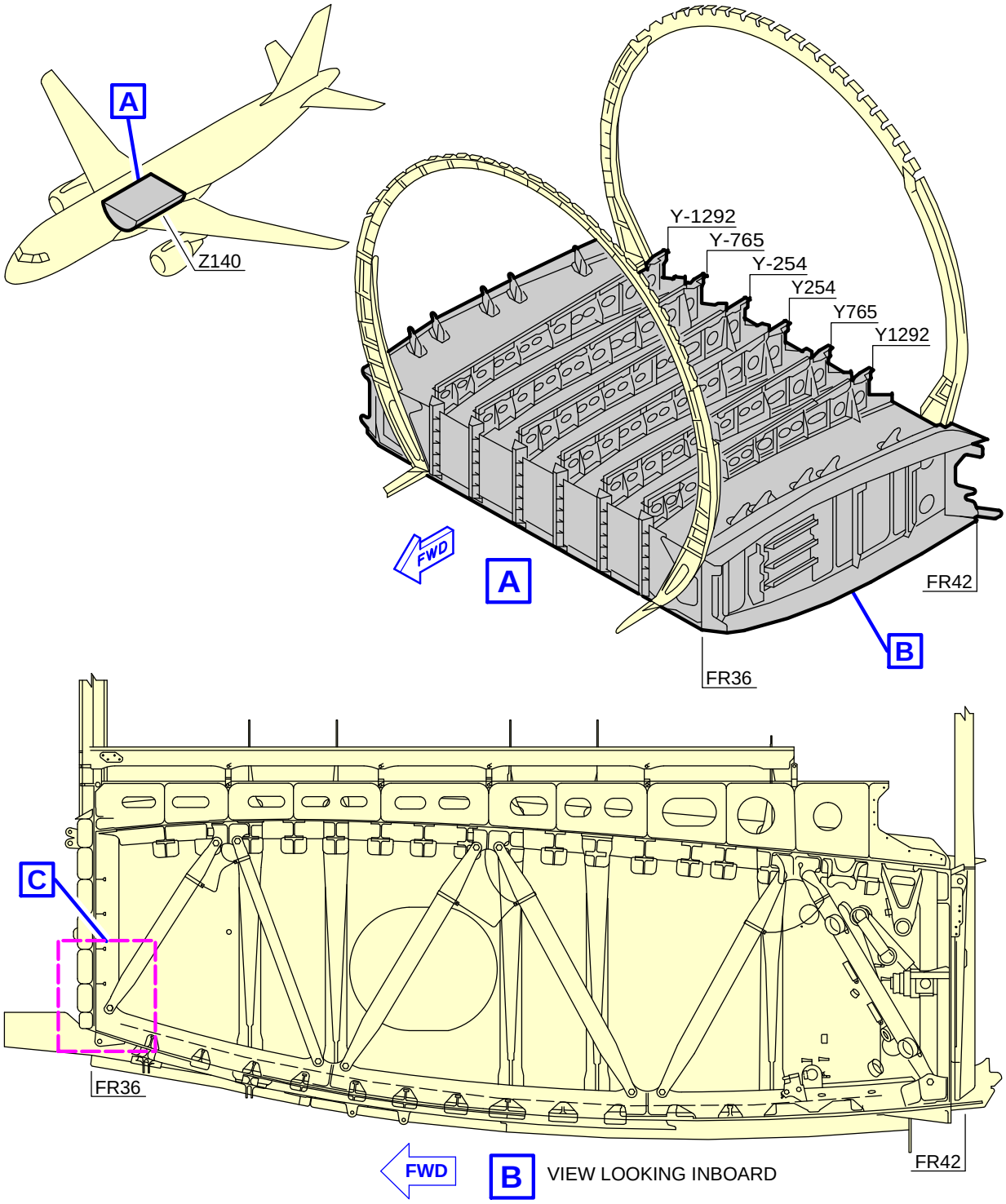
1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain

1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

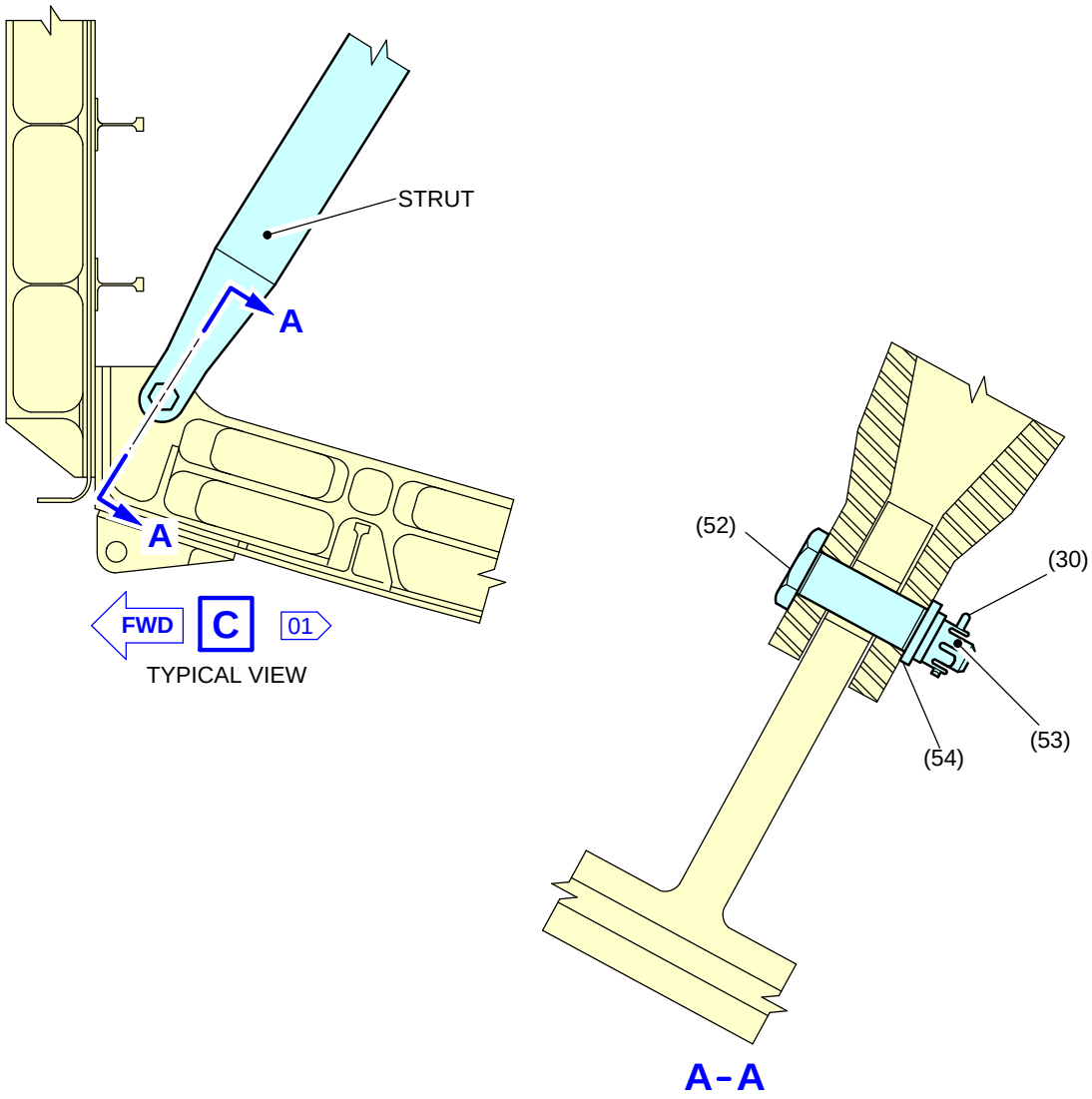
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(58) Task A320-A-57-XX-1228-17001-520A-A - Remove the Vertical Stringer on Y-765 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

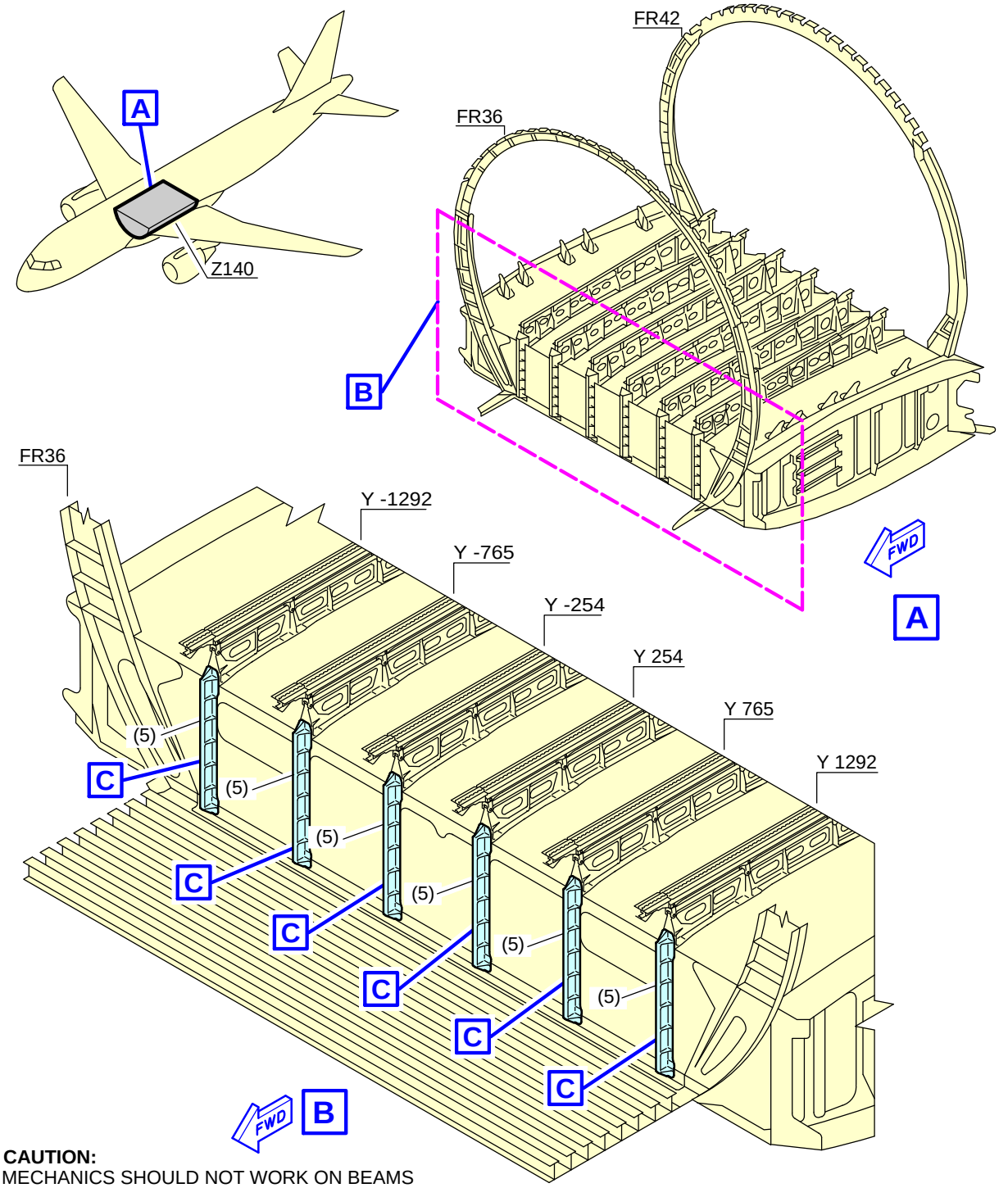
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-22ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

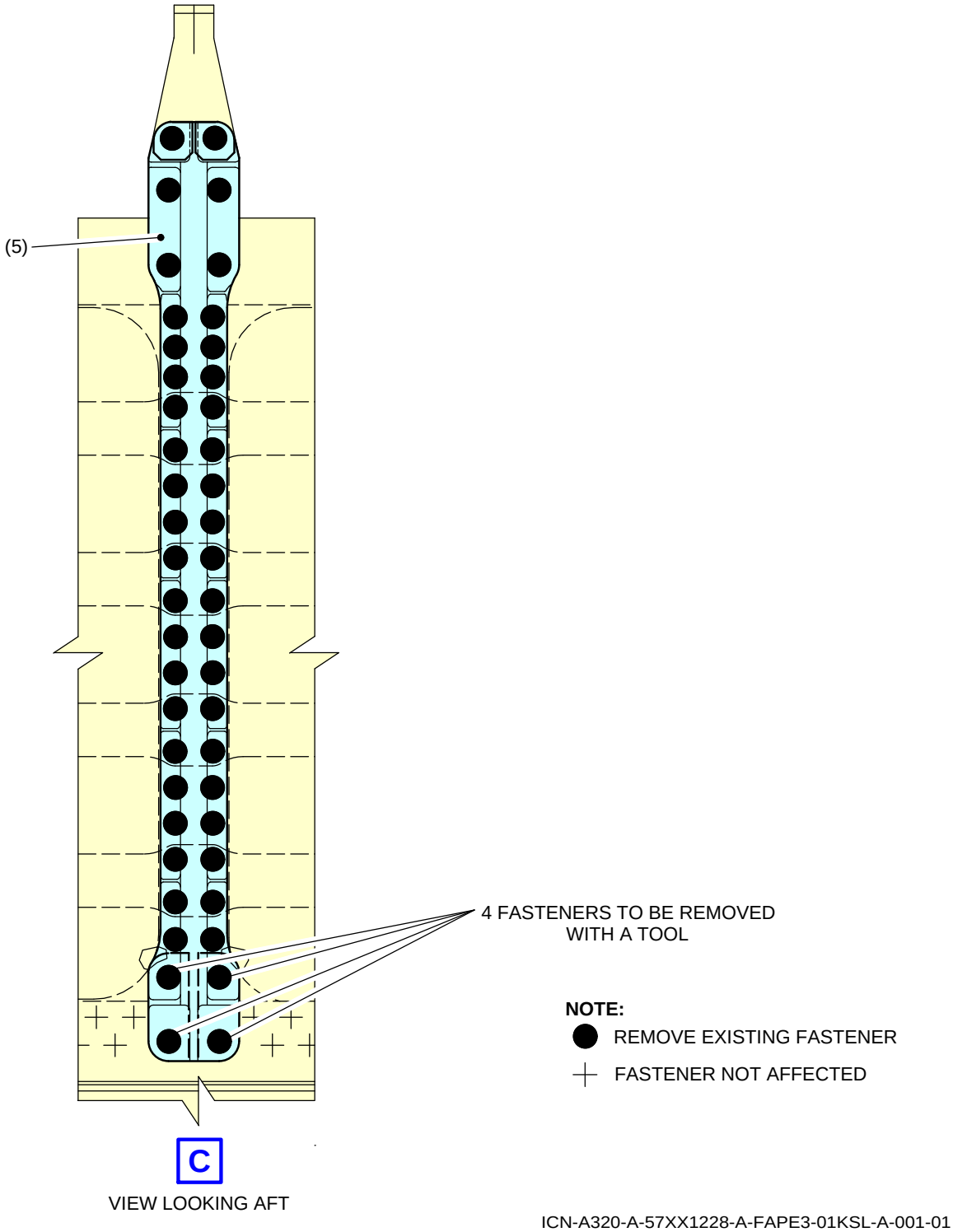


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

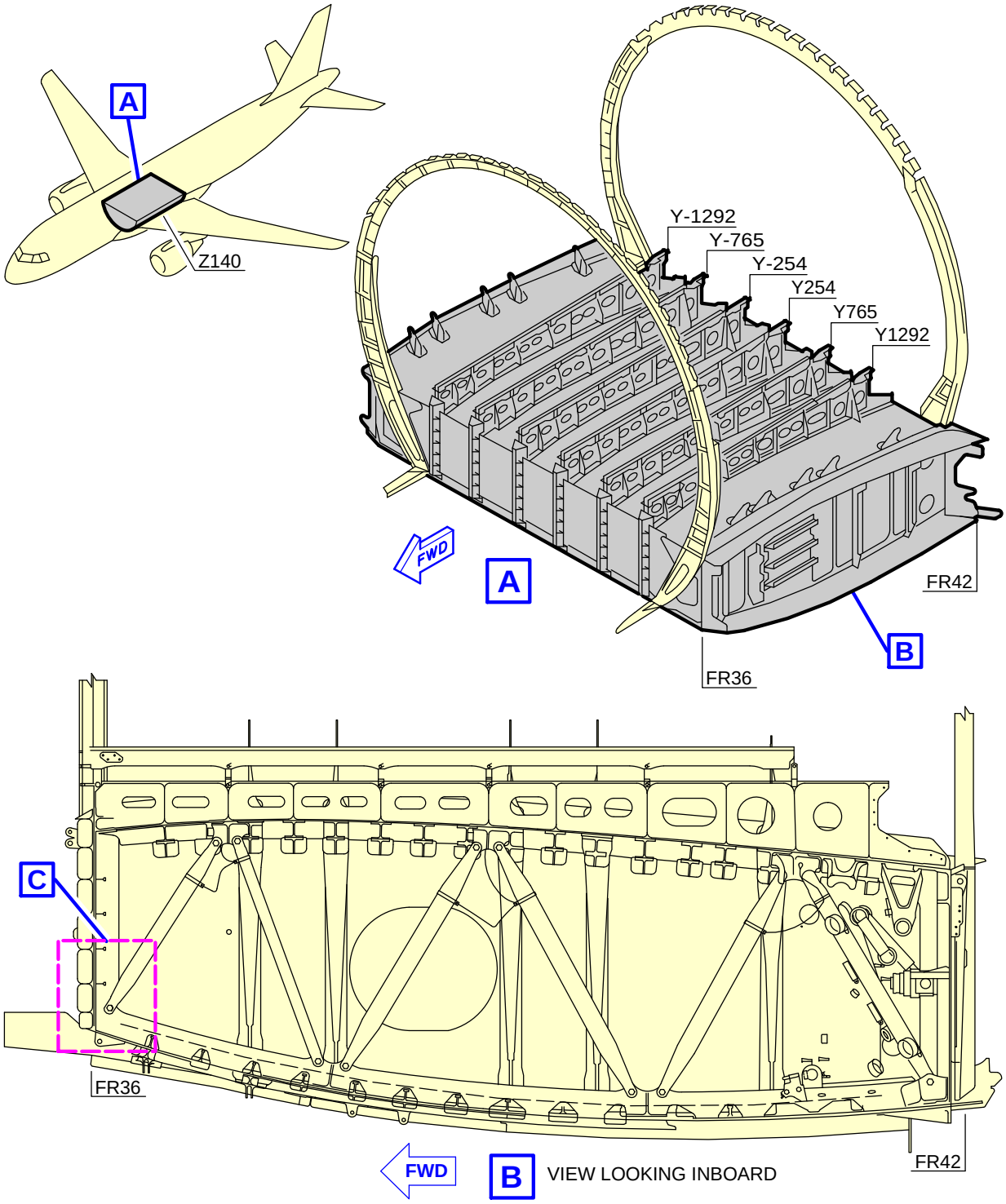
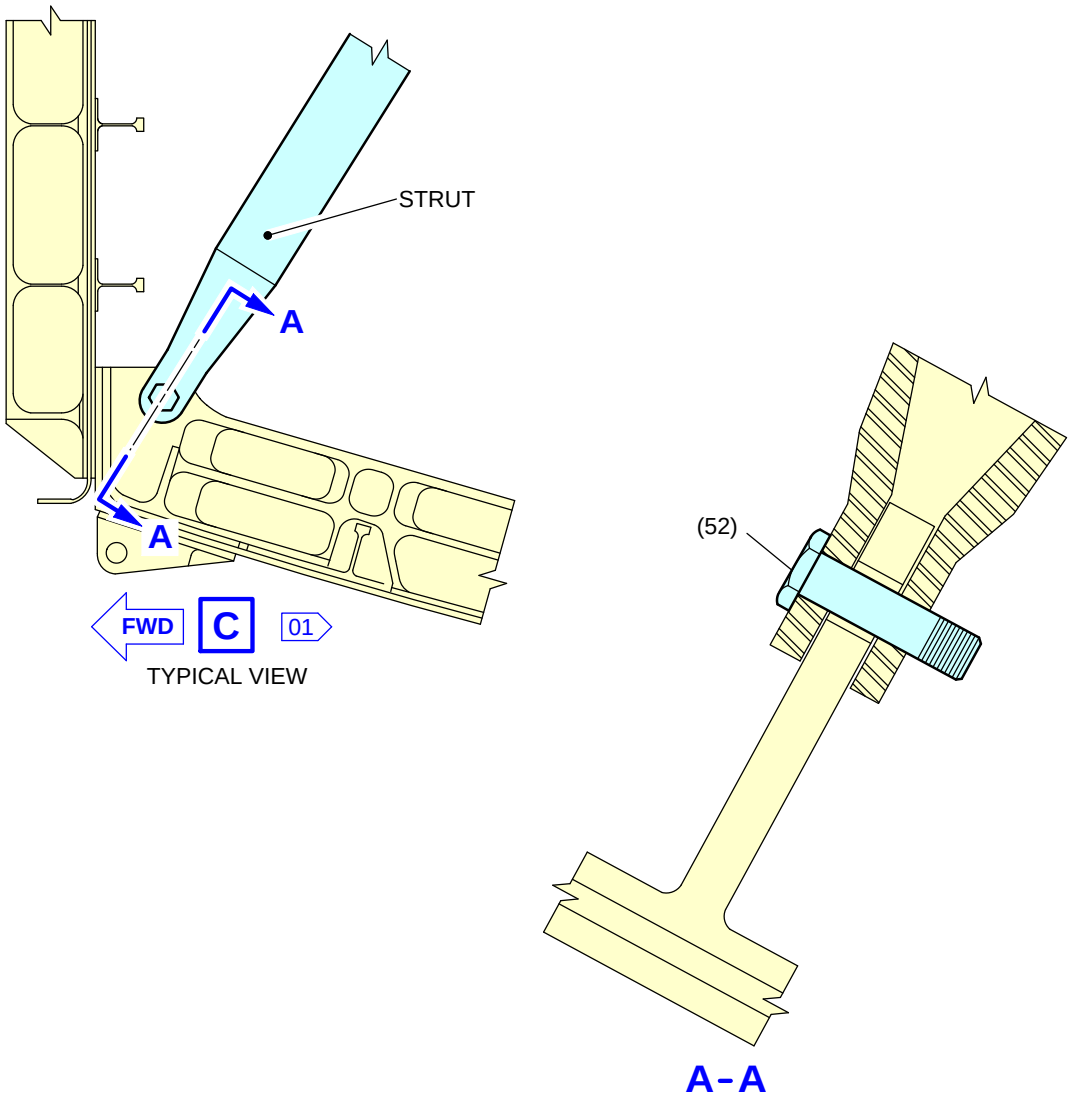


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(58) Task A320-A-57-XX-1228-17002-520A-A - Remove the Vertical Stringer on Y-765 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

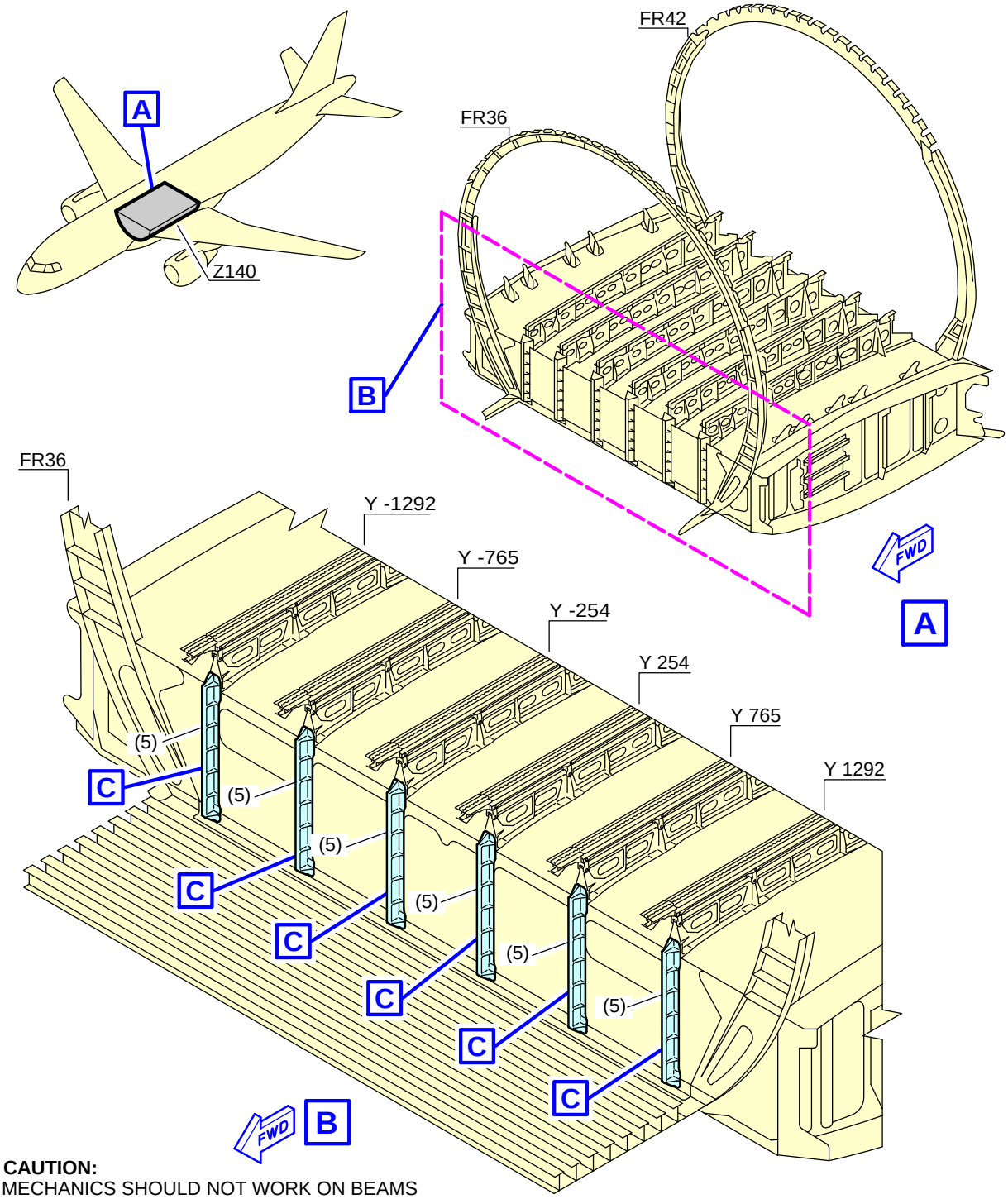
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-22ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

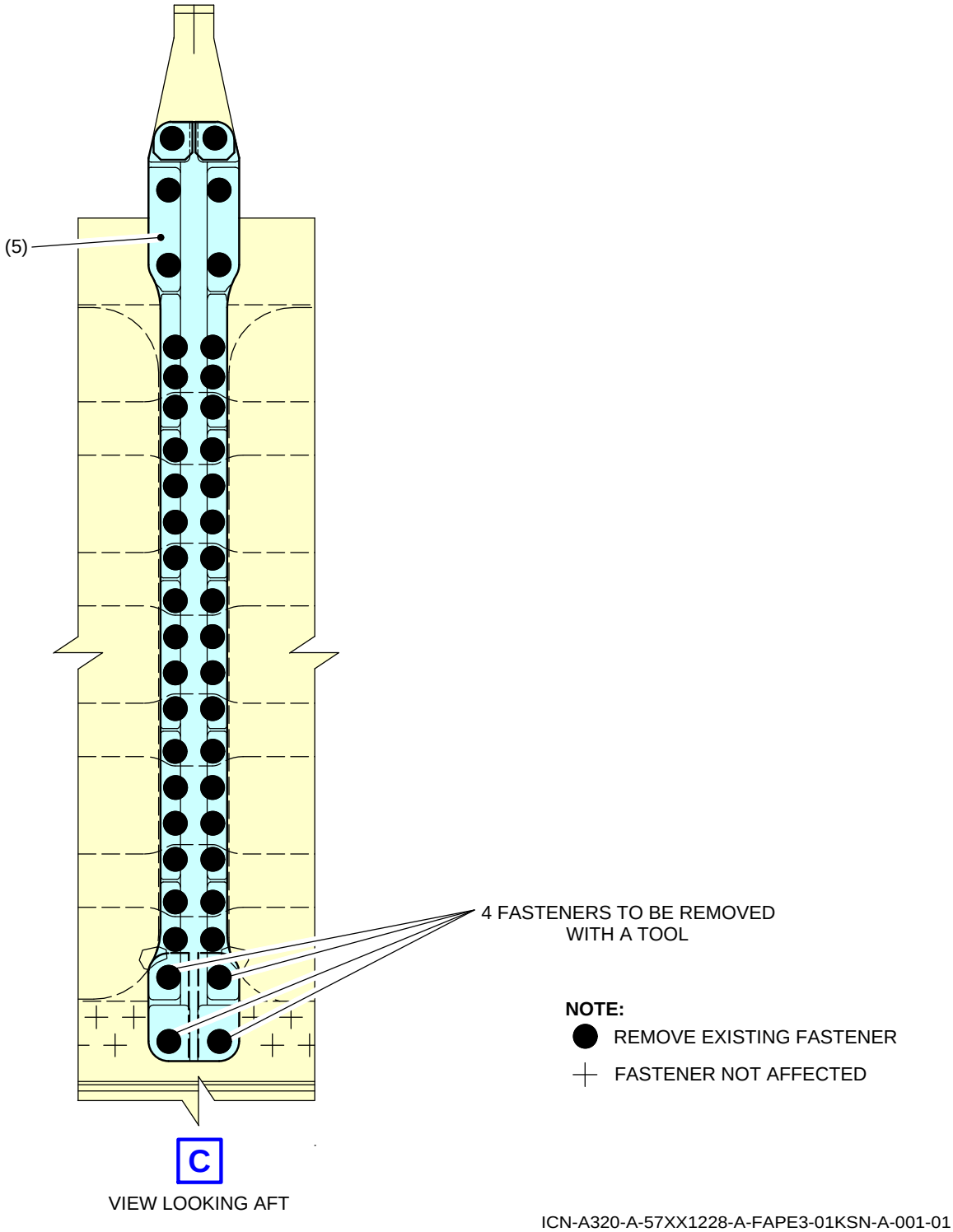


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

CONF 002

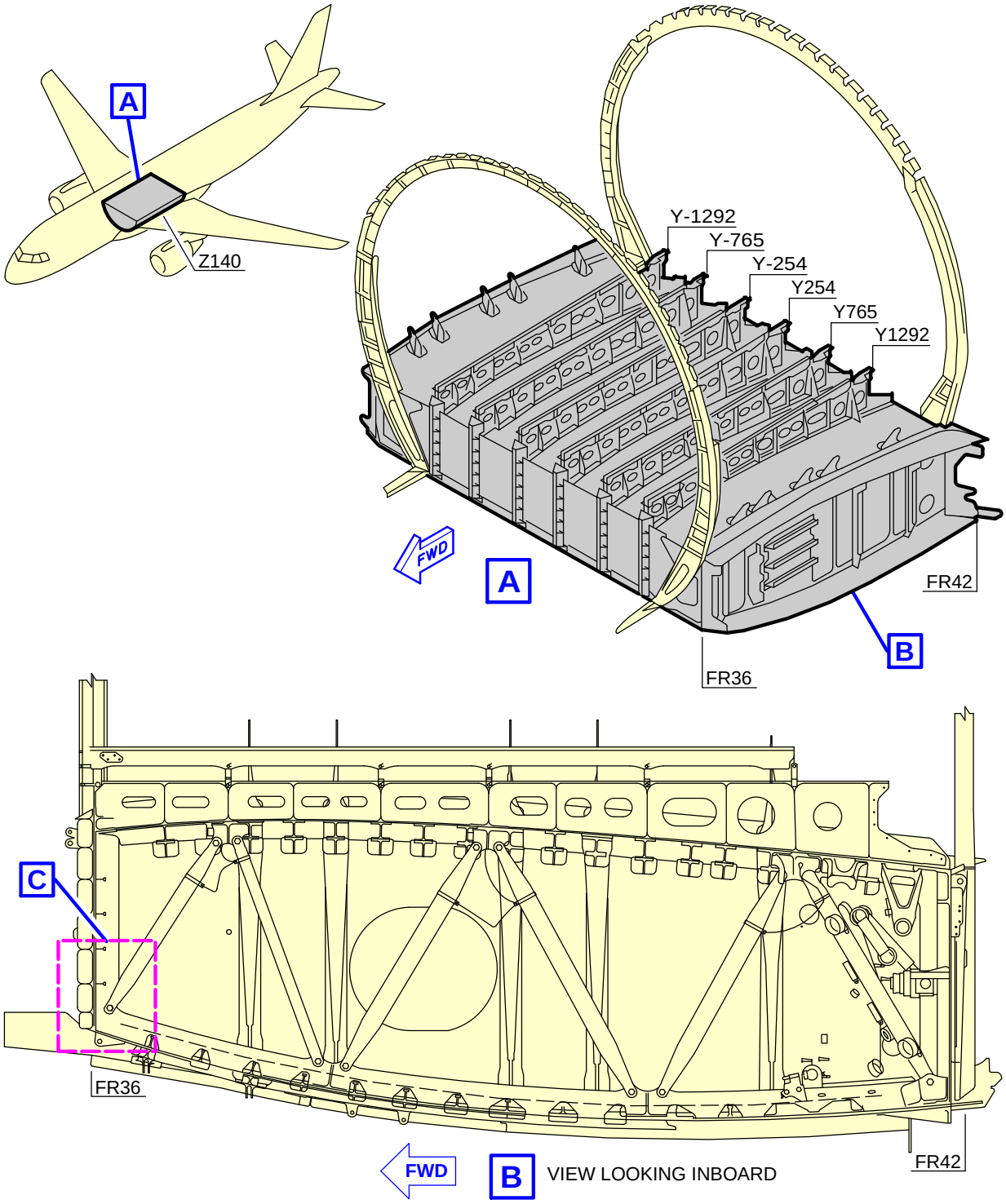
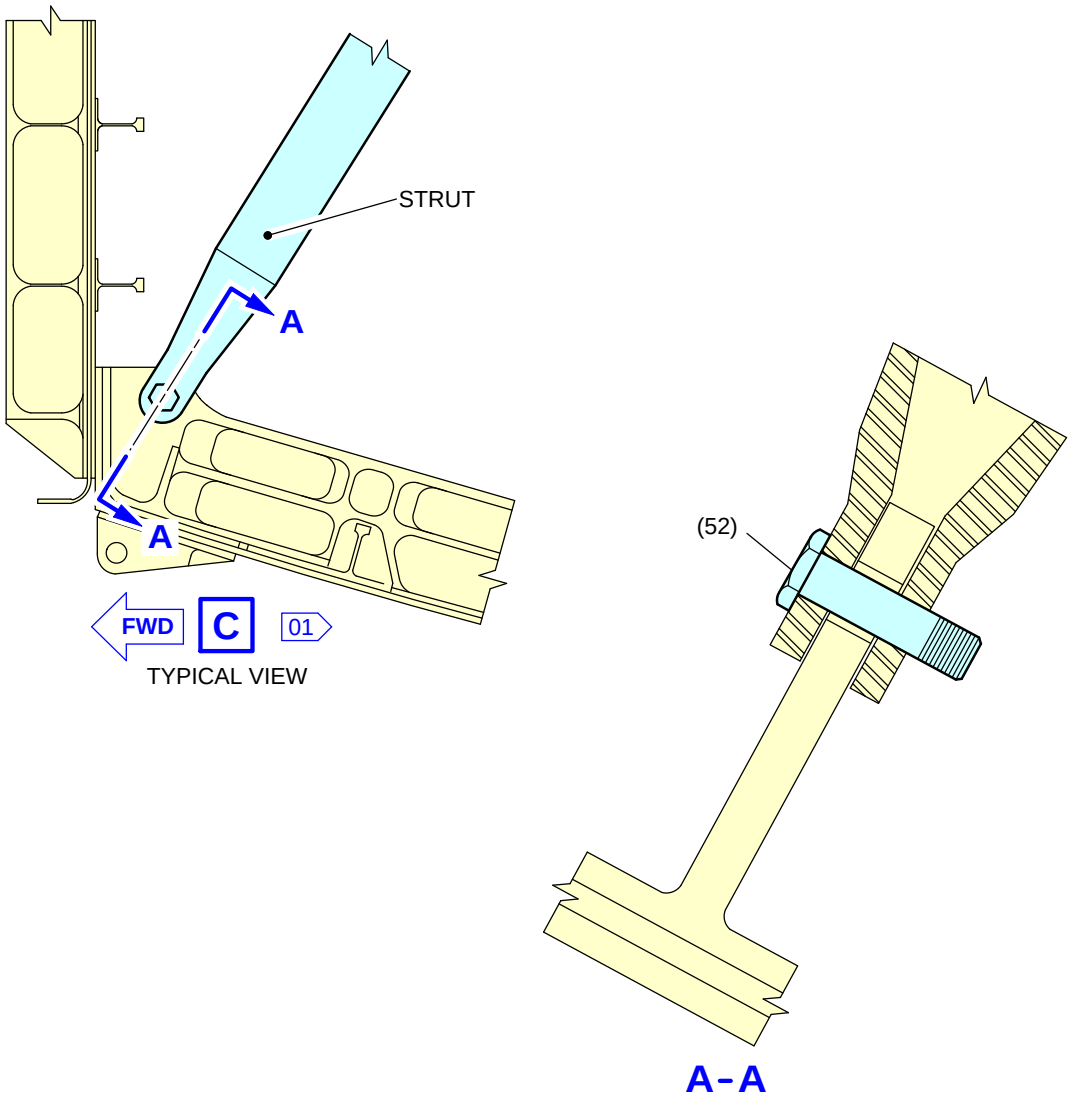


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(59) Task A320-A-57-XX-1228-09001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - 08BAA9
General

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-09ZZZ-900Z-A.

CONF 001 003 004

(60) Task A320-A-57-XX-1228-09001-900A-A - Drill the New Vertical Stringer on Y-765 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER VERTICAL D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

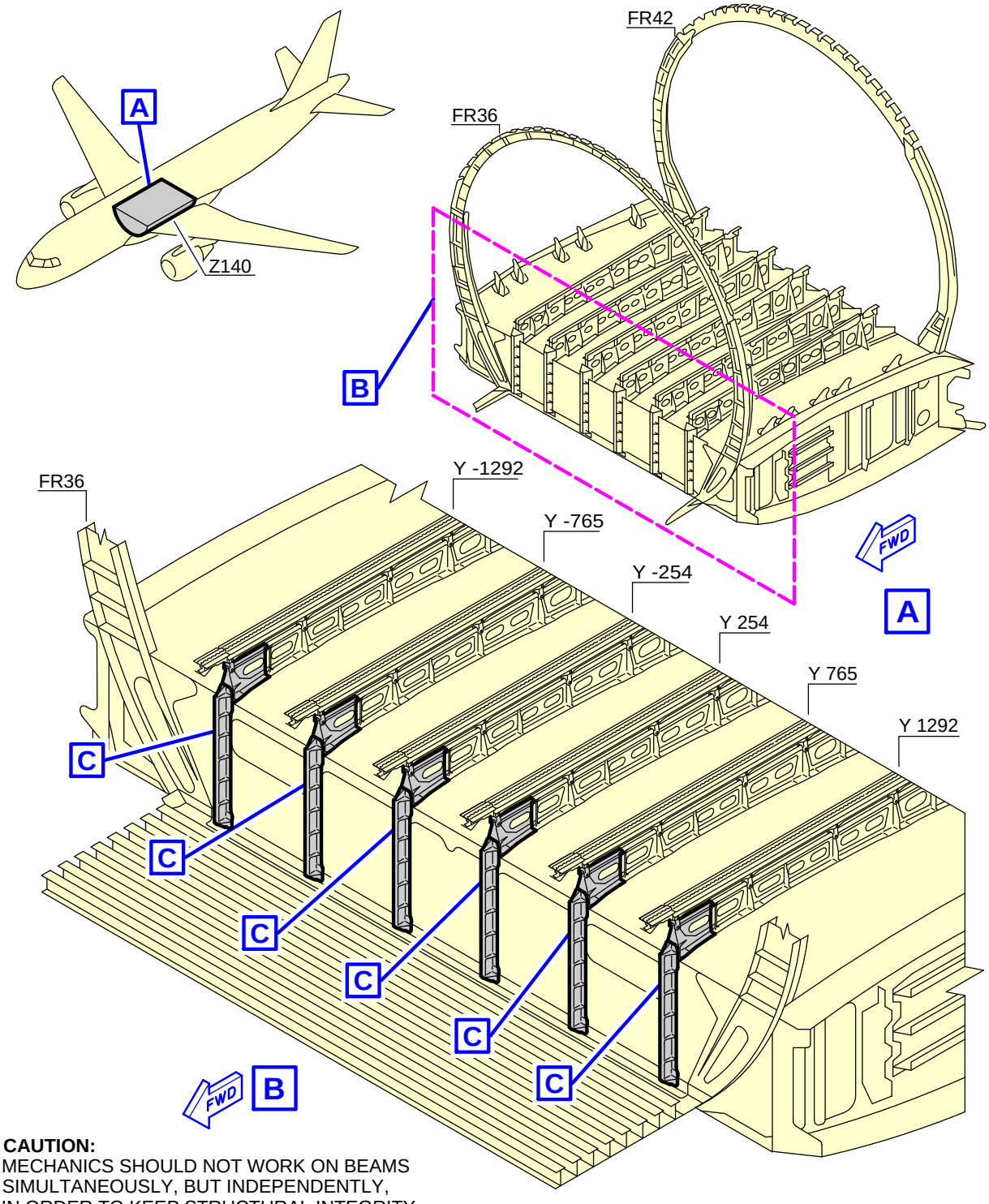
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 001 003 004

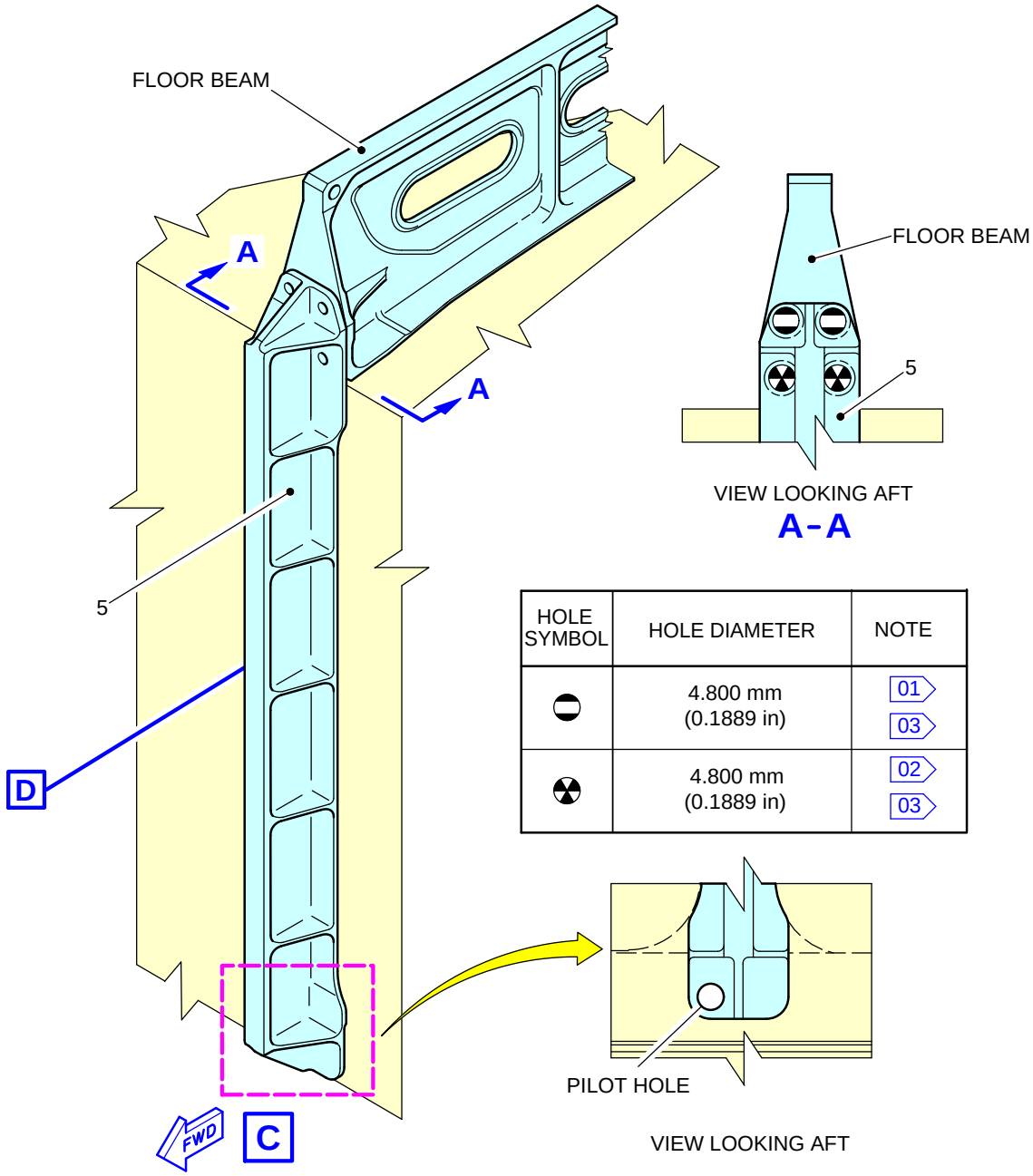


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

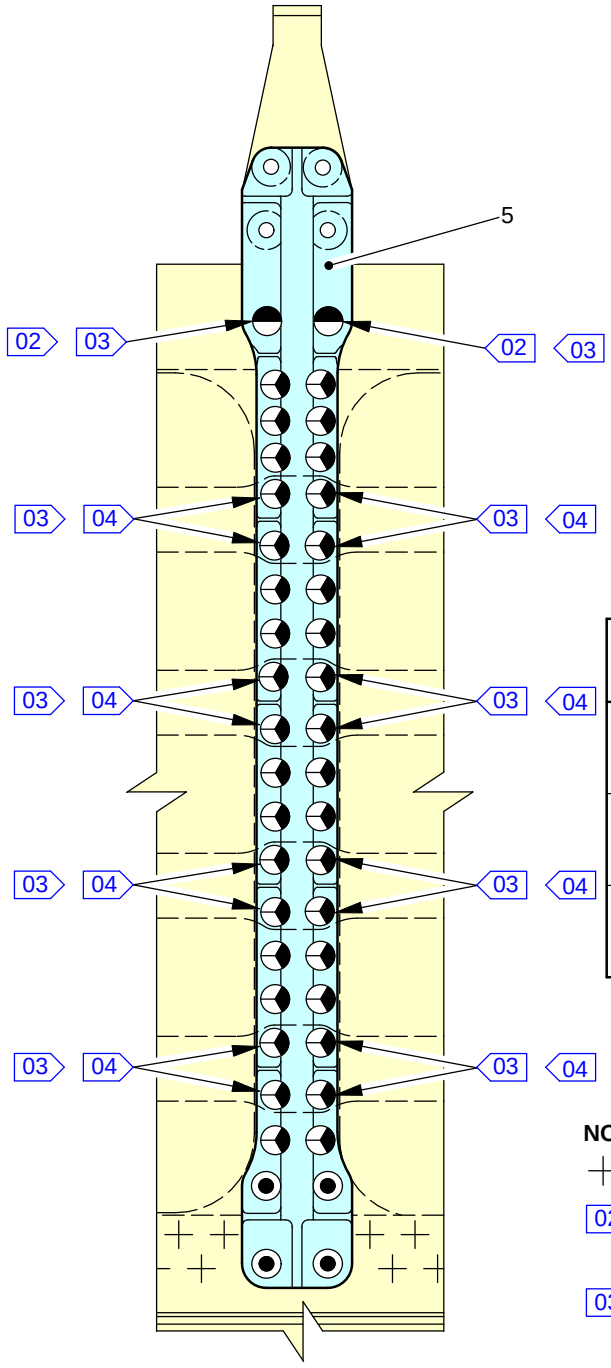
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

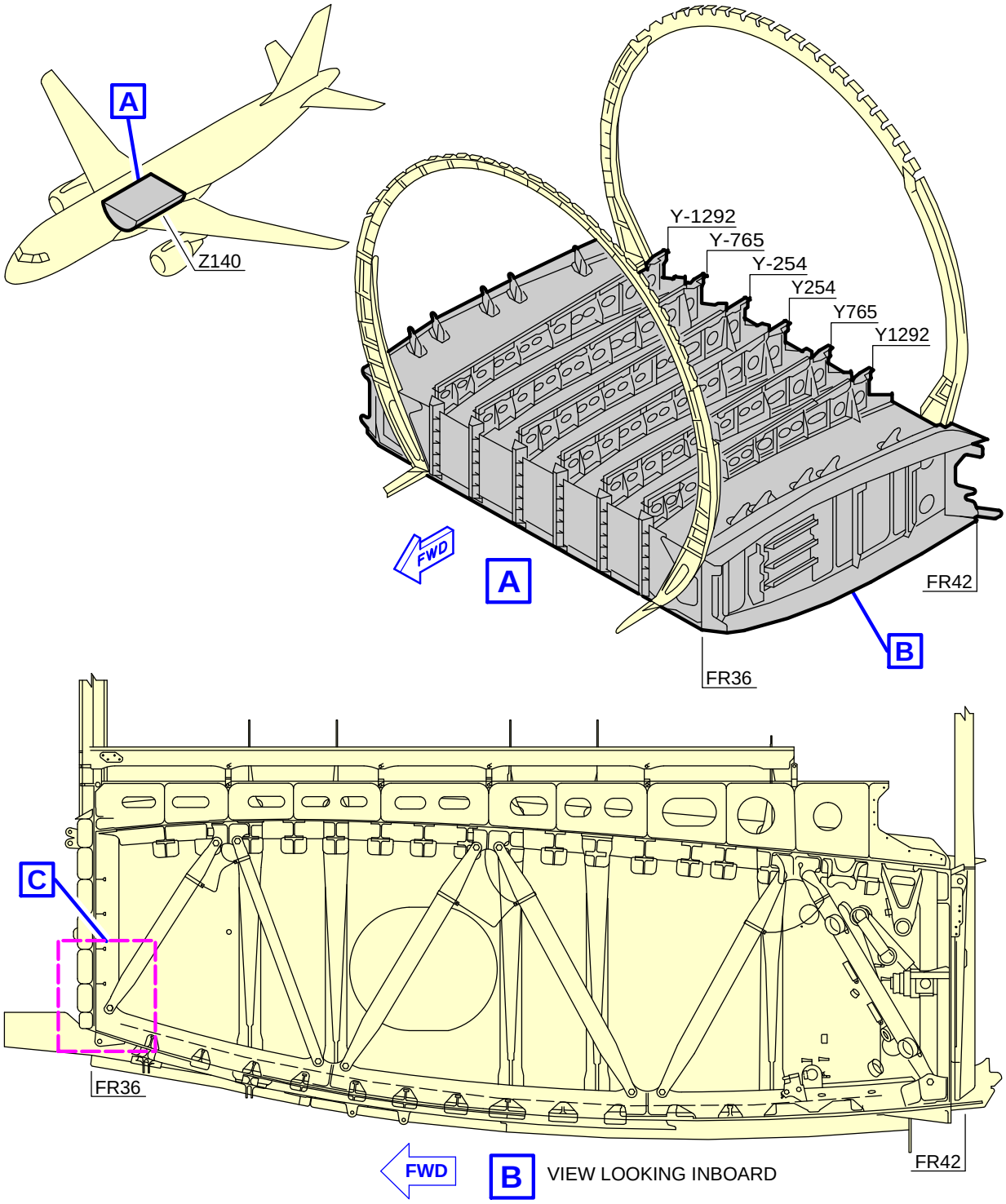
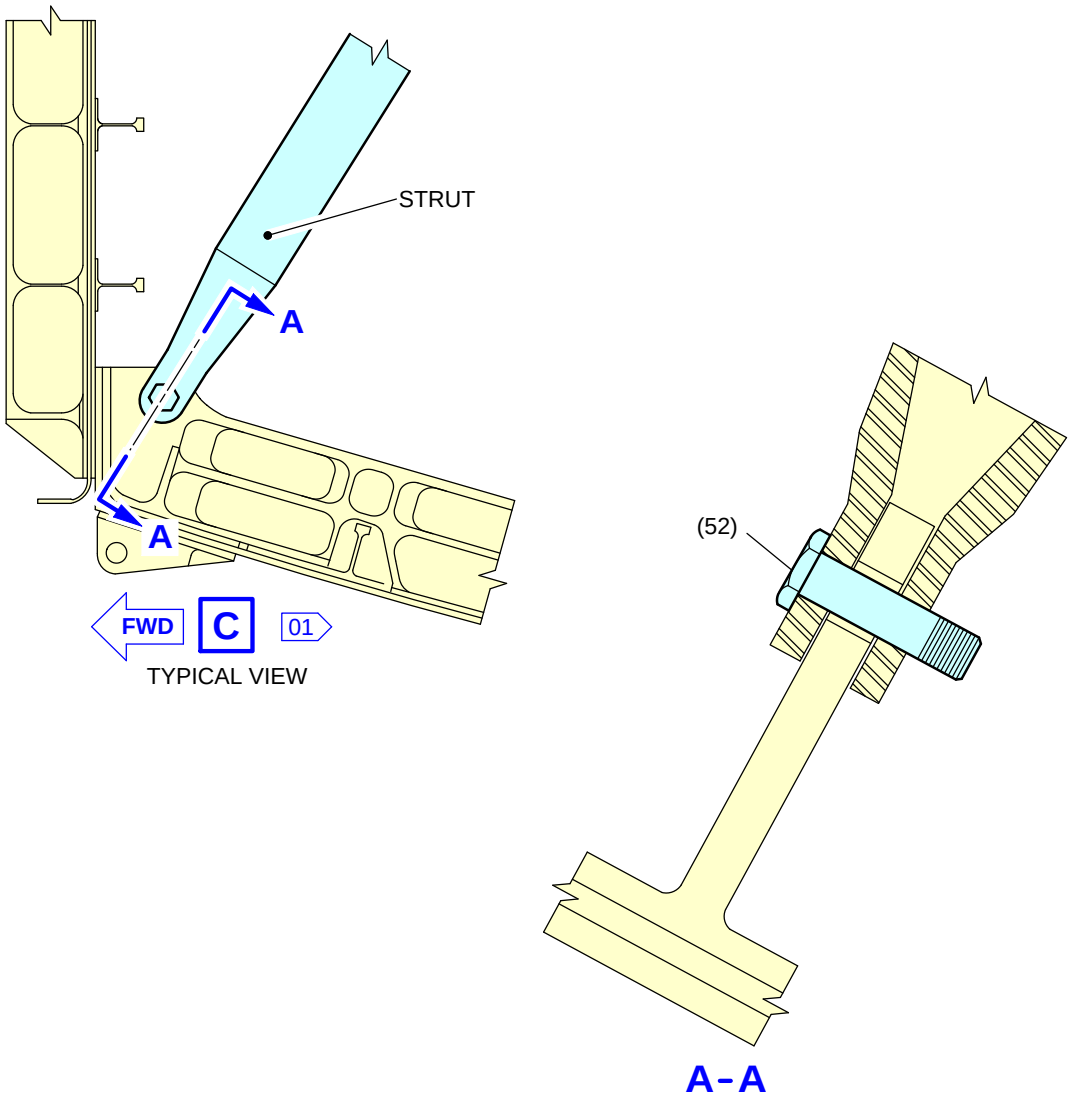


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(60) Task A320-A-57-XX-1228-09002-900A-A - Drill the New Vertical Stringer on Y-765 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER VERTICAL	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

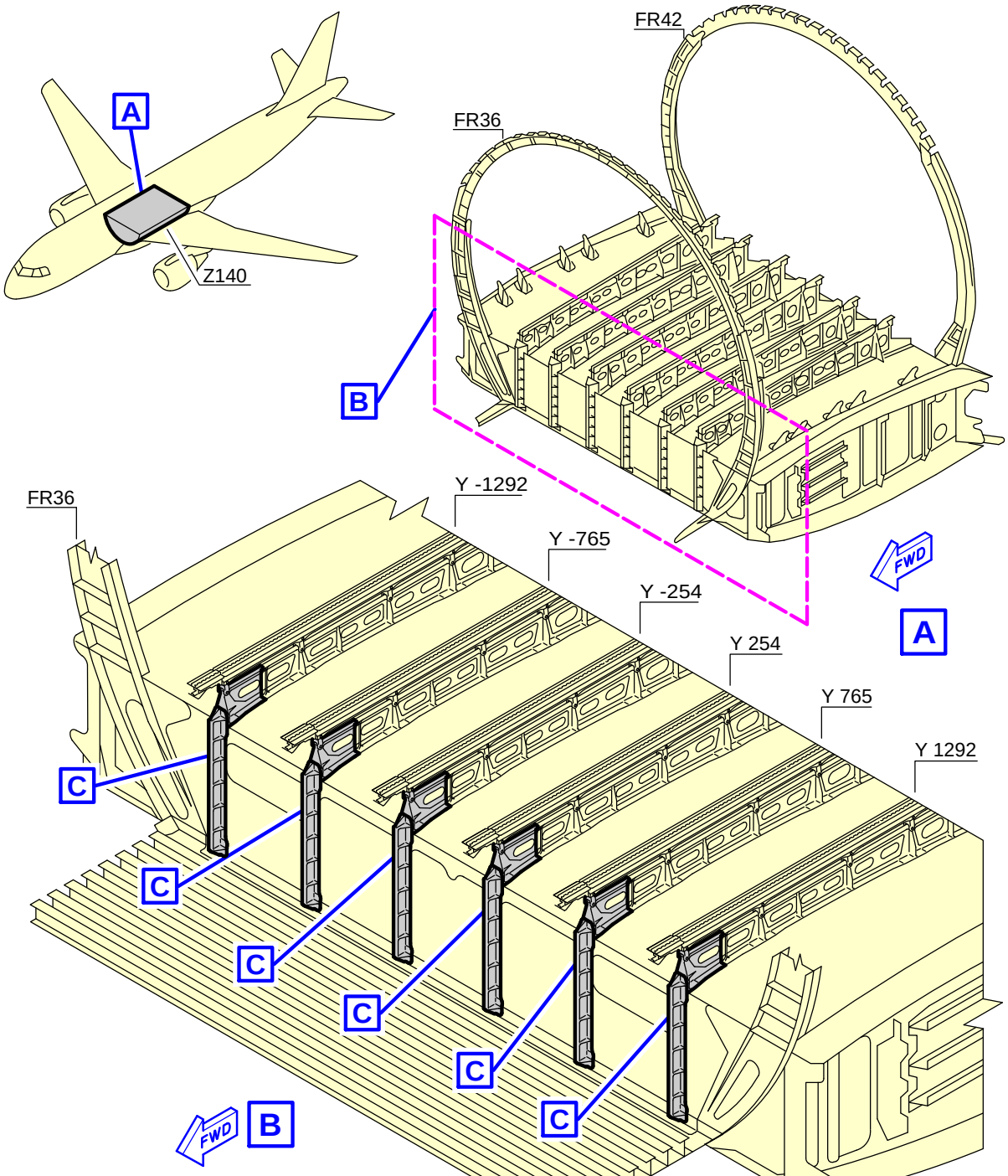
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

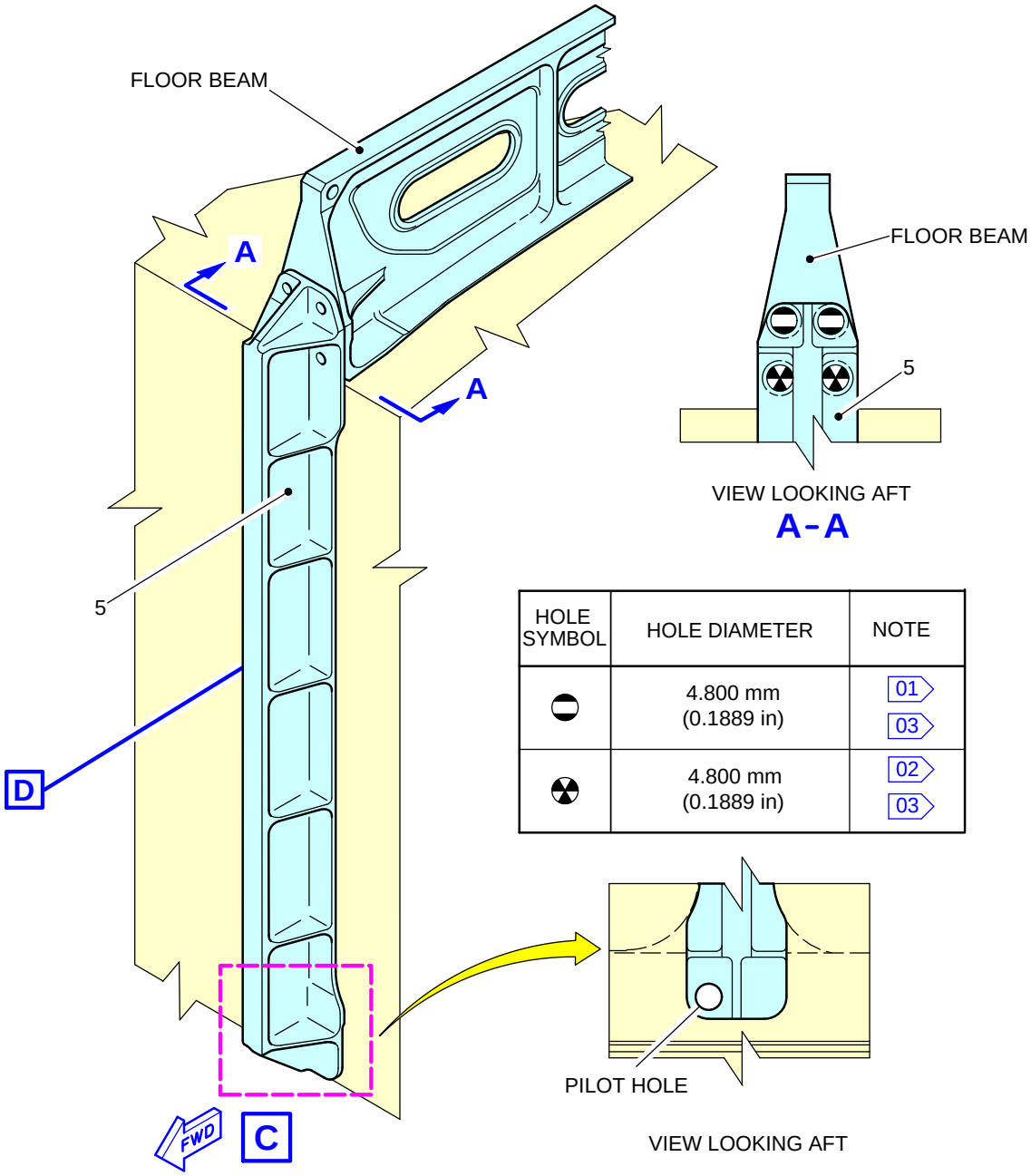


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

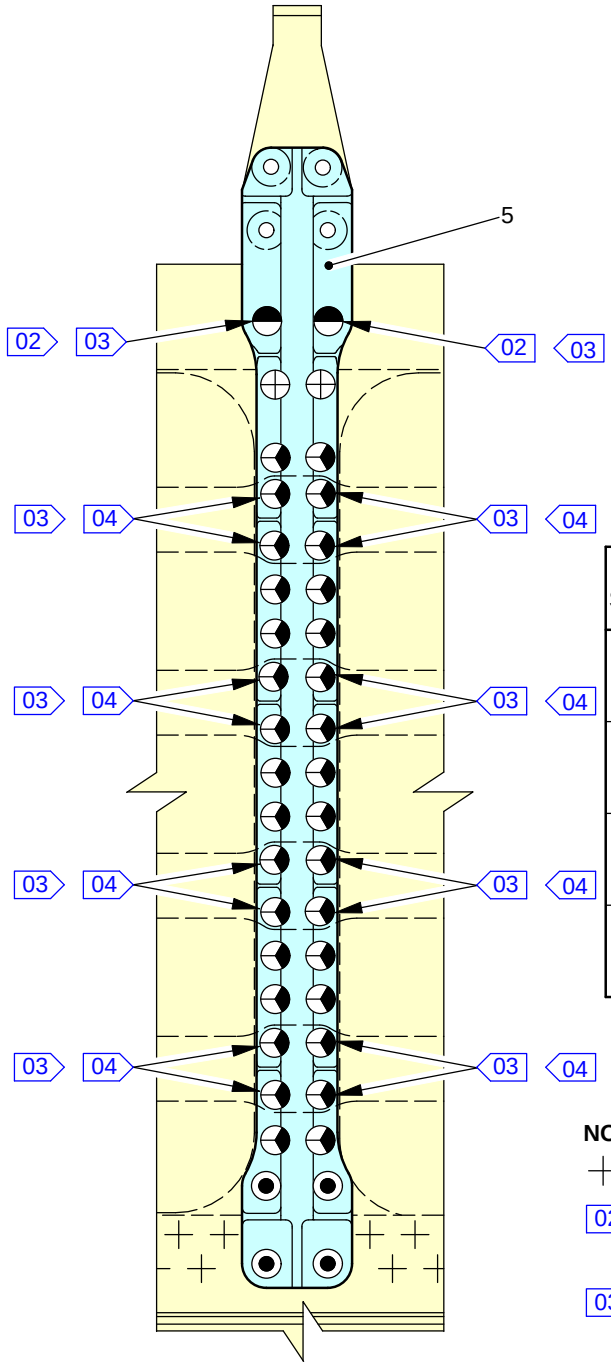
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

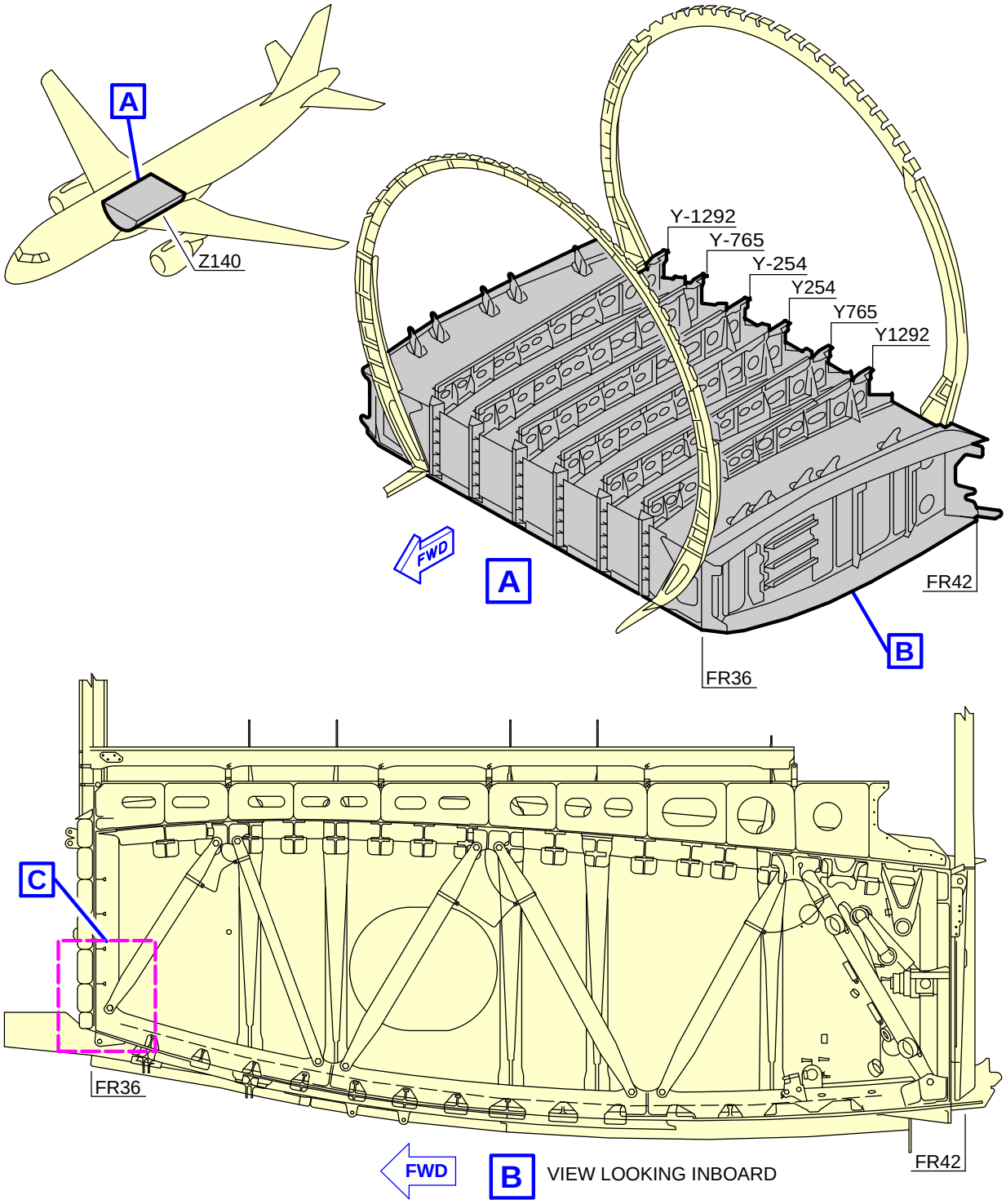
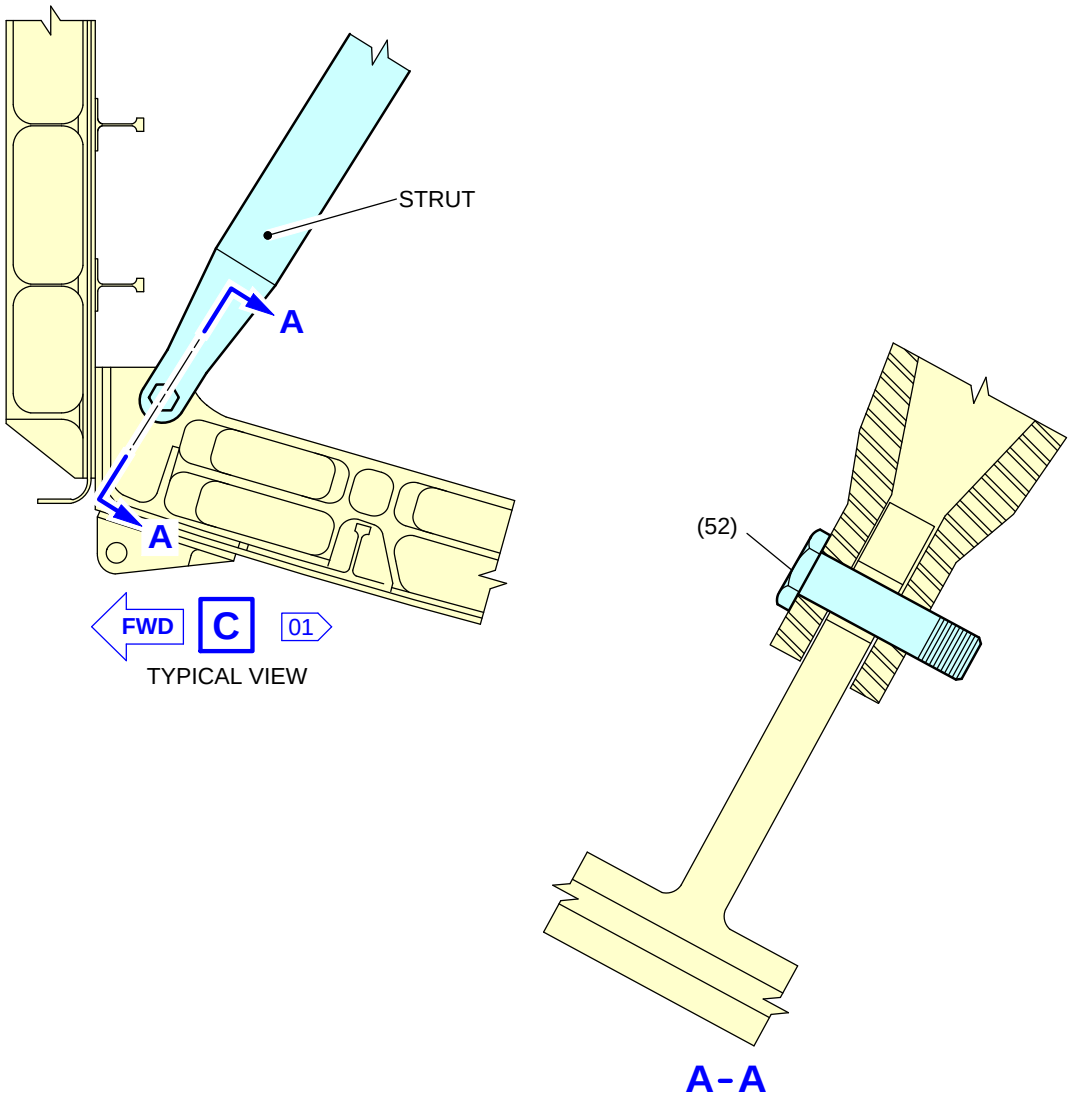


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(61) Task A320-A-57-XX-1228-22001-720A-A - Install the New Vertical Stringer on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001

Manuals/Drawings	References/Sheets
	06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

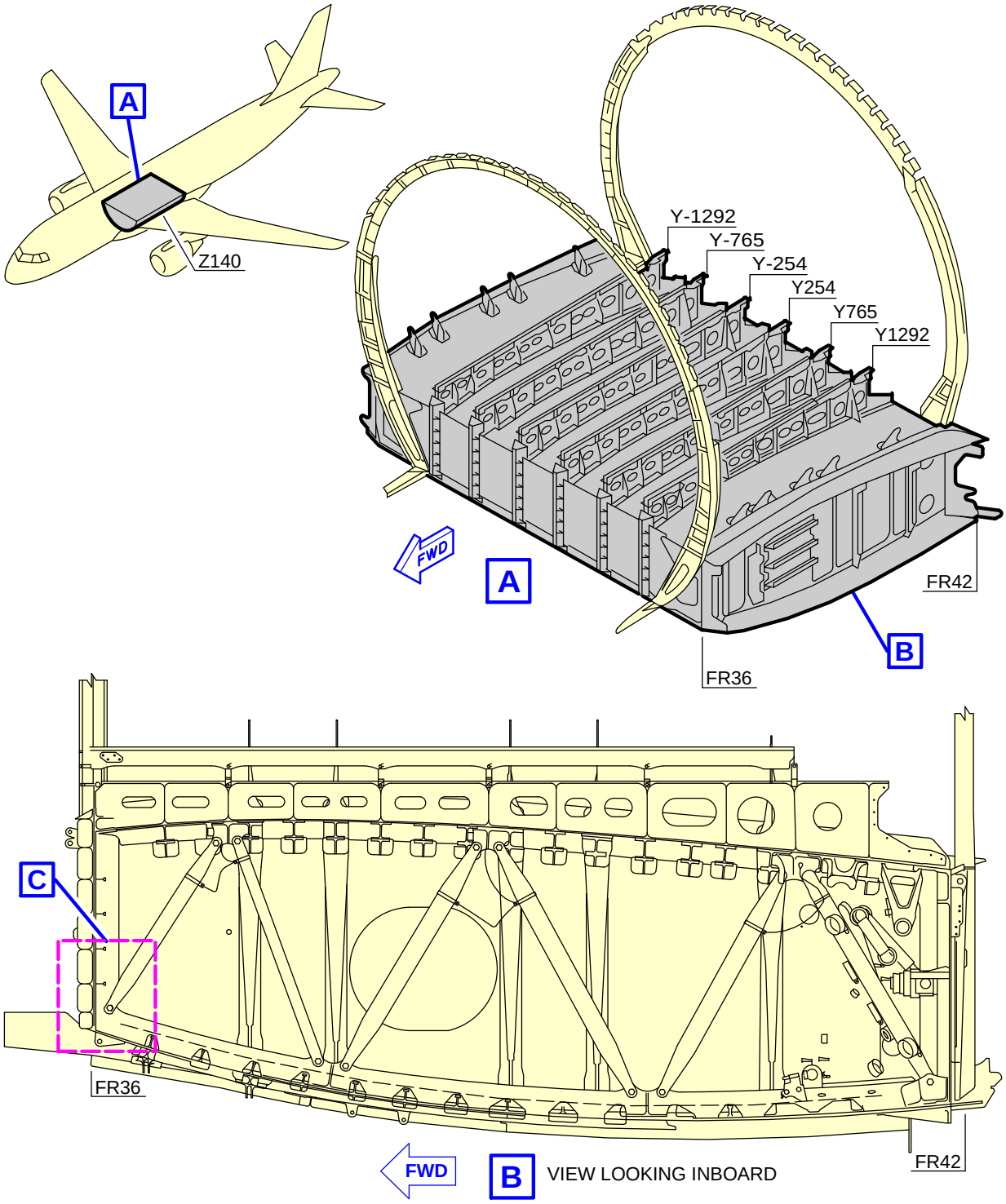
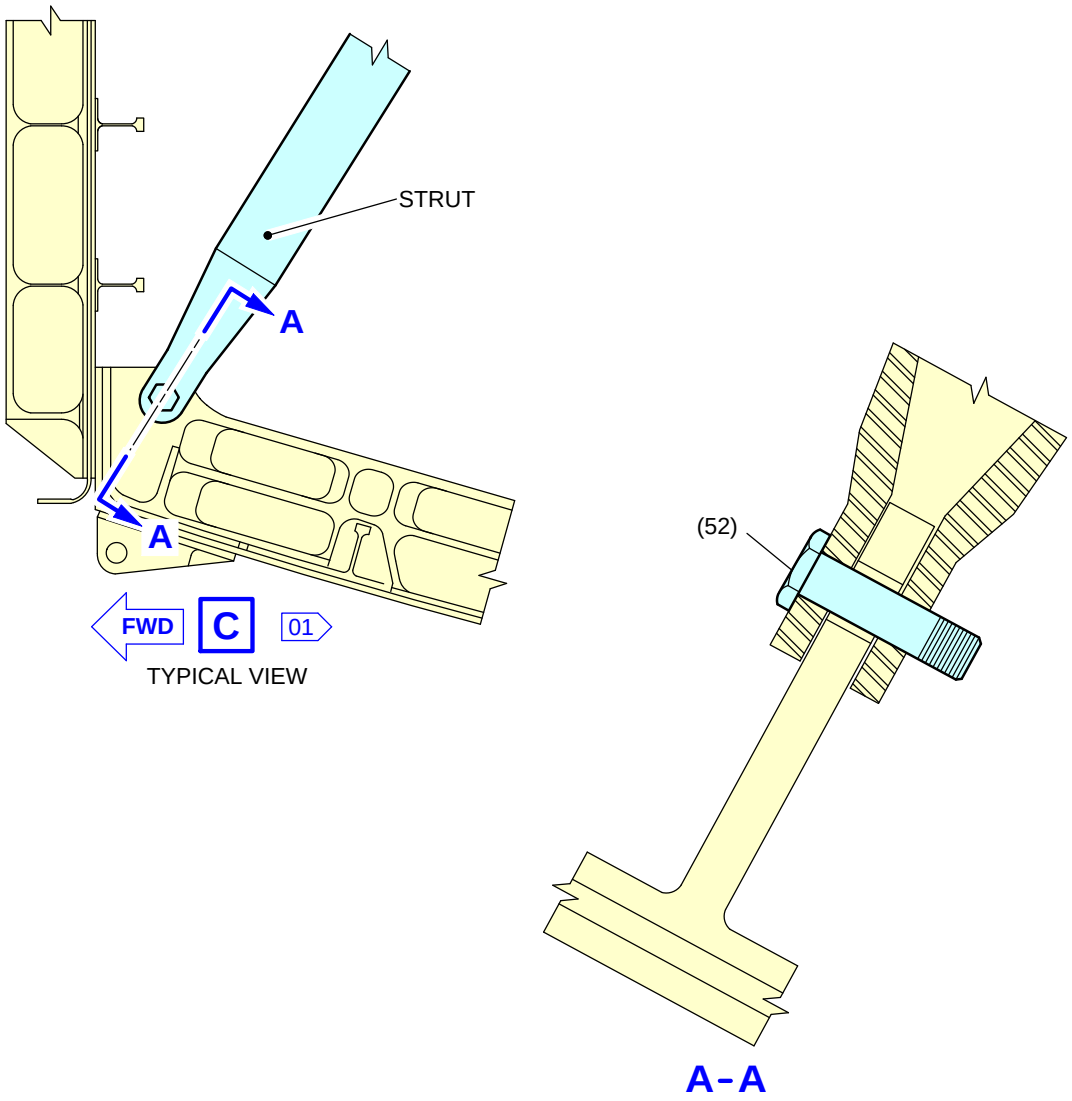


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



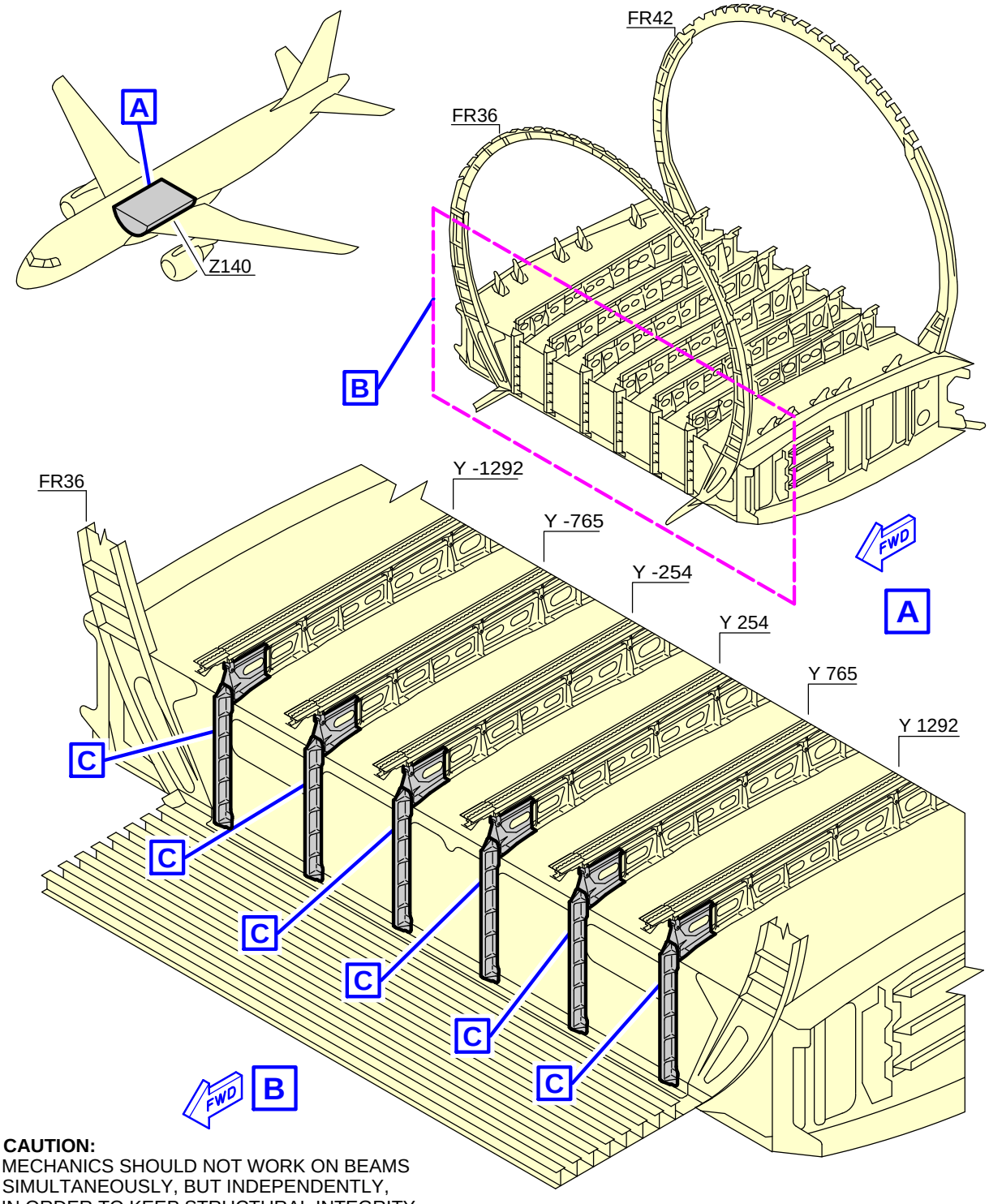
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

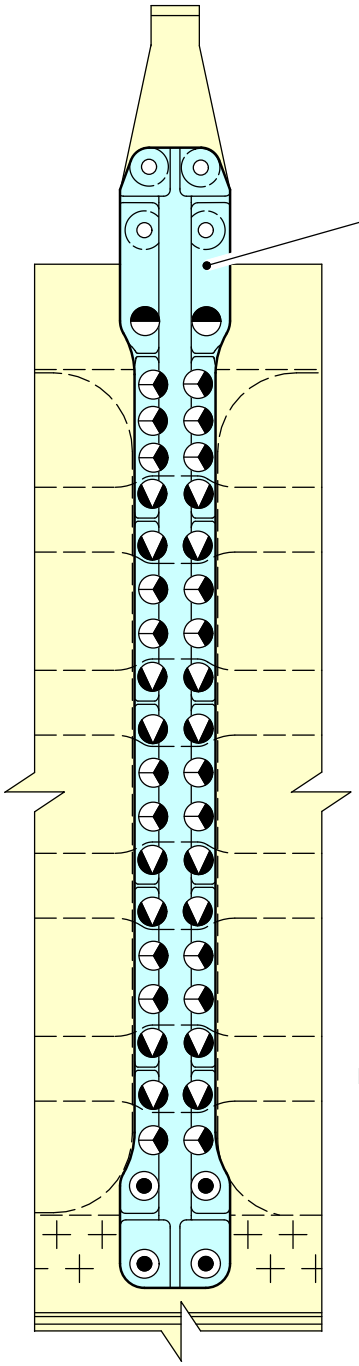


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(61) Task A320-A-57-XX-1228-22002-720A-A - Install the New Vertical Stringer on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

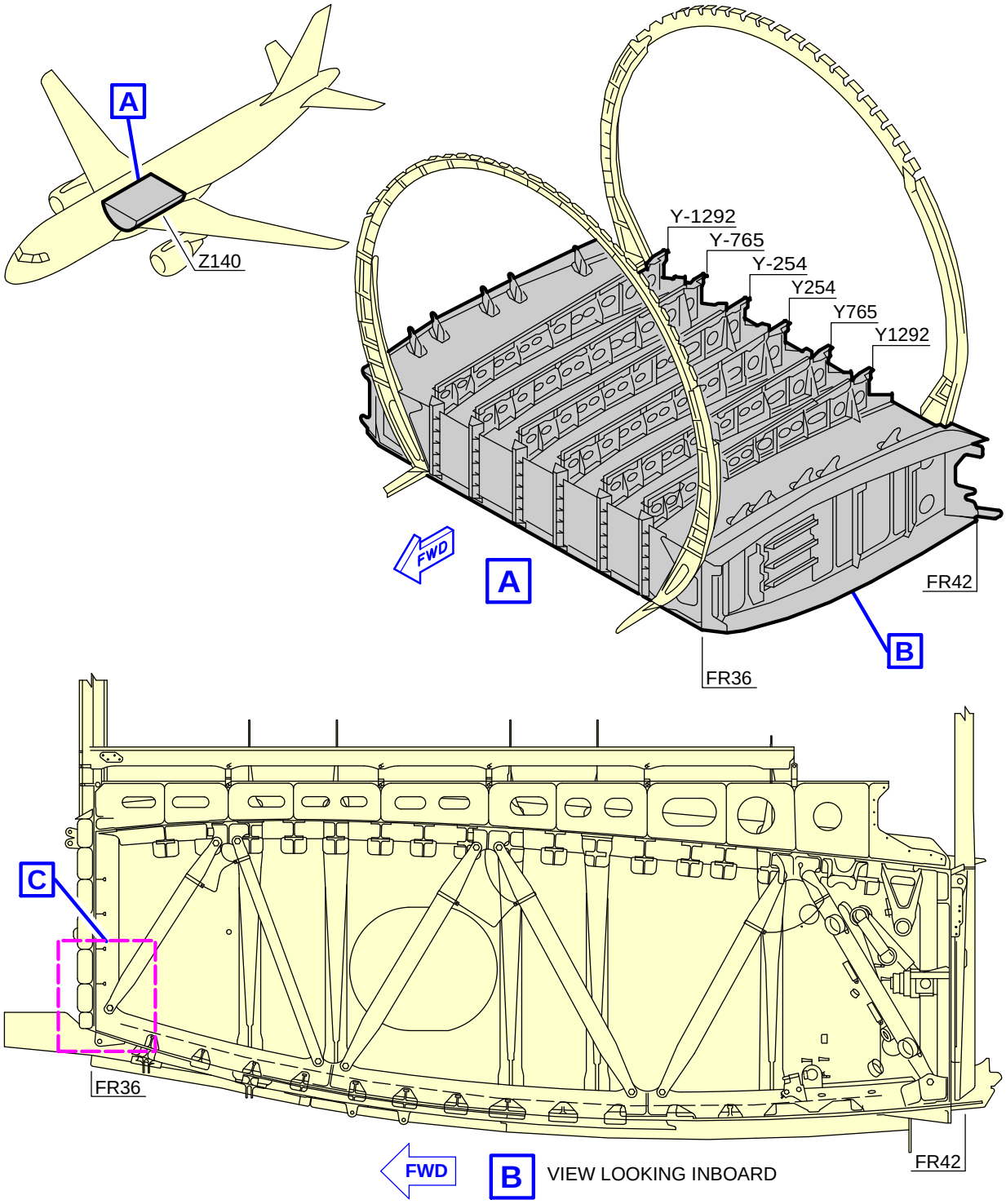
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

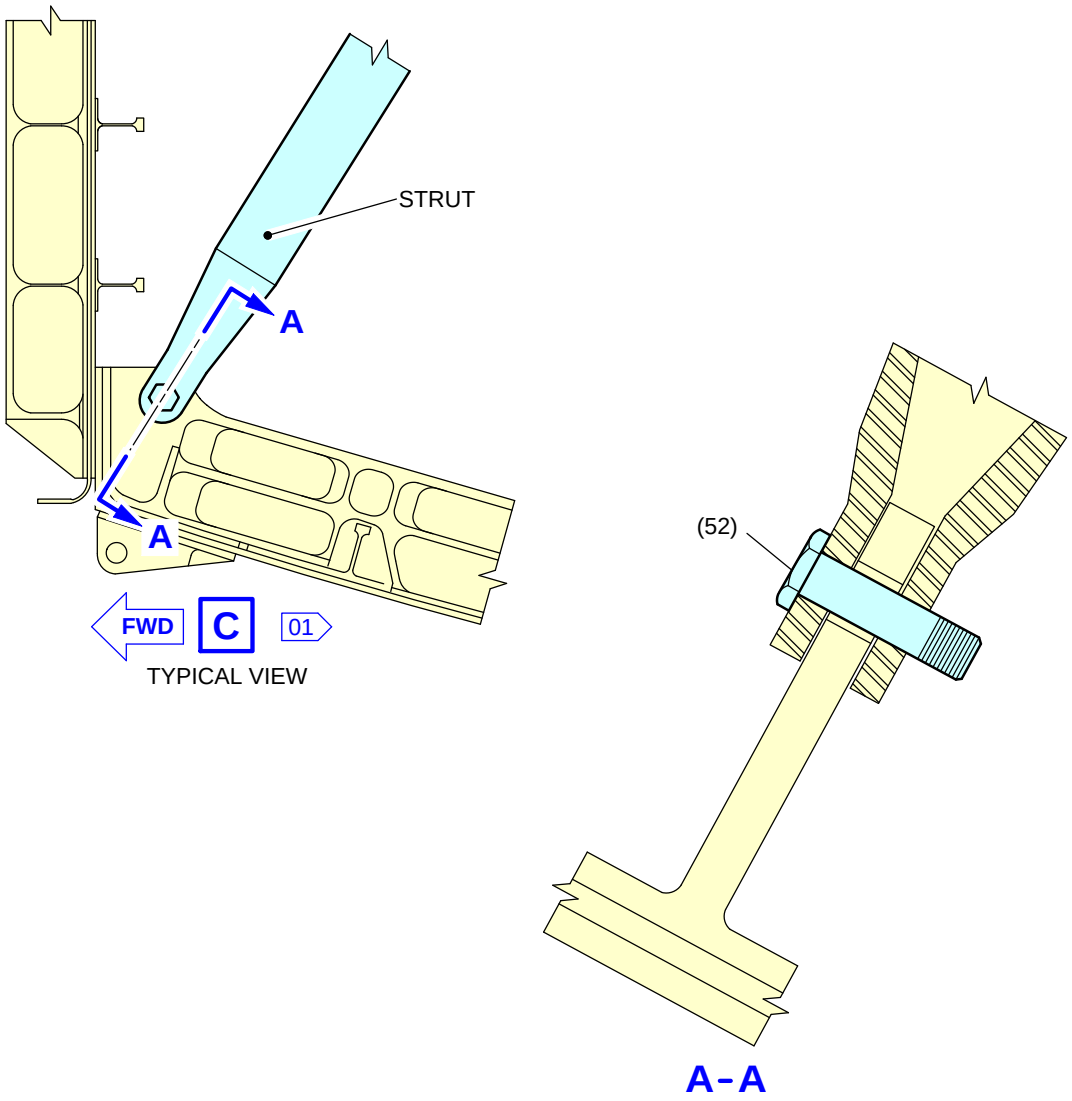
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



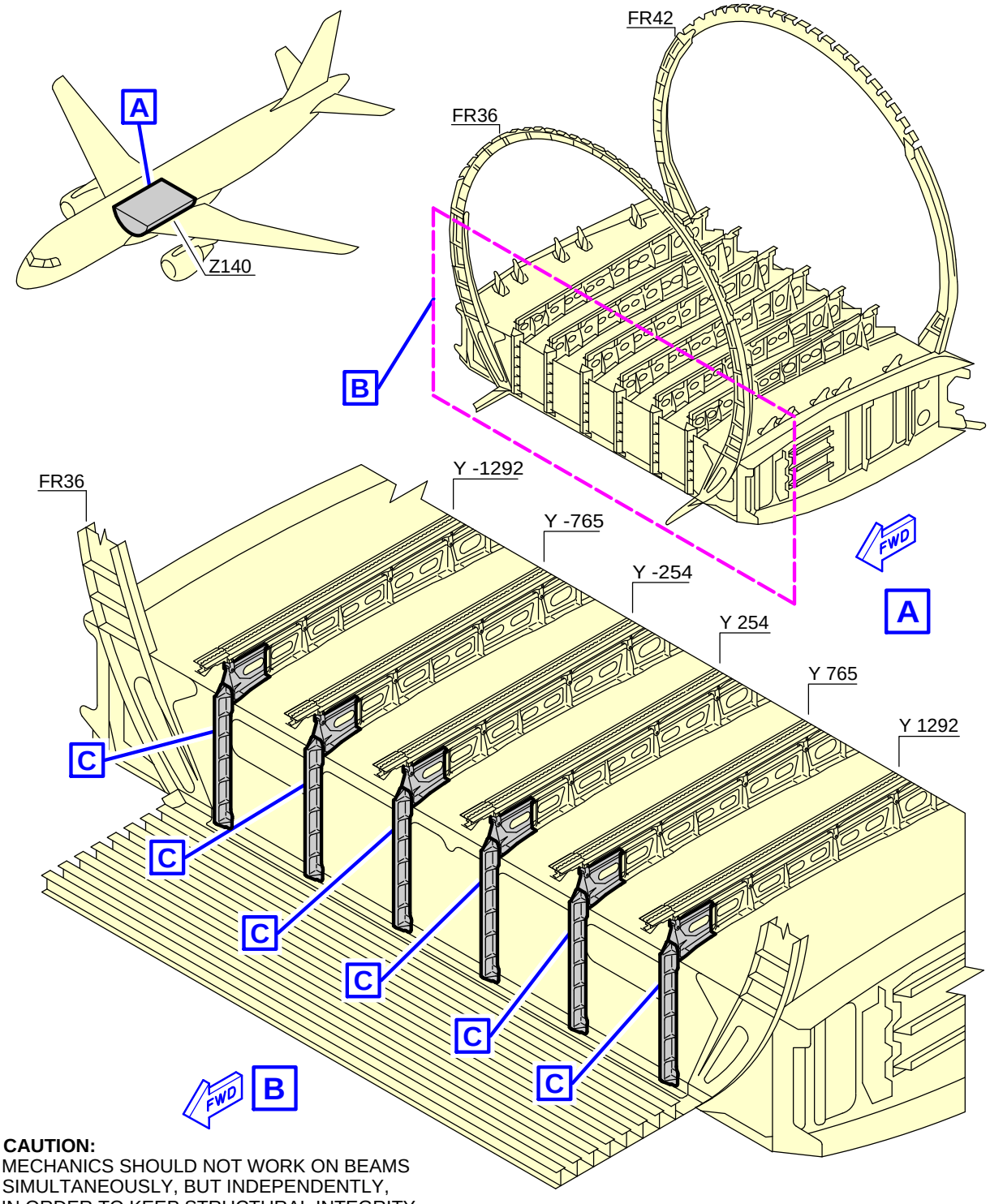
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

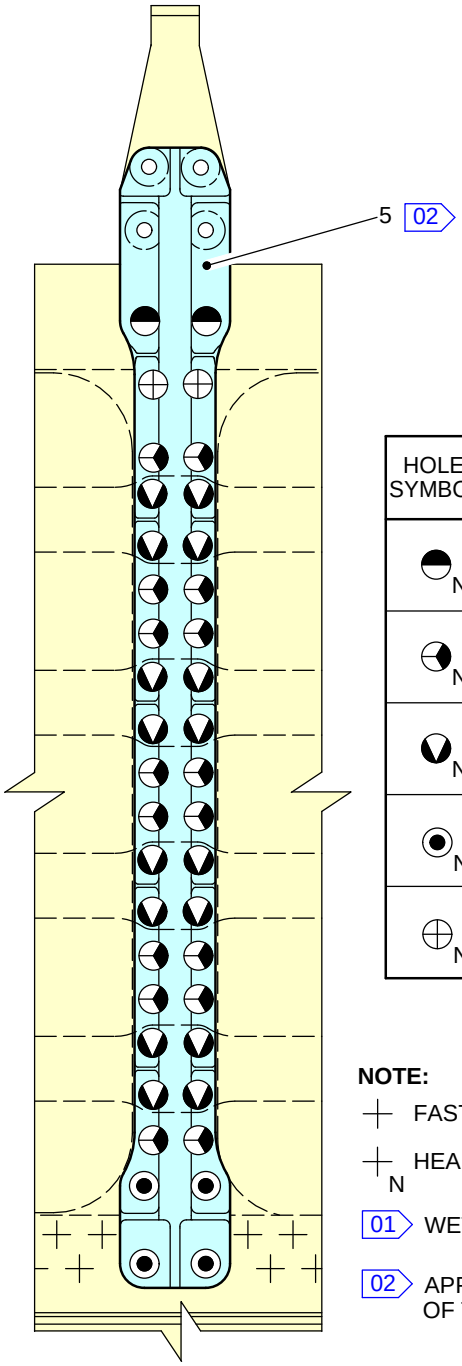


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(62) Task A320-A-57-XX-1228-23001-720A-A - Install the Strut Lower Attachment on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

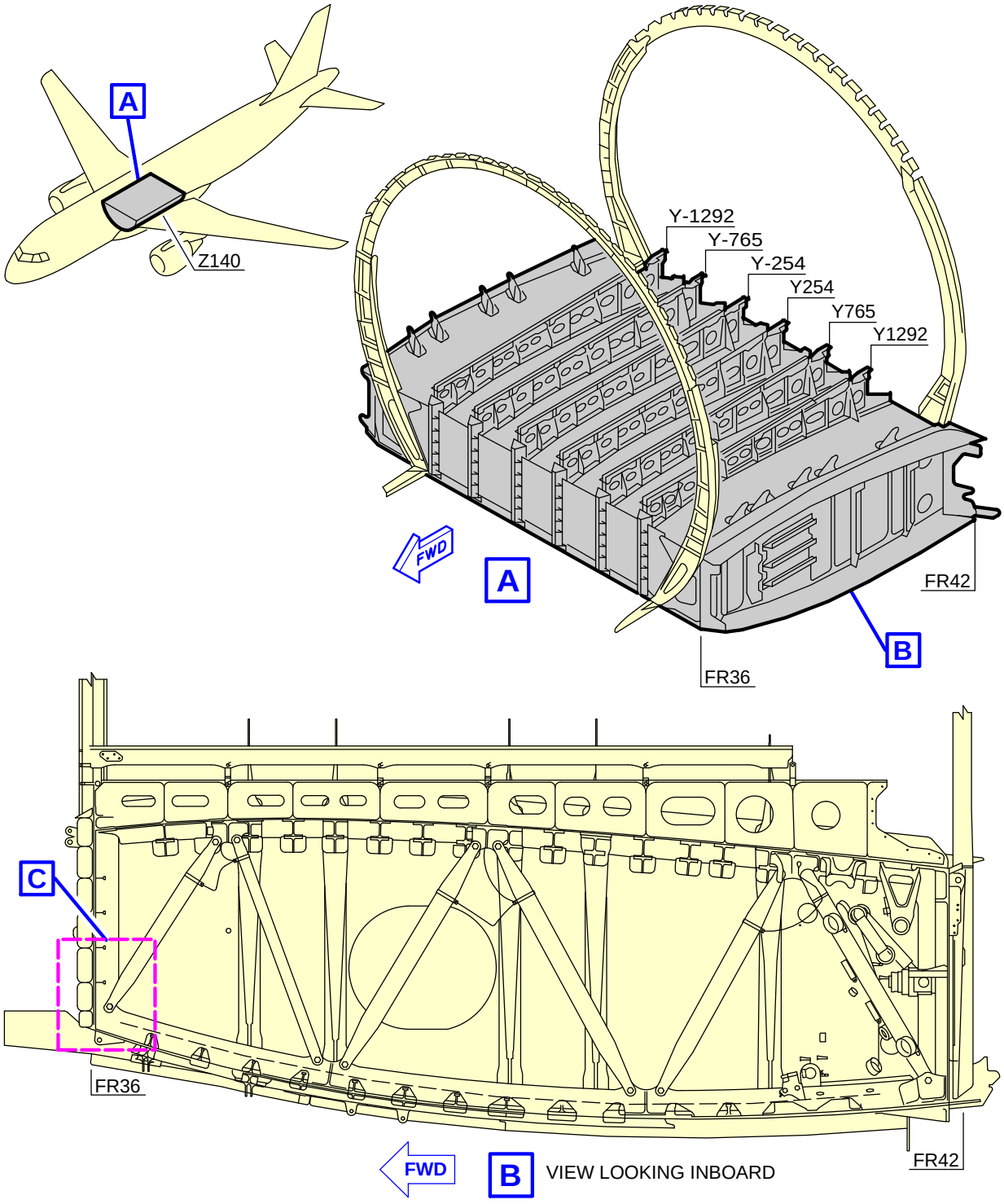
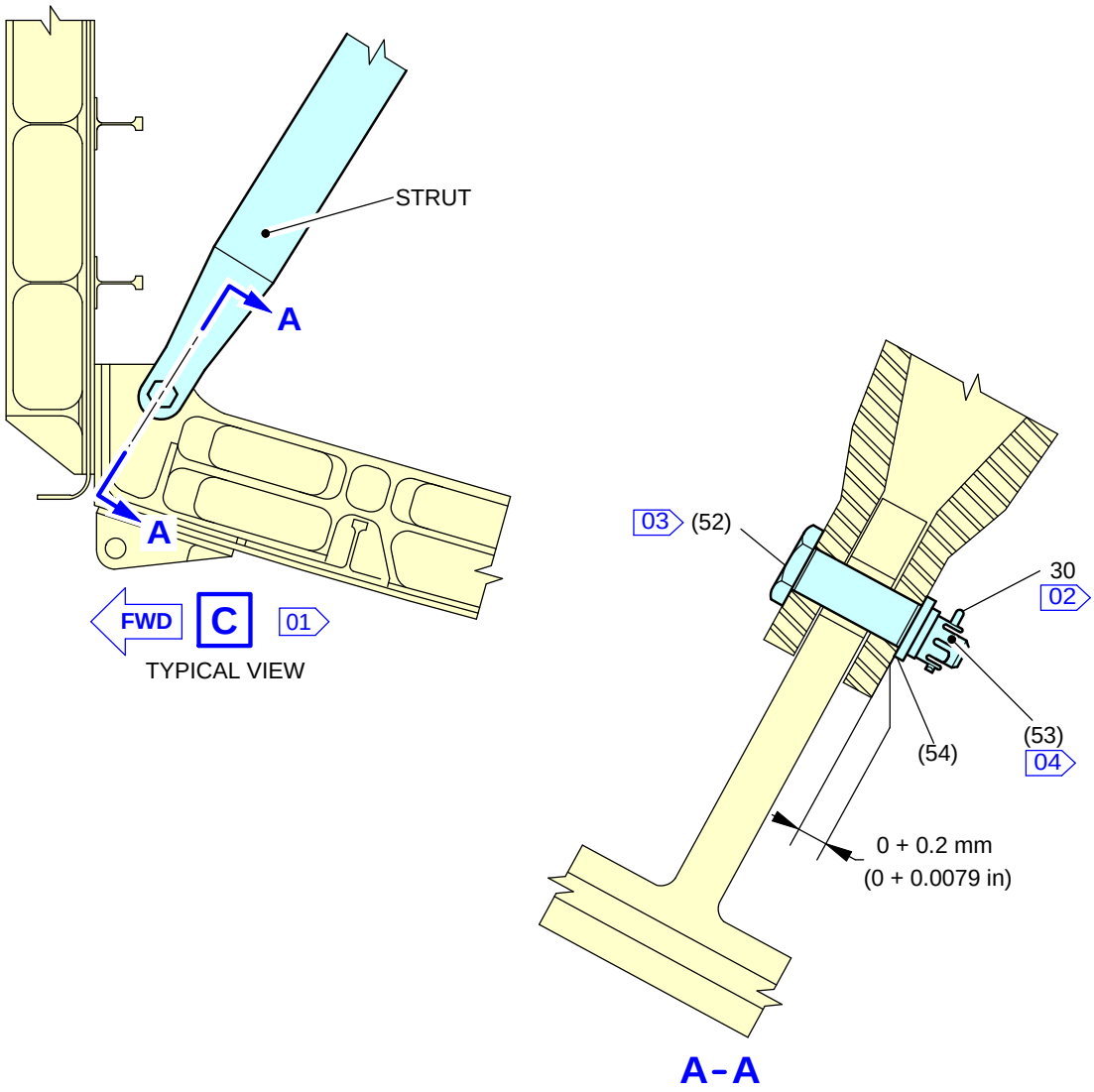


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(62) Task A320-A-57-XX-1228-23002-720A-A - Install the Strut Lower Attachment on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 002

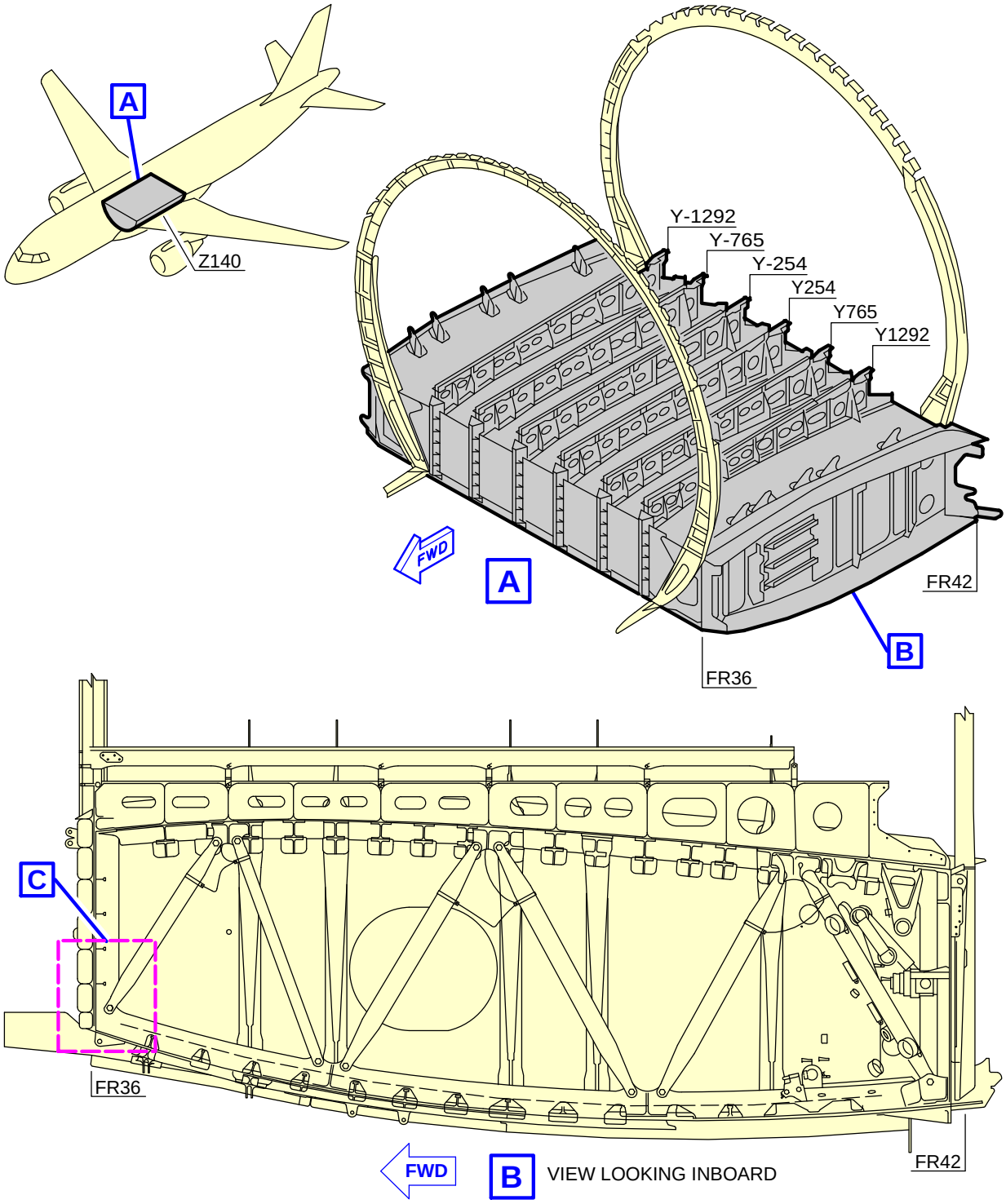
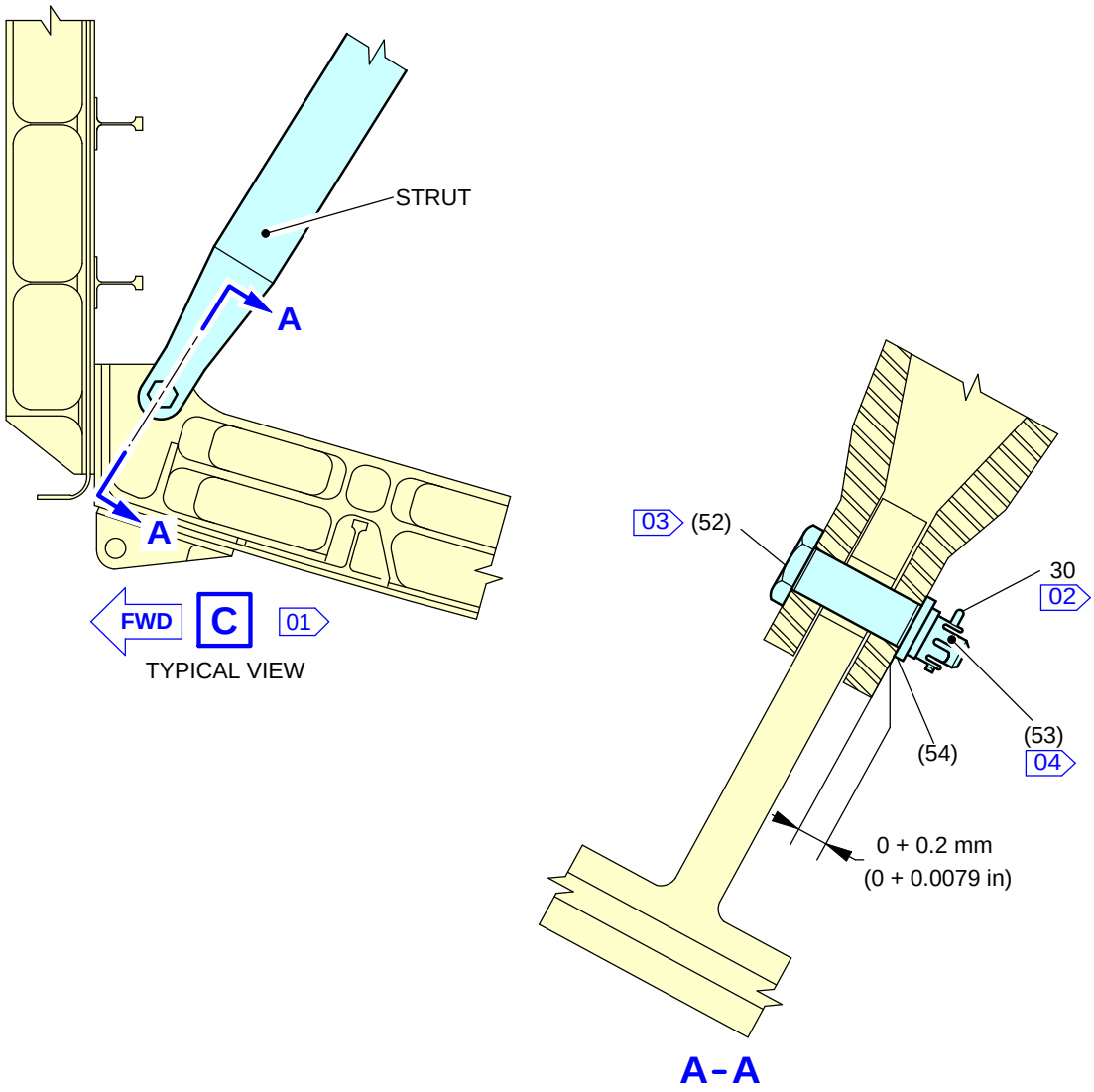


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(63) Task A320-A-57-XX-1228-18001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

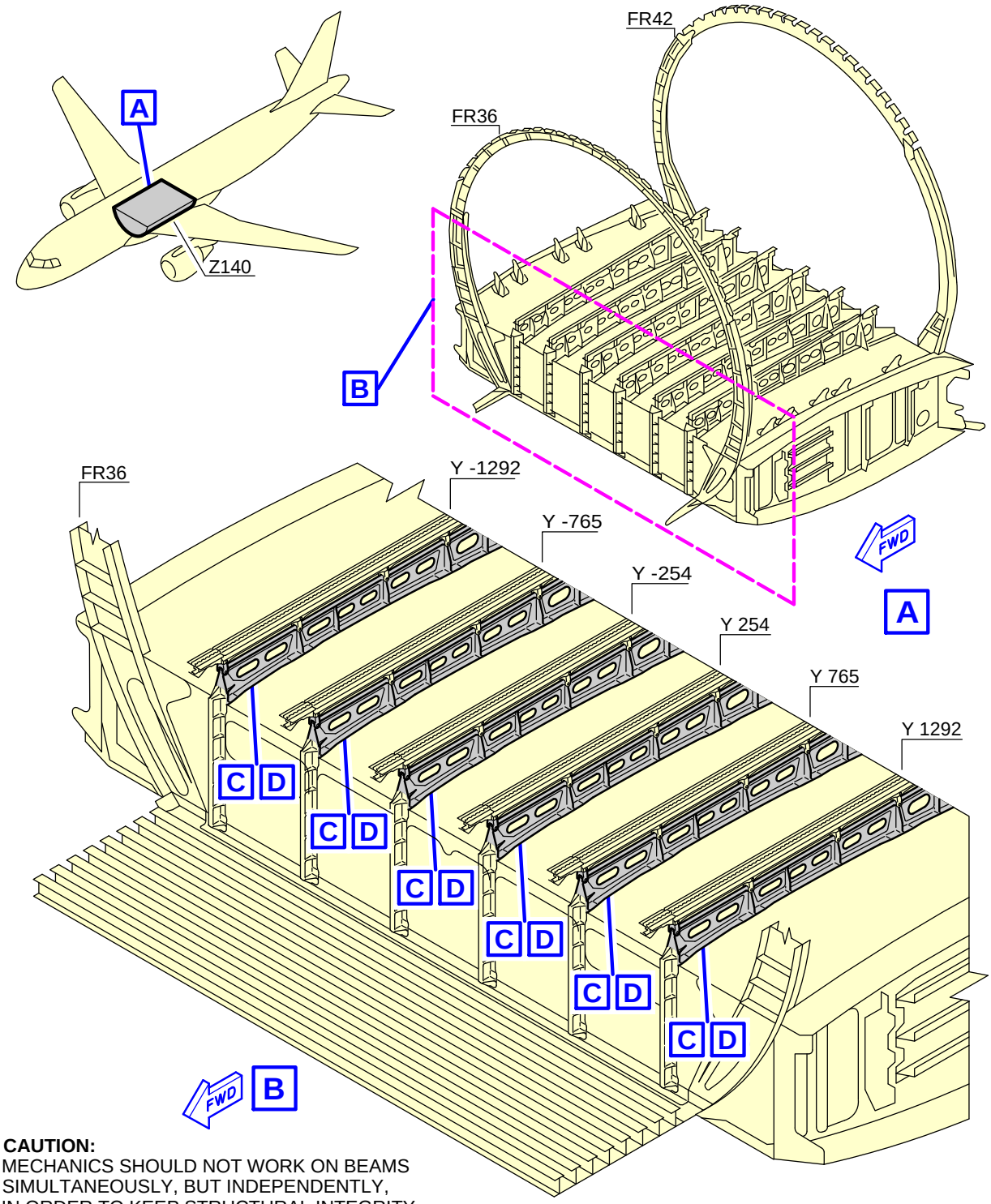
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-25ZZZ-720Z-A.

CONF ALL

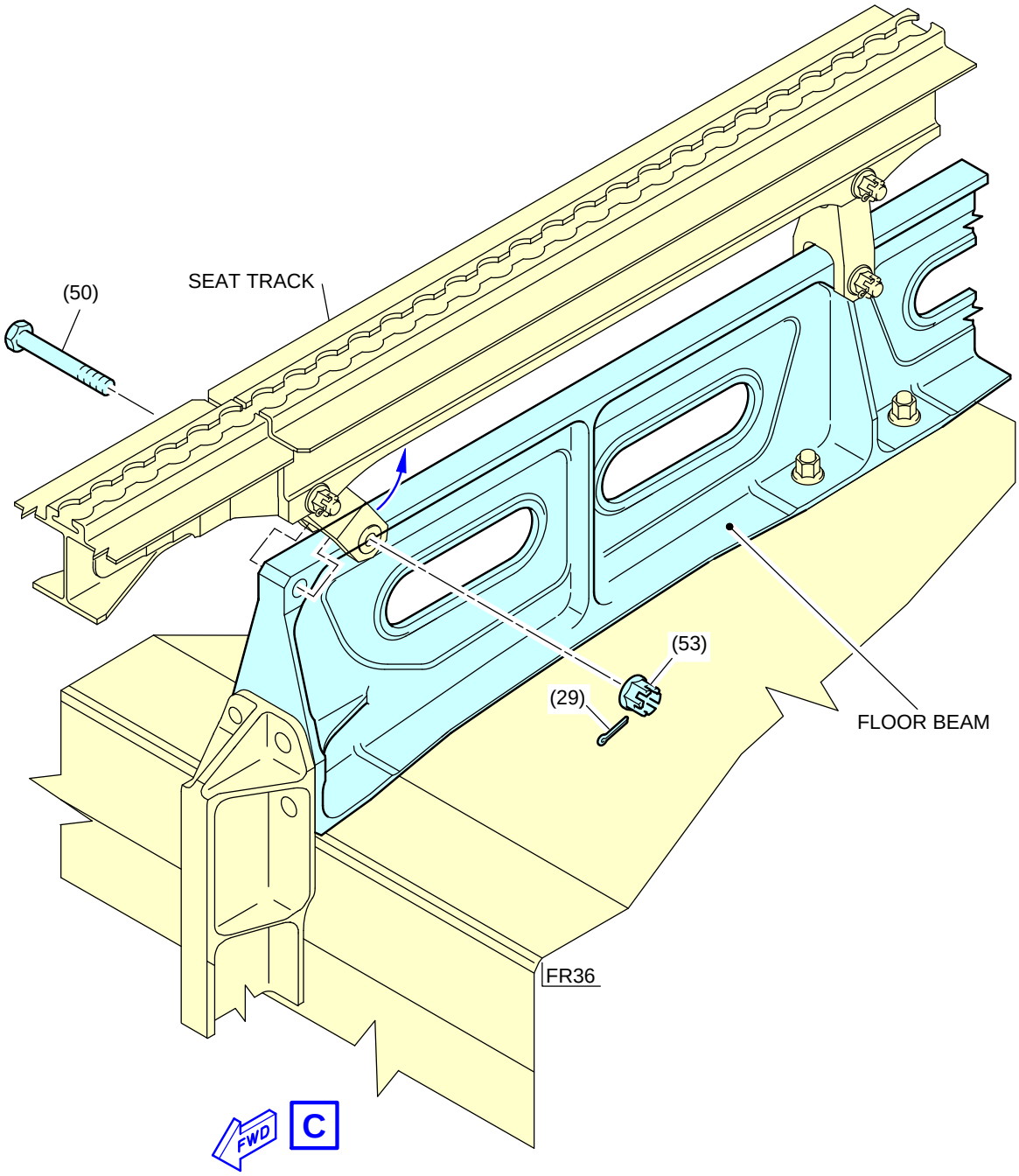


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

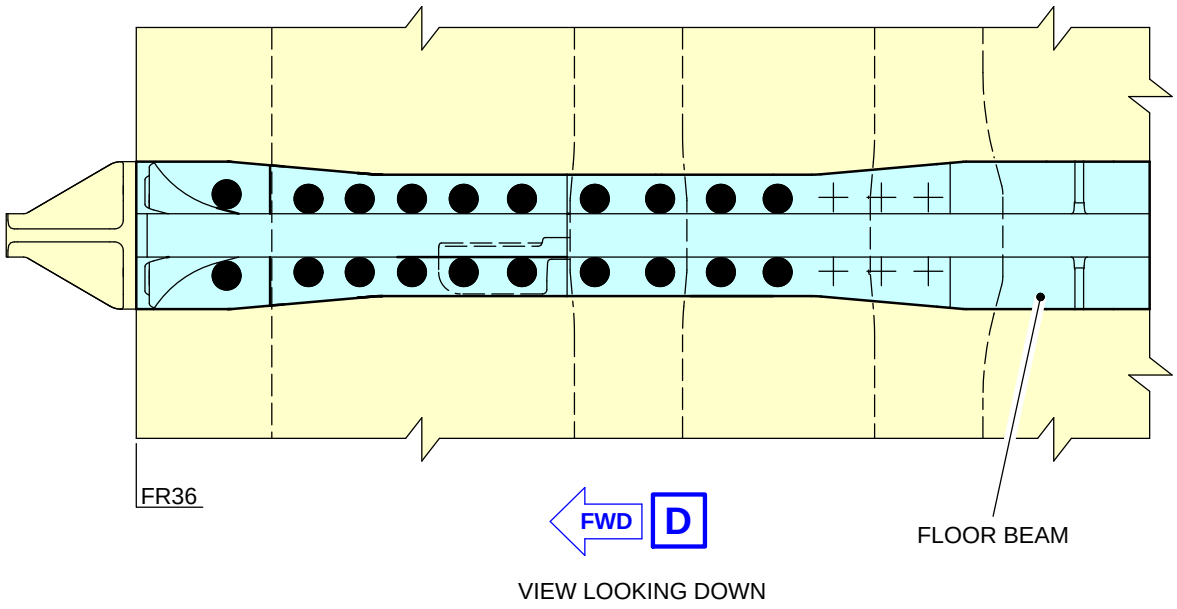
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(64) Task A320-A-57-XX-1228-05001-650A-A - Cut out the Forward End Floor Beam on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

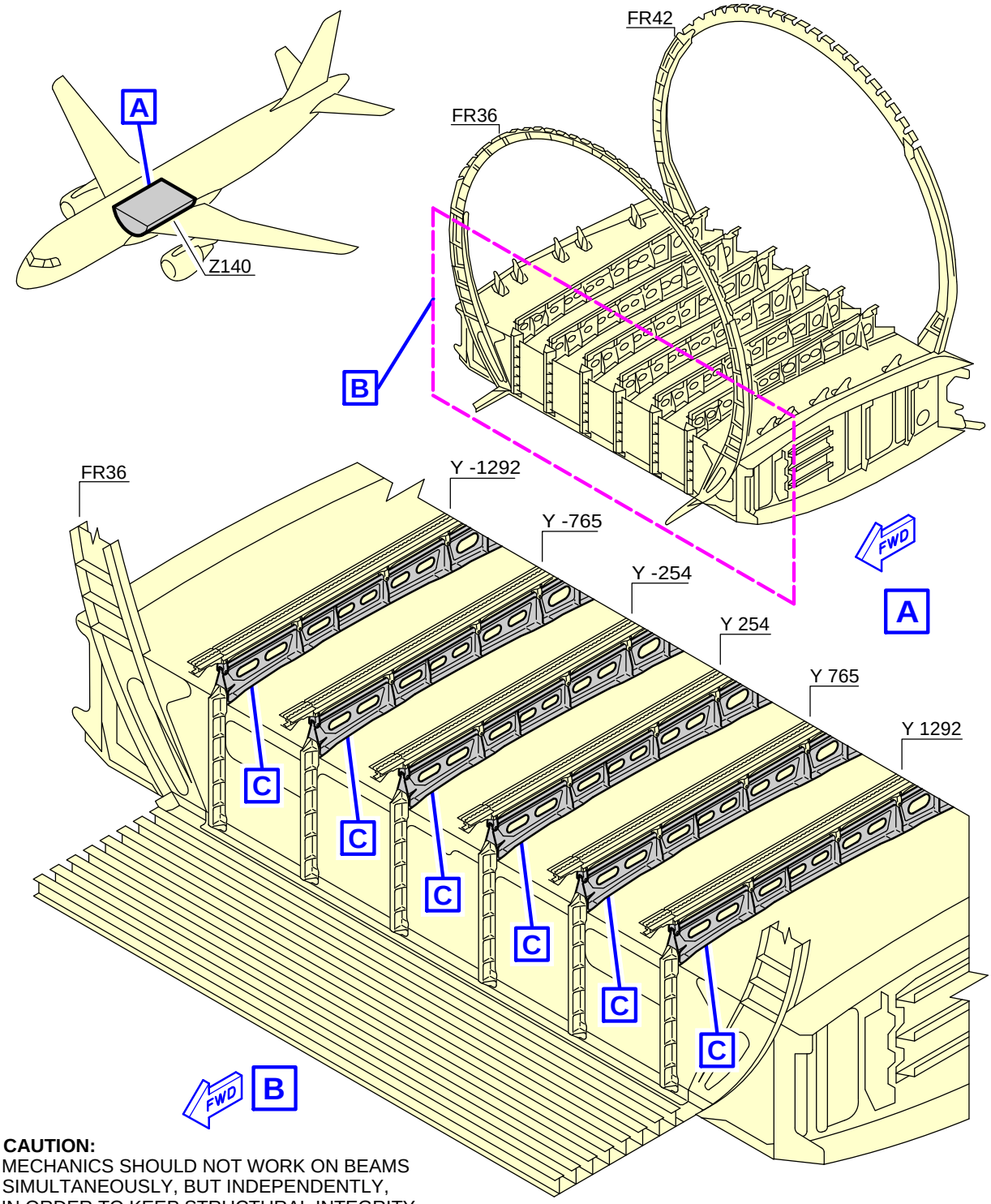
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

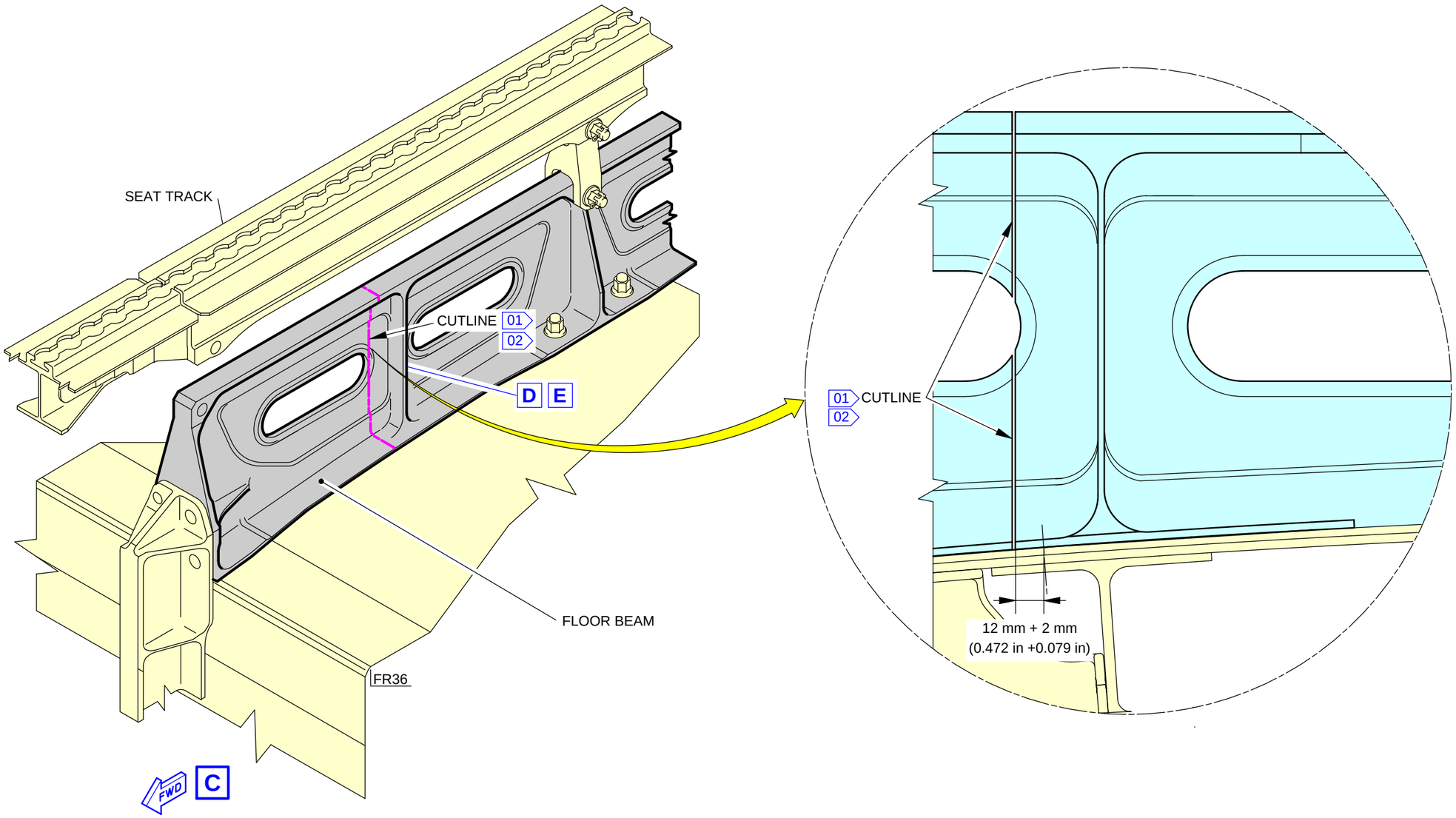


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

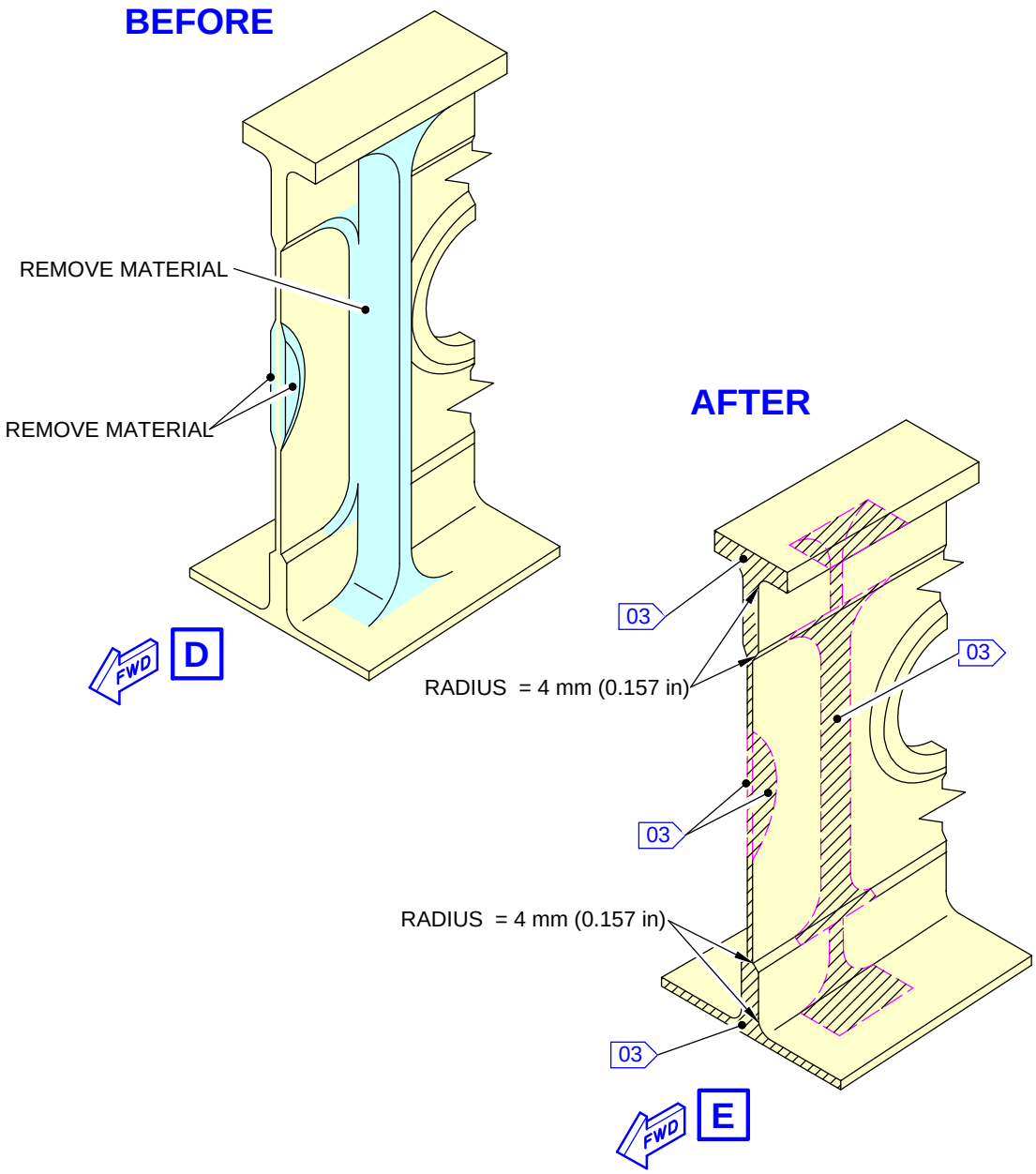
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(65) Task A320-A-57-XX-1228-10001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-24ZZZ-720Z-C.

CONF 001 003 004

(66) Task A320-A-57-XX-1228-24001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

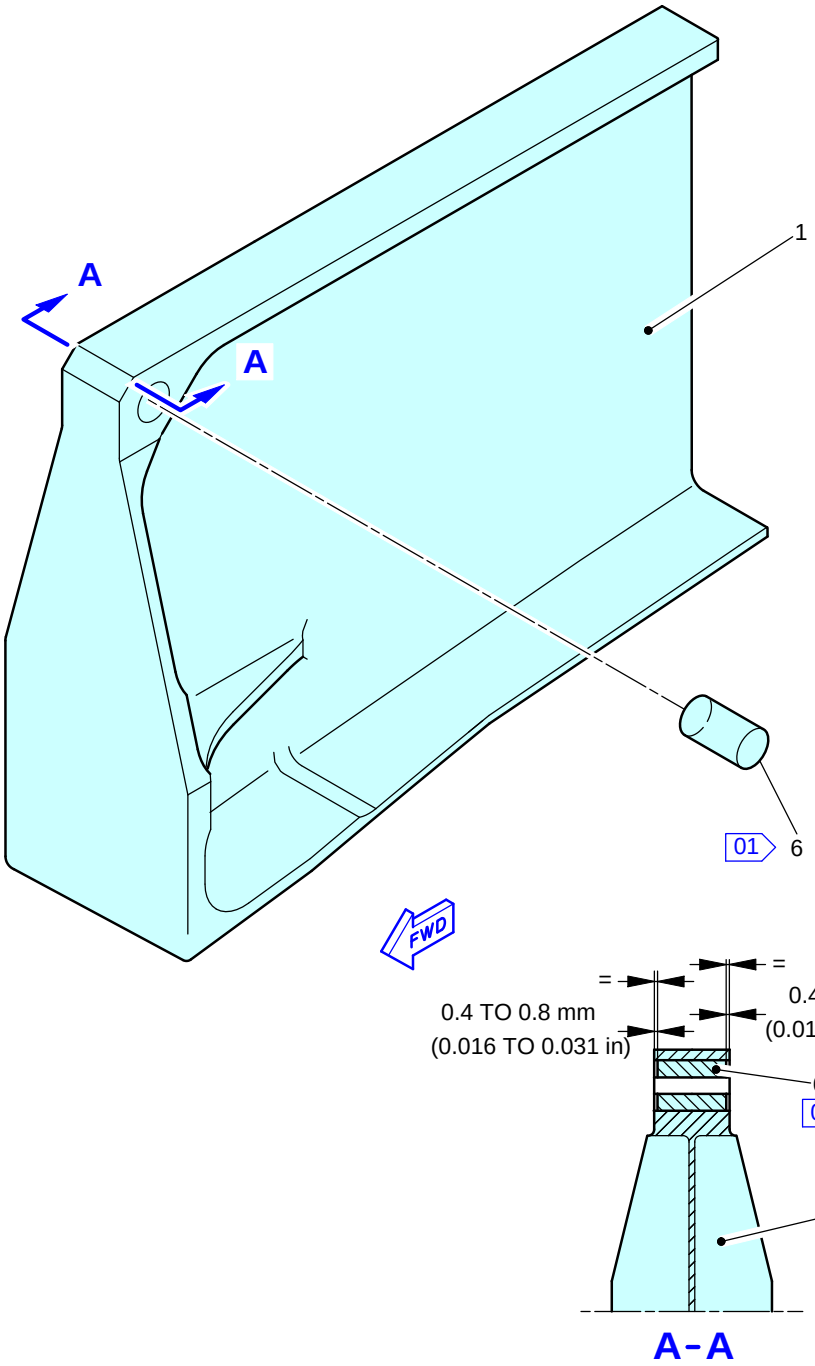
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(66) Task A320-A-57-XX-1228-24002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-765 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

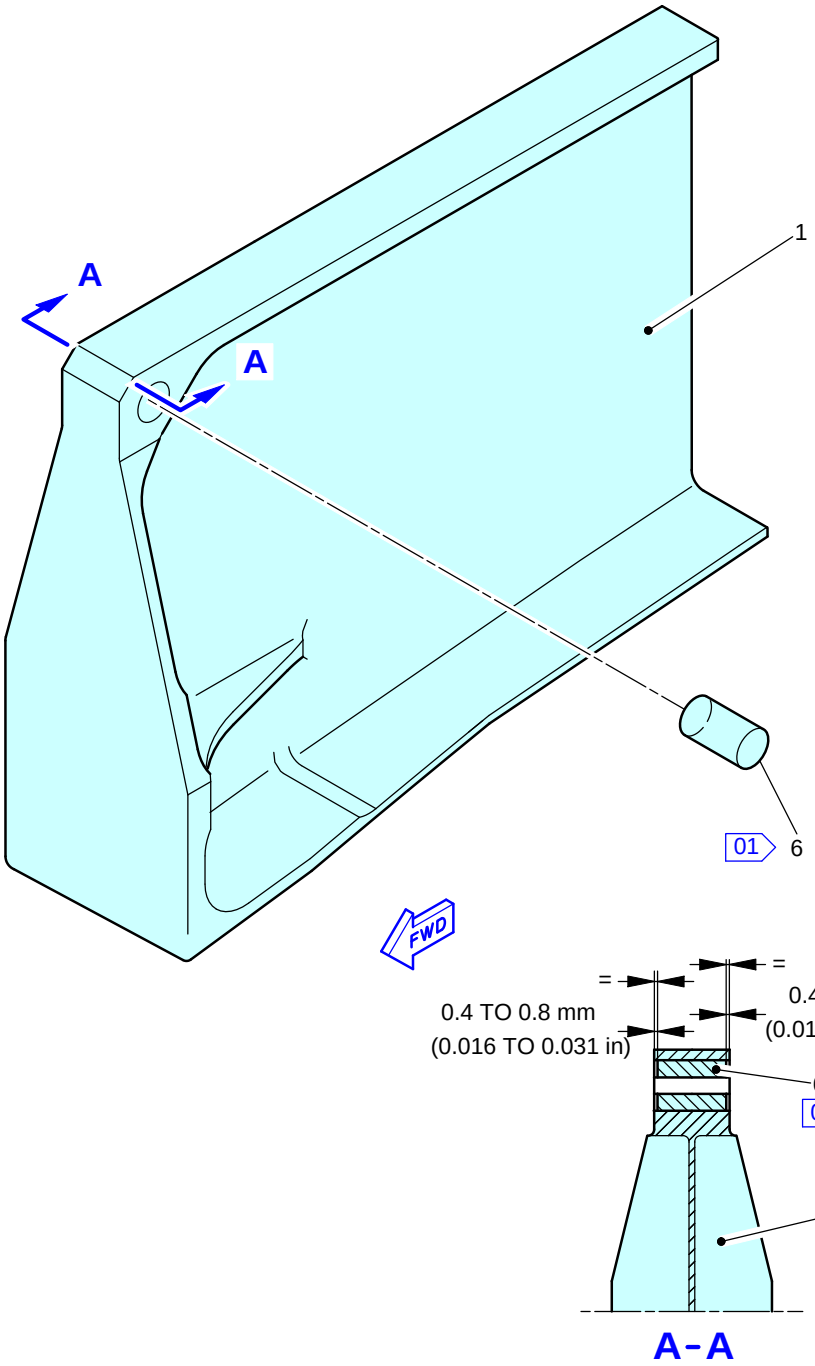
2 Install:

1	BUSHING	D5713006420000	Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(67) Task A320-A-57-XX-1228-05001-270A-A - Temporarily, Install the New Parts for Adjustment on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

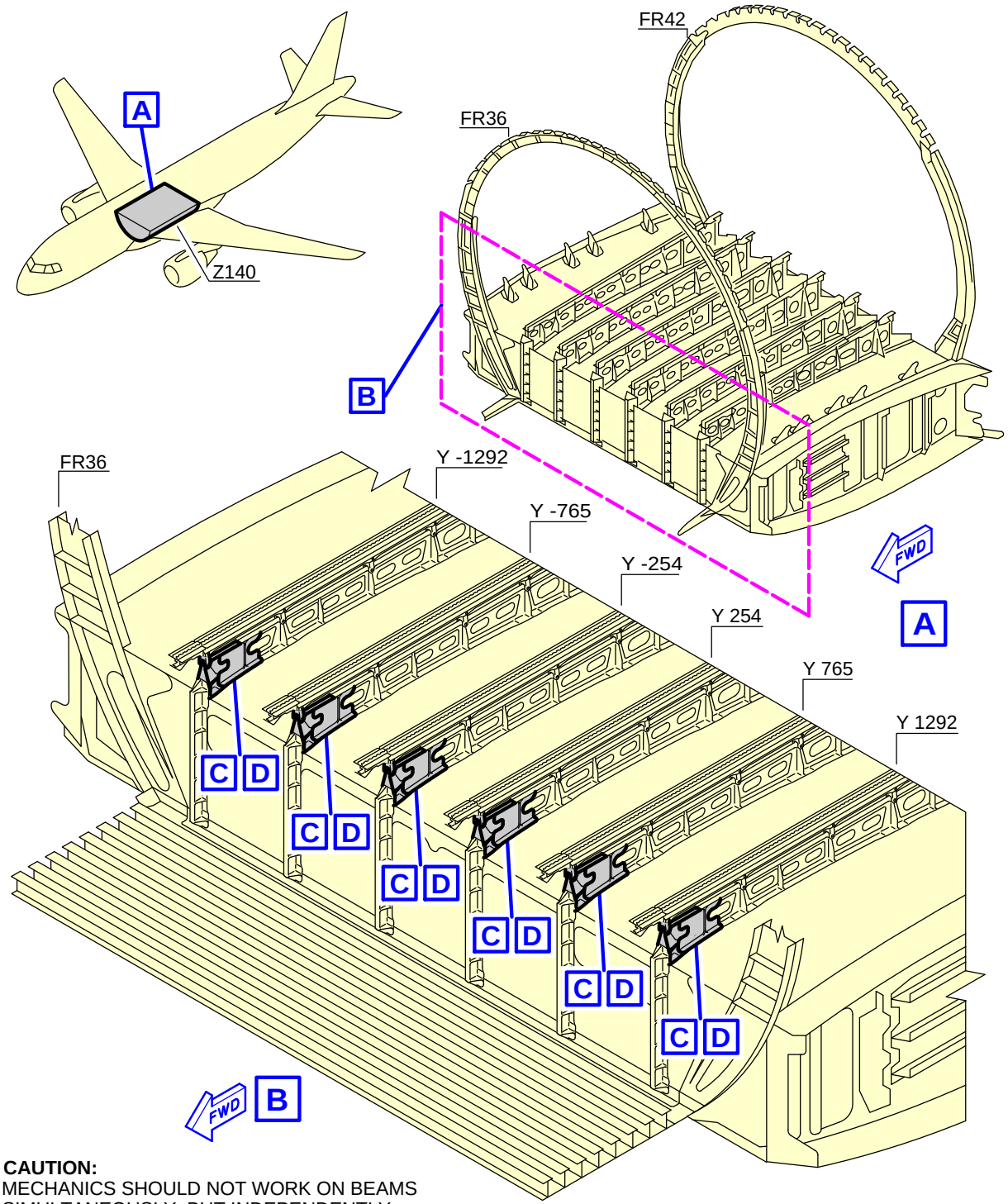
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

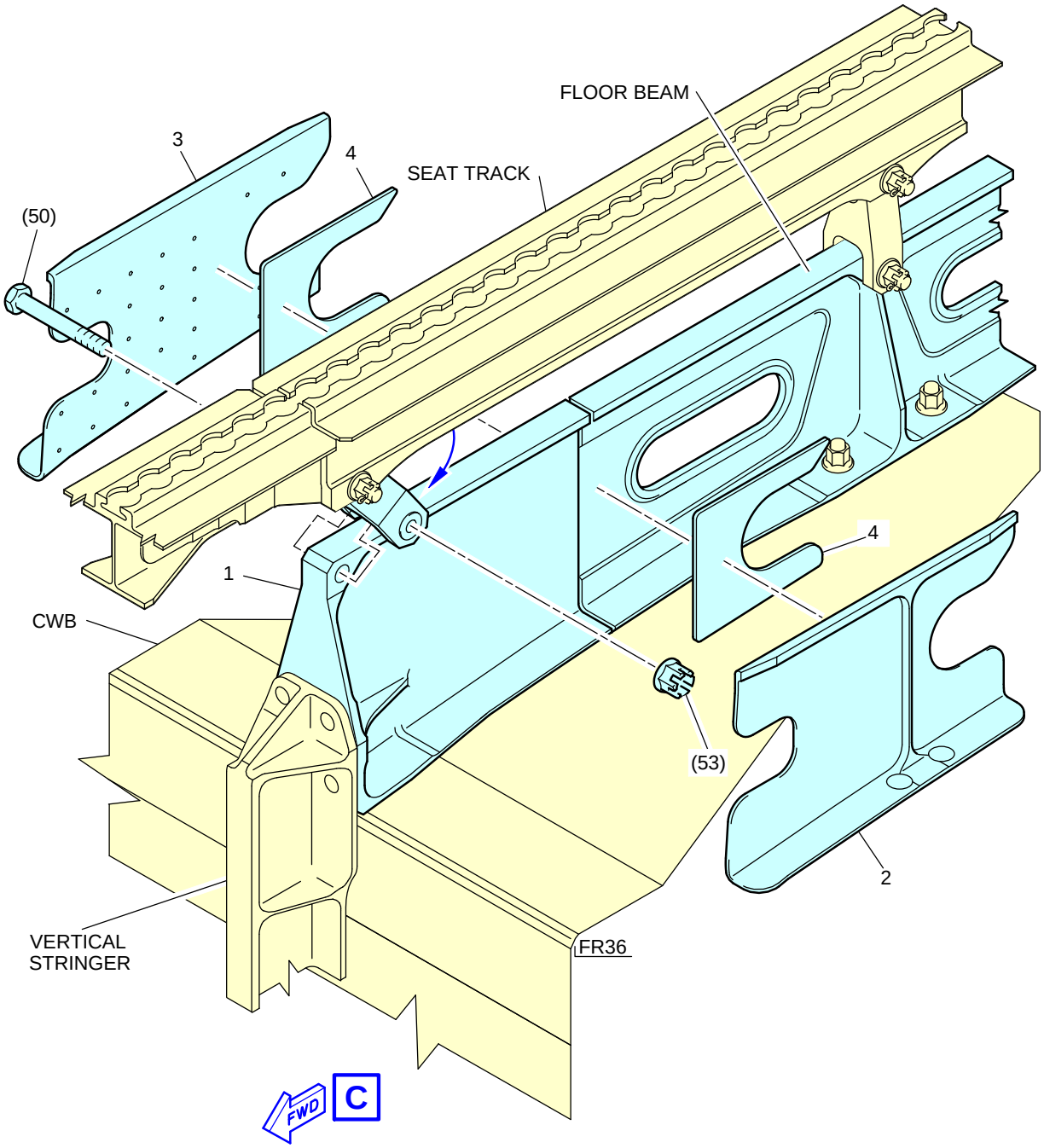


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

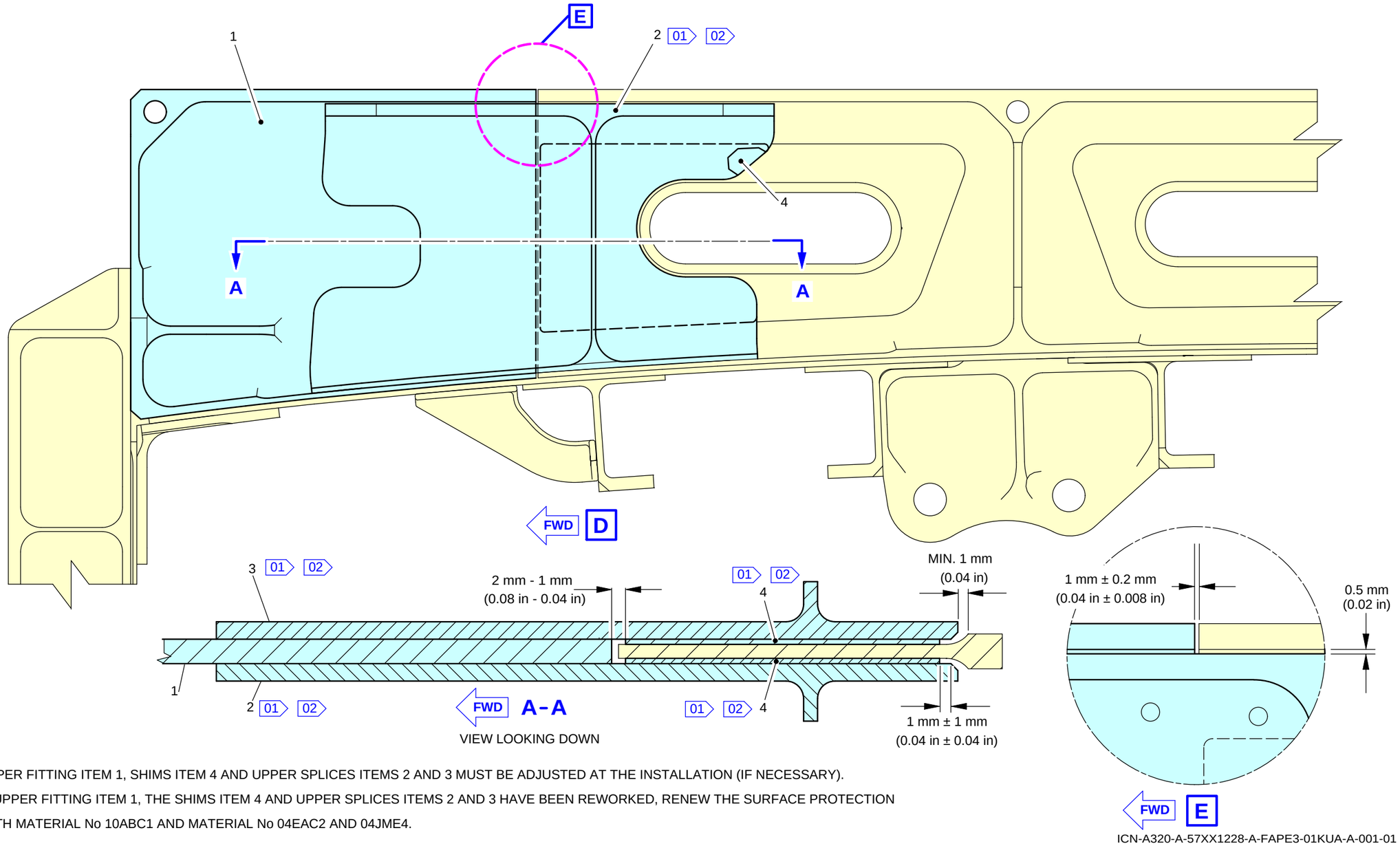
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(67) Task A320-A-57-XX-1228-05002-270A-A - Temporarily, Install the New Parts for Adjustment on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

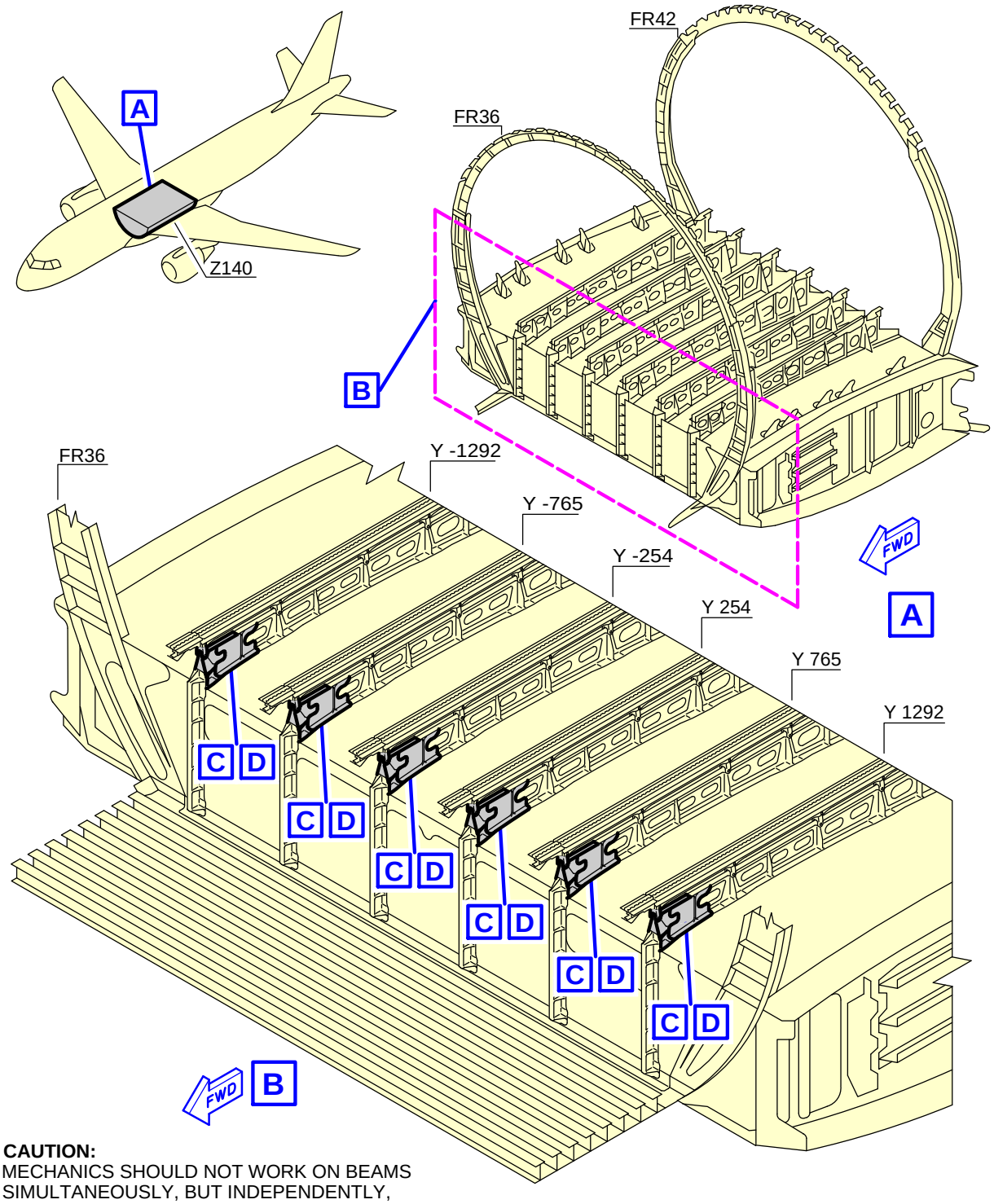
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

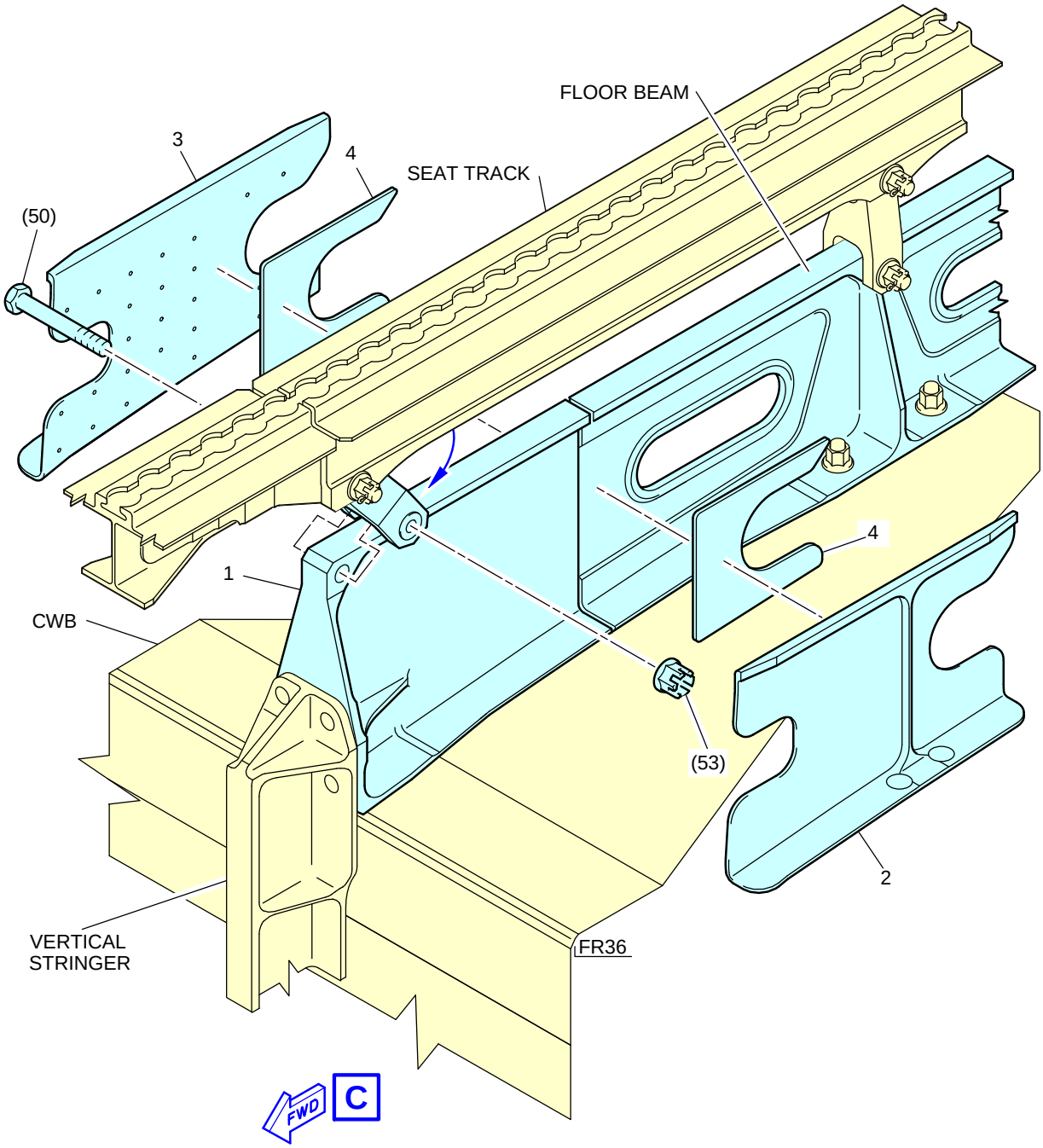


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

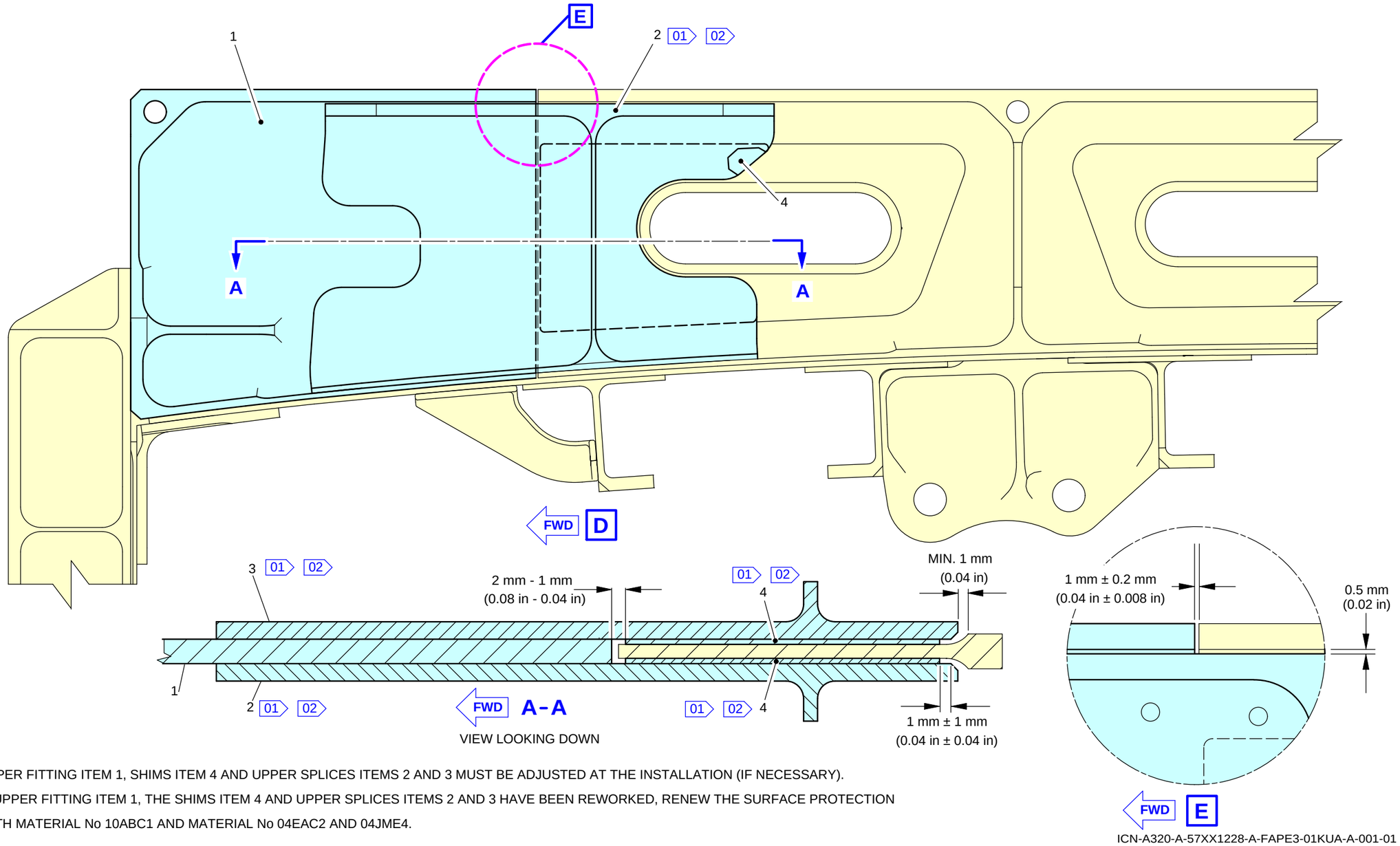
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(68) Task A320-A-57-XX-1228-10001-900A-A - Drill the New Parts on Y-765 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

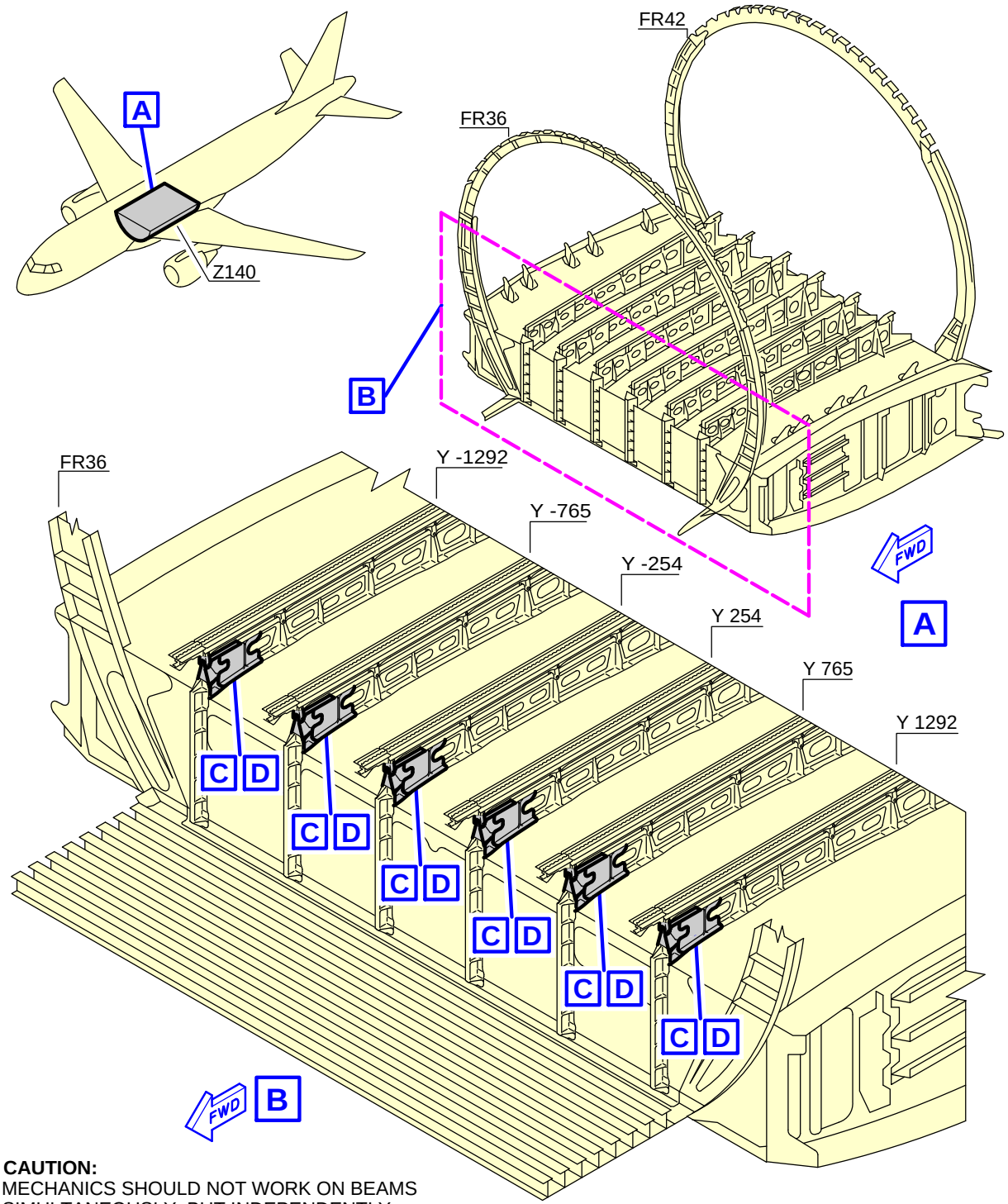
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

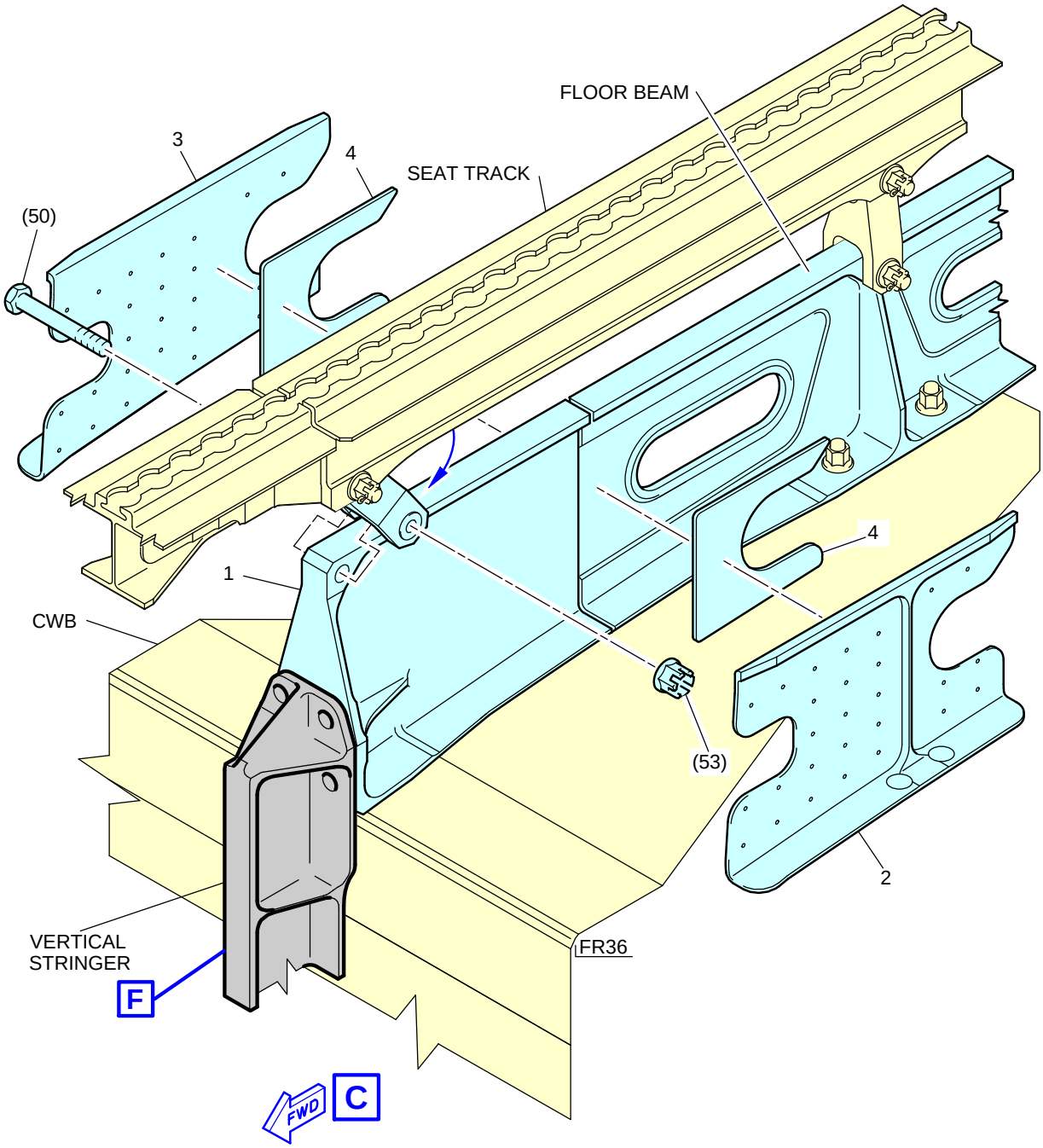


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

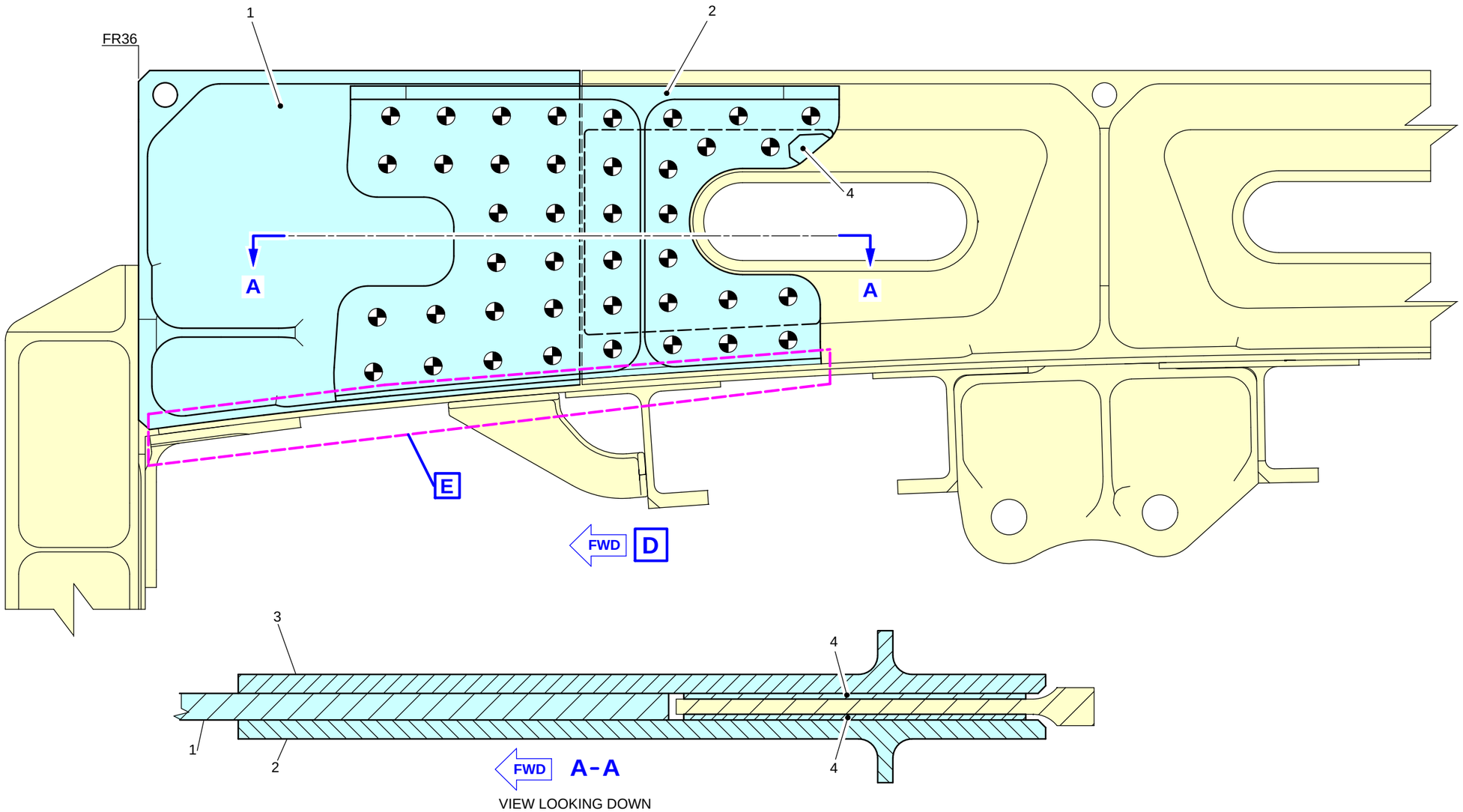
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

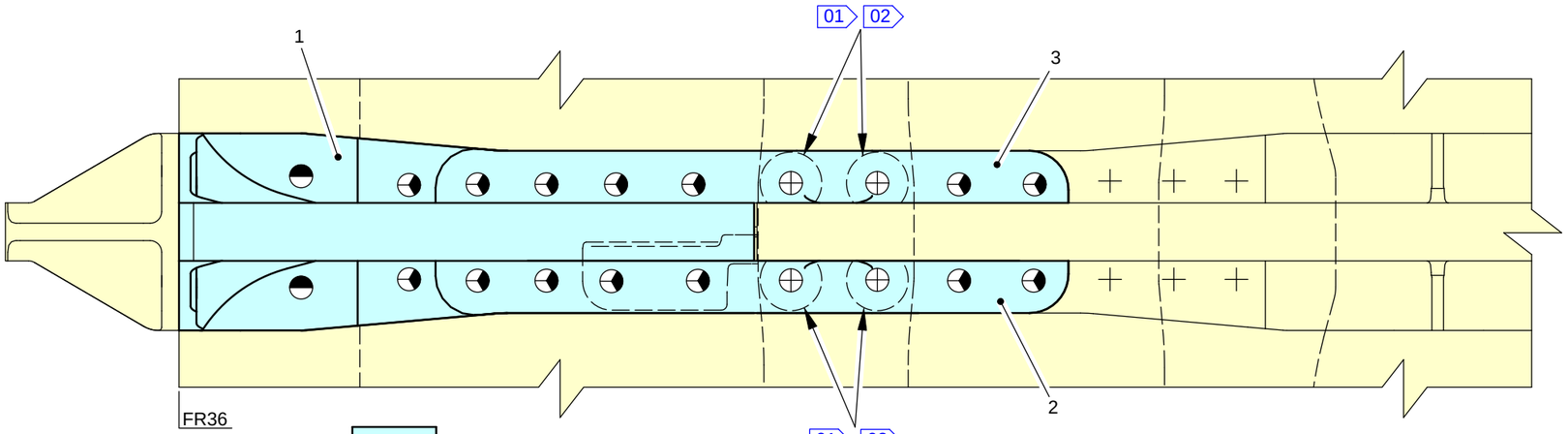


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

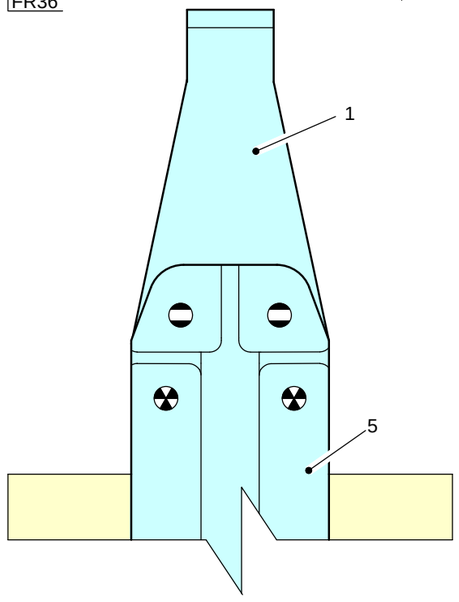
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◒	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(68) Task A320-A-57-XX-1228-10002-900A-A - Drill the New Parts on Y-765 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12

Manuals/Drawings	References/Sheets
	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

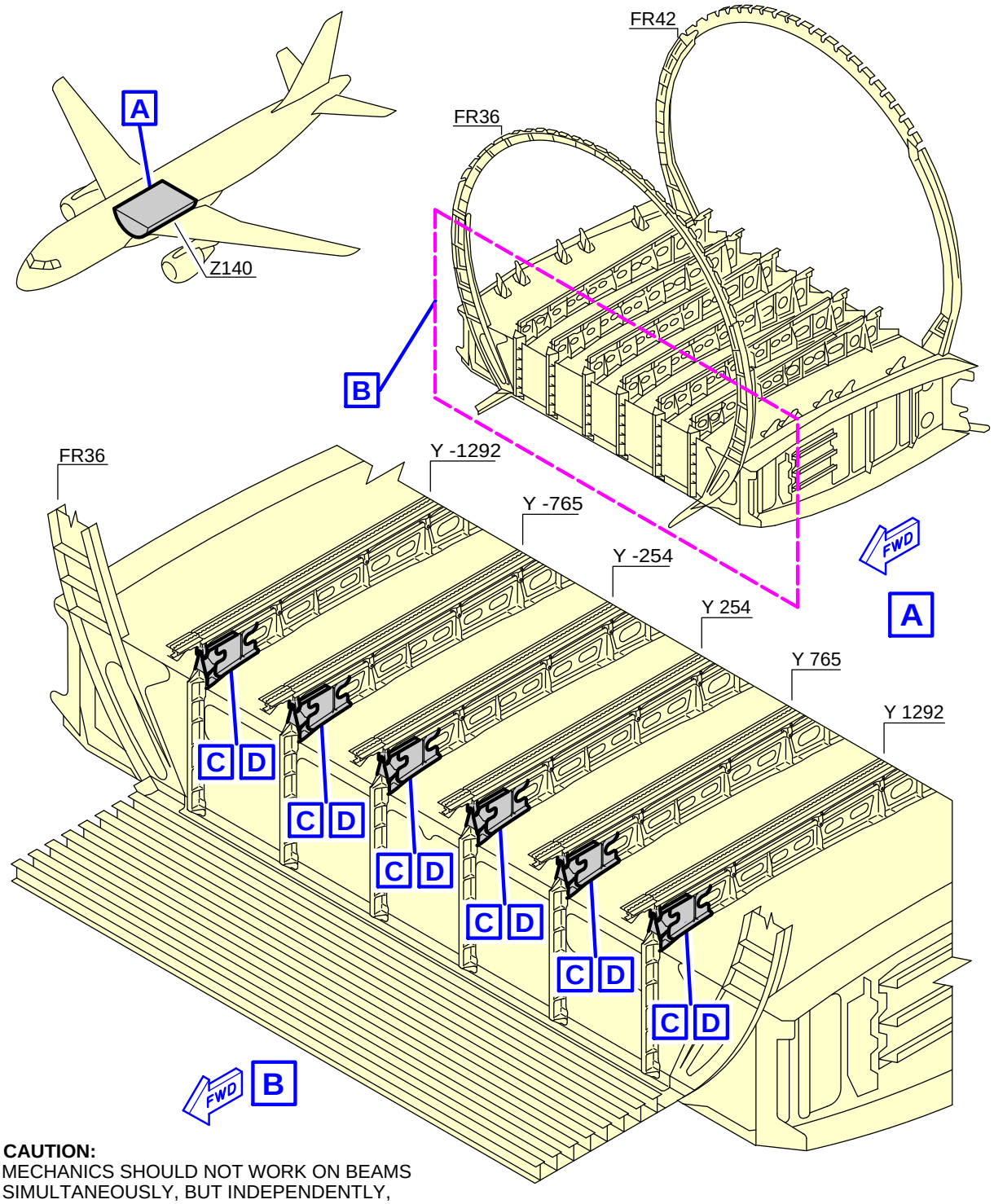
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

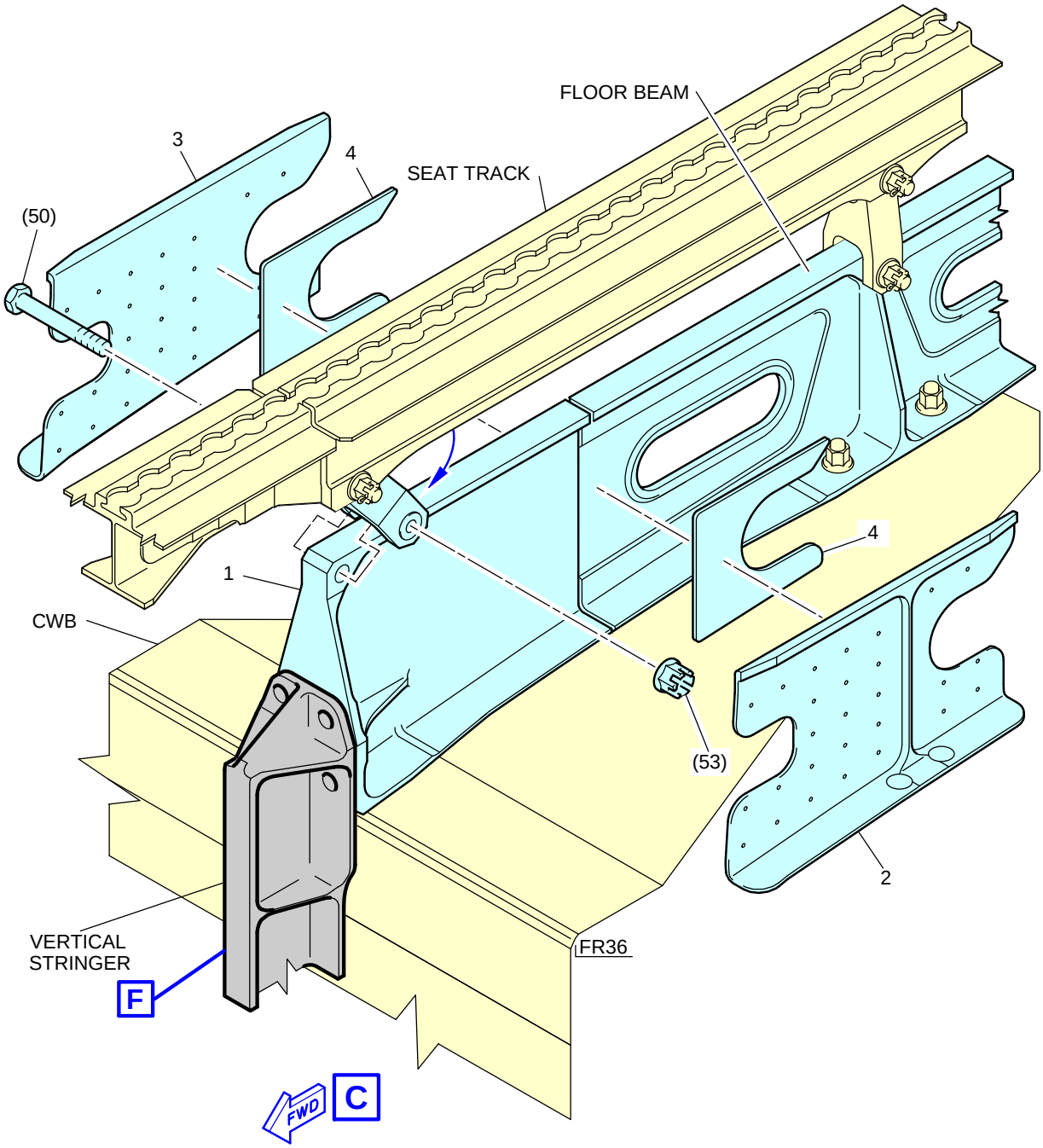


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

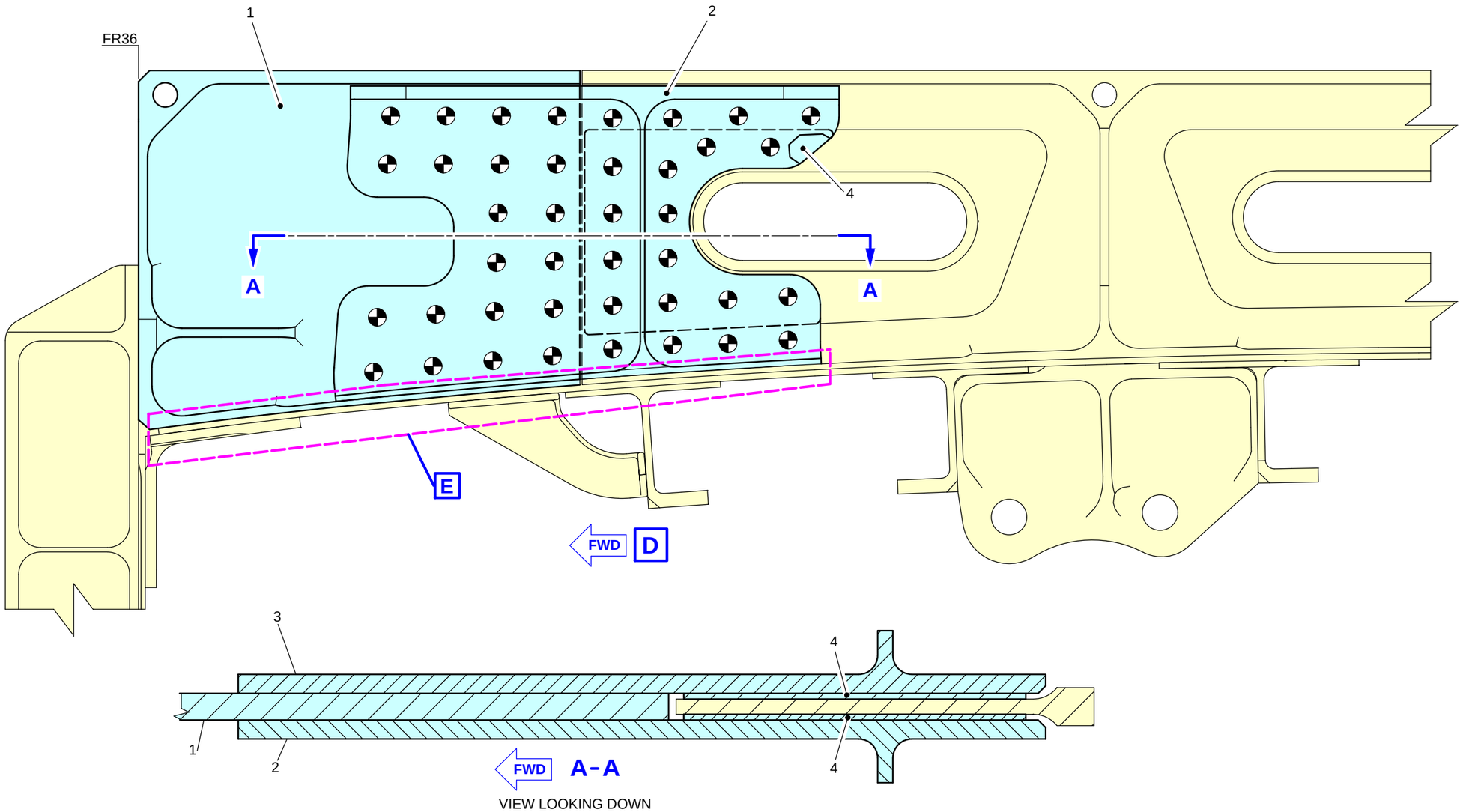
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

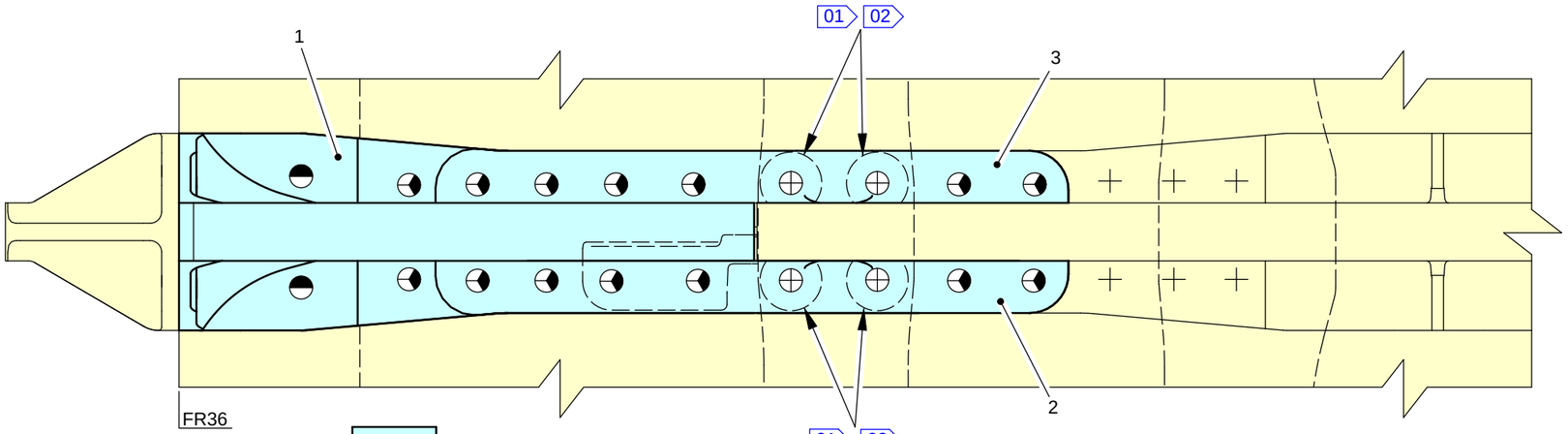


ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01

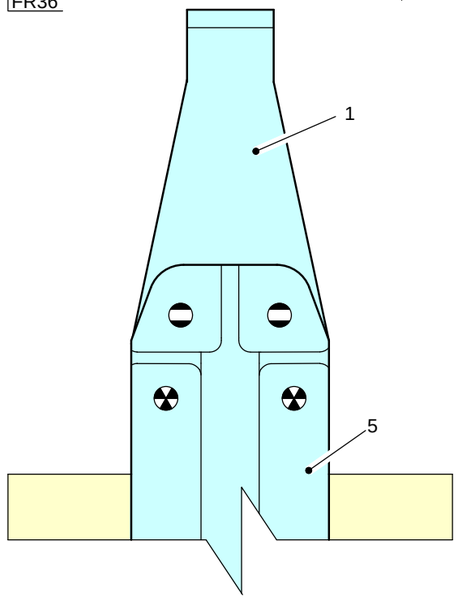
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(69) Task A320-A-57-XX-1228-25001-720A-A - Install the New Parts on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

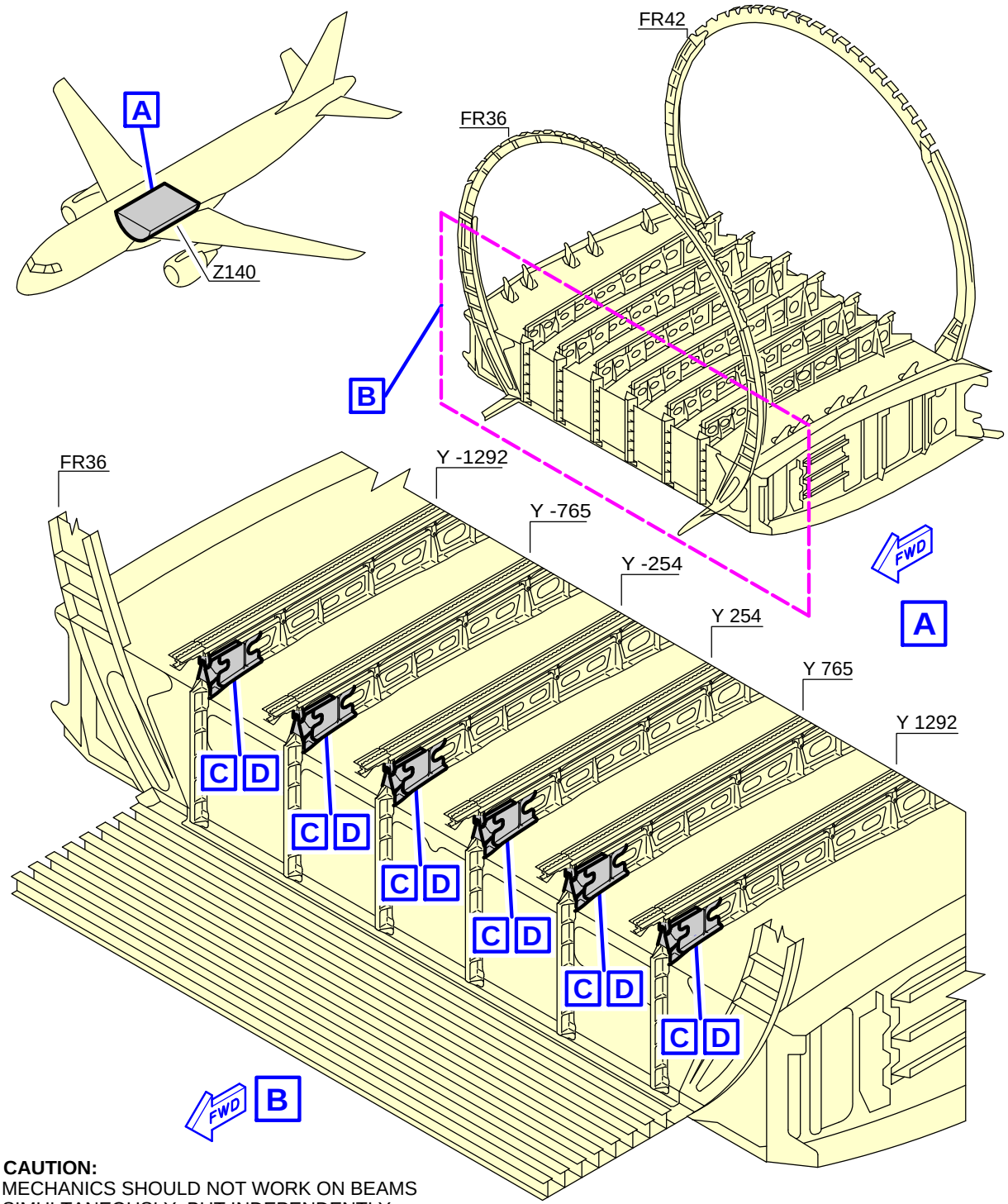
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

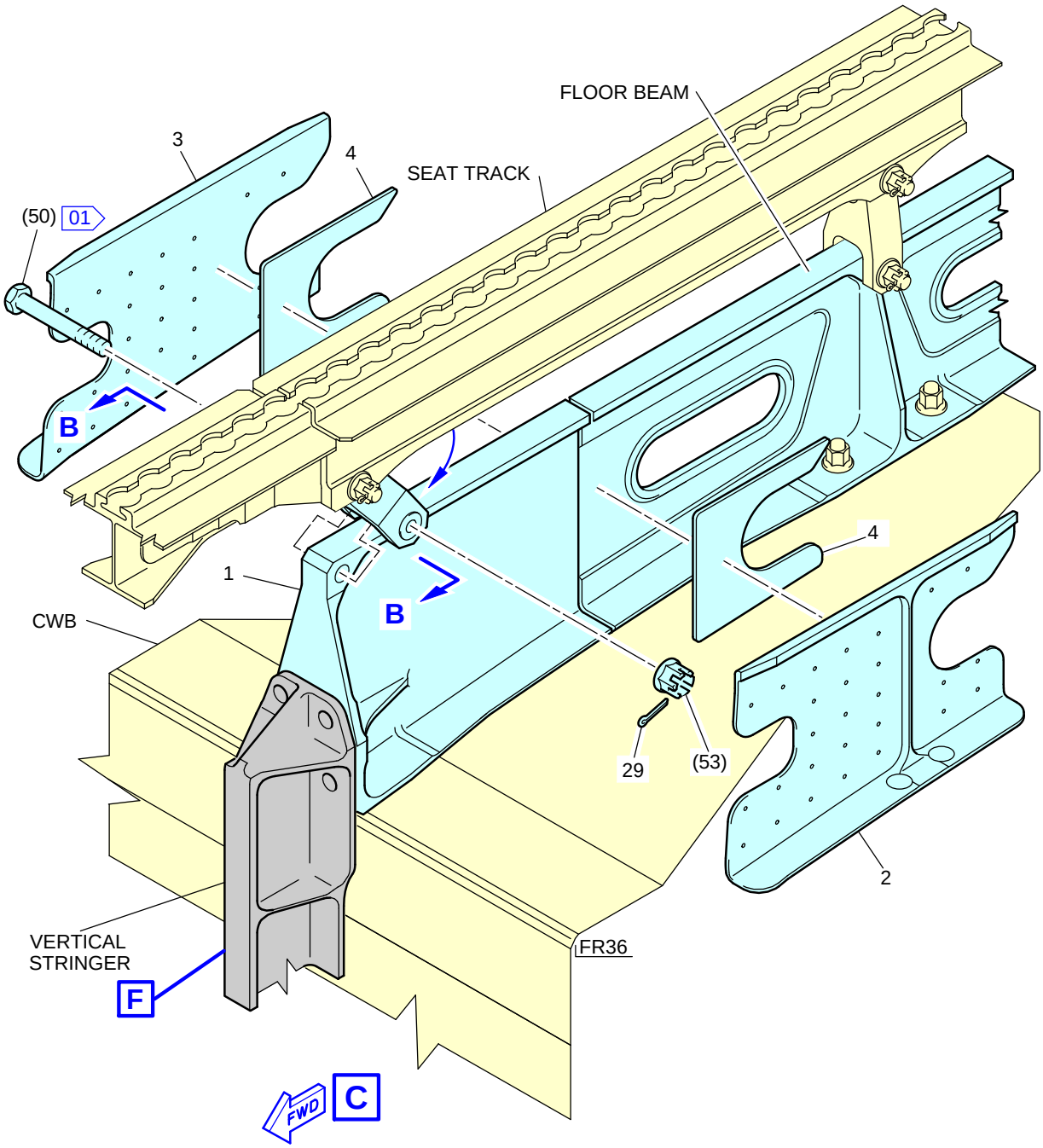


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



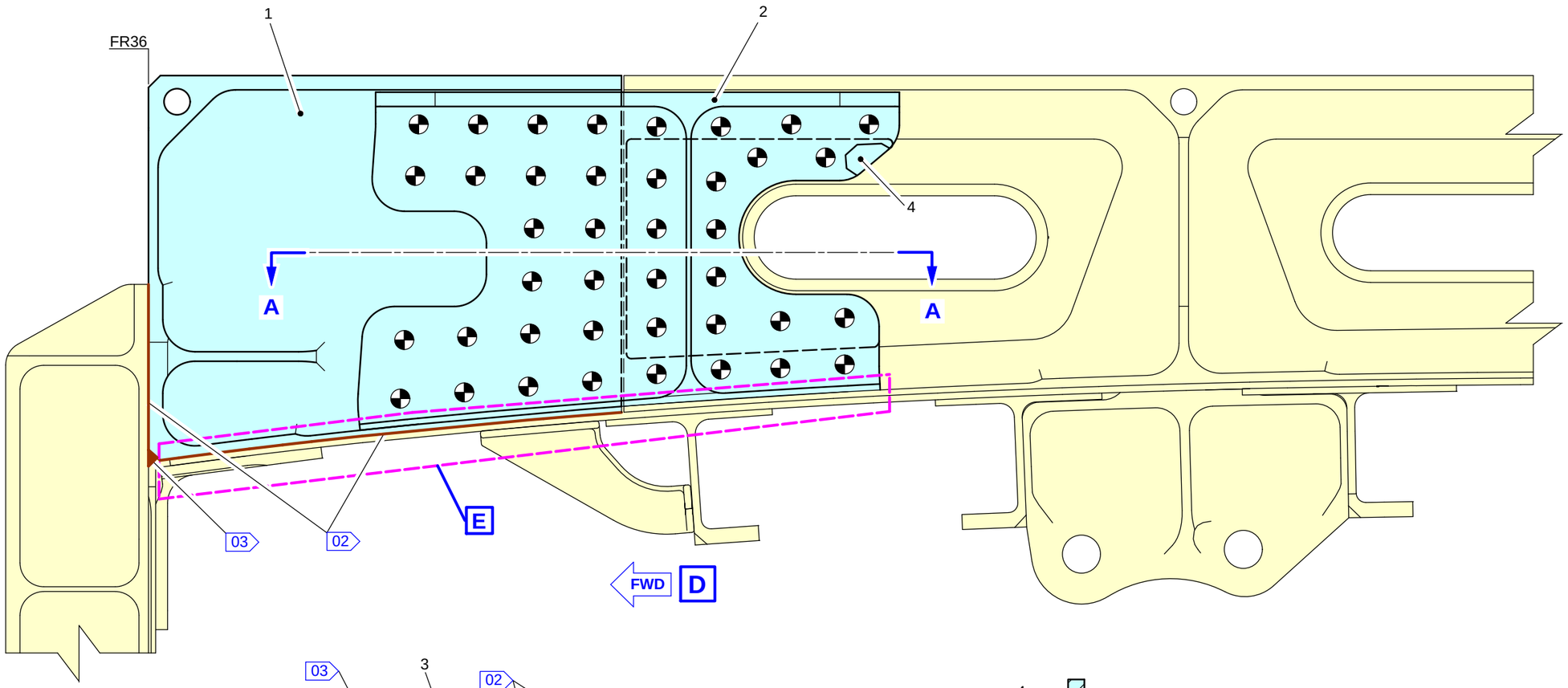
NOTE:

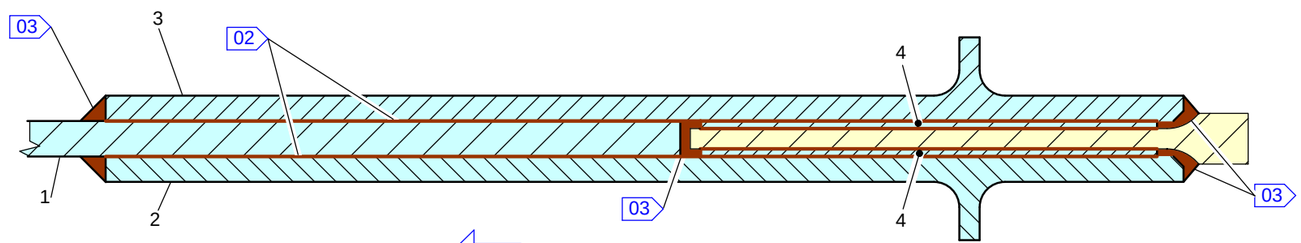
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

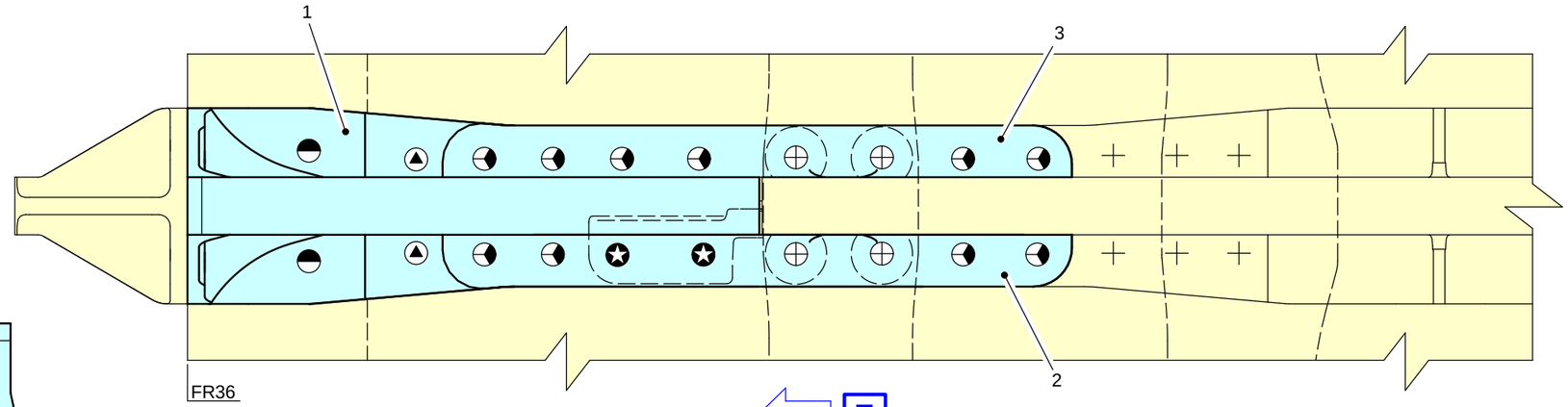
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

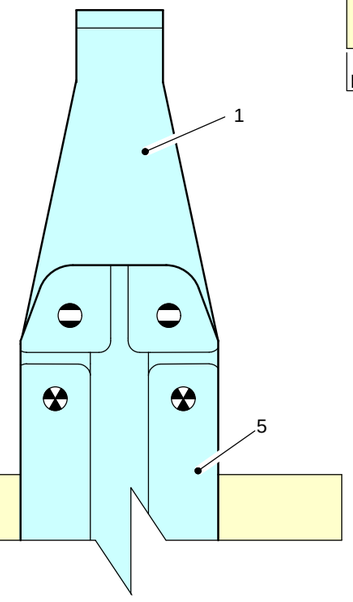
ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

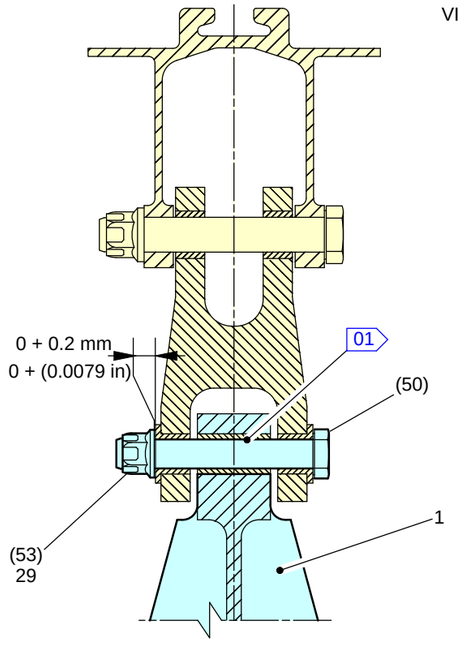
CONF 001 003 004





F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

FWD E

VIEW LOOKING DOWN

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 002

(69) Task A320-A-57-XX-1228-25002-720A-A - Install the New Parts on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

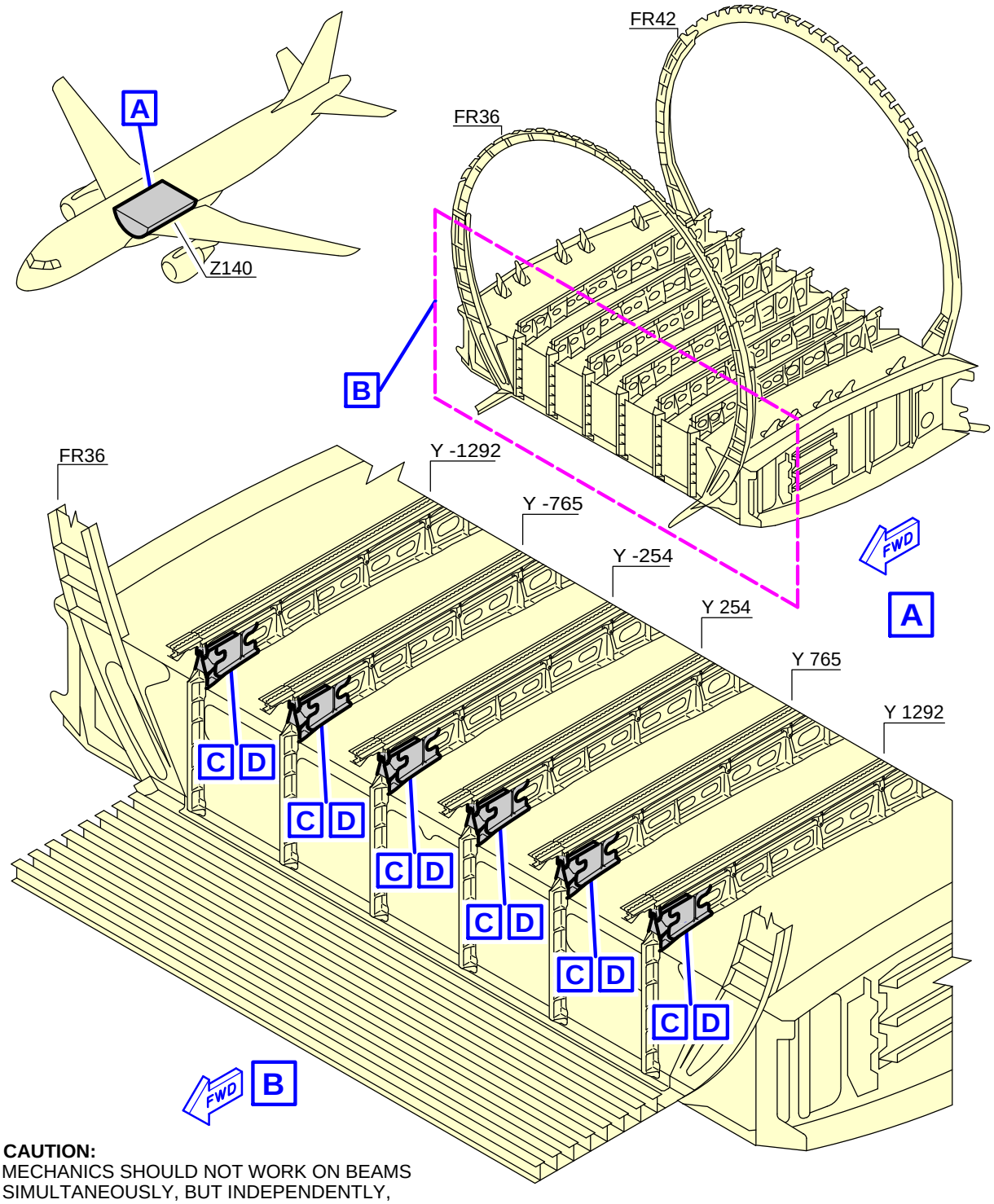
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

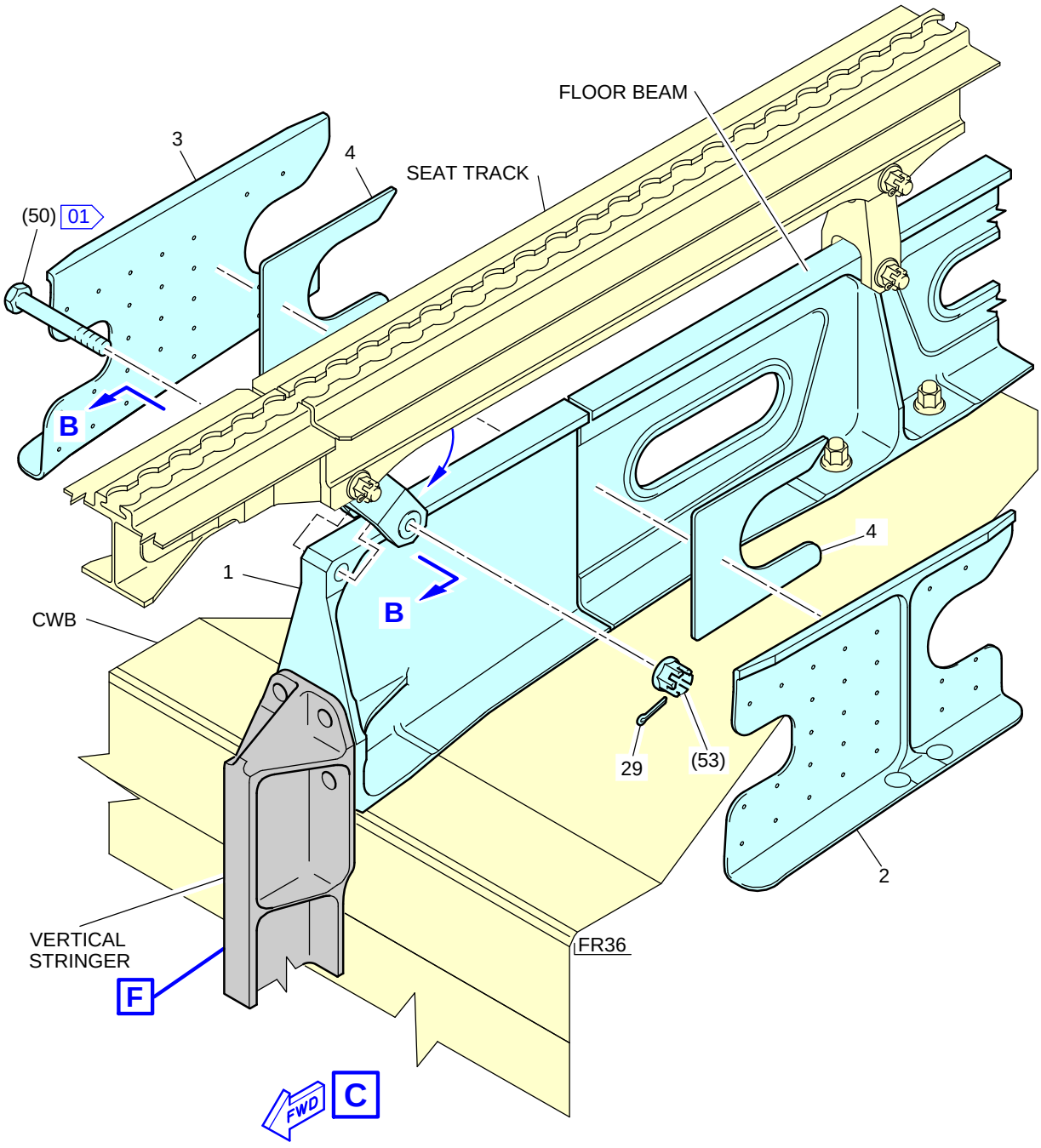


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



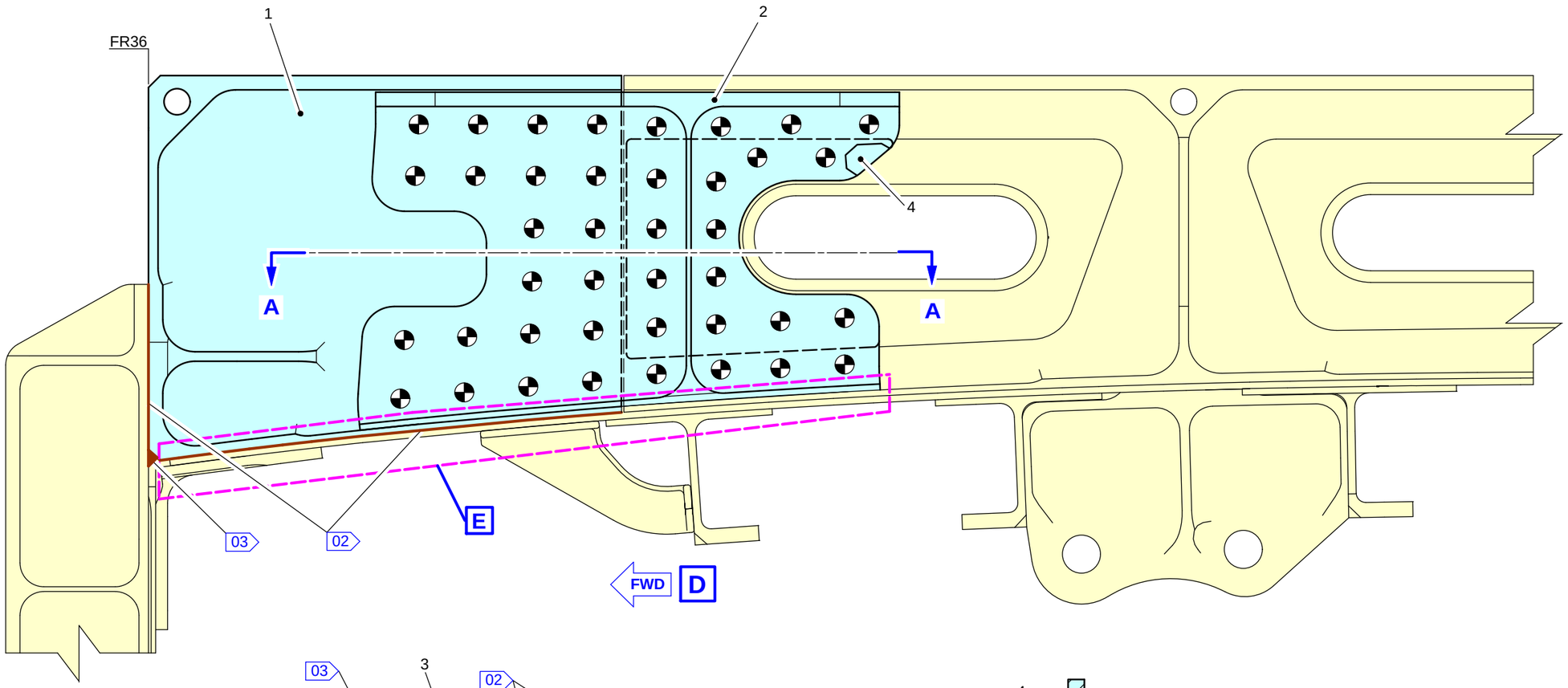
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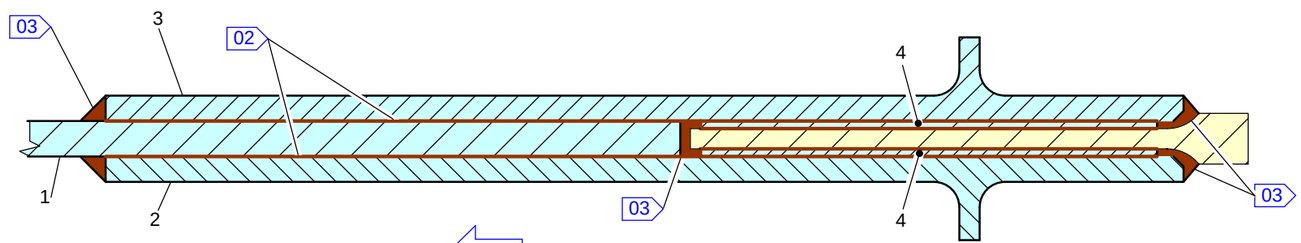
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

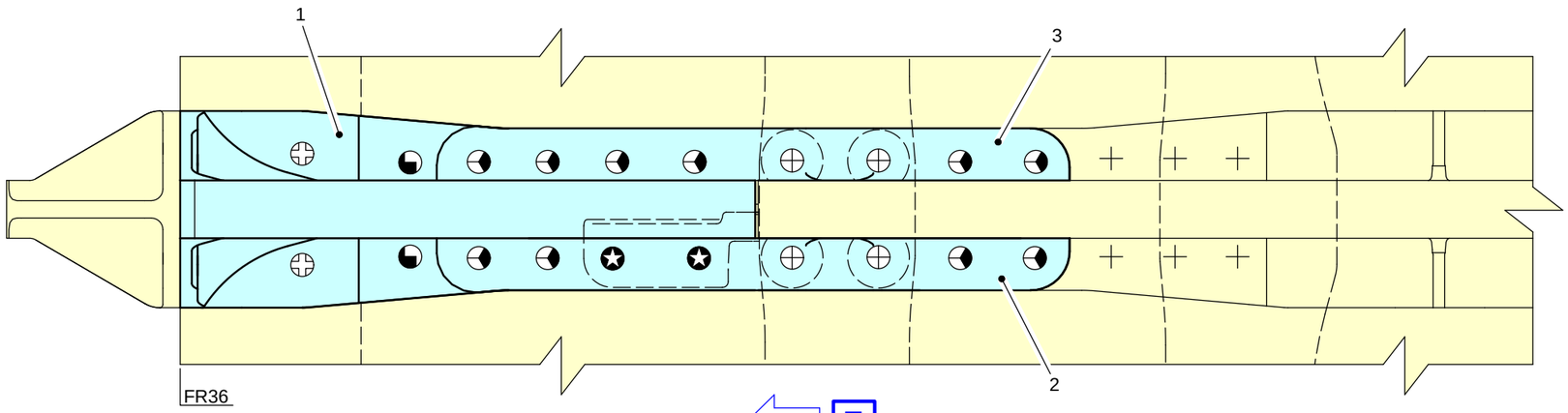
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

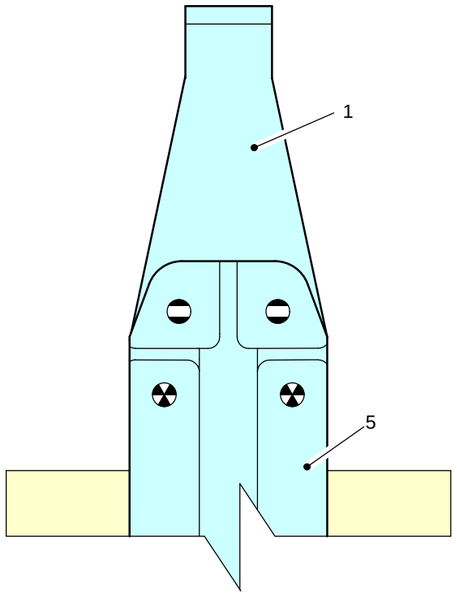
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

CONF 002

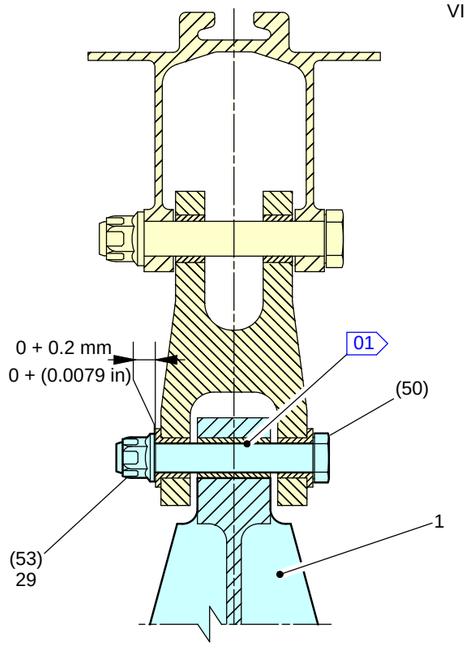


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(70) Task A320-A-57-XX-1228-05001-250A-A - Protect the Fasteners and the New Parts on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

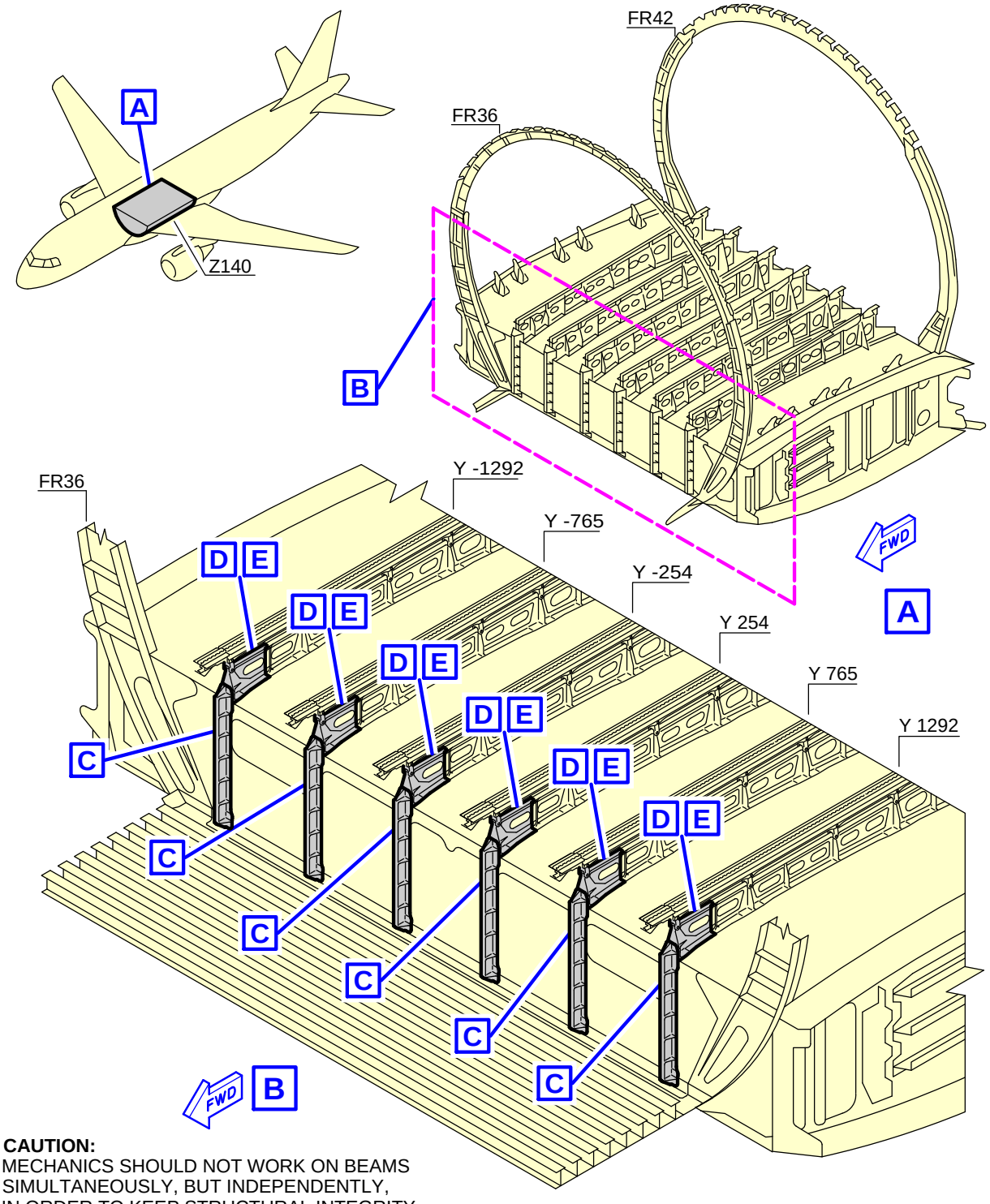
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

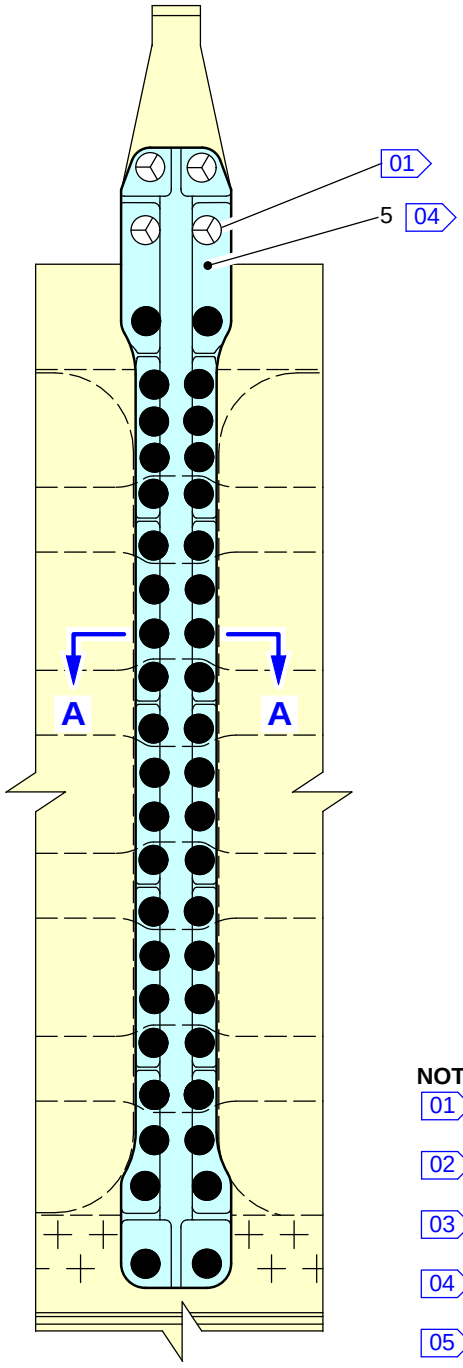


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

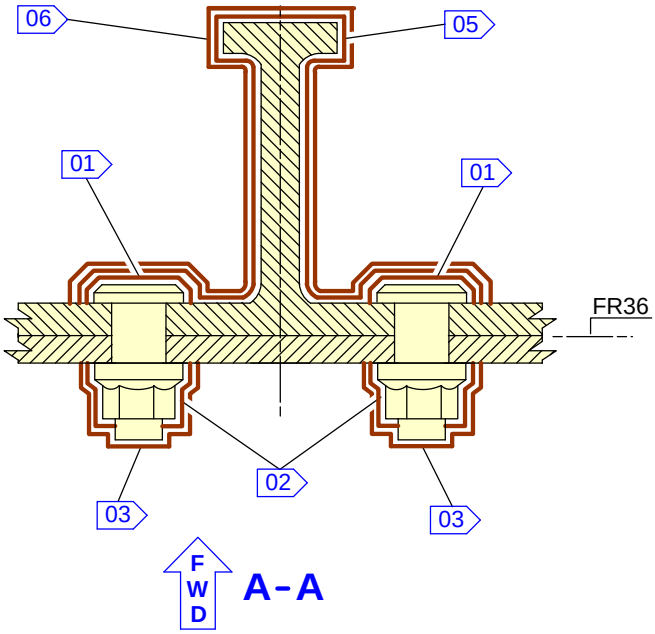
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊘	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

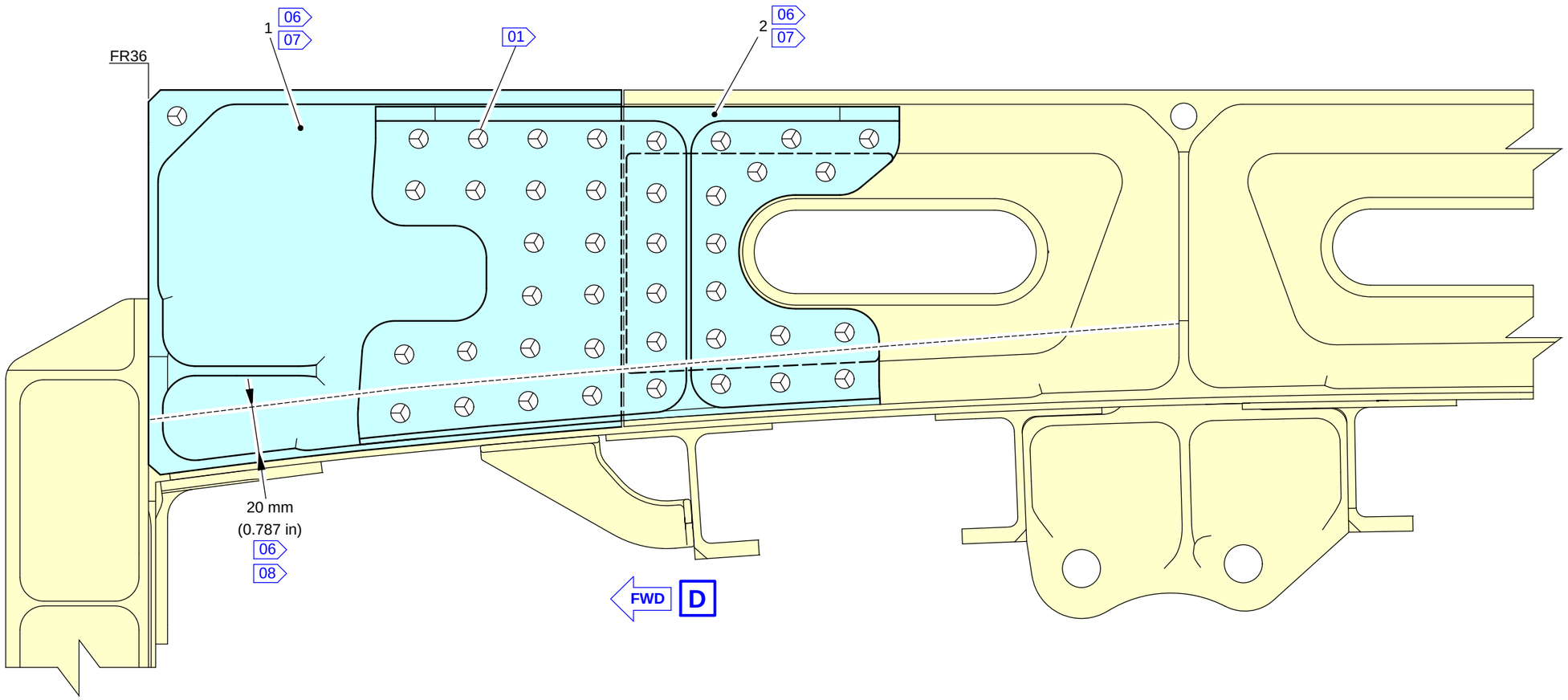
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

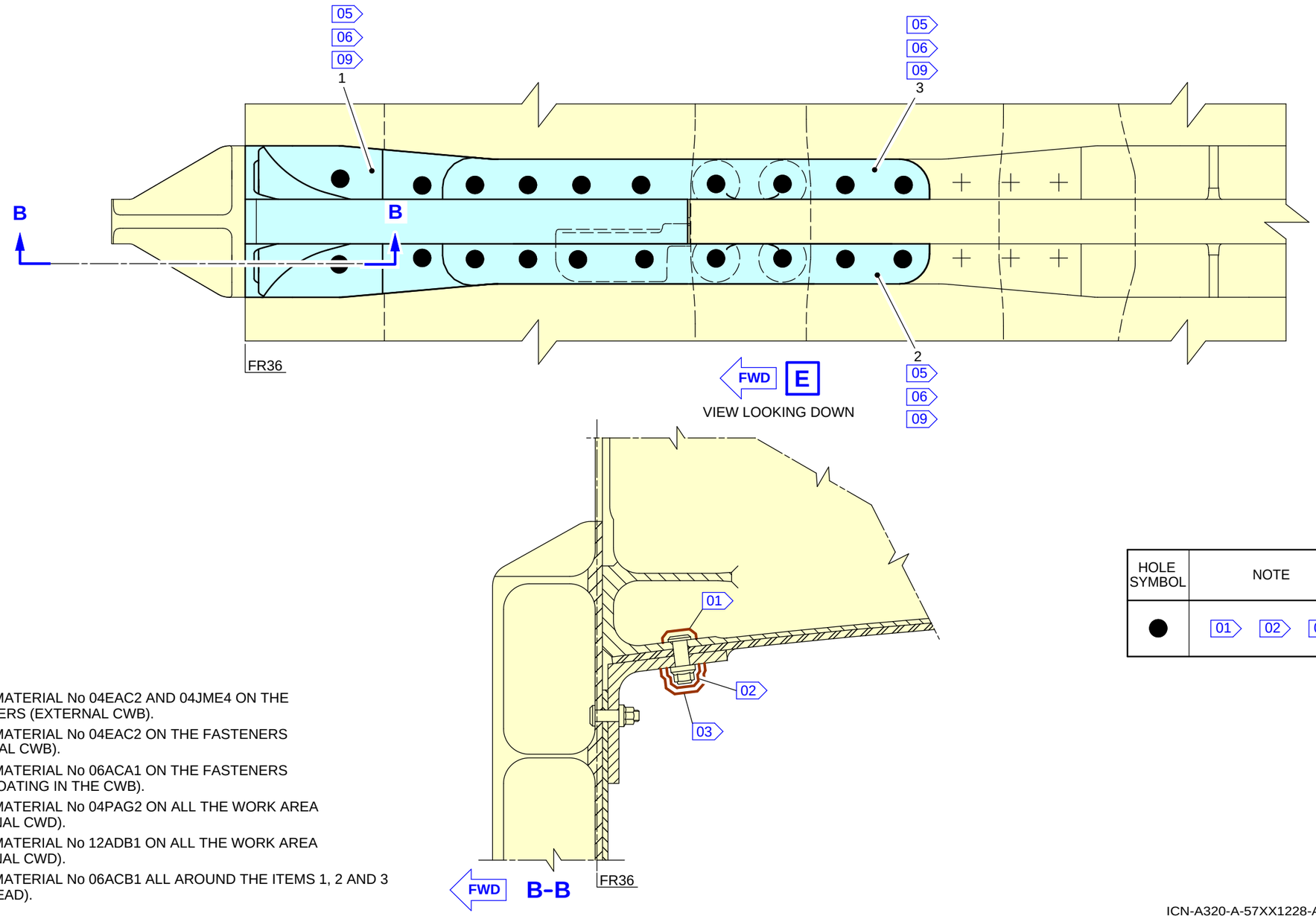
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(70) Task A320-A-57-XX-1228-05002-250A-A - Protect the Fasteners and the New Parts on Y-765 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

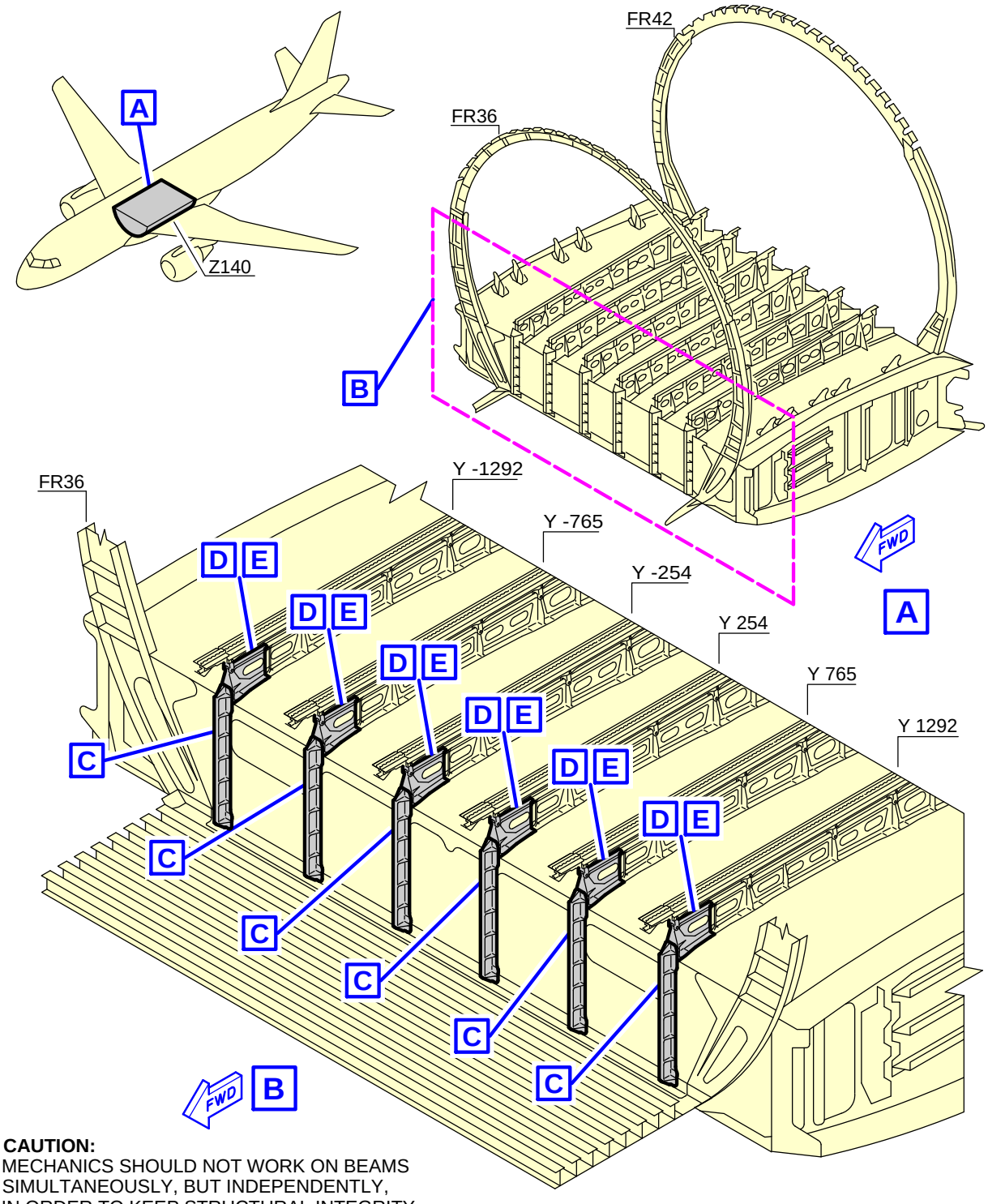
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

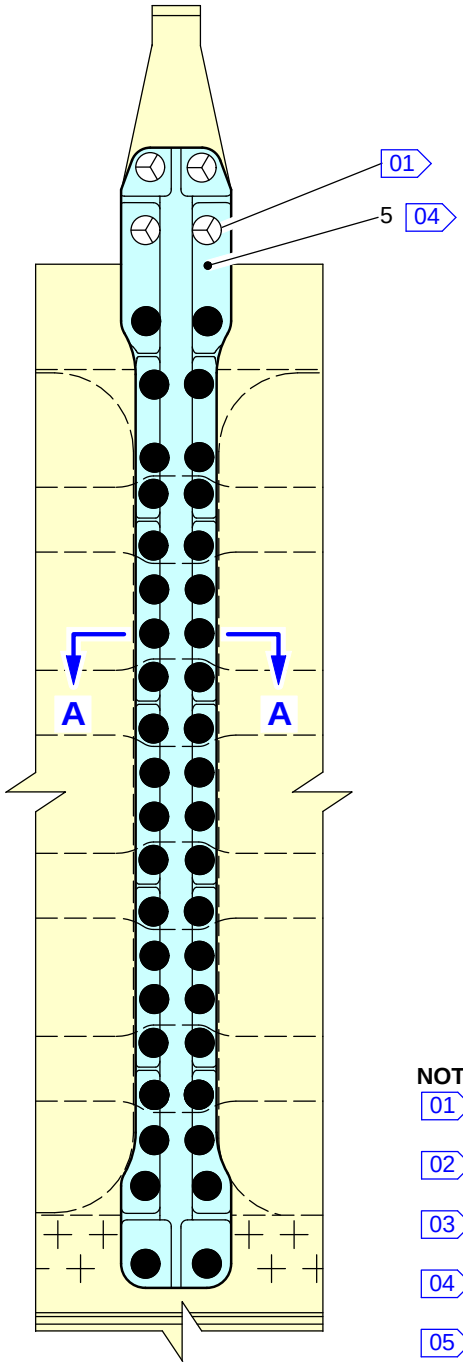


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

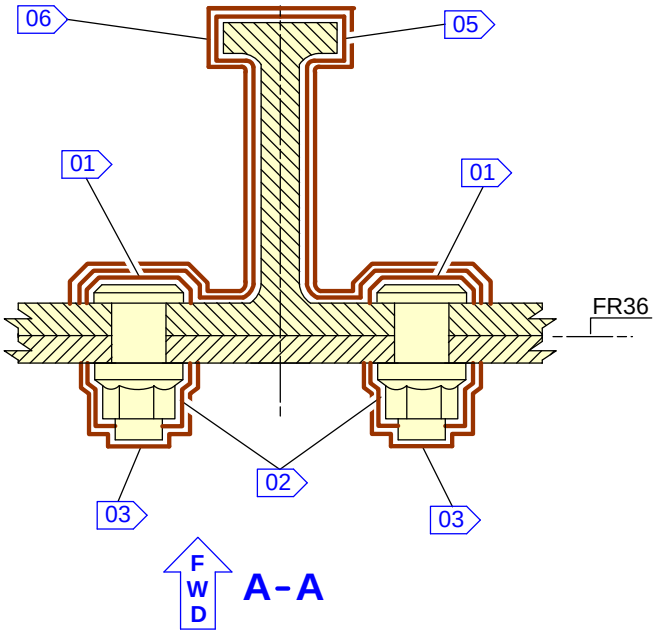
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

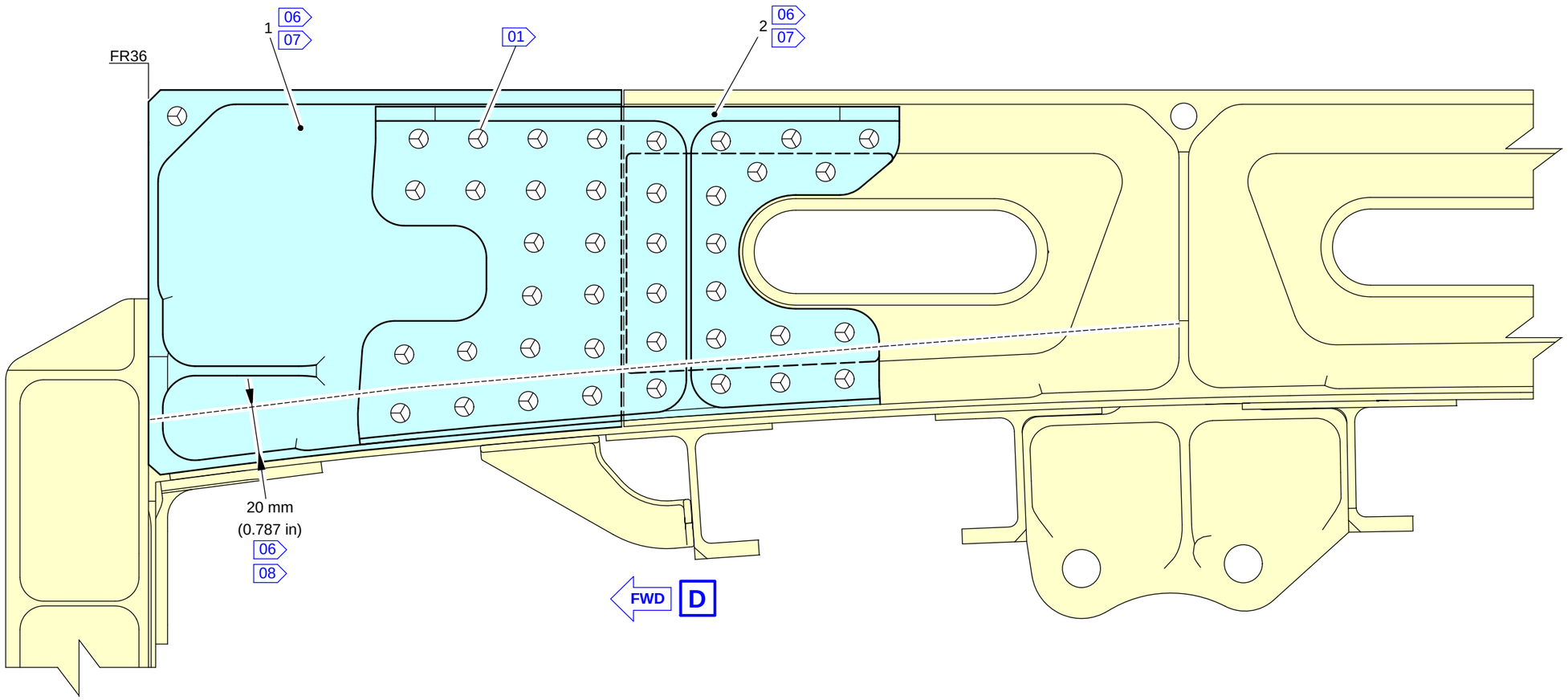
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

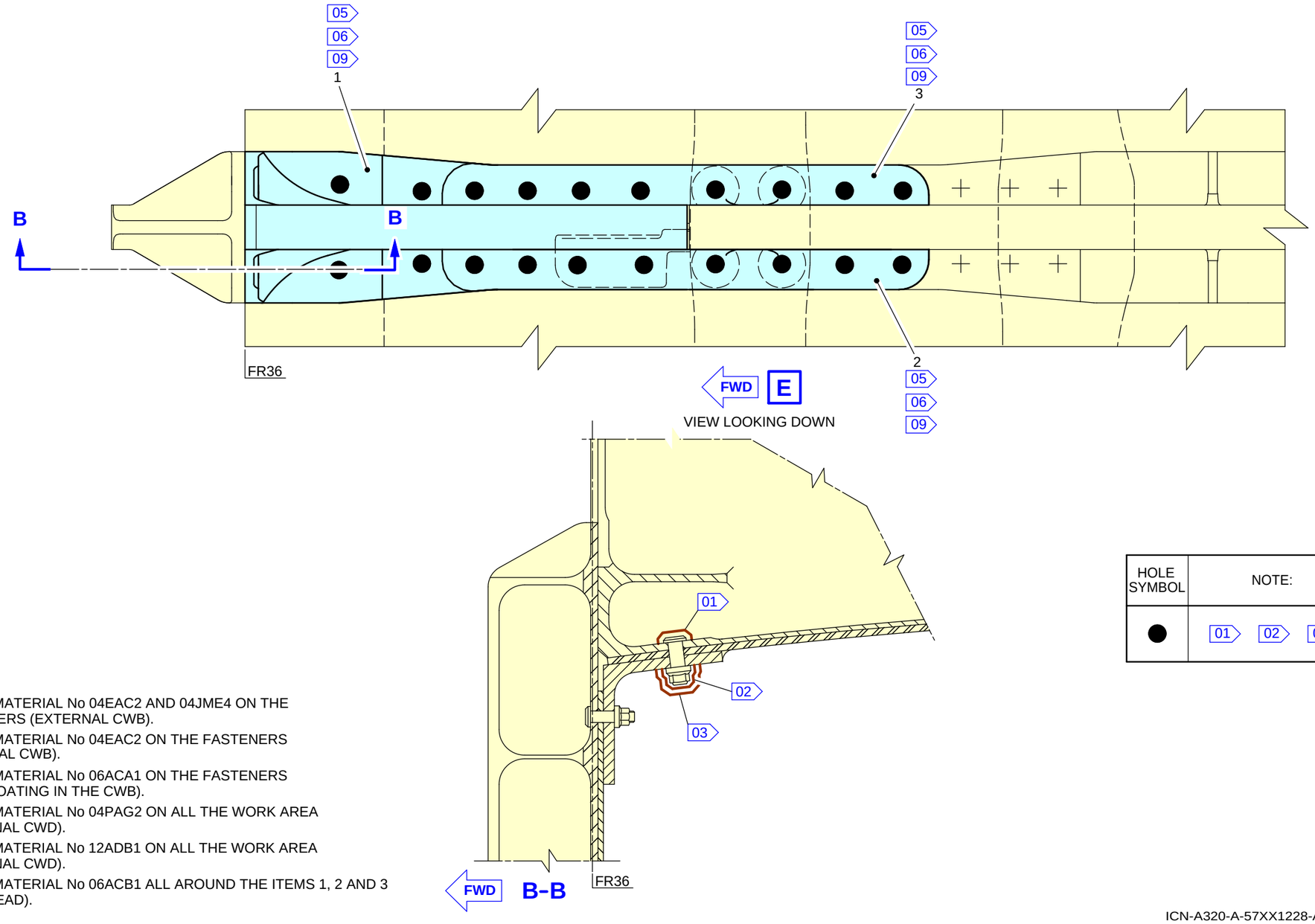
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

(71) Task A320-A-57-XX-1228-19001-520A-A - Remove the Strut Lower Attachment on Y-1292 at FR36

CAUTION: IT IS NOT ALLOWED TO REMOVE TWO STRUTS AT THE SAME TIME. THE FOLLOWING PROCEDURE HAS TO BE PERFORMED ONE RIB FOOT AT A TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
SRM	51-42-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 Tag all the parts you must remove and retain to make the subsequent installation easier.

6 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the strut lower attachment, refer to Ref. Fig. Removal of the Strut Lower Attachments at FR36.

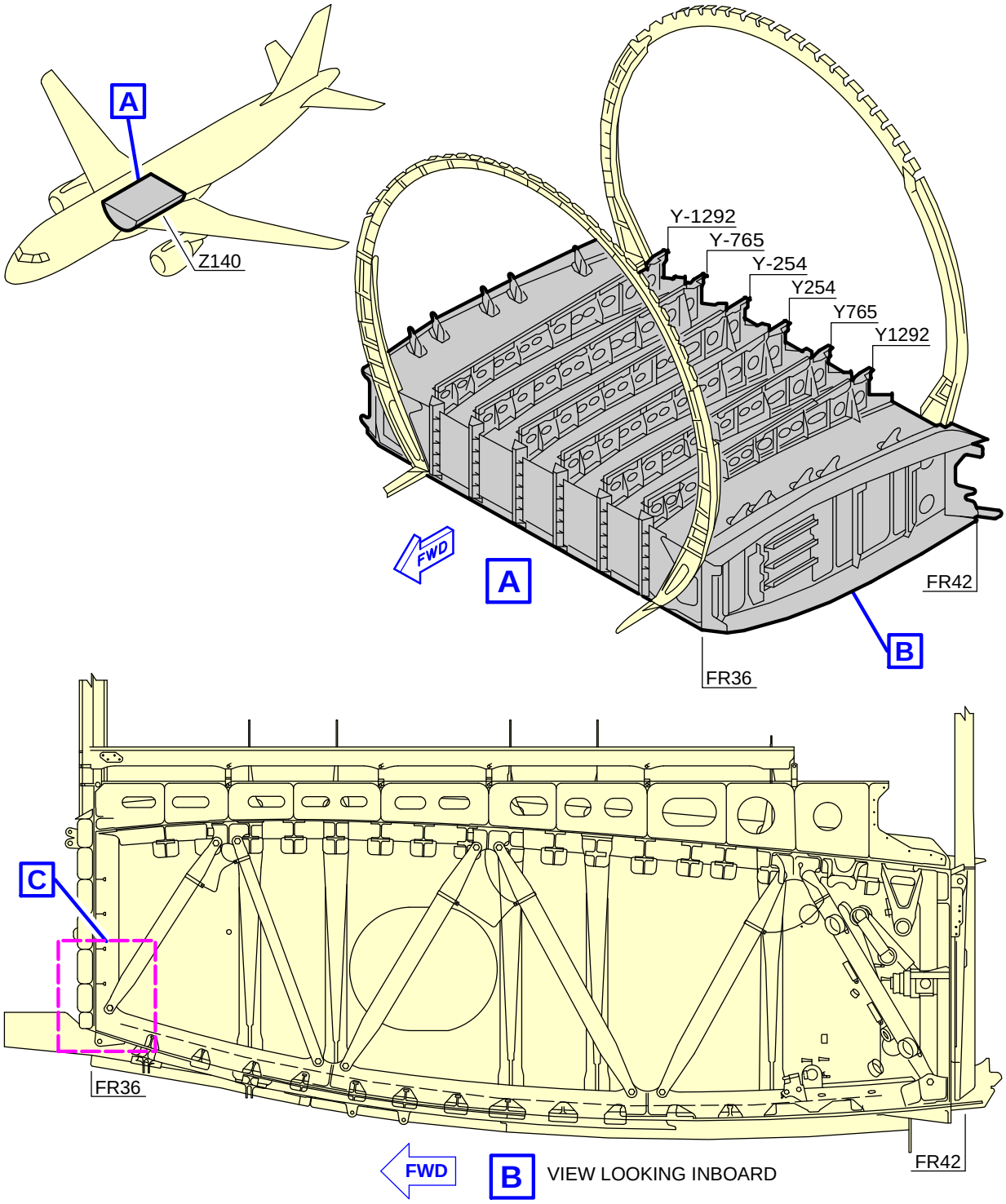
1 Remove:

1	PIN	Item (30)	Discard
1	NUT	Item (53)	Retain
1	WASHER	Item (54)	Retain

1	AXLE	Item (52)	Retain

2 Move and attach the strut out of the working area.

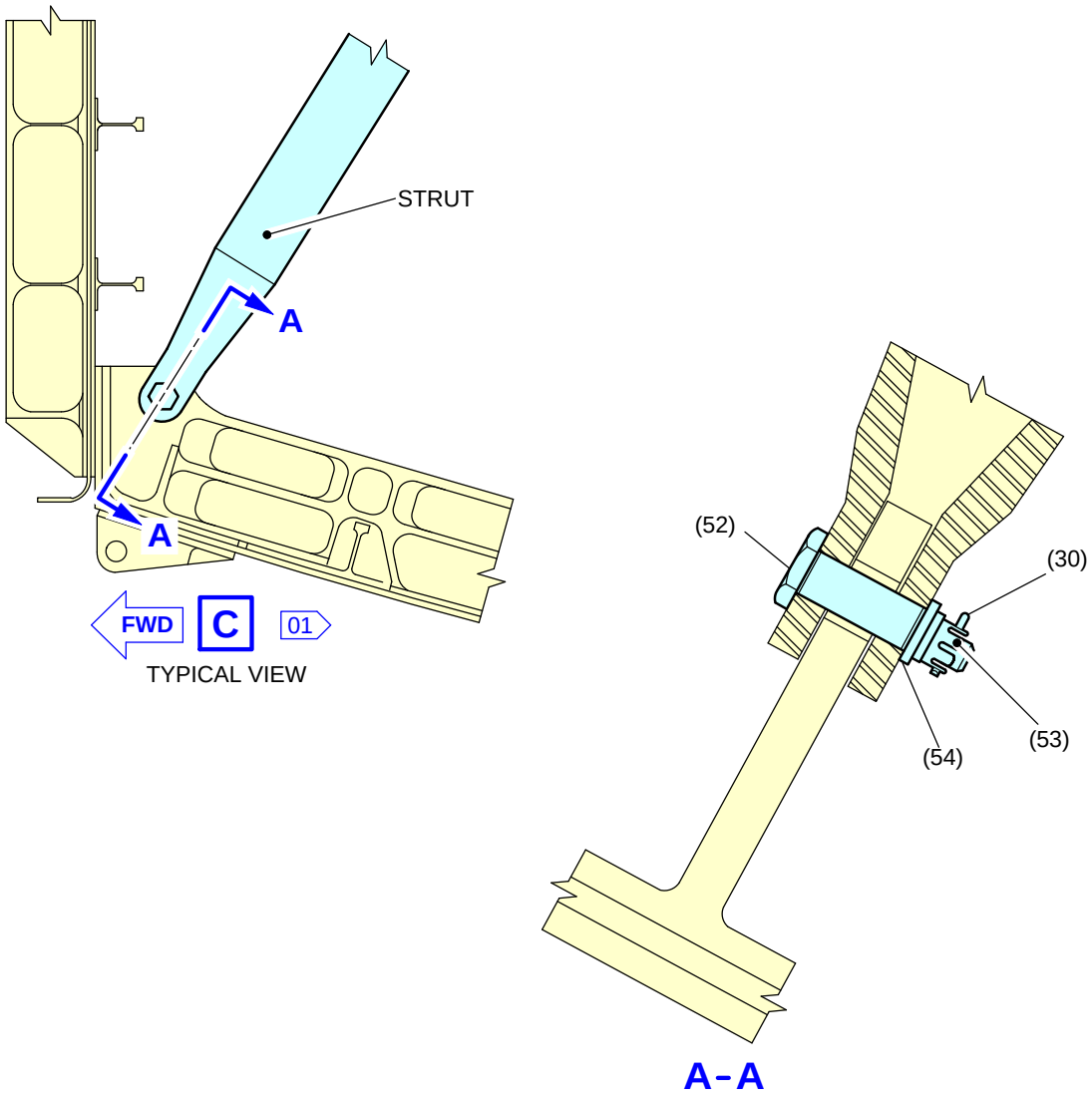
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTW-A-001-01 SHEET 1/2

CONF ALL



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTX-A-002-01 SHEET 2/2

CONF 001 003 004

(72) Task A320-A-57-XX-1228-20001-520A-A - Remove the Vertical Stringer on Y-1292 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

42	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

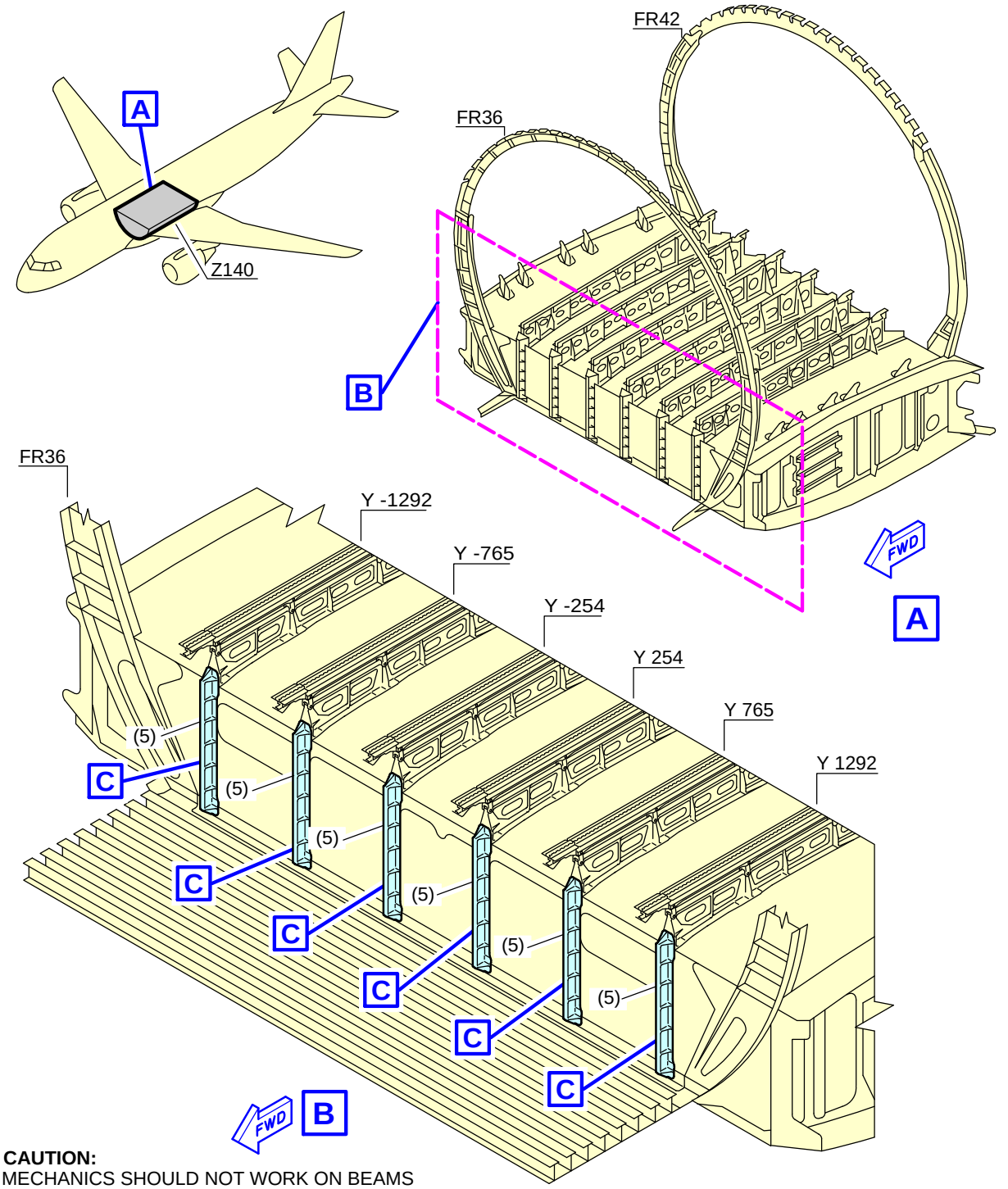
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-26ZZZ-720Z-A.

CONF 001 003 004



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSK-A-002-01 SHEET 1/2

CONF 001 003 004

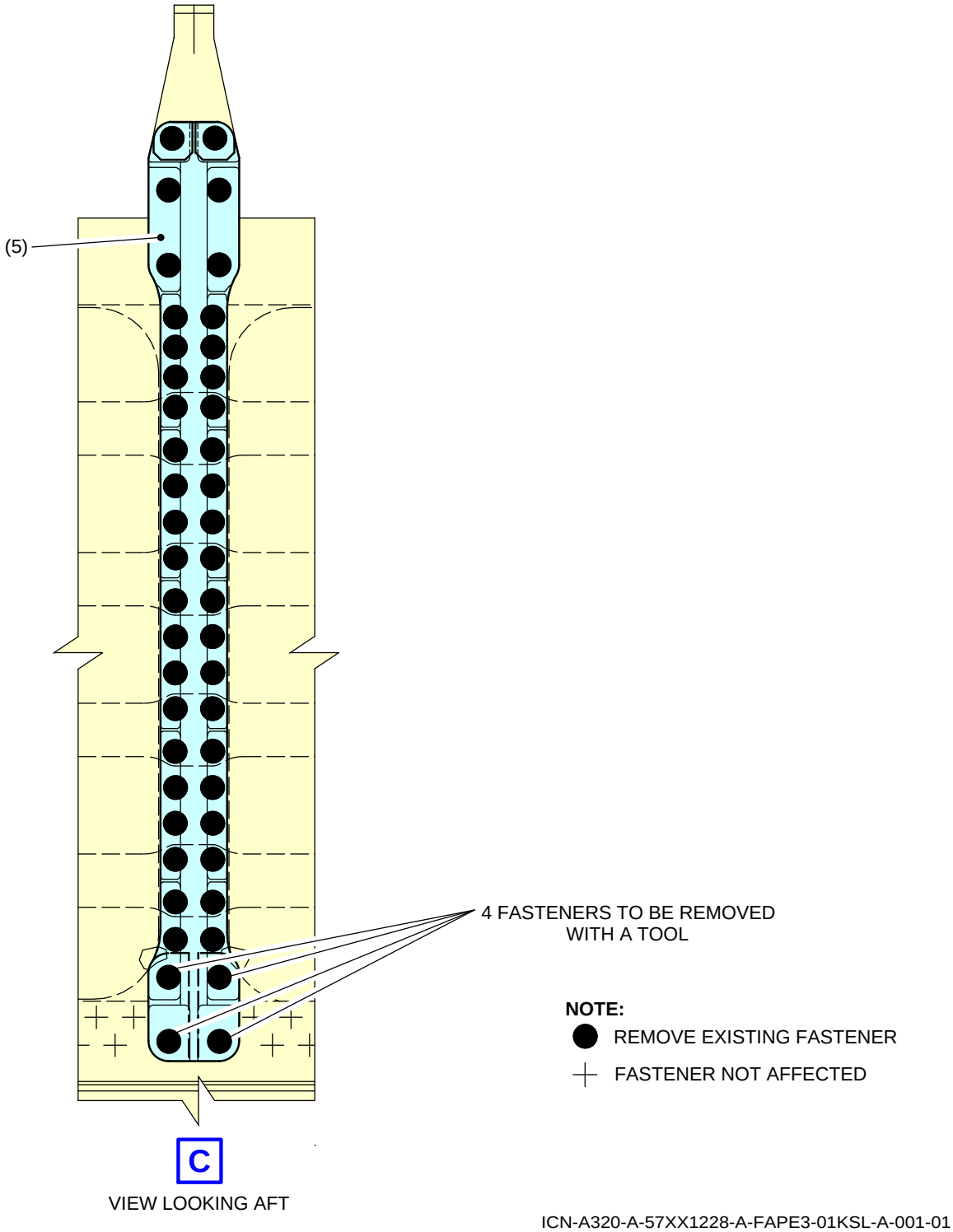


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSL-A-001-01 SHEET 2/2

CONF 001 003 004

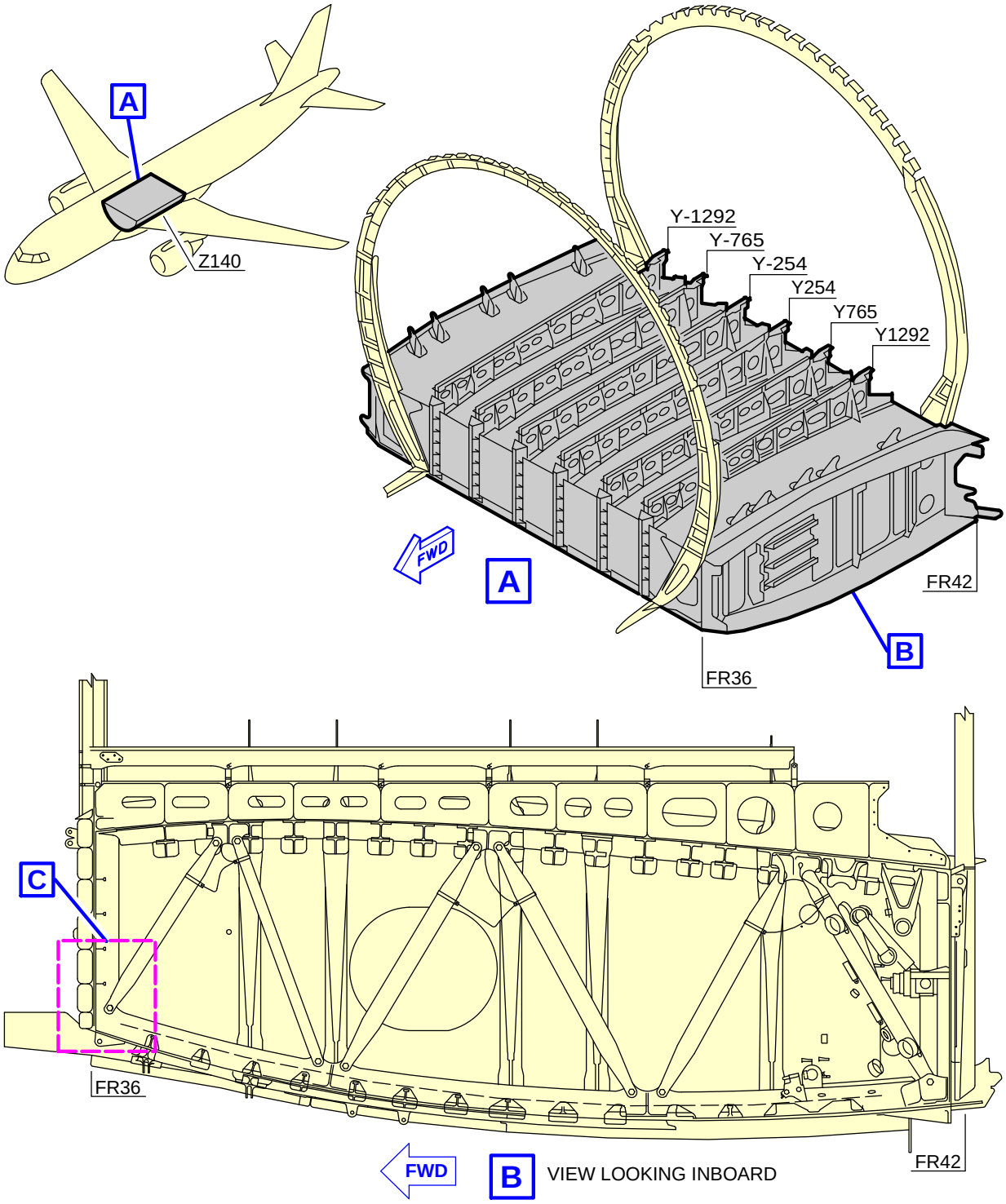
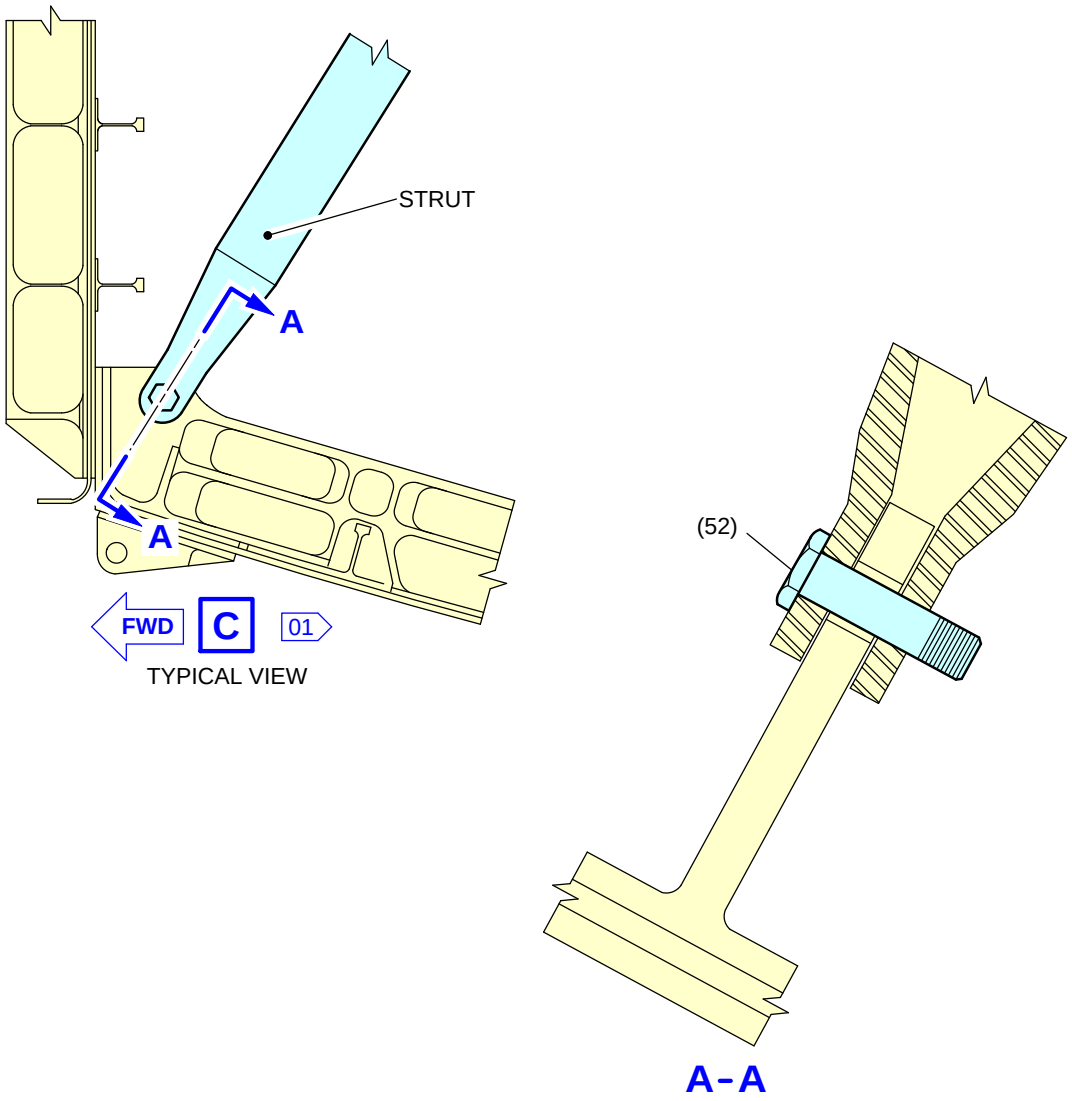


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(72) Task A320-A-57-XX-1228-20002-520A-A - Remove the Vertical Stringer on Y-1292 at FR36

CAUTION: TWO NON-ADJACENT VERTICAL STRINGERS CAN BE REPLACED AT THE SAME TIME. IT IS NOT POSSIBLE TO WORK ON THE FLOOR BEAMS AND THE VERTICAL STRINGERS AT THE SAME TIME. ALL VERTICAL STRINGERS MUST BE IN PLACE TO WORK ON THE HORIZONTAL BEAMS. THEN IT IS POSSIBLE TO REPLACE TWO NON-ADJACENT HORIZONTAL BEAMS AT THE SAME TIME.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	7.25 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Tool kit 571228T01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98D57103003000	1	EXTRACTR		

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 Do the cleaning process in accordance with Ref. SRM 51-78-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the vertical stringer, refer to Ref. Fig. Removal of the Vertical Stringers at FR36.

1 Remove the bottom 4 nuts from inside the CWB:

4	NUT		Discard

2 From inside the CWB push the bottom 4 fasteners until they are flush.

NOTE: Do not remove the fasteners by pushing them through the stack up.

3 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

4 Remove the bottom 4 fasteners from outside the CWB using the special extractor tool:

4	FASTENER		Discard
	using:		
1	EXTRACTOR FR36	98D57103003000	

5 Remove the remaining fasteners from the vertical stringer item (5):

40	FASTENER		Discard

6 Remove the stringer from the CWB:

1	STRINGER	Item (5)	Retain

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Do the inspection of the old vertical stringer for secondary structure brackets.

1 If no brackets are found, discard the stringer item (5).

2 If there are brackets installed on the old vertical stringer.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

c Discard the stringer item (5).

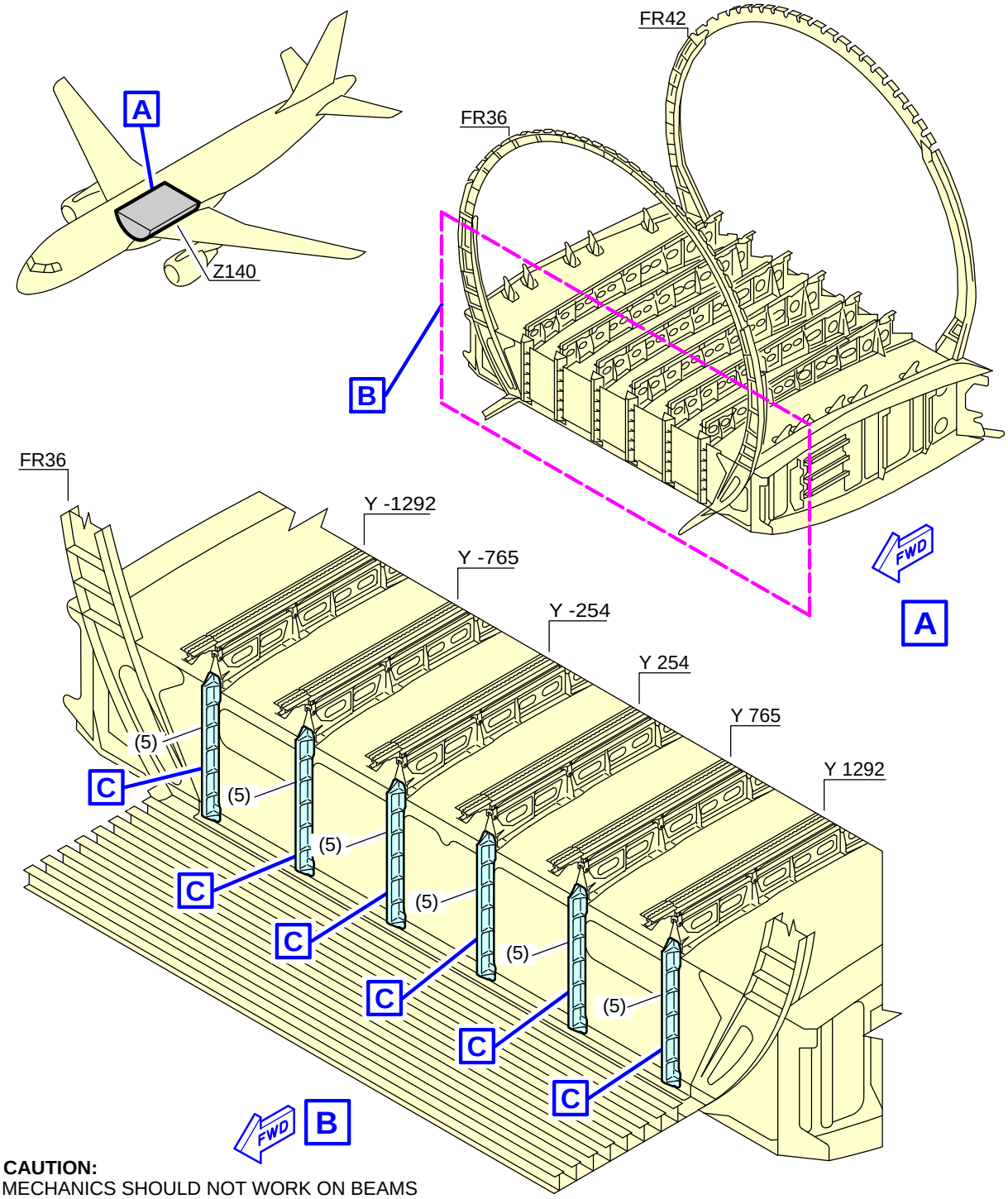
d Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

e Re-install the brackets after the installation of the new vertical stringer in accordance with Ref. Task A320-A-57-XX-1228-26ZZZ-720Z-A.

CONF 002



CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSM-A-002-01 SHEET 1/2

CONF 002

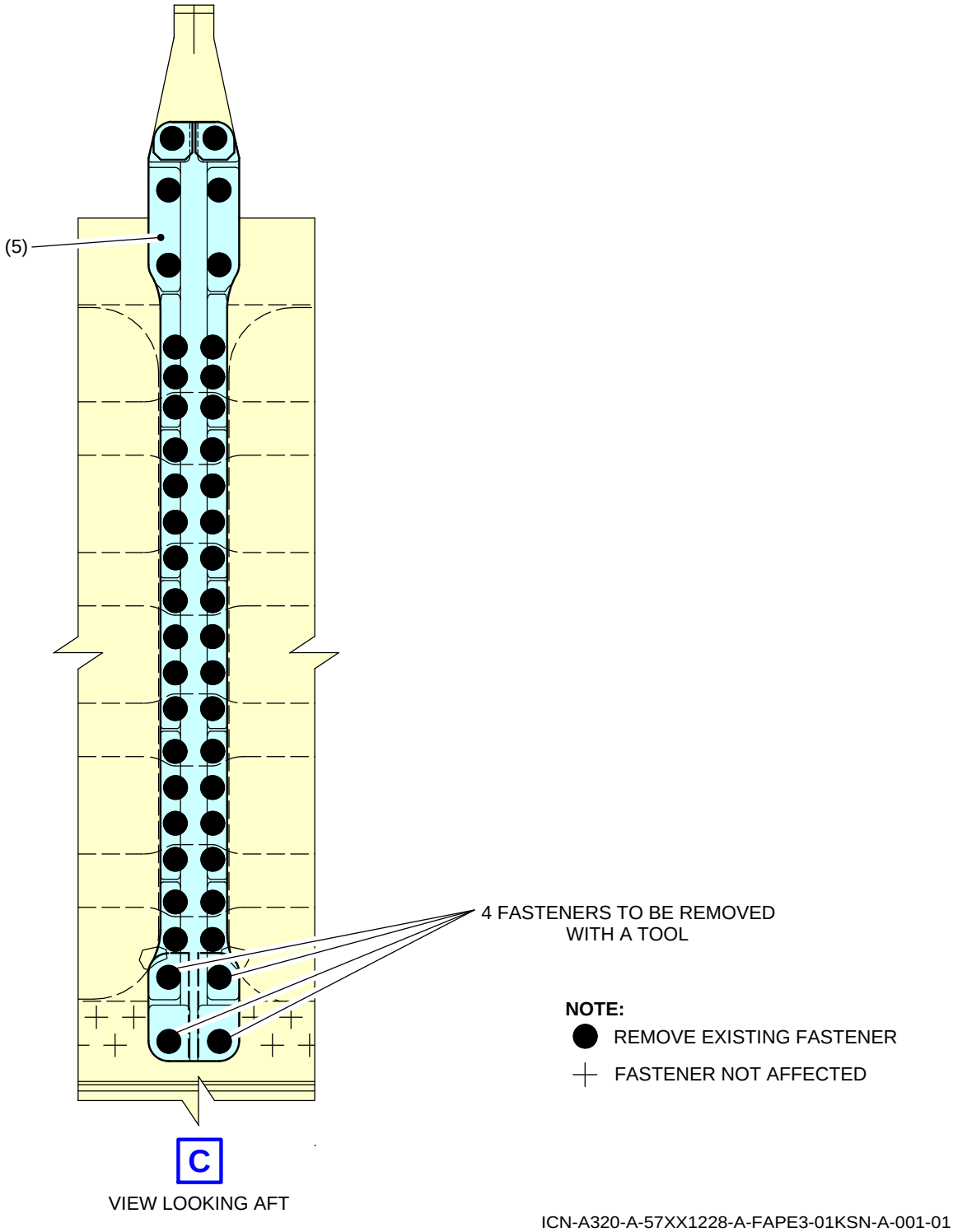


Figure ICN-A320-A-57XX1228-A-FAPE3-01KSN-A-001-01 SHEET 2/2

CONF 002

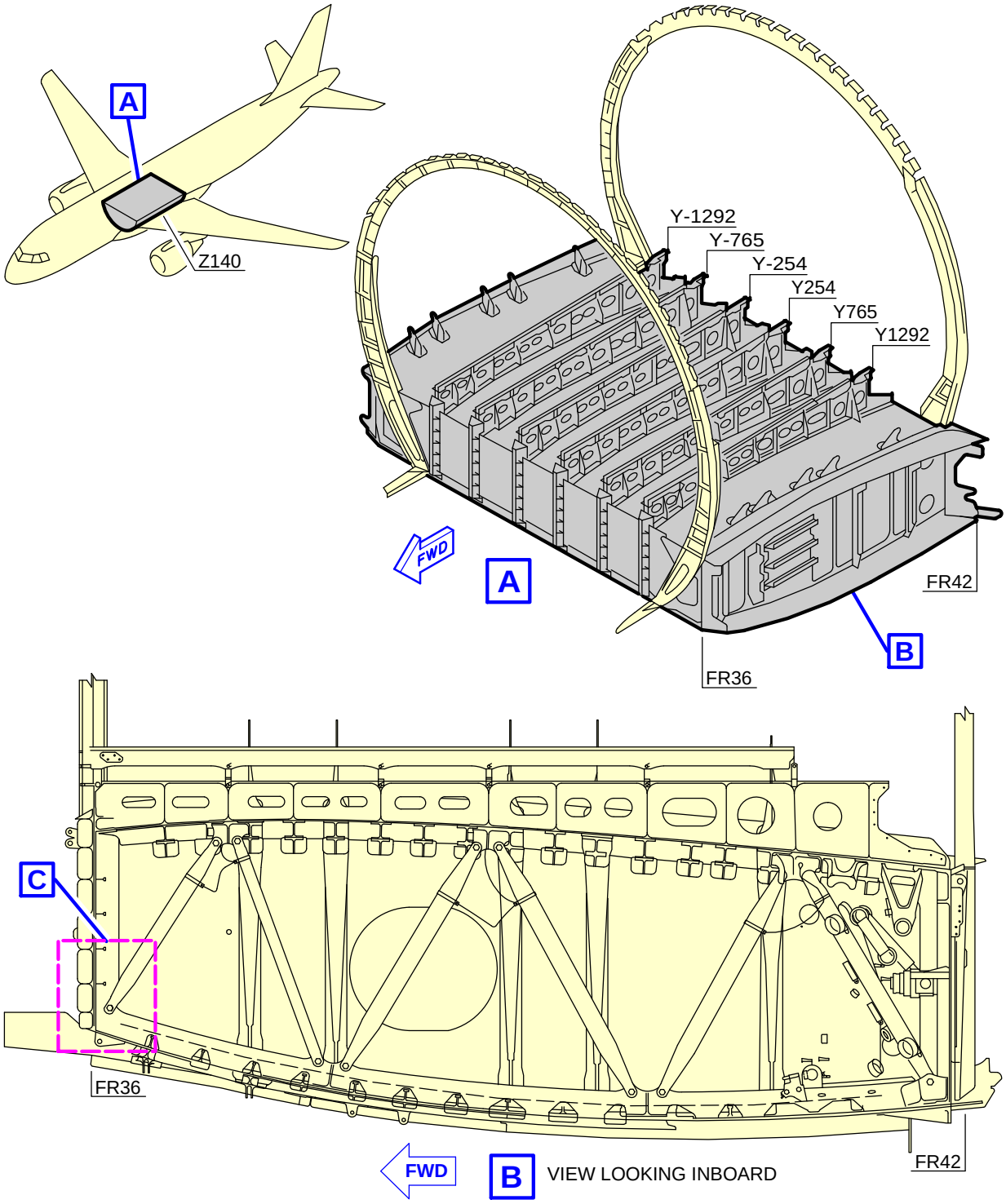
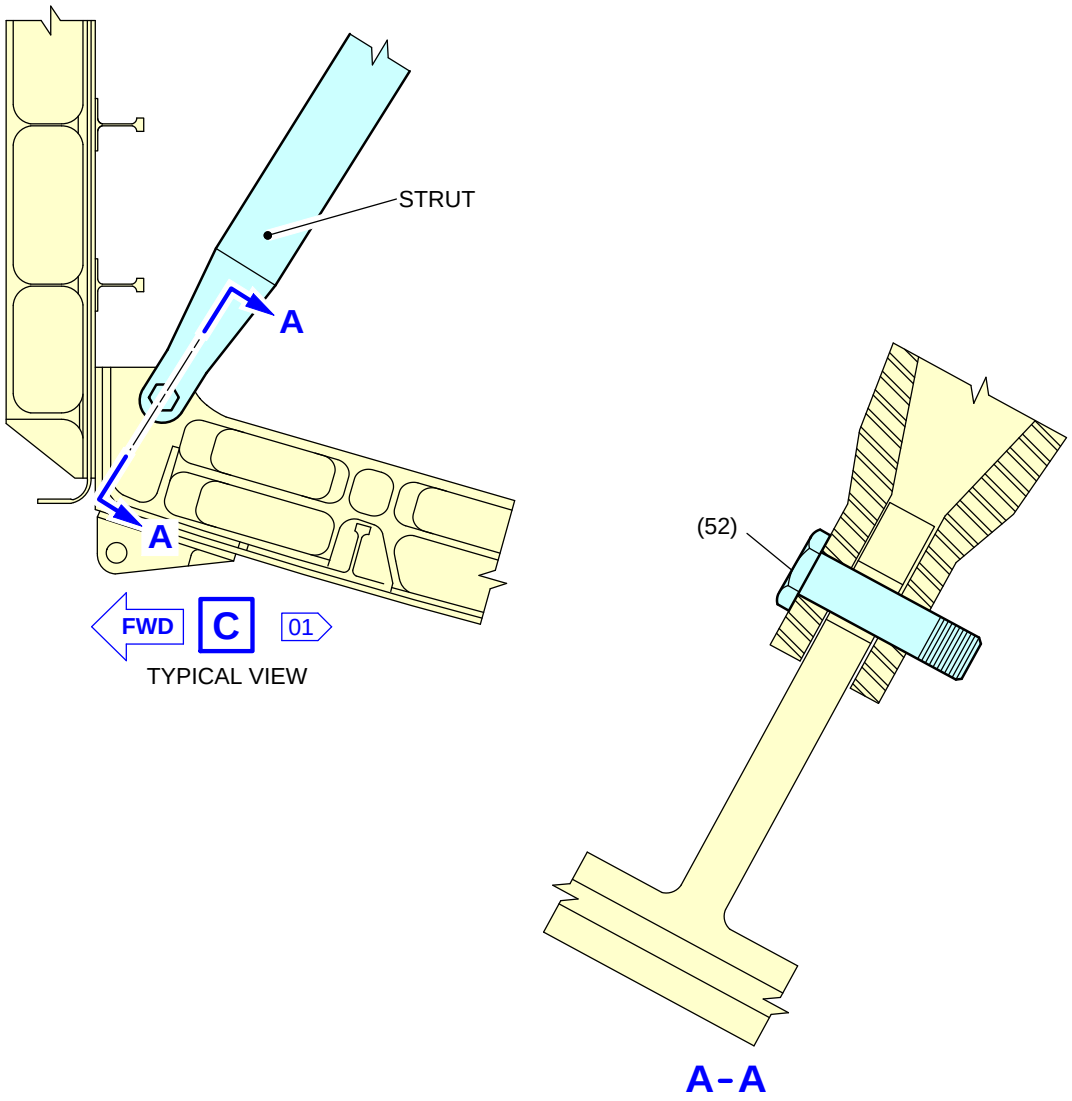


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF ALL

(73) Task A320-A-57-XX-1228-11001-353A-A - Do a Rotating Probe Inspection on the Center Wing Box of the Vertical Stringer Fastener Holes on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

(b) Do the inspection on the CWB of the vertical stringer fastener holes.

1 Clean the work area and the fastener holes with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Do a Detailed Inspection (DI) of the work area and a rotating probe inspection of the fastener holes to check for cracks.

a If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

b If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-11ZZZ-900Z-A.

CONF 001 003 004

(74) Task A320-A-57-XX-1228-11001-900A-A - Drill the New Vertical Stringer on Y-1292 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1 STRINGER VERTICAL D0041005820000 Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

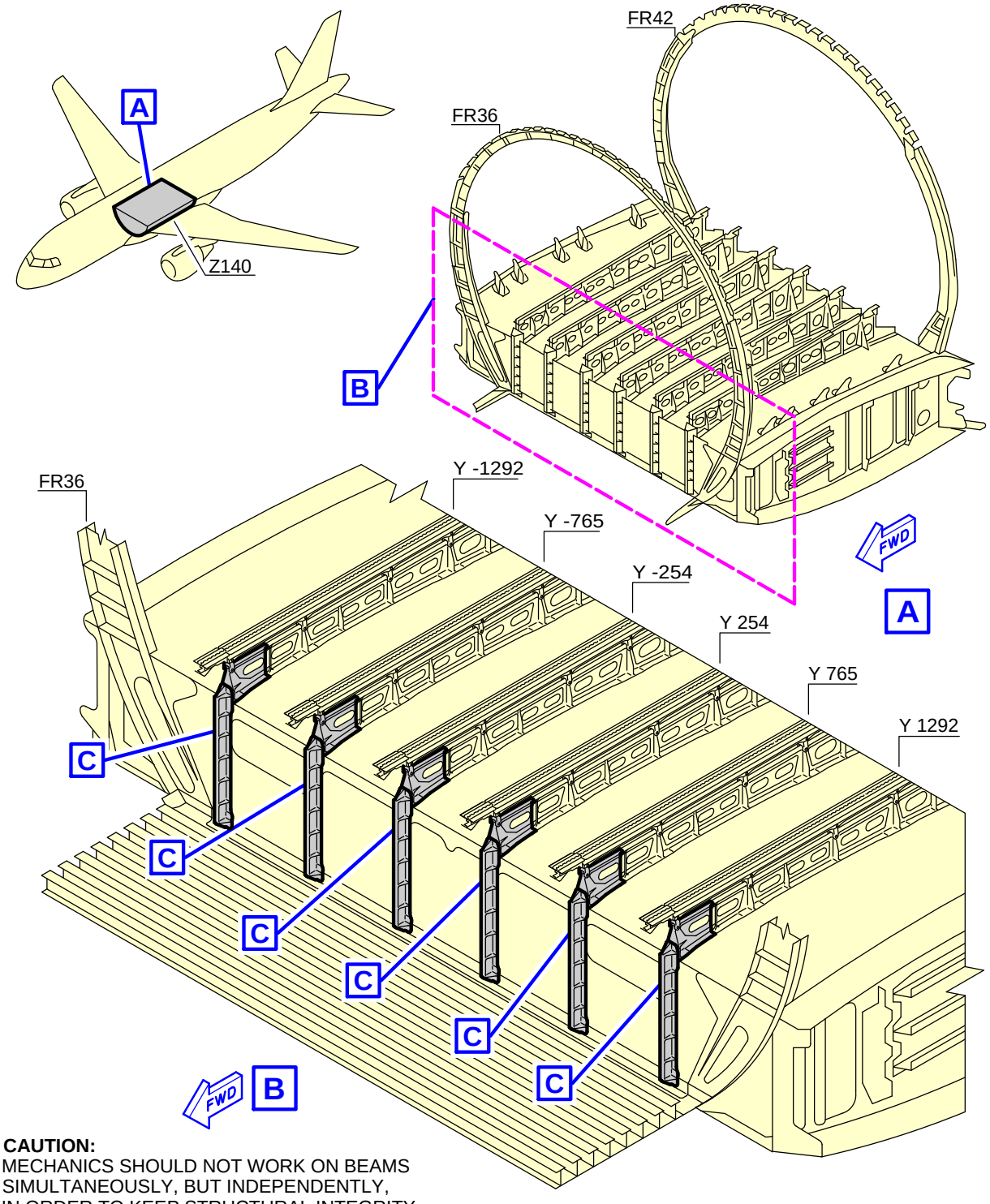
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 001 003 004

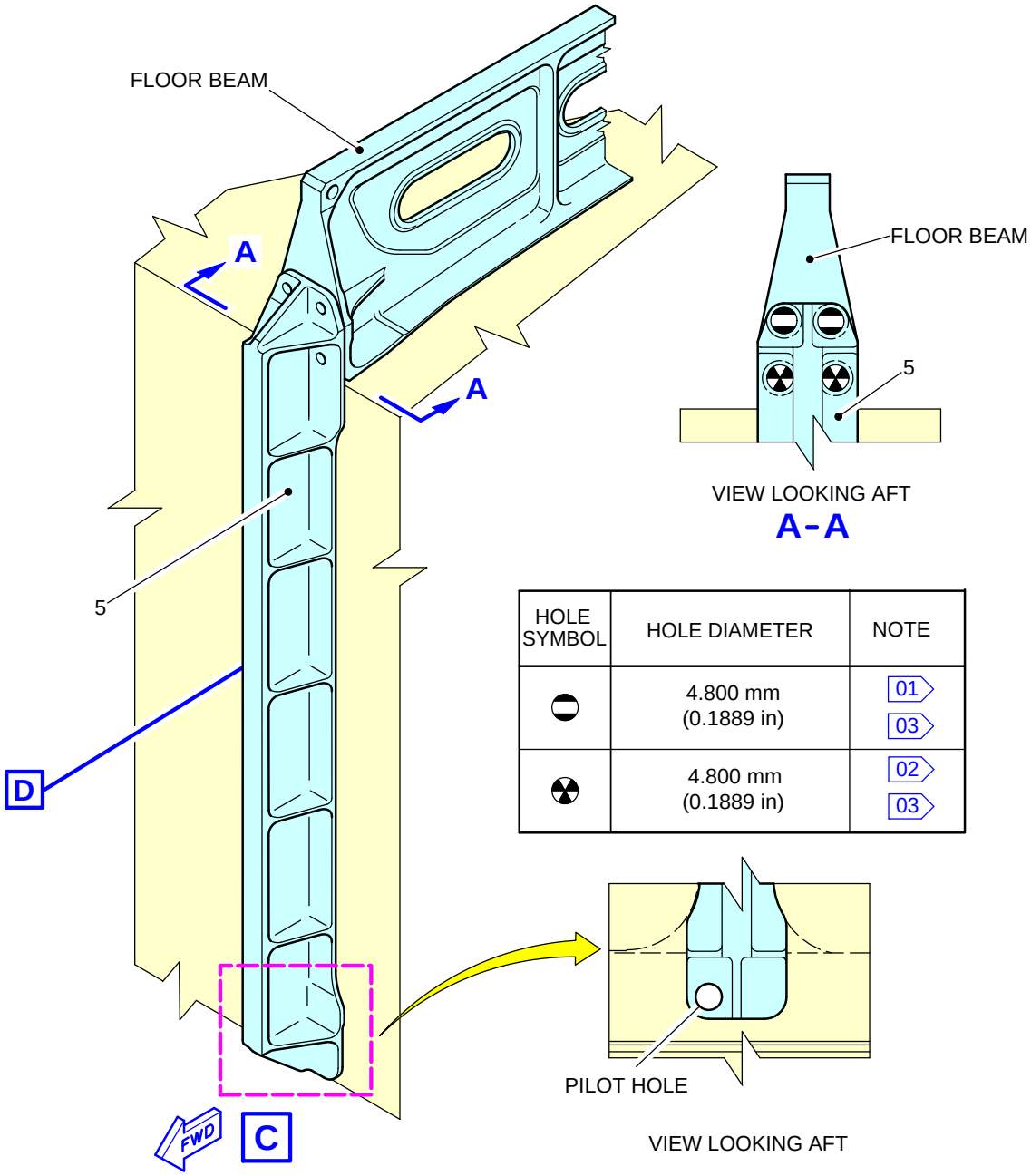


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSA-A-002-01 SHEET 1/3

CONF 001 003 004



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

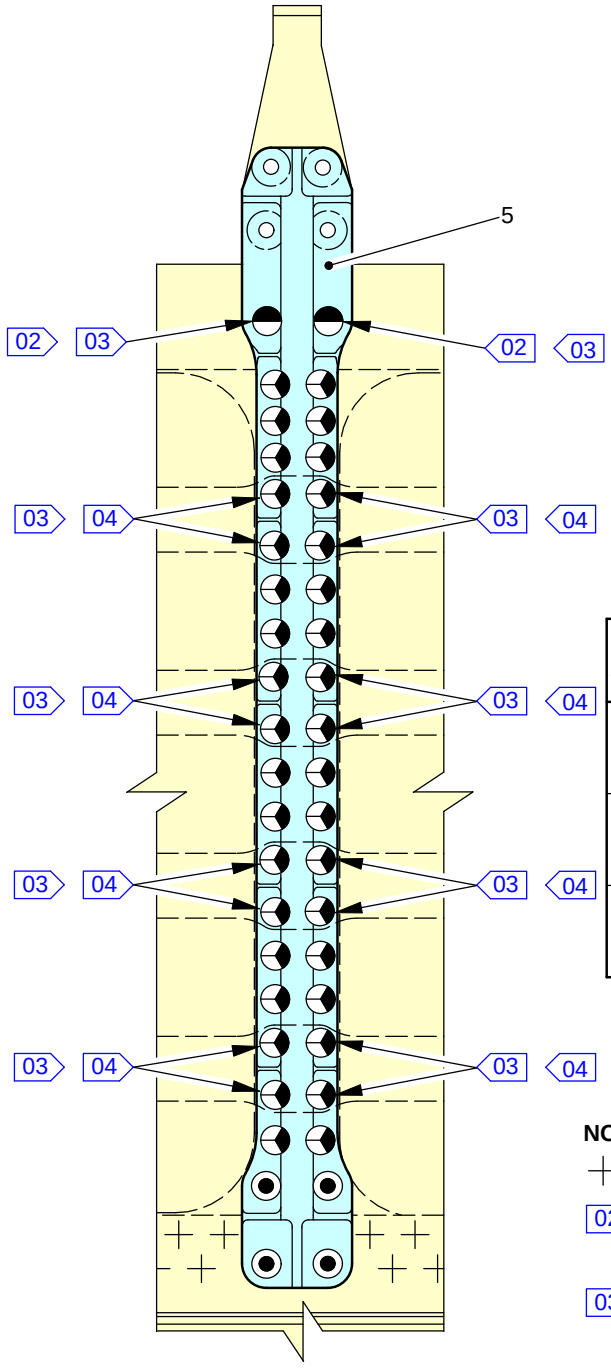
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSB-A-002-01 SHEET 2/3

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSC-A-003-01 SHEET 3/3

CONF 001 003 004

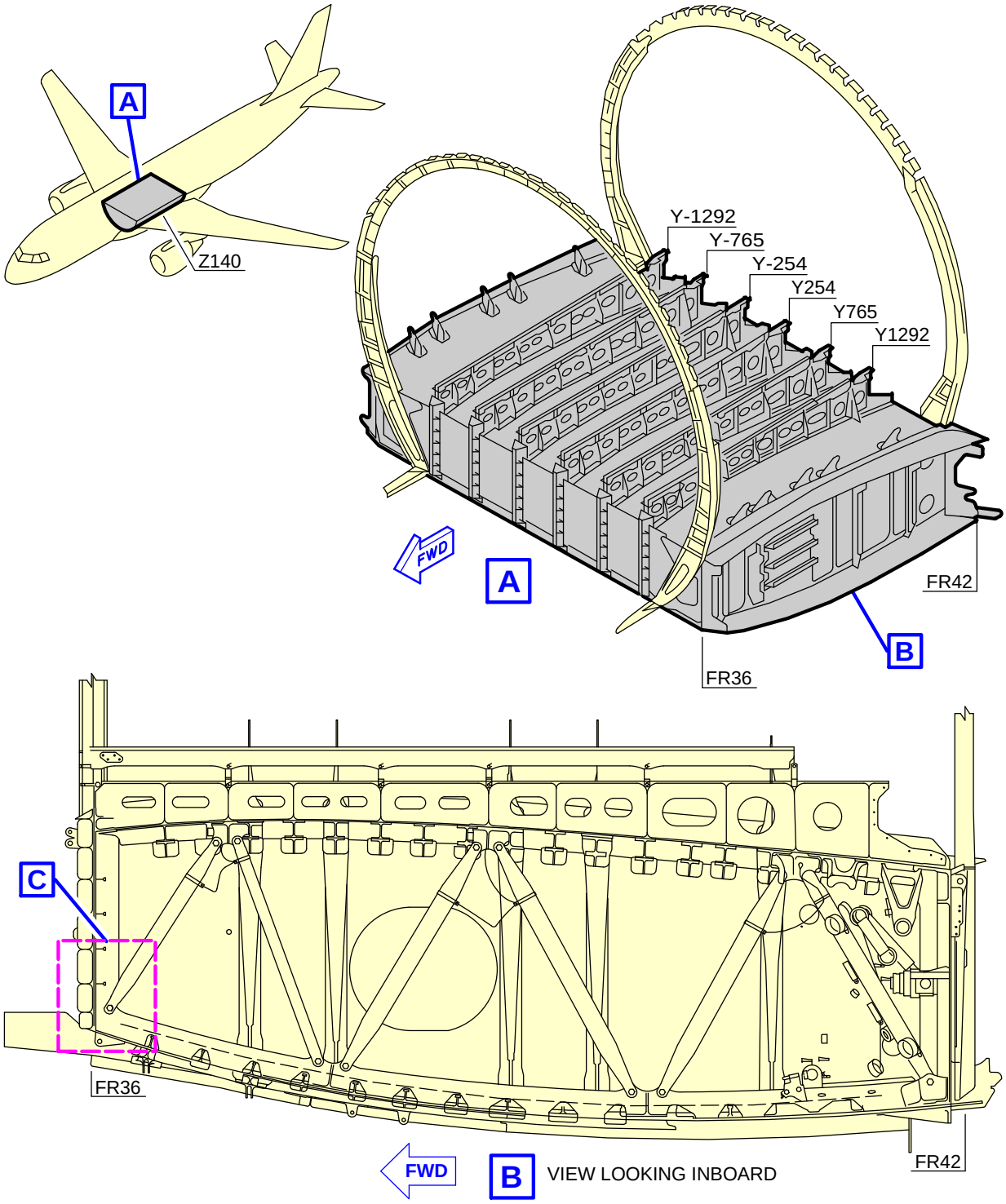
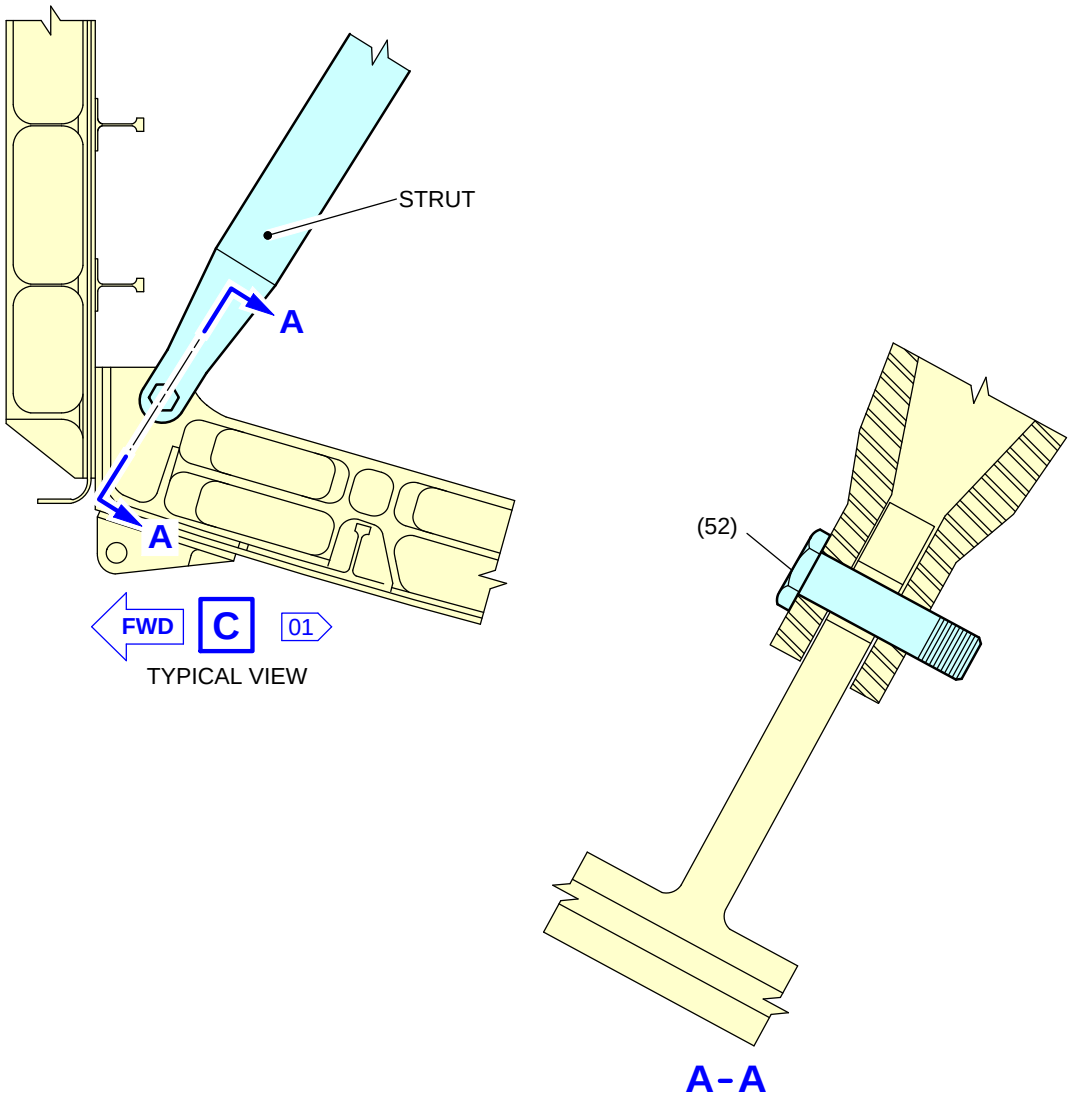


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

(74) Task A320-A-57-XX-1228-11002-900A-A - Drill the New Vertical Stringer on Y-1292 at FR36

CAUTION: MAKE SURE THAT THE VERTICAL STRINGER IS FIXED AND NOT MISALIGNED FROM THE CORRECT POSITION.

CAUTION: TRANSFER THE HOLES OF THE CWB STRUCTURE TO THE VERTICAL STRINGER BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	10.00 h
Minimum Number of person	2
Elapsed Time	5.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
5	D0041005820000	1	STRINGER		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new vertical stringer, refer to Ref. Fig. Drilling of the New Vertical Stringers at FR36.

1 Temporarily, install the new vertical stringer onto the CWB and the Forward (FWD) end floor beam:

1	STRINGER VERTICAL	D0041005820000	Item 5

2 Align the pilot hole at the bottom of the vertical stringer item 5 with the correct location on the CWB using a screw pin.

3 Align the top of the vertical stringer item 5 with the FWD end floor beam using a clamp.

NOTE: The vertical stringer item 5 must be in place and aligned perfectly with the flange of the FWD end floor beam that has not yet been cut.

4 Drill 4 holes with a 4.8 mm (0.1889 in) diameter in the vertical stringer item 5 to align with the holes of the flange of the FWD end floor beam.

NOTE: Final diameter will be done when the new upper fitting will be installed.

5 Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retain

6 Drill the remaining holes in the vertical stringer item 5 to align with the holes of the CWB.

7 Drill all holes carefully to the final diameter.

8 Temporarily, install the strut, refer to Ref. Fig. Temporarily, Removal/ Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

9 Remove and retain the vertical stringer item 5 from the CWB and the FWD end floor beam.

10 Do the spot facing as necessary on the vertical stringer item 5 to ensure a good seating of the fasteners.

11 Deburr all drilled holes.

12 Clean the work area and the vertical stringer item 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

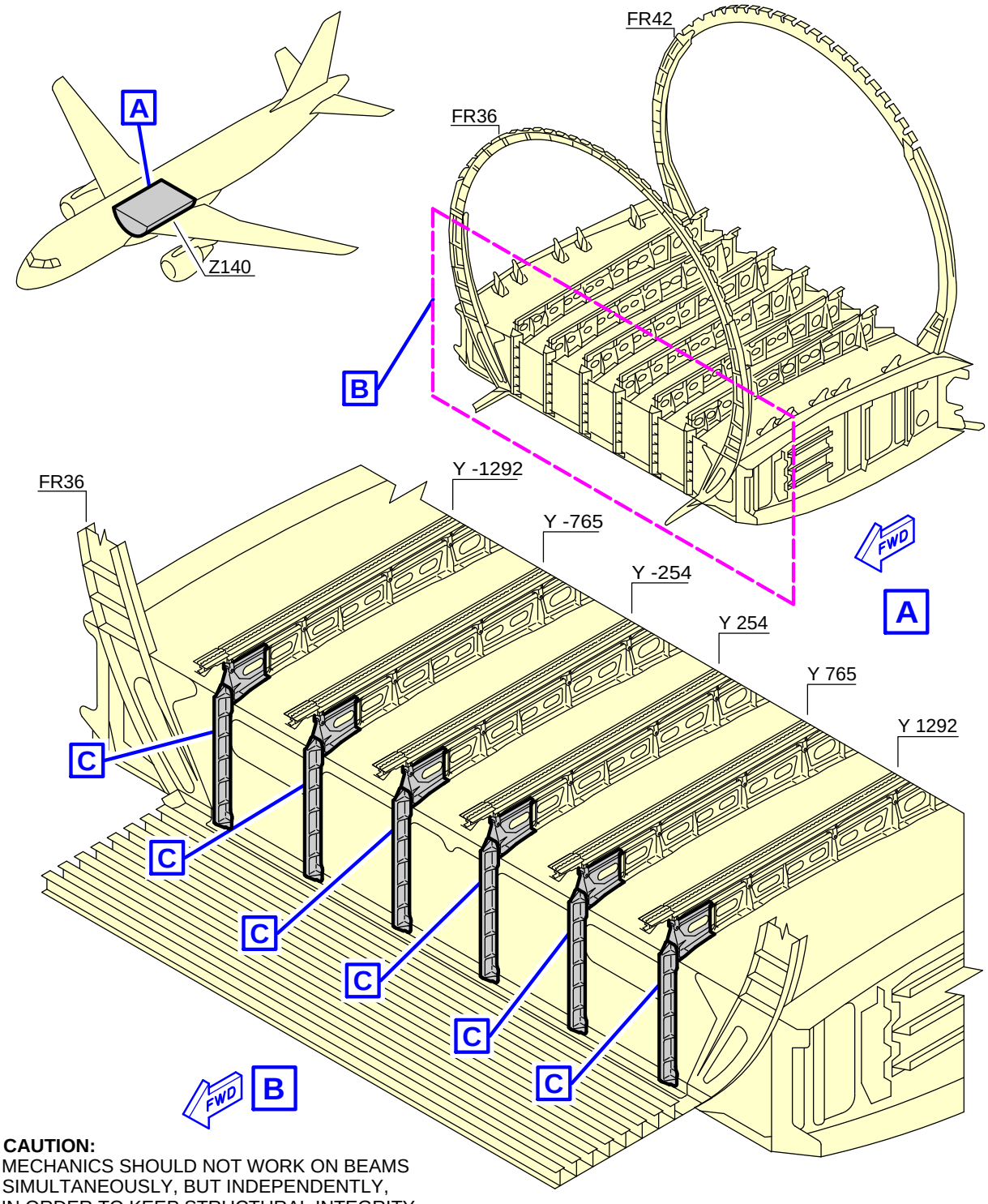
13 Protect the surface of the spot facing with :

Wash Primer - - - Structure 04CMA2
and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

CONF 002

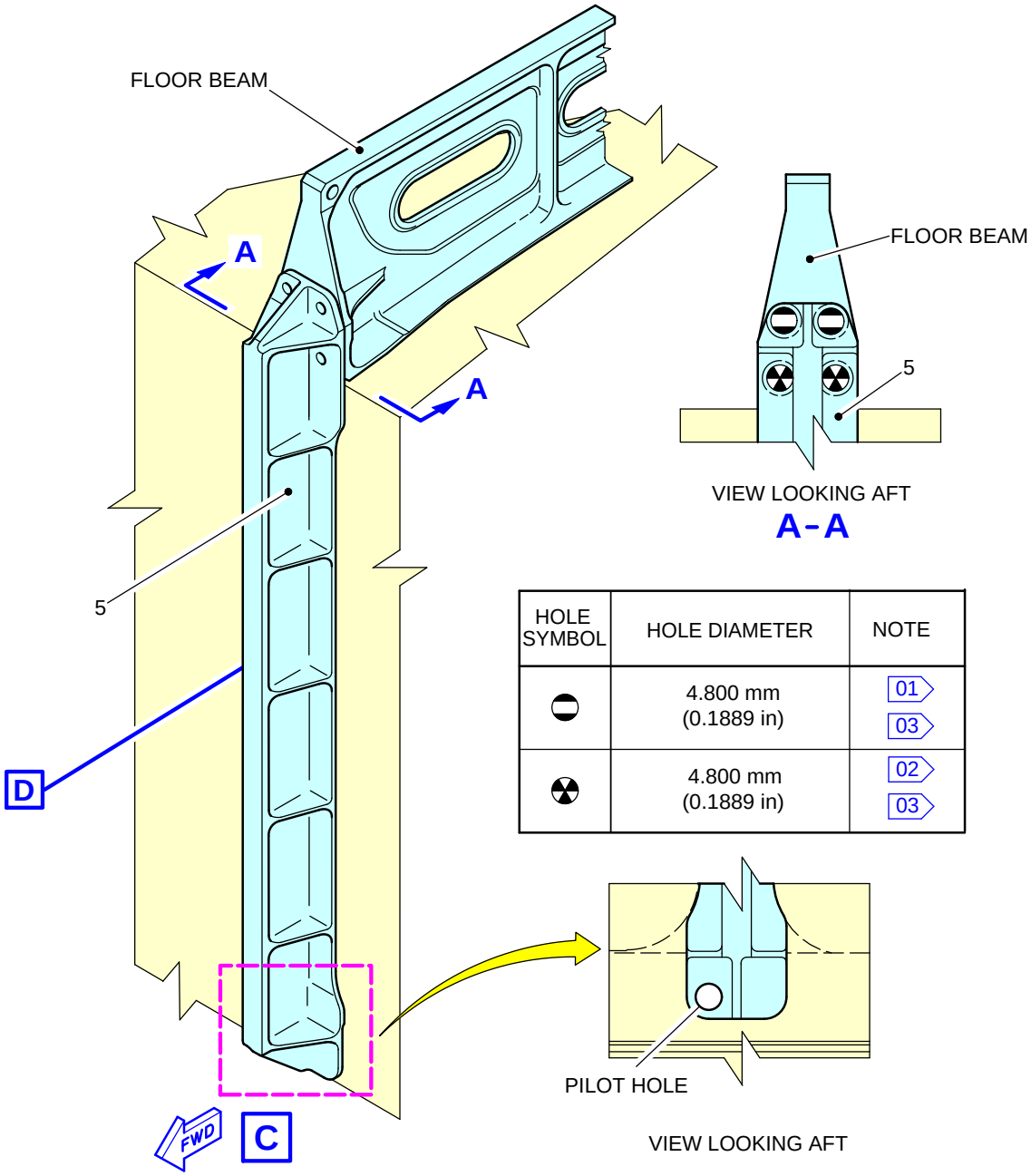


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSD-A-002-01 SHEET 1/3

CONF 002



HOLE SYMBOL	HOLE DIAMETER	NOTE
⊖	4.800 mm (0.1889 in)	01 03
☢	4.800 mm (0.1889 in)	02 03

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

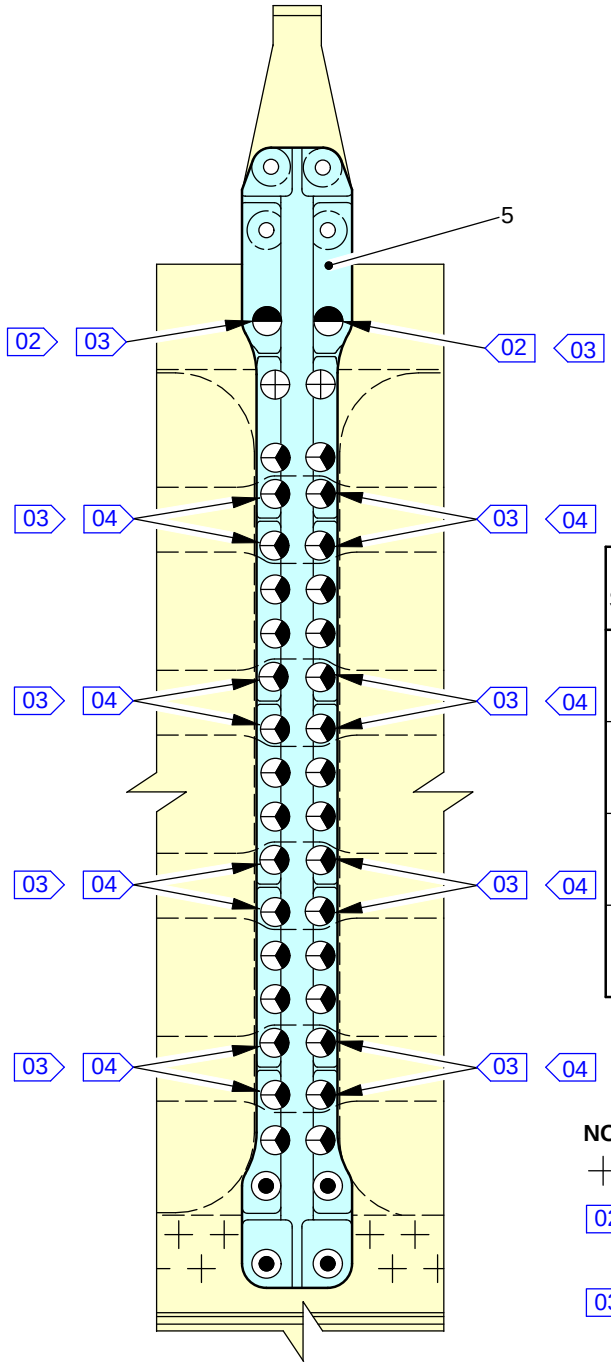
02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL. (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSE-A-002-01 SHEET 2/3

CONF 002



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
◓	8.296 mm (0.3266 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◔	5.113 mm (0.2013 in)	5.153 mm (0.2029 in)	FIRST OVERSIZE TRANSITION FIT
◉	8.206 mm (0.3231 in)	8.246 mm (0.3246 in)	FIRST OVERSIZE HIGH INTERFERENCE FIT
⊕	6.707 mm (0.2640 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

┼ FASTENER NOT AFFECTED

02 DO 20 mm (0.7874 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

03 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND No 04JME4.

04 IF NECESSARY, DO 15 mm (0.5905 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSF-A-003-01 SHEET 3/3

CONF 002

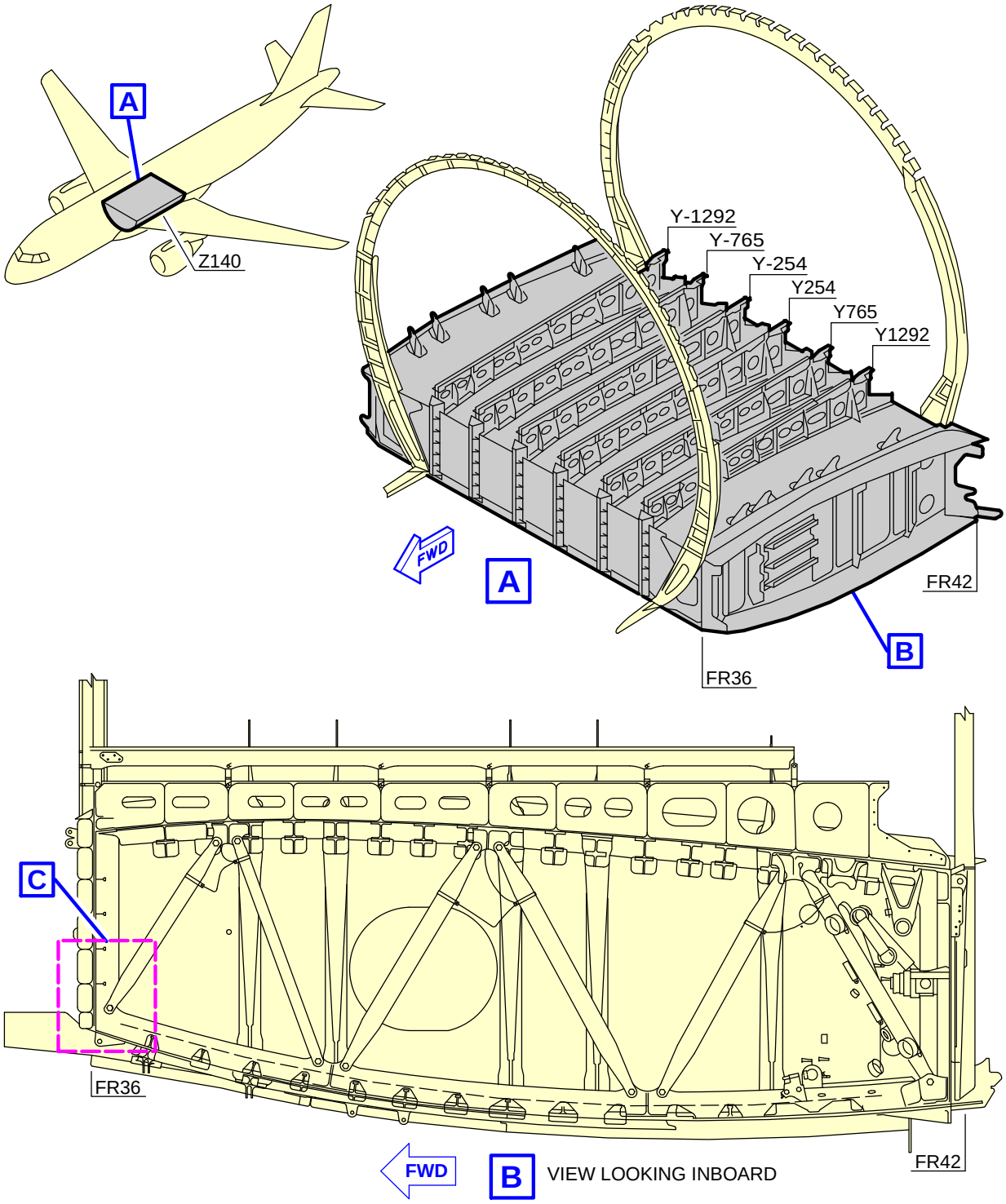
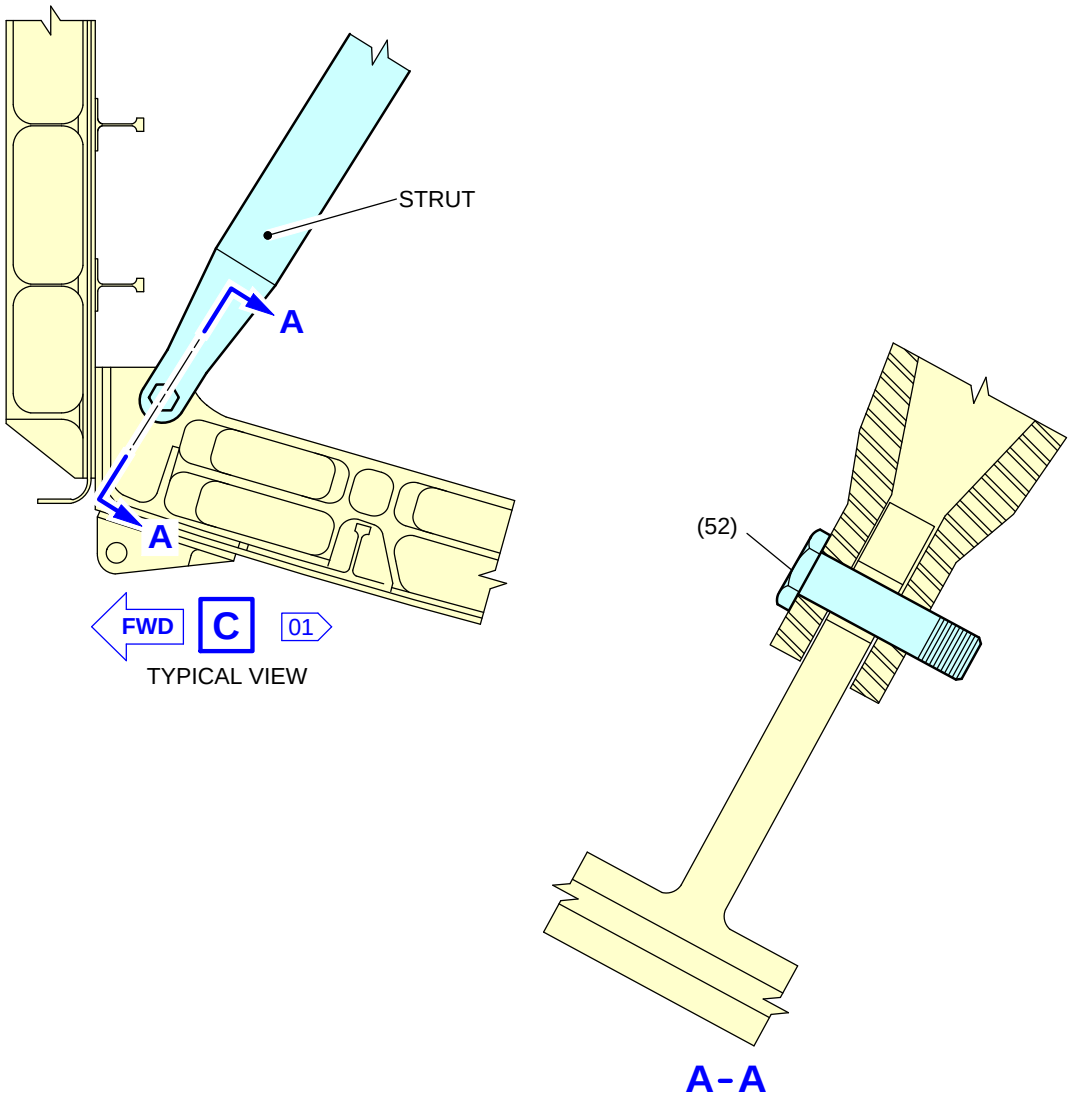


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

(75) Task A320-A-57-XX-1228-26001-720A-A - Install the New Vertical Stringer on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	20	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	20	BOLT		
21	EN6115V3X6	16	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001

Manuals/Drawings	References/Sheets
	06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

to the mating surface of all the parts.

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
20	BOLT	EN6115V3X5	Item 20
20	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT with:	EN6115K5X15	Item 17
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay 06ABC1

7 Wet install the fasteners:

10	RIVET	ASNA2050DCJ3215

		or/and	
10		RIVET with:	ASNA2050DXJ4020
		Polysulfide Sealant - Fuel Tank Interfay	06ABC1
	8	Renew the protective finish with:	
		Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
		Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

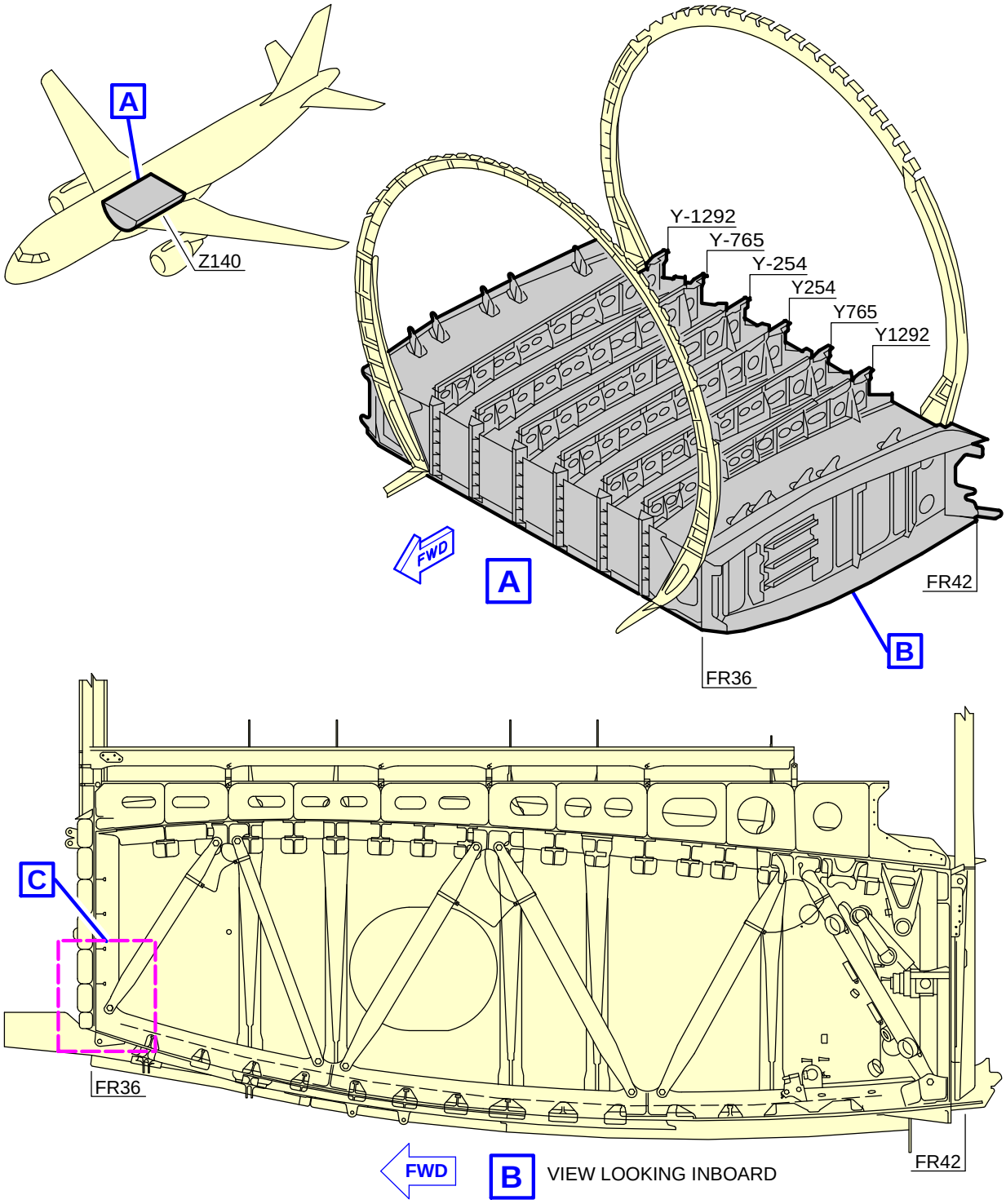
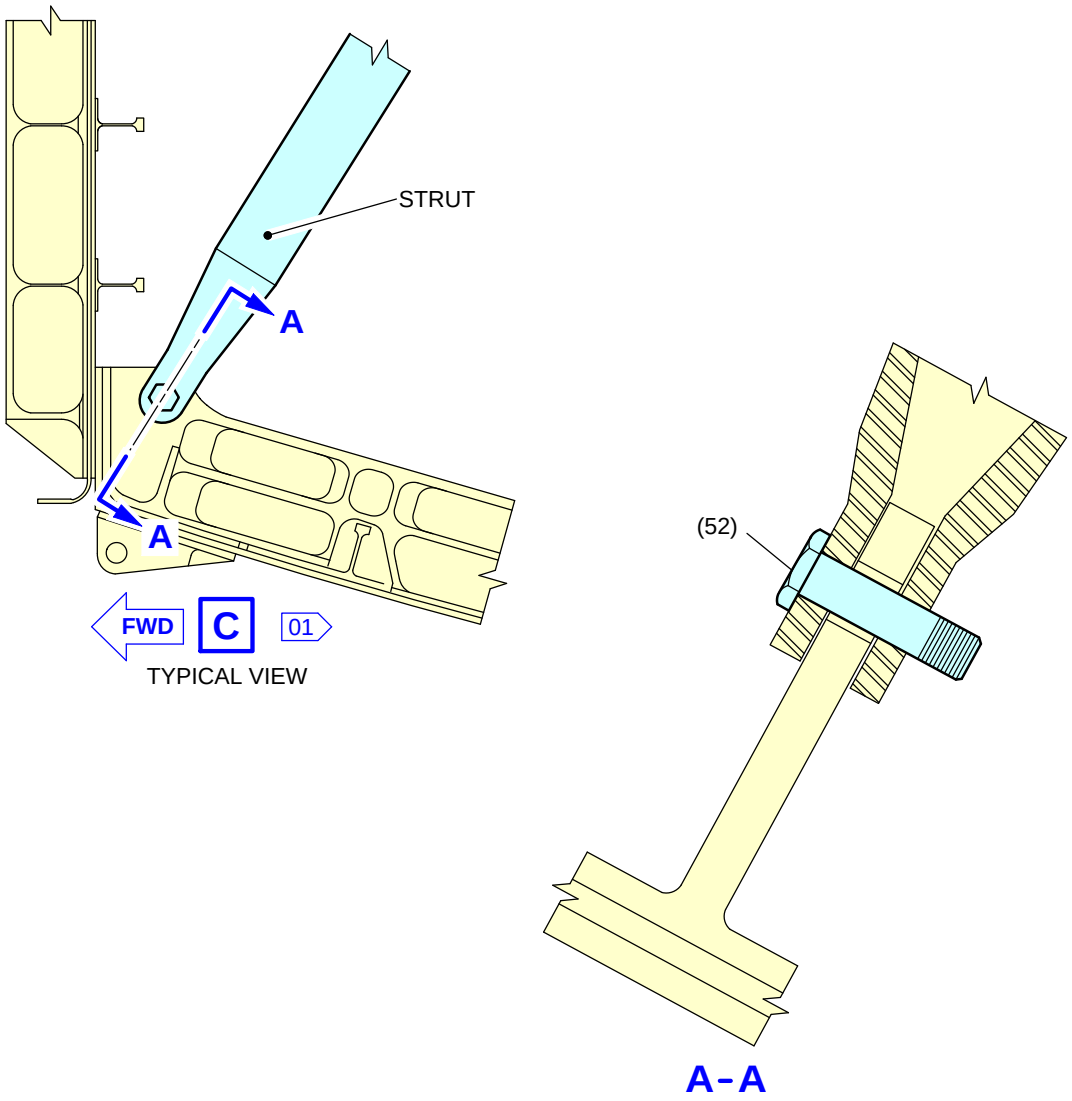


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 001 003 004



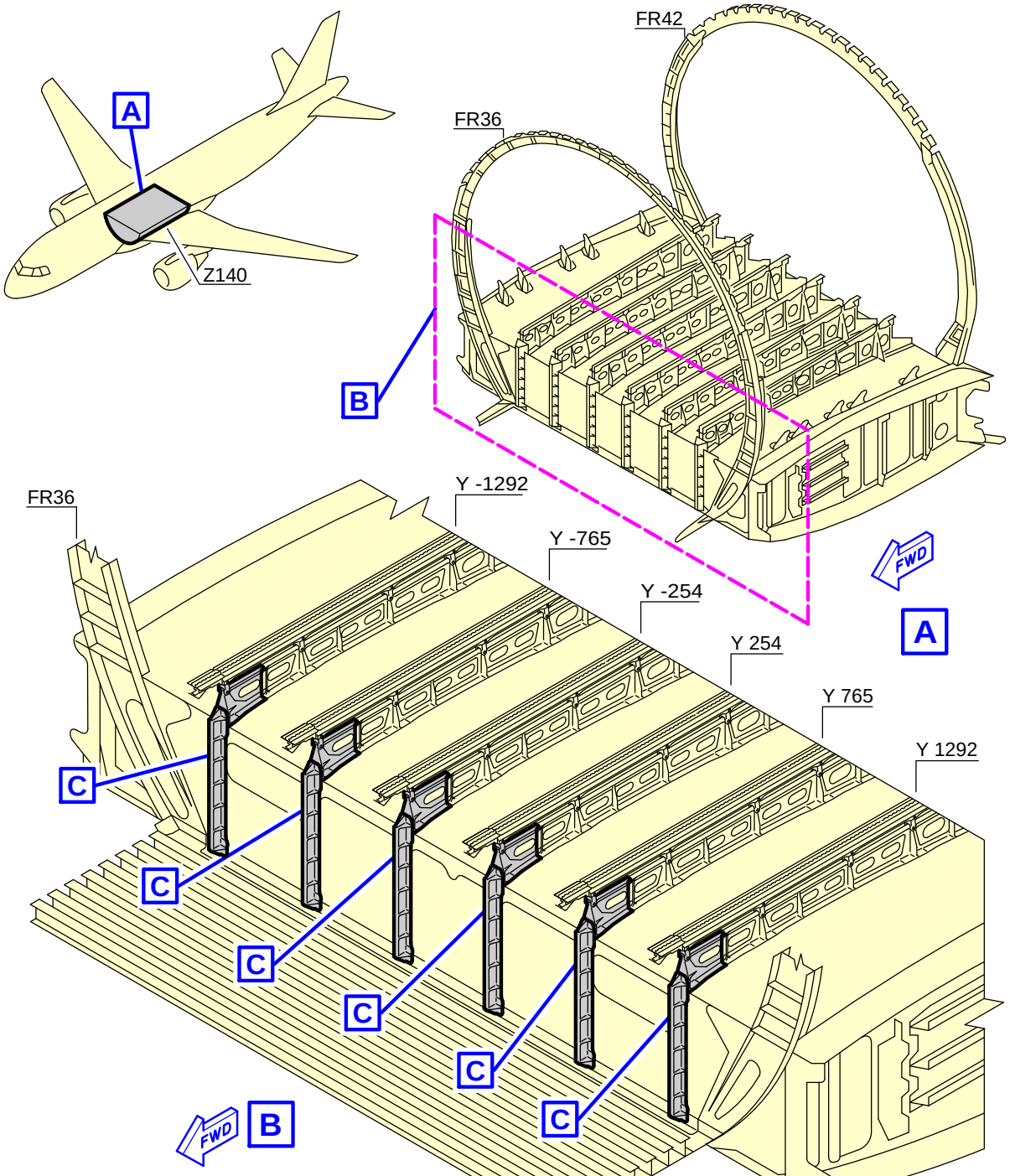
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 001 003 004

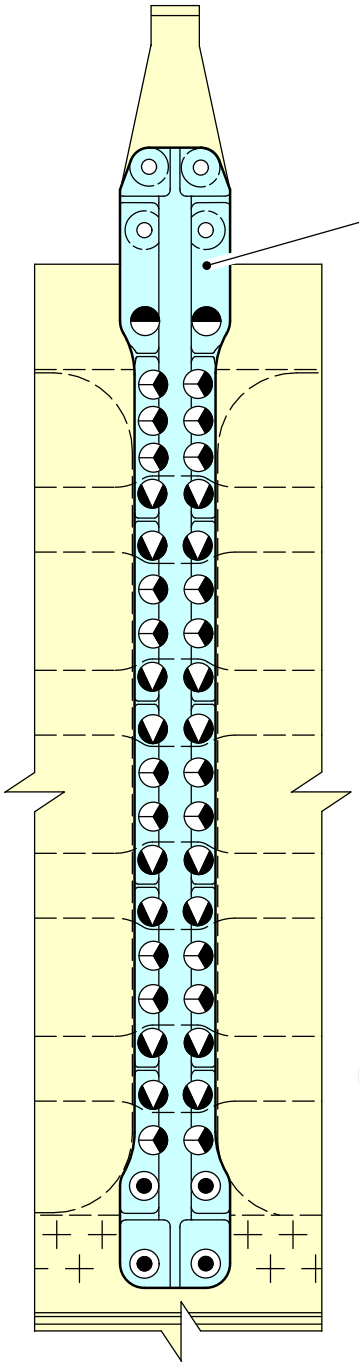


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSO-A-002-01 SHEET 1/2

CONF 001 003 004



VIEW LOOKING AFT

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSP-A-001-01 SHEET 2/2

CONF 002

(75) Task A320-A-57-XX-1228-26002-720A-A - Install the New Vertical Stringer on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ

Manpower/Resources/Skills

Man-hours	6.25 h
Minimum Number of person	2
Elapsed Time	3.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
5	D0041005820000	1	STRINGER		
10	ASNA2528-3	16	NUT		
11	ASNA2528-4	2	NUT		
13	ASNA2536-3	16	NUT		
15	ASNA2536-5	6	NUT		
17	EN6115K5X15	4	BOLT		
20	EN6115V3X5	16	BOLT		
21	EN6115V3X6	16	BOLT		
23	EN6115V4X5	2	BOLT		
28	EN6115V5X9	2	BOLT		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Temporarily, remove the strut and attach out of the working area, refer to Ref. Fig. Temporarily, Removal/Installation of the Strut Lower Attachments at FR36.

1	AXLE	Item (52)	Retained

(c) Install the vertical stringer item 5, refer to Ref. Fig. Installation of the New Vertical Stringers at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	STRINGER with:	D0041005820000	Item 5
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
6	NUT	ASNA2536-5	Item 15
16	BOLT	EN6115V3X5	Item 20
16	NUT	ASNA2528-3	Item 10
16	BOLT	EN6115V3X6	Item 21
16	NUT	ASNA2536-3	Item 13
4	BOLT	EN6115K5X15	Item 17
2	BOLT	EN6115V4X5	Item 23
2	NUT with:	ASNA2528-4	Item 11
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

(d) If removed, install the secondary structure brackets on the new vertical stringer (secondary structure brackets removed from the old vertical stringer).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new vertical stringer to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

6 Install the brackets with:

	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

	Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
	Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

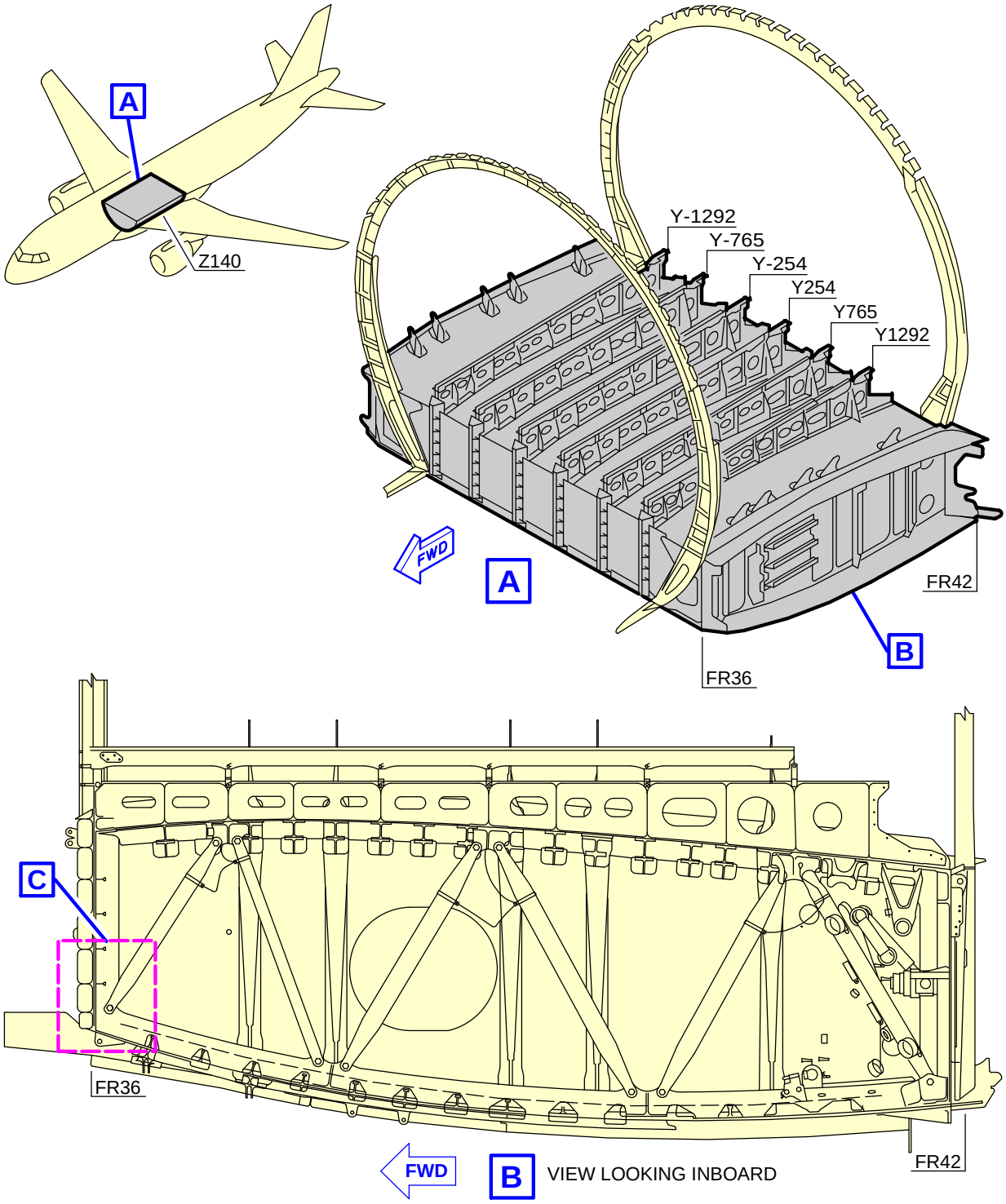
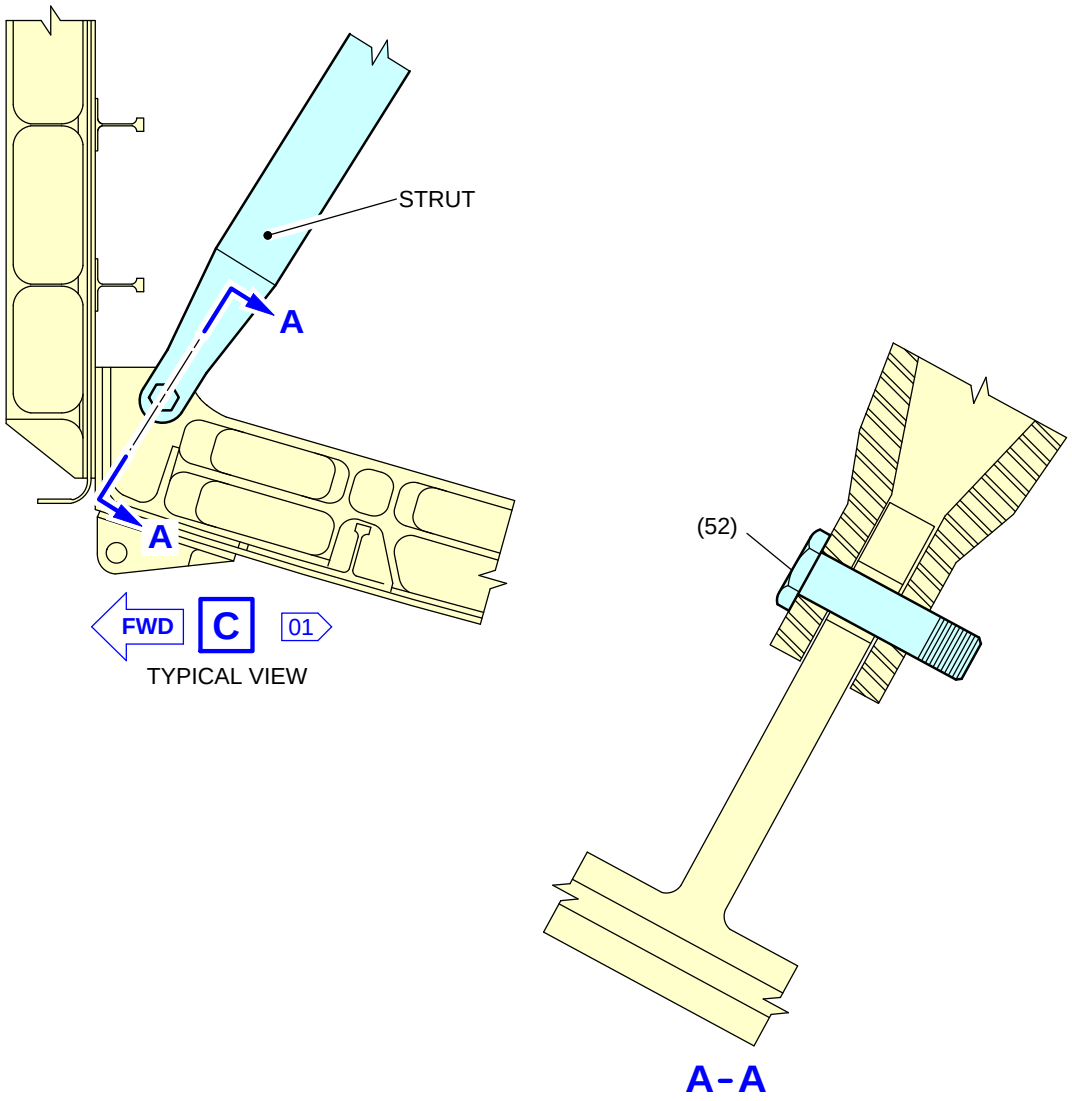


Figure ICN-A320-A-57XX1228-A-FAPE3-01MMB-A-001-01 SHEET 1/2

CONF 002



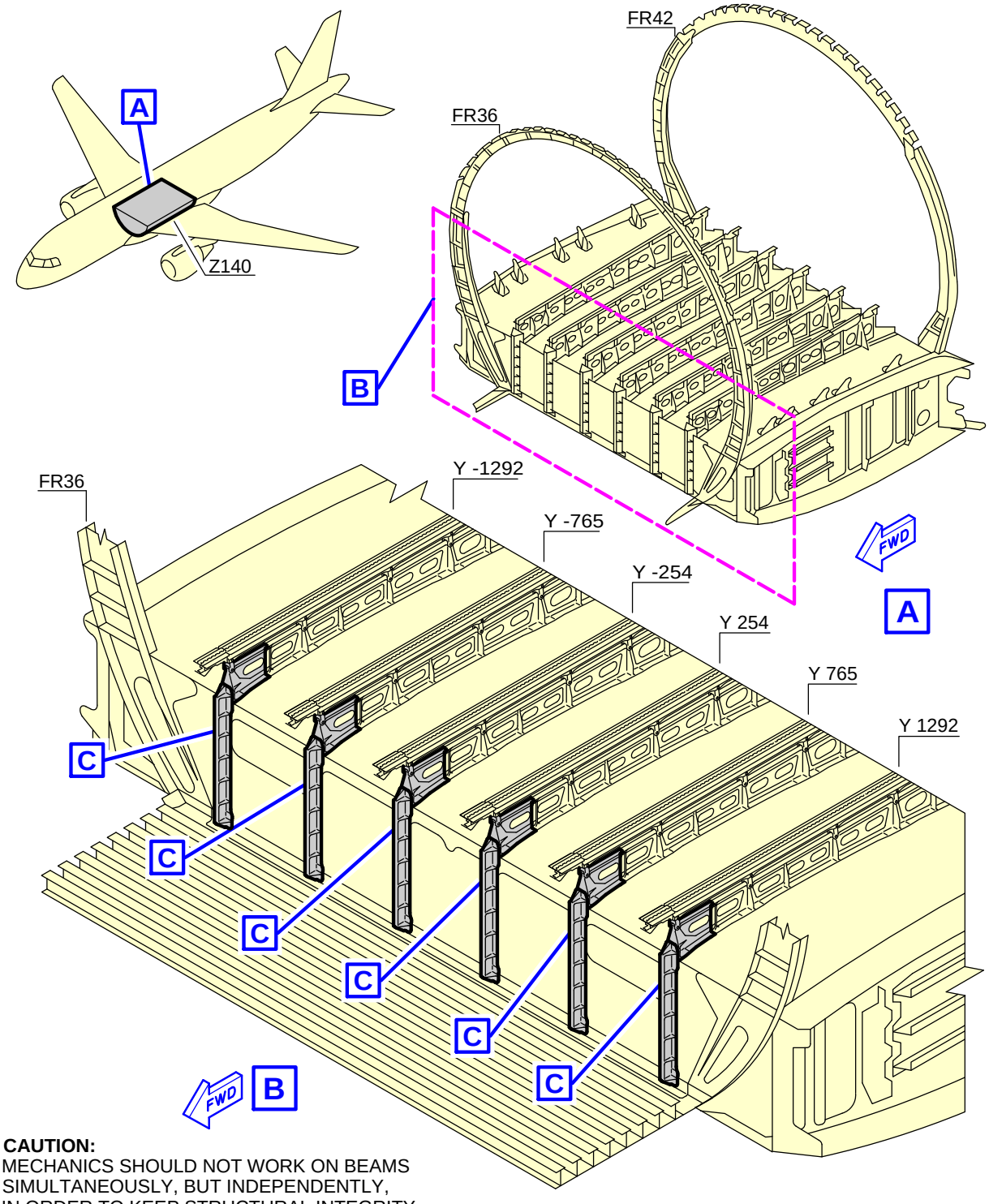
NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMC-A-001-01 SHEET 2/2

CONF 002

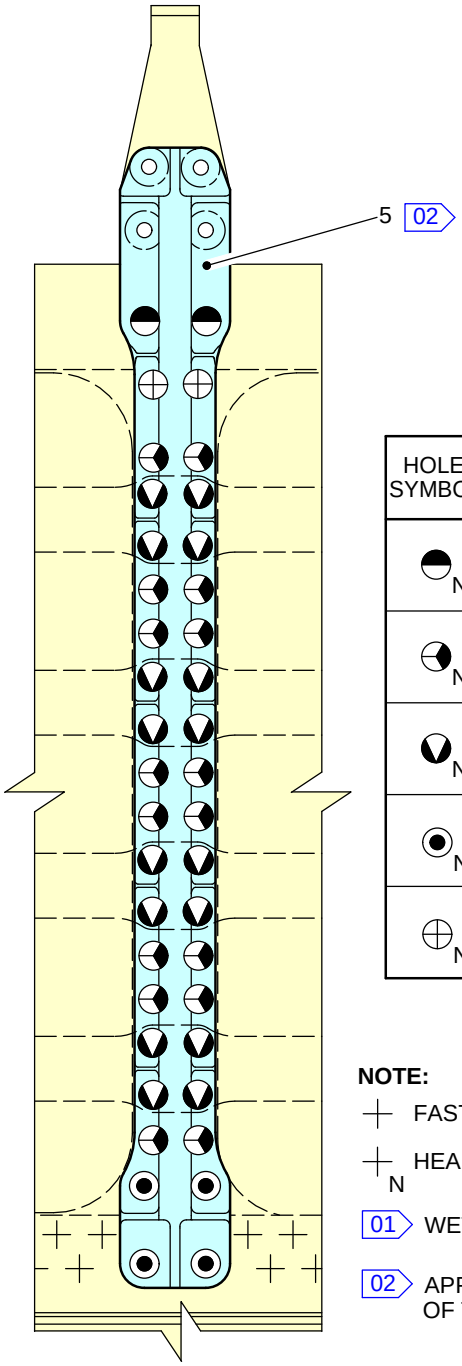


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTU-A-002-01 SHEET 1/2

CONF 002



HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	28	EN6115V5X9	BOLT	01
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	01
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	01
	13	ASNA2536-3	NUT	
N	17	EN6115K5X15	BOLT	01
	15	ASNA2536-5	NUT	
N	23	EN6115V4X5	BOLT	01
	11	ASNA2528-4	NUT	

NOTE:

FASTENER NOT AFFECTED

N HEAD ON NEAR SIDE

01 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF THE VERTICAL STRINGER ITEM 5.

ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTV-A-001-01 SHEET 2/2

CONF 001 003 004

(76) Task A320-A-57-XX-1228-27001-720A-A - Install the Strut Lower Attachment on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 001 003 004

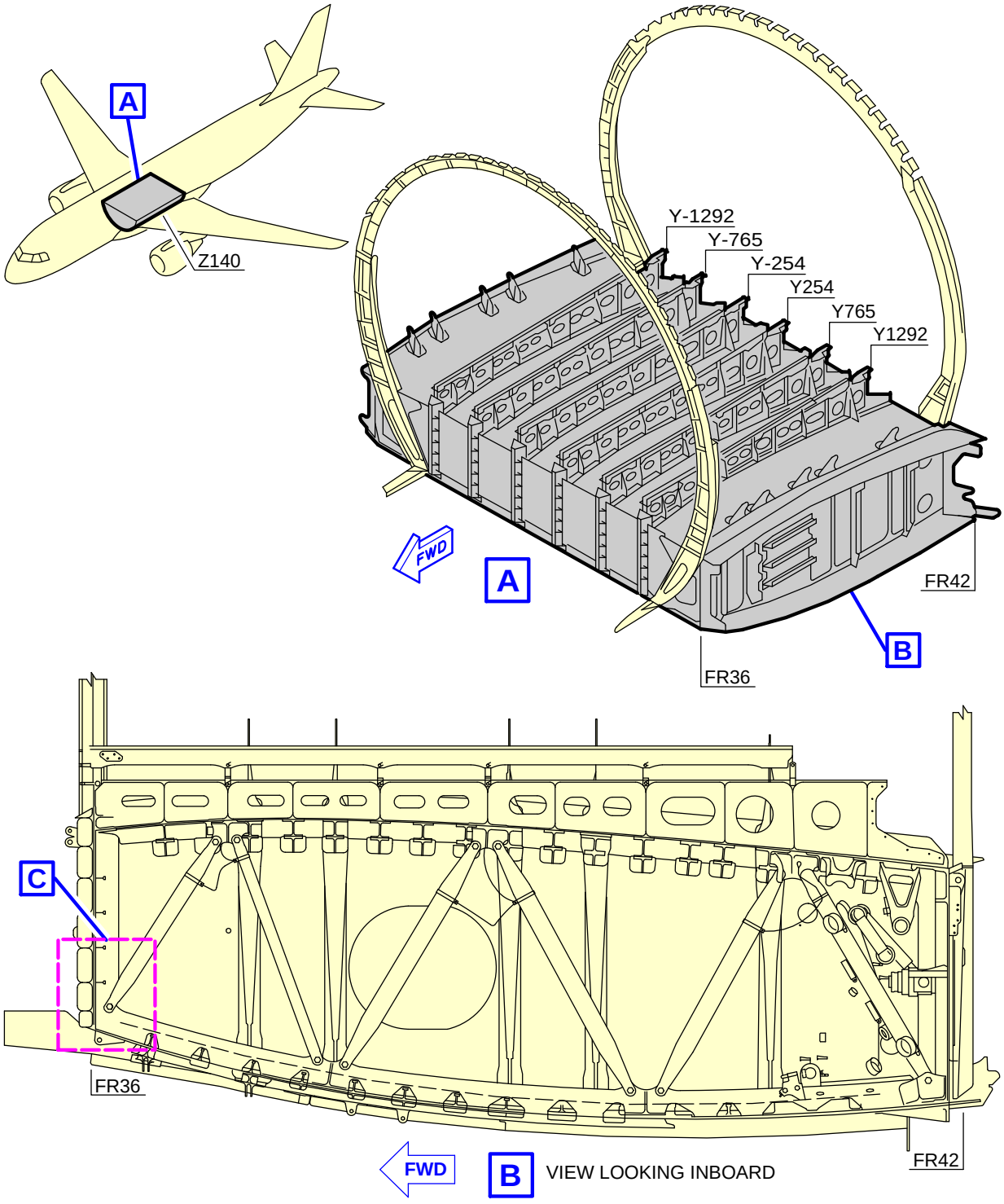
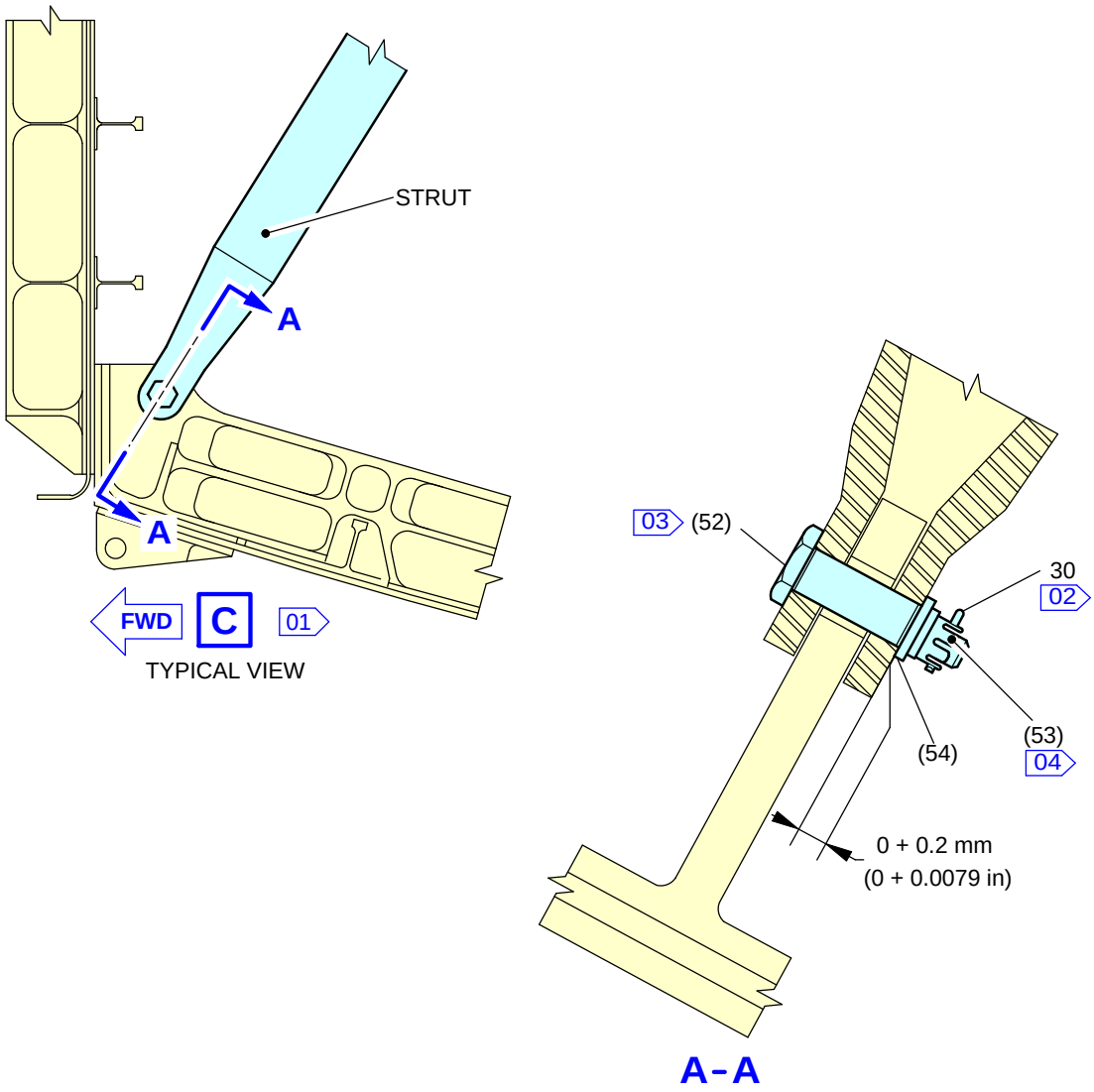


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 001 003 004



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF 002

(76) Task A320-A-57-XX-1228-27002-720A-A - Install the Strut Lower Attachment on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
30	MS24665-153	1	PIN		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-42-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

8 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Put in position the strut and install the lower attachment, refer to Ref. Fig. Installation of the Strut Lower Attachments at FR36.

1 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

2 Install:

1	AXLE		Item (52)	Retained
1	WASHER		Item (54)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER	MS24665-153	Item 30	

3 Protect the fastener head with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2

4 Overcoat the nut with:

Polysulfide Sealant - Low Density MultiPurpose Brushable	06ACA1

CONF 002

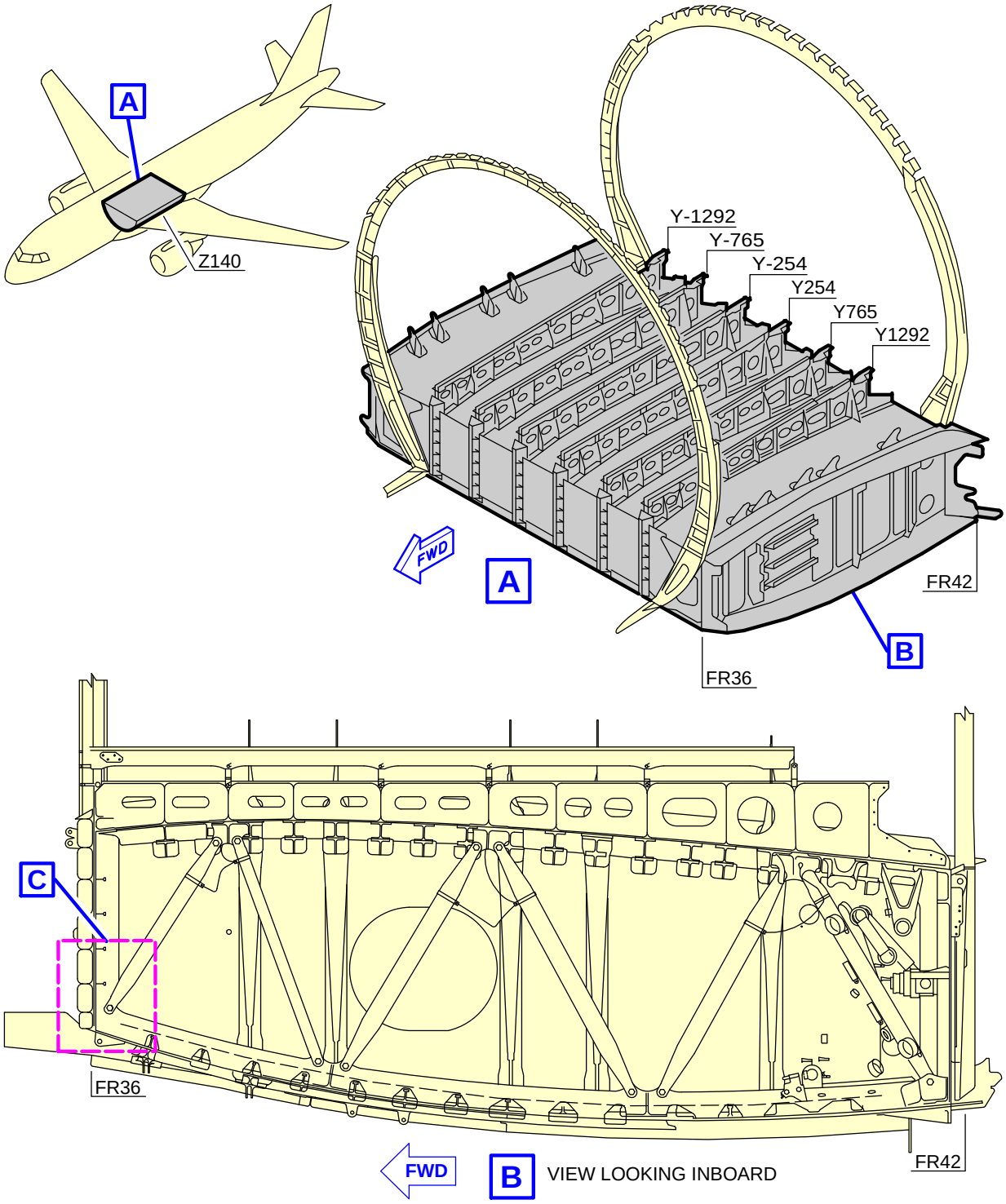
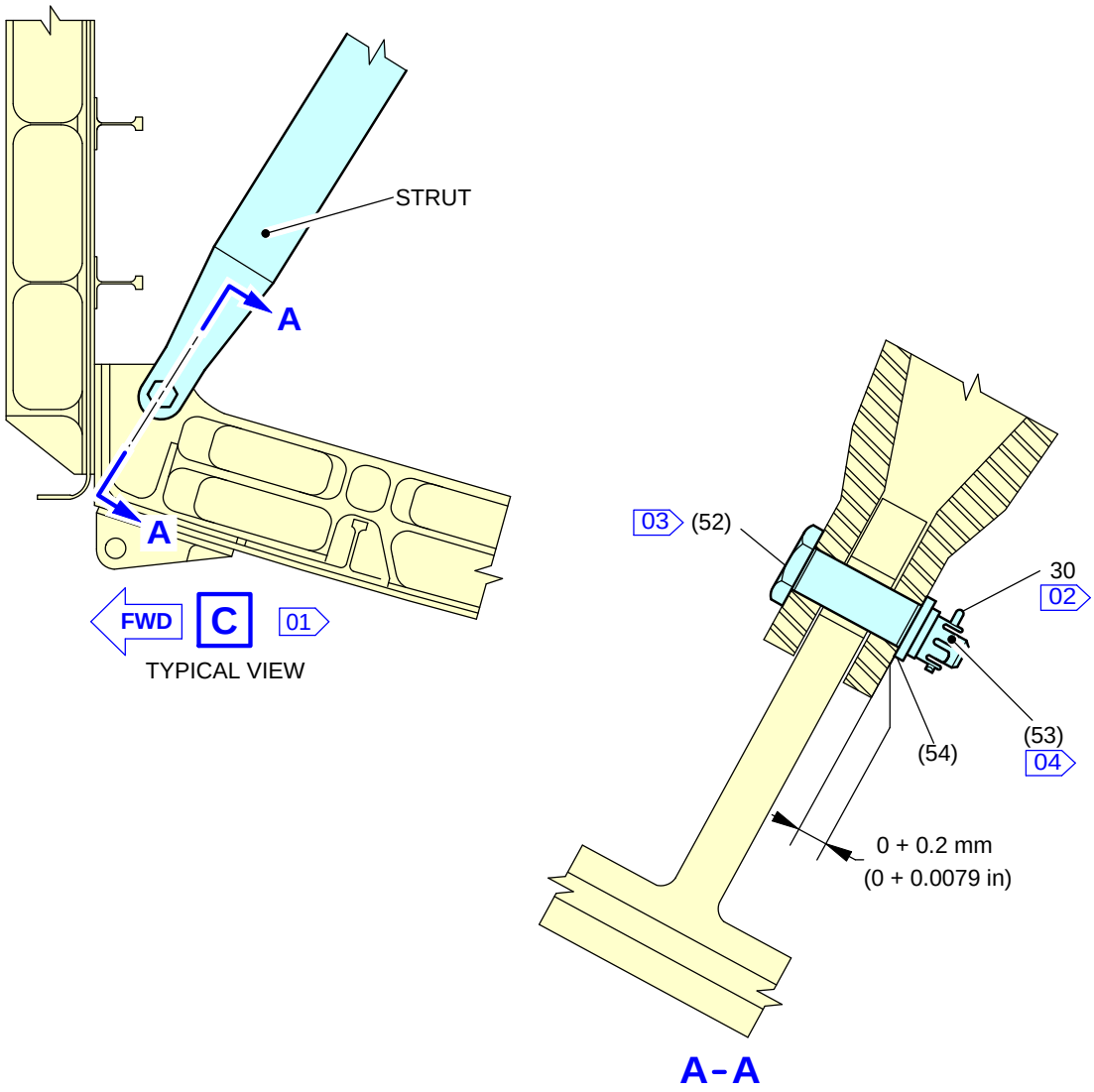


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM2-A-001-01 SHEET 1/2

CONF 002



NOTE:

01 TYPICAL INSTALLATION FOR ALL POSITIONS (Y-1292, Y-765, Y-254, Y254, Y765 AND Y1292).

02 PIN ENDS TO BE CAREFULLY FOLDED AGAINST NUT.

03 APPLY MATERIAL No 04EAC2 ON THE FASTENER HEAD.

04 APPLY MATERIAL No 06ACA1 ON THE NUT.

ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM3-A-001-01 SHEET 2/2

CONF ALL

(77) Task A320-A-57-XX-1228-21001-520A-A - Remove the Fasteners of the Forward End Floor Beams on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	2.75 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

7 Tag all the parts you must remove and retain to make the subsequent installation easier.

8 Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

(b) Remove the fasteners from the FWD end floor beam, refer to Ref. Fig. Removal of the Fasteners of the Forward End Floor Beams at FR36.

1 Remove the link attachment:

1	PIN	Item (29)	Discard
1	NUT	Item (53)	Retain
1	AXLE	Item (50)	Retain

2 Move and attach the link out of the working area.

3 Remove the fasteners:

20	FASTENER	Discard

(c) Inspect the FWD end floor beam for secondary structure brackets.

1 If no brackets are found this step is complete.

2 If there are brackets installed on the FWD end floor beam.

a Record the dimensions and positioning of the brackets for re-installation.

b Remove and retain the brackets while discarding the rivets.

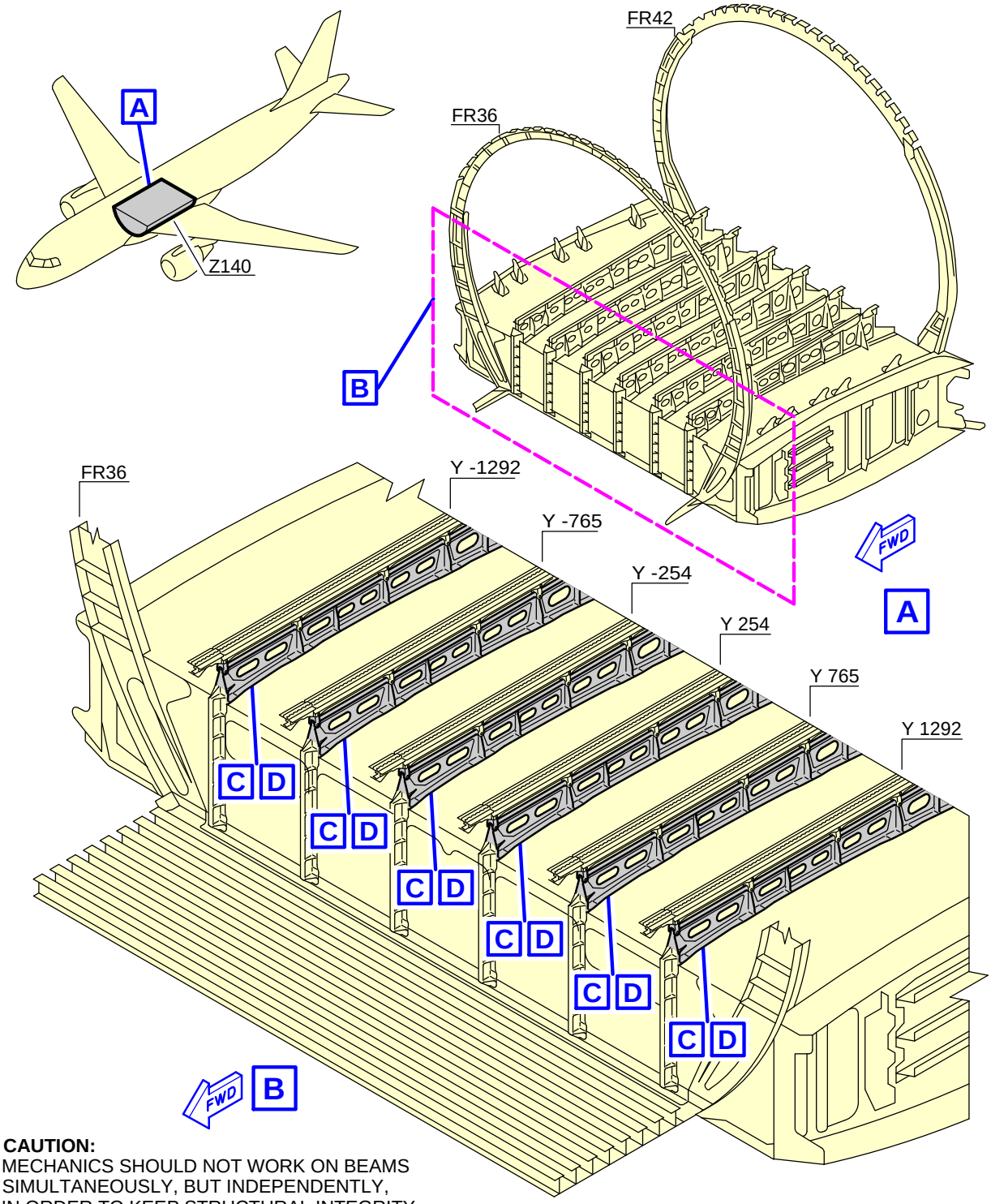
c Remove the sealant with a plastic spatula from the brackets and clean with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

d Re-install the brackets after the installation of the new FWD end floor beam in accordance with Ref. Task A320-A-57-XX-1228-29ZZZ-720Z-A.

CONF ALL

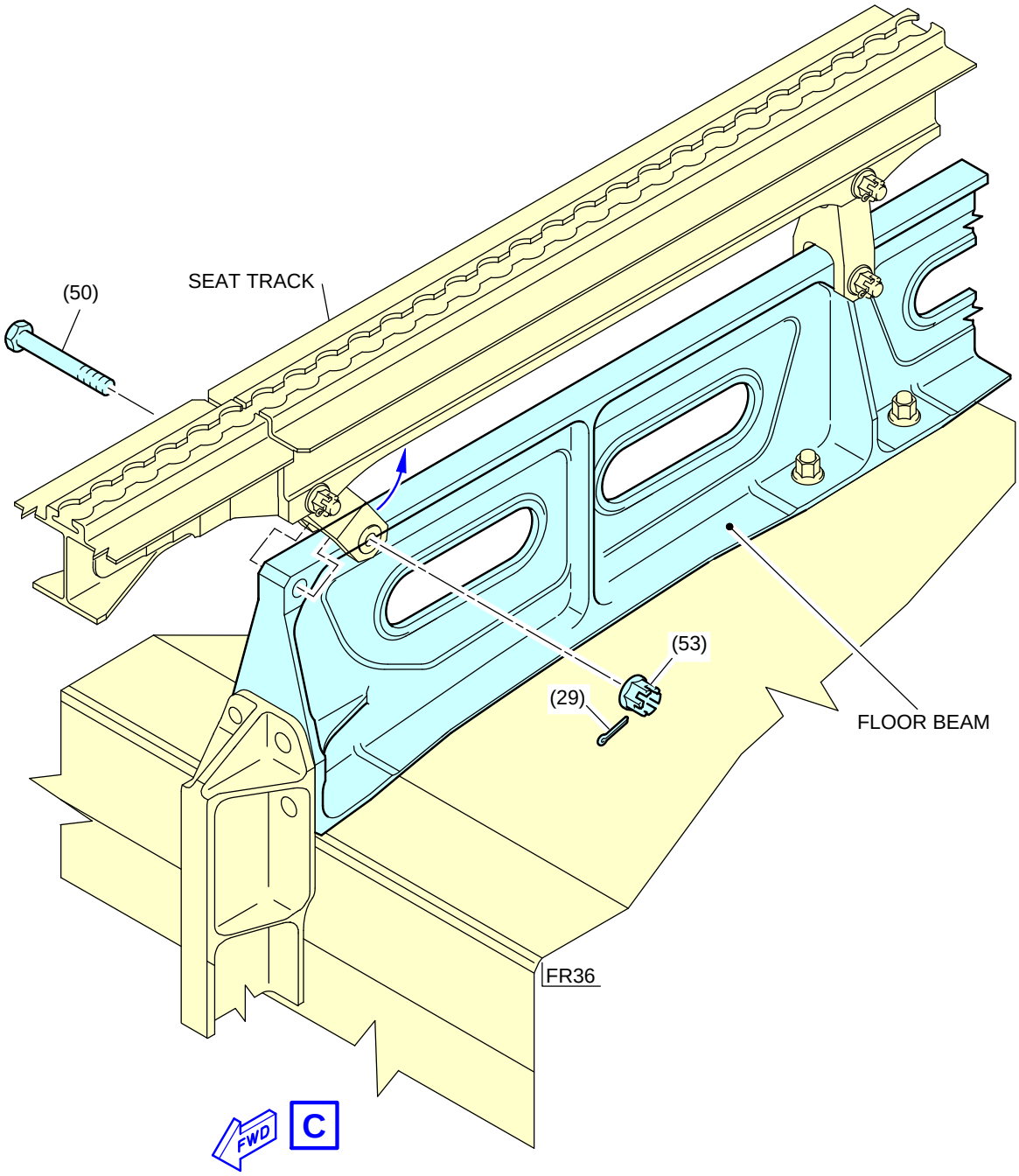


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU1-A-002-01 SHEET 1/3

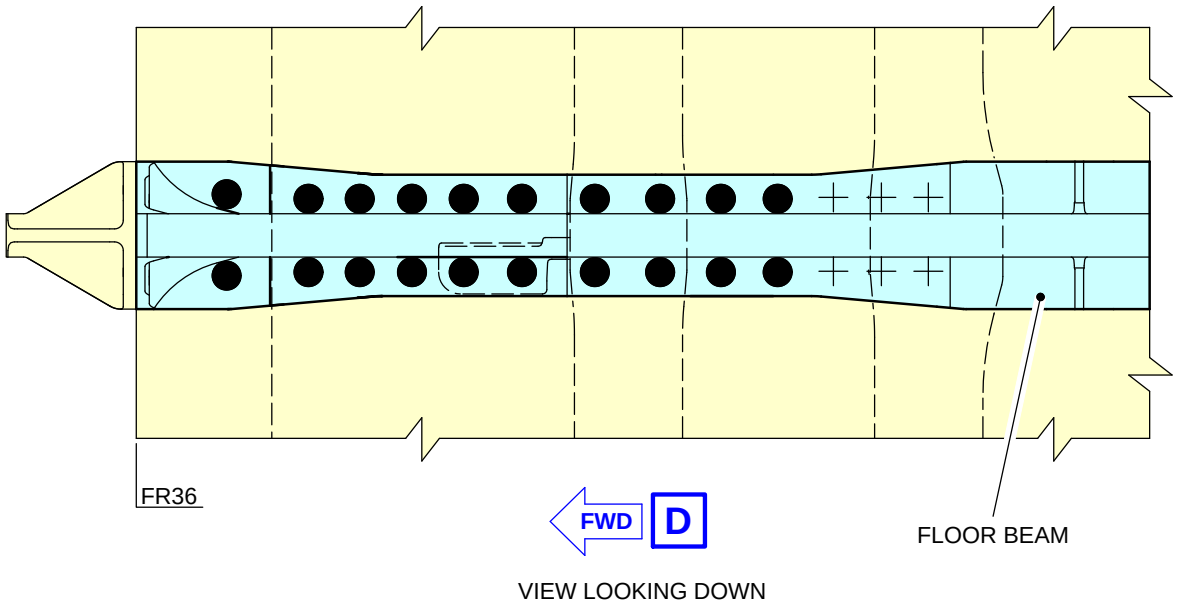
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU2-A-001-01 SHEET 2/3

CONF ALL



NOTE:

● REMOVE EXISTING FASTENER

┼ FASTENER NOT AFFECTED

ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU3-A-001-01 SHEET 3/3

(78) Task A320-A-57-XX-1228-06001-650A-A - Cut out the Forward End Floor Beam on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	3.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Cut out the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

1 Machine the web area.

2 Identify and mark the cutline on the FWD end floor beam with a water resistant marker pen.

3 Insert a steel protection between the FWD end floor beam and the CWB at the cutline.

4 Trim off the FWD end floor beam at the cutline.

NOTE: Use the new upper fitting as a guide to respect the edge distance and correct gap requirements at the trim location.

5 Remove the FWD end floor beam from the aircraft structure.

6 Remove the steel protection.

7 Remove the sealant with a plastic spatula from the CWB work area and clean with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

(c) Protect the cut area of the FWD end floor beam, refer to Ref. Fig. Cut out of the Forward End Floor Beams at FR36.

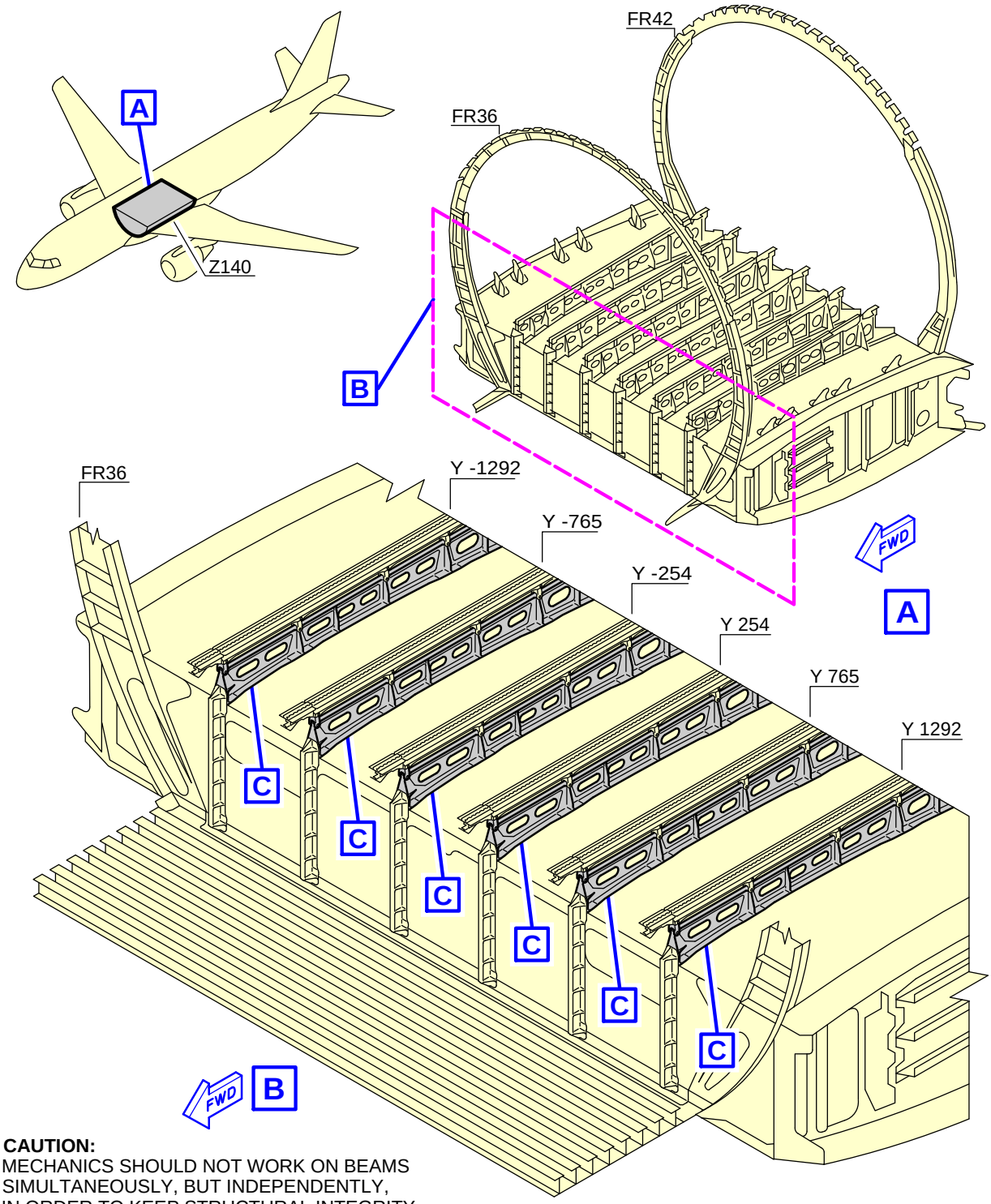
1 Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

2 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

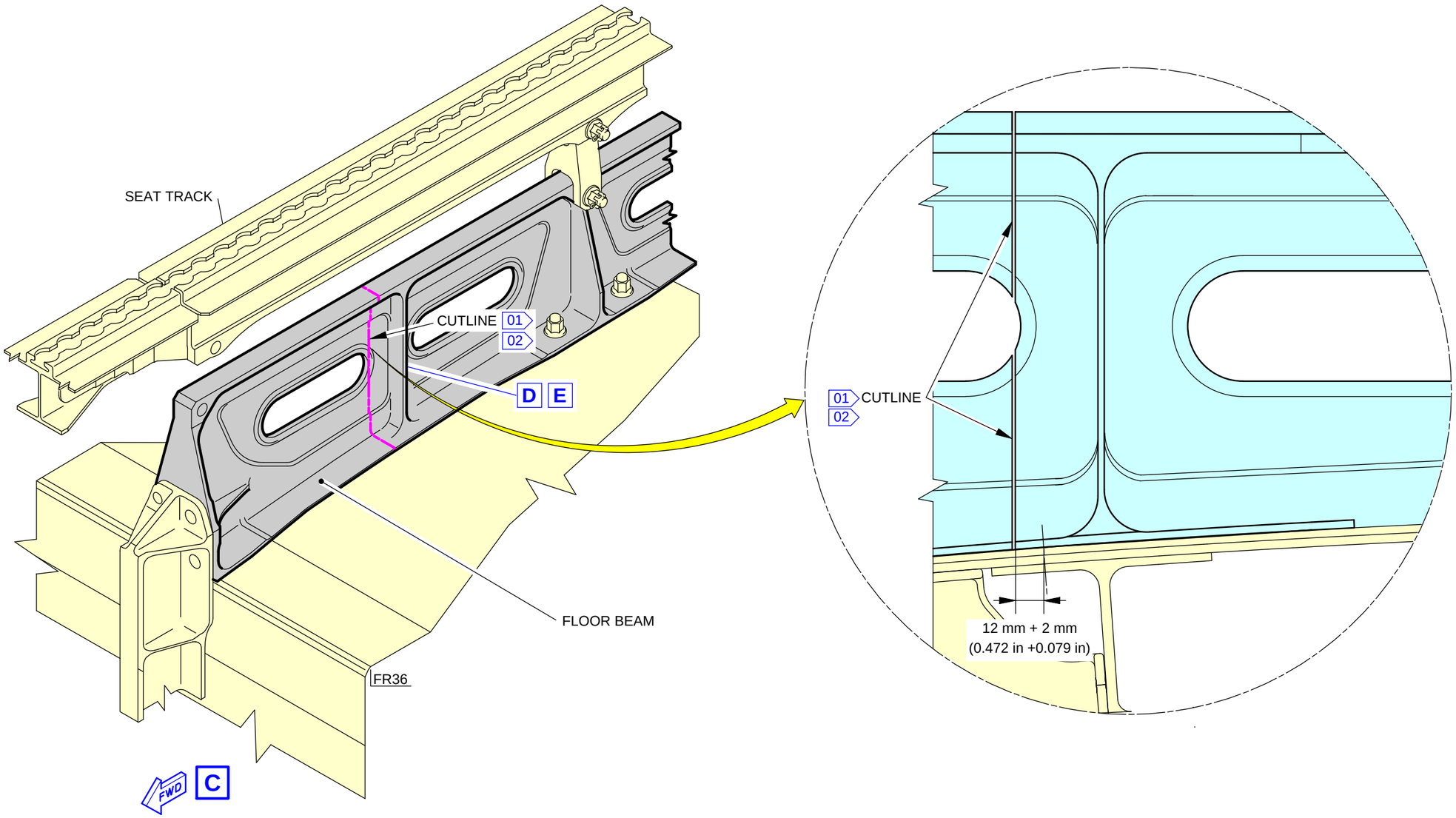


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTY-A-002-01 SHEET 1/3

CONF ALL



NOTE:

01 CUTLINE MATCHED WITH NEW UPPER FITTING.

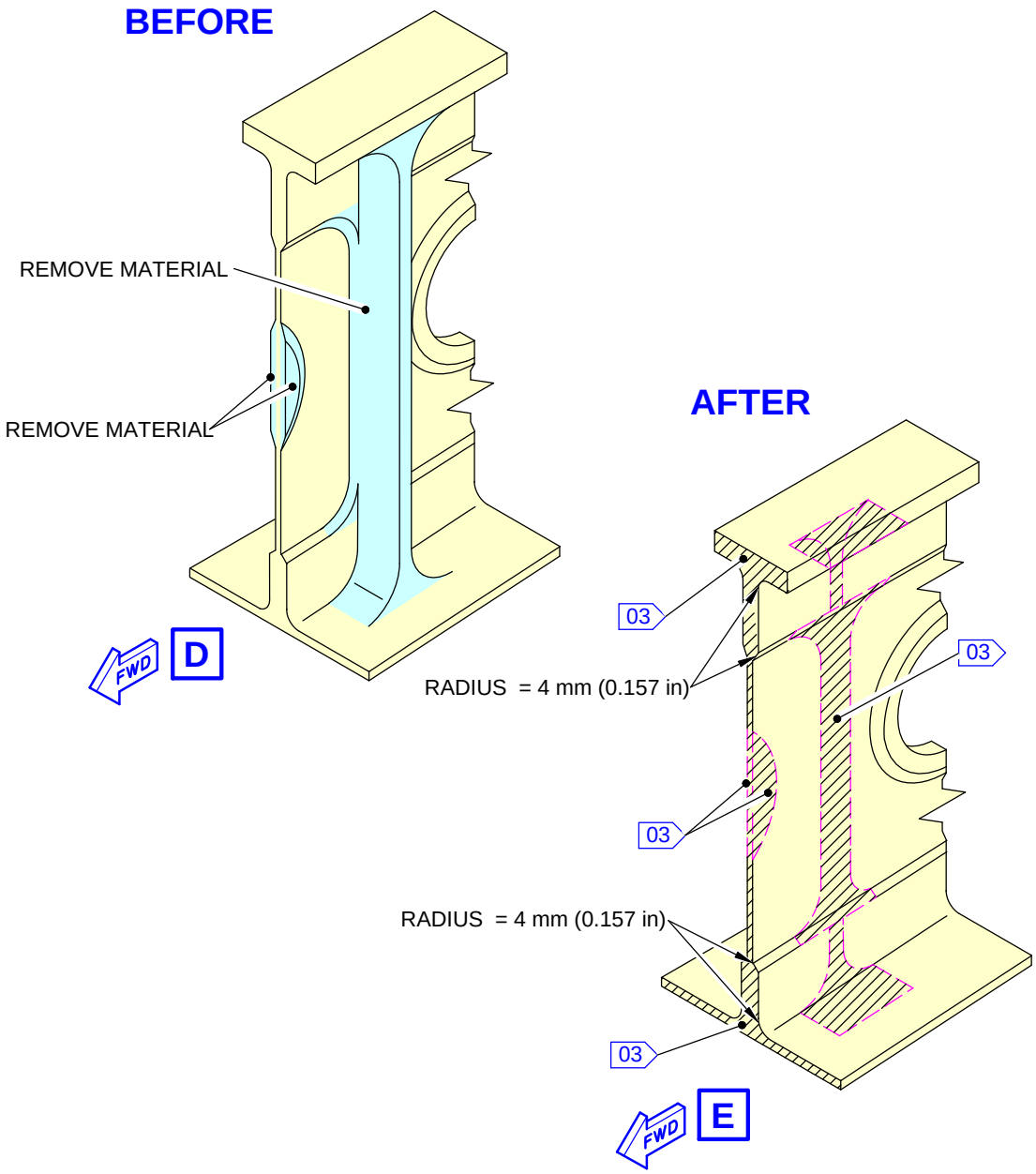
02 MAKE SURE TO KEEP 12 MM (0.472 IN) MIN EDGE DISTANCE ON THE BEAM FLANGE AND TO GET CLEARANCE BETWEEN BEAM WEB OPENING AND NEW UPPER FITTING.

ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTZ-A-001-01 SHEET 2/3

Cut out of the Forward End Floor Beams at FR36

CONF ALL



NOTE:

03 PROTECT THE SURFACE WITH MATERIAL No 10ABC1
AND APPLY MATERIAL No 04EAC2 AND 04JME4 (CUT AREAS).

ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU0-A-001-01 SHEET 3/3

(79) Task A320-A-57-XX-1228-12001-353A-A - Do a Rotating Probe Inspection of the Forward End Floor Beam Fastener Holes and a HFEC of the Cut Edges on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Non-Destructive Testing

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
NTM	51-10-01 51-10-08
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Do a rotating probe inspection, refer to Ref. NTM 51-10-01.

6 Do a High Frequency Eddy Current (HFEC) inspection, refer to Ref. NTM 51-10-08.

(b) Clean the fastener holes and the cut edges with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Do the Detailed Inspection (DI) of the work area, the rotating probe inspection of the FWD end floor beam fastener holes and the HFEC of the cut edges.

1 If a crack is found, contact AIRBUS (inspection.results@airbus.com) before next flight and follow their instructions.

2 If a crack is not found, continue in accordance with Ref. Task A320-A-57-XX-1228-28ZZZ-720Z-C.

CONF 001 003 004

(80) Task A320-A-57-XX-1228-28001-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

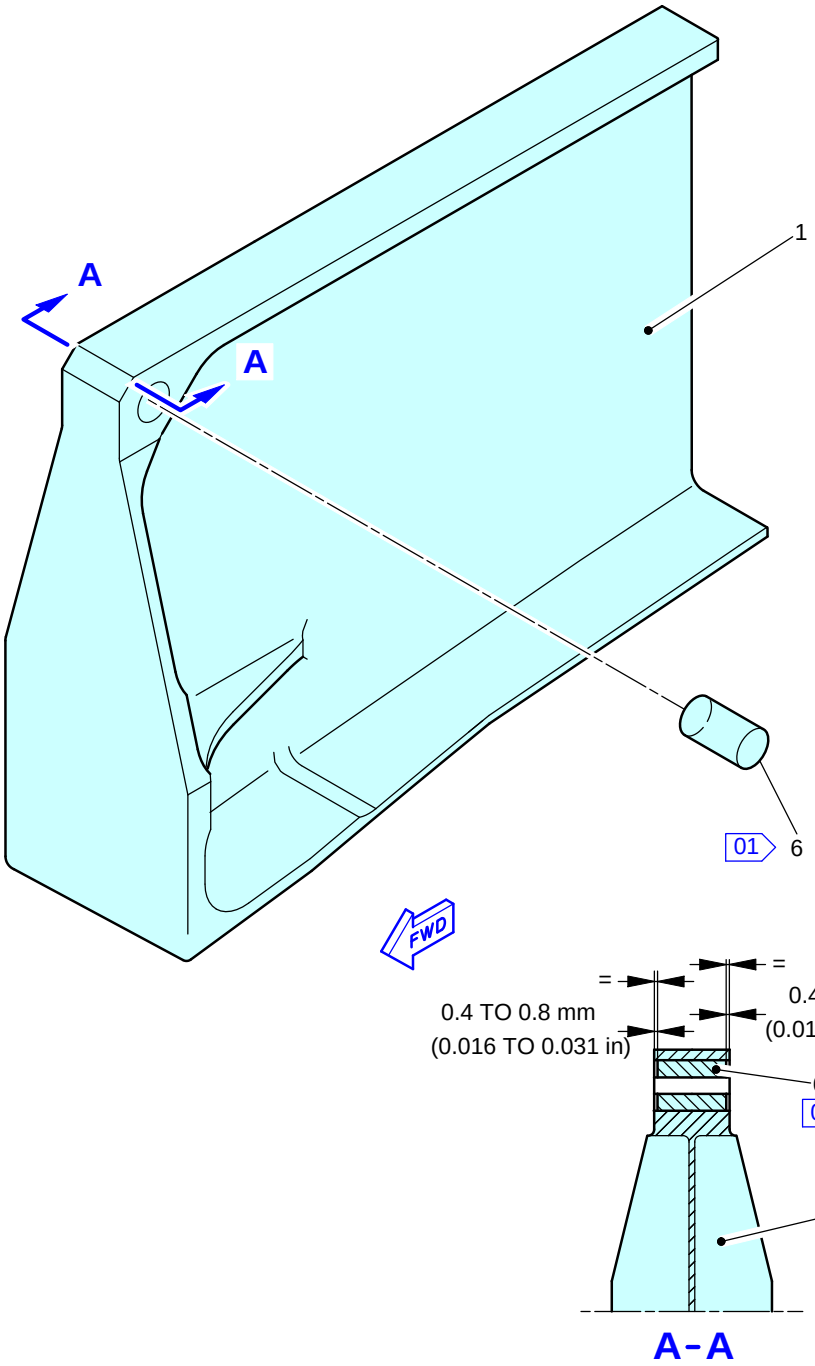
Textile - Lint free Cotton and	14SBA1	
Non Aqueous Cleaner - General	08BAA9	

2 Install:

1	BUSHING with:	D5713006420000	Item 6
	Epoxy Adhesive - - - Legacy 3 in:	05EML7	
1	FITTING	D0041005320000	Item 1

CONF 001 003 004

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 002

(80) Task A320-A-57-XX-1228-28002-720A-C - On Bench Install the Bush in the New Upper Fitting to Be Installed on Y-1292 at FR36

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.25 h
Minimum Number of person	1
Elapsed Time	0.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	05EML7	Epoxy Adhesive - - - Legacy 3		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
6	D5713006420000	1	BUSHING		

Referenced Information

Manuals/Drawings	**References/Sheets**
CML	CONSUMABLE MATERIAL LIST (CML)
PMS	01-04-66
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

1 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

2 Do the installation of the bush, refer to Ref. PMS 01-04-66.

3 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bush in the new upper fitting, refer to Ref. Fig. Installation of the Bush into the New Upper Fitting on Bench.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

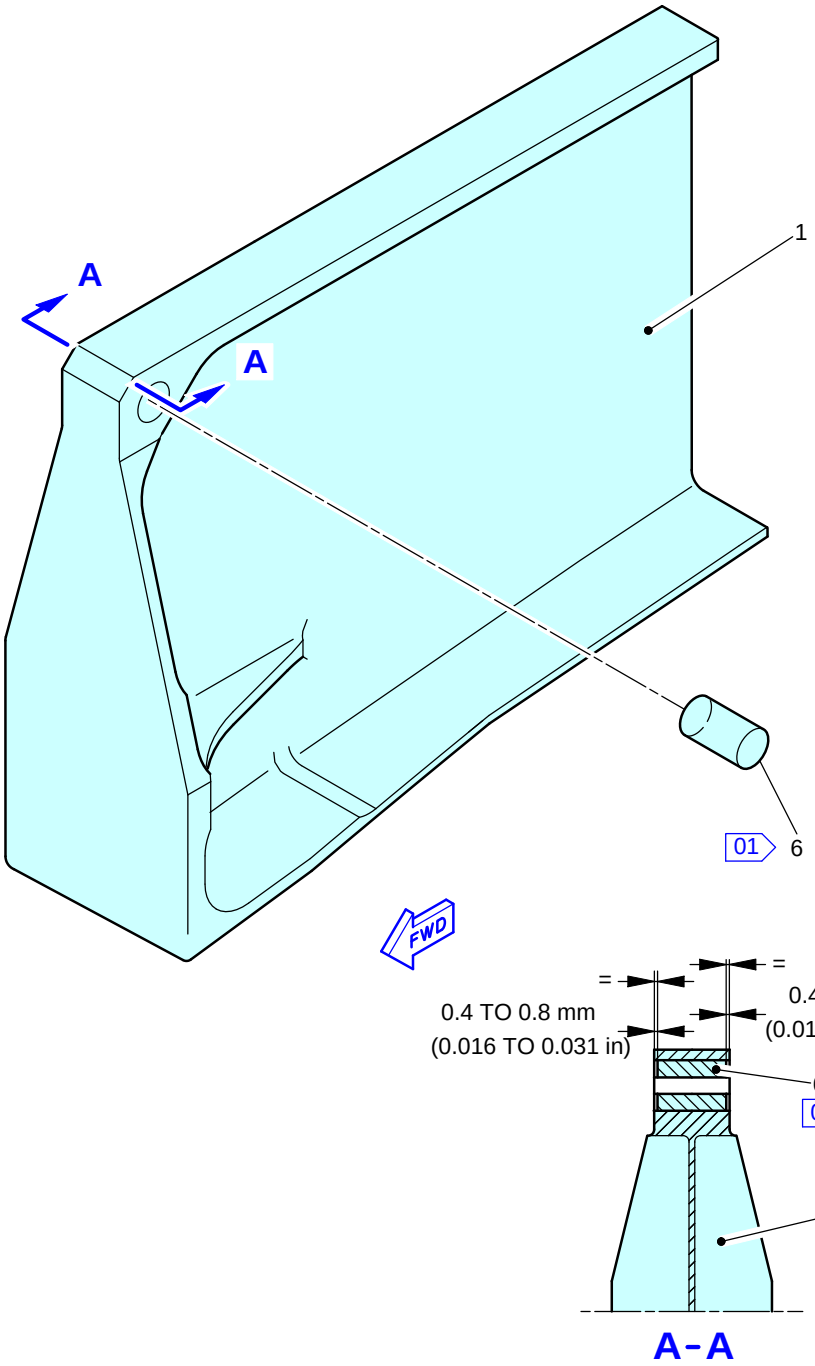
2 Install:

1	BUSHING	D5713006420000	Item 6

	with:		
	Epoxy Adhesive - - - Legacy 3	05EML7	
	in:		
1	FITTING	D0041005320000	Item 1

CONF 002

ON BENCH



NOTE:

01 APPLY MATERIAL No 05EML7.

ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSV-A-003-01 SHEET 1/1

CONF 001 003 004

(81) Task A320-A-57-XX-1228-06001-270A-A - Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

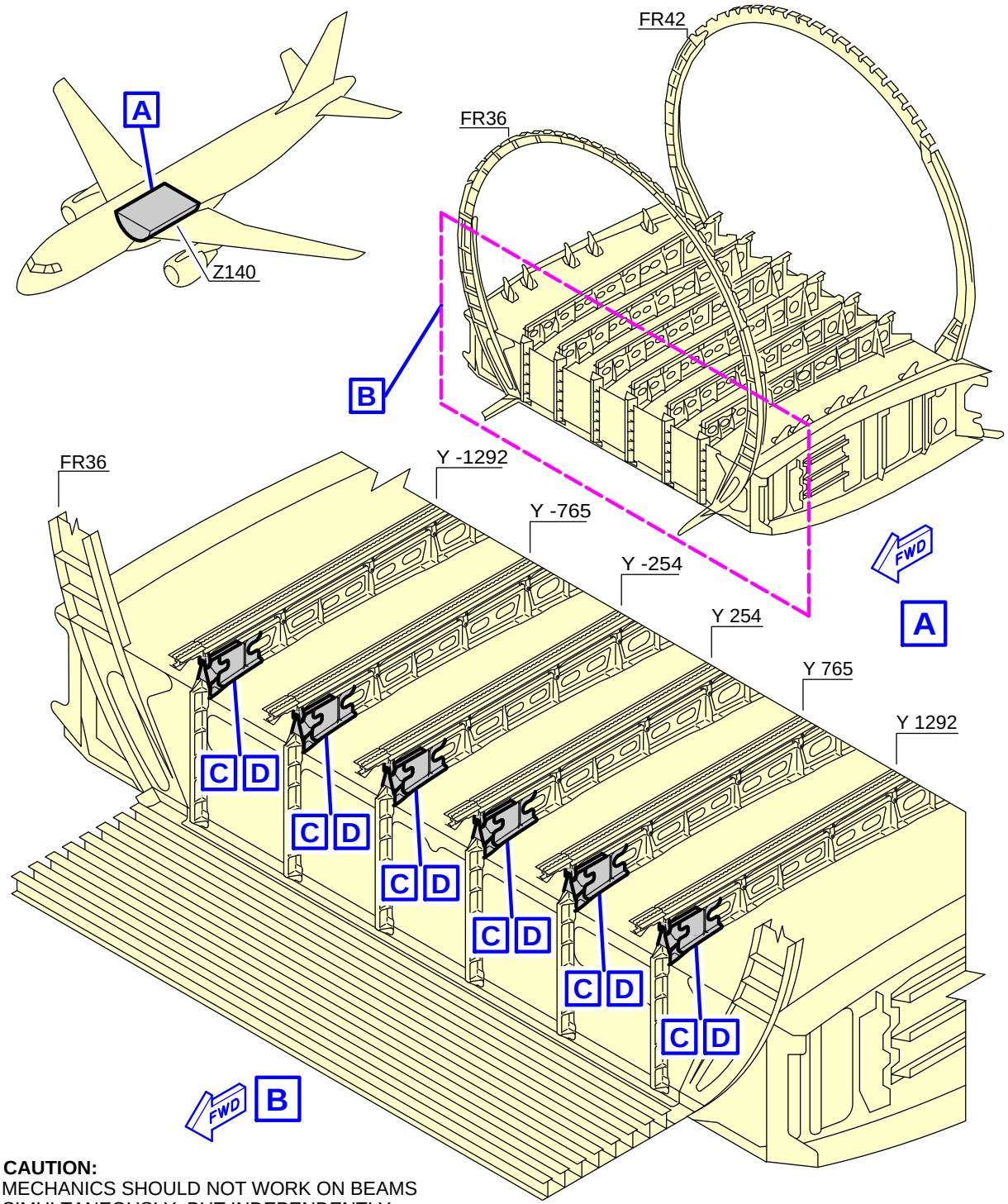
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 001 003 004

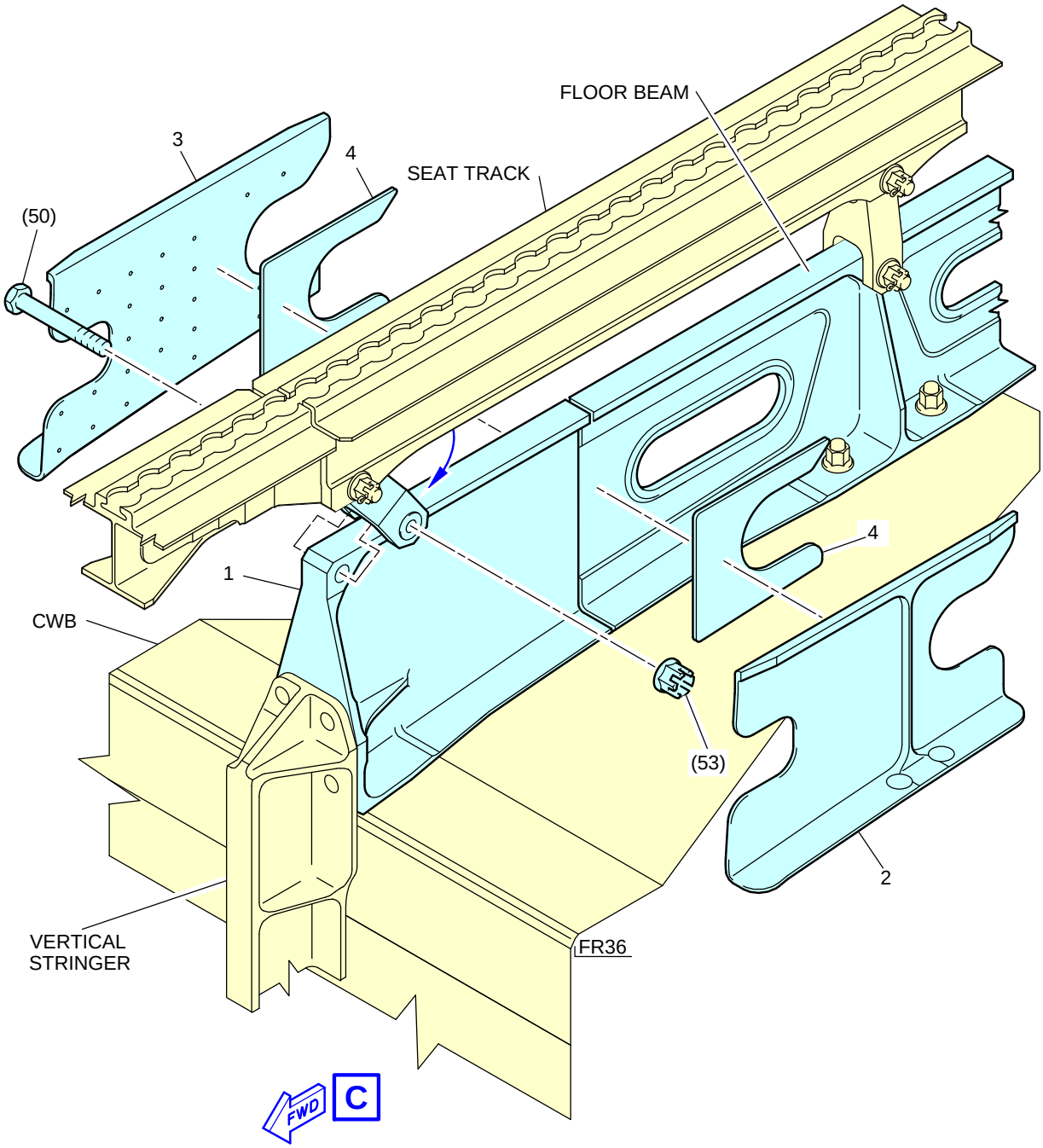


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS
SIMULTANEOUSLY, BUT INDEPENDENTLY,
IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

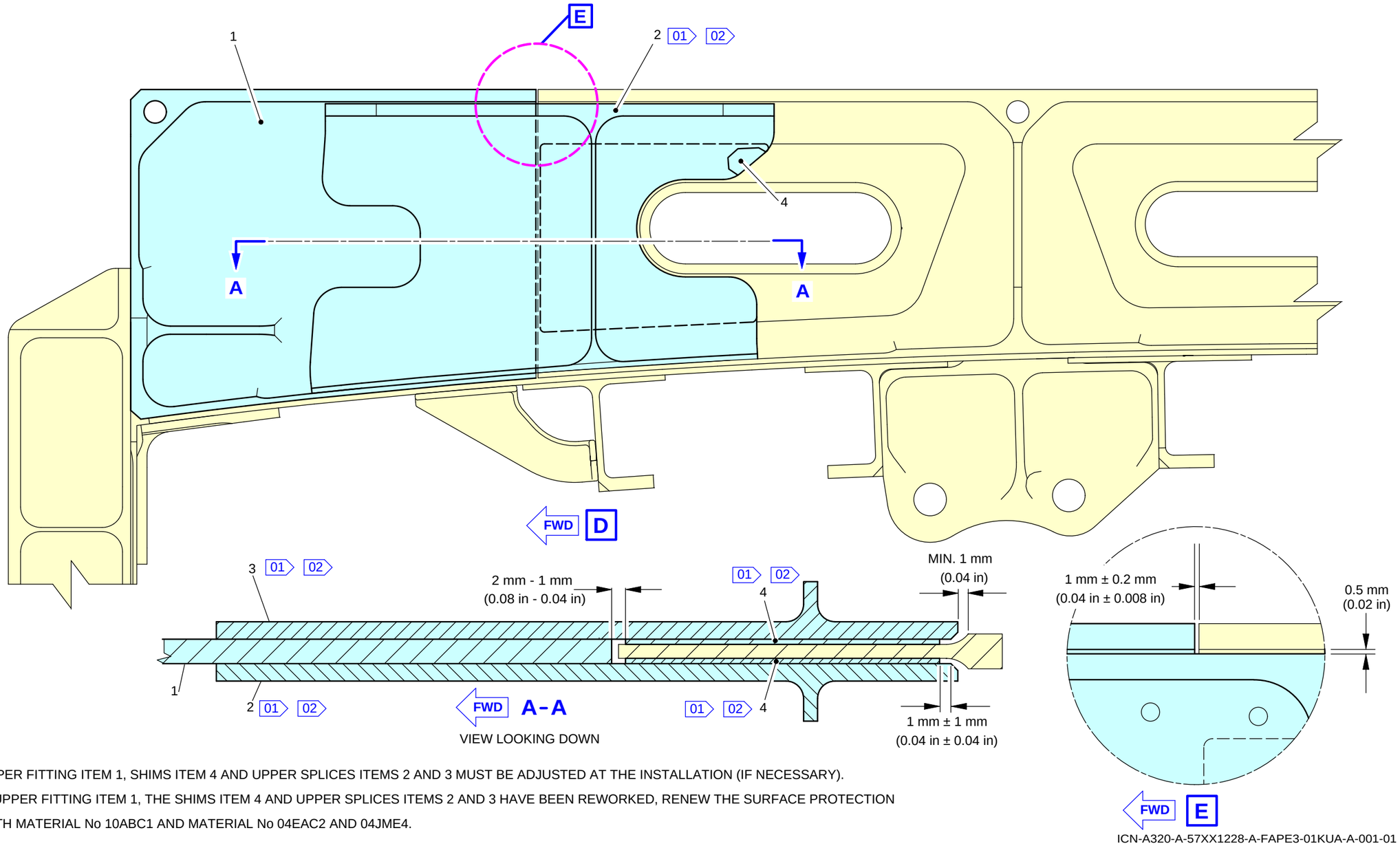
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 002

(81) Task A320-A-57-XX-1228-06002-270A-A - Temporarily, Install the New Parts for Adjustment on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	Frame 36

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	10ABC1	Surface Pretreatment - Light Alloys Chemical Conversion Yellow		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-27-11 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 Cut and/or machine metallic structures in accordance with Ref. SRM 51-27-11.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

5 Renew the protective finish in accordance with Ref. SRM 51-75-12.

6 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

(b) Temporarily, install the new parts for adjustment, refer to Ref. Fig. Temporarily Installation of the New Parts for Adjustment at FR36.

1 Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Temporarily, put in position on the CWB and against the vertical stringer:

1	FITTING	D0041005320000	Item 1	
2	SHIM	D0041005520000	Item 4	
1	SPLICE	D0041005420000	Item 2	
1	SPLICE	D0041005420200	Item 3	
1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

3 Inspect the fit of all the new parts items 1, 2, 3 and 4 .

a If all the parts items 1, 2, 3 and 4 are in the gap tolerance, this step is complete.

b If the parts items 1, 2, 3 and 4 are not in the gap tolerance:

<1> Remove the parts concerned.

<2> Machine the concerned parts to obtain the gap tolerance requested.

<3> Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

<4> Protect the cut area of the parts reworked with:

<a> Protect the surface with:

Surface Pretreatment - Light Alloys Chemical Conversion Yellow	10ABC1

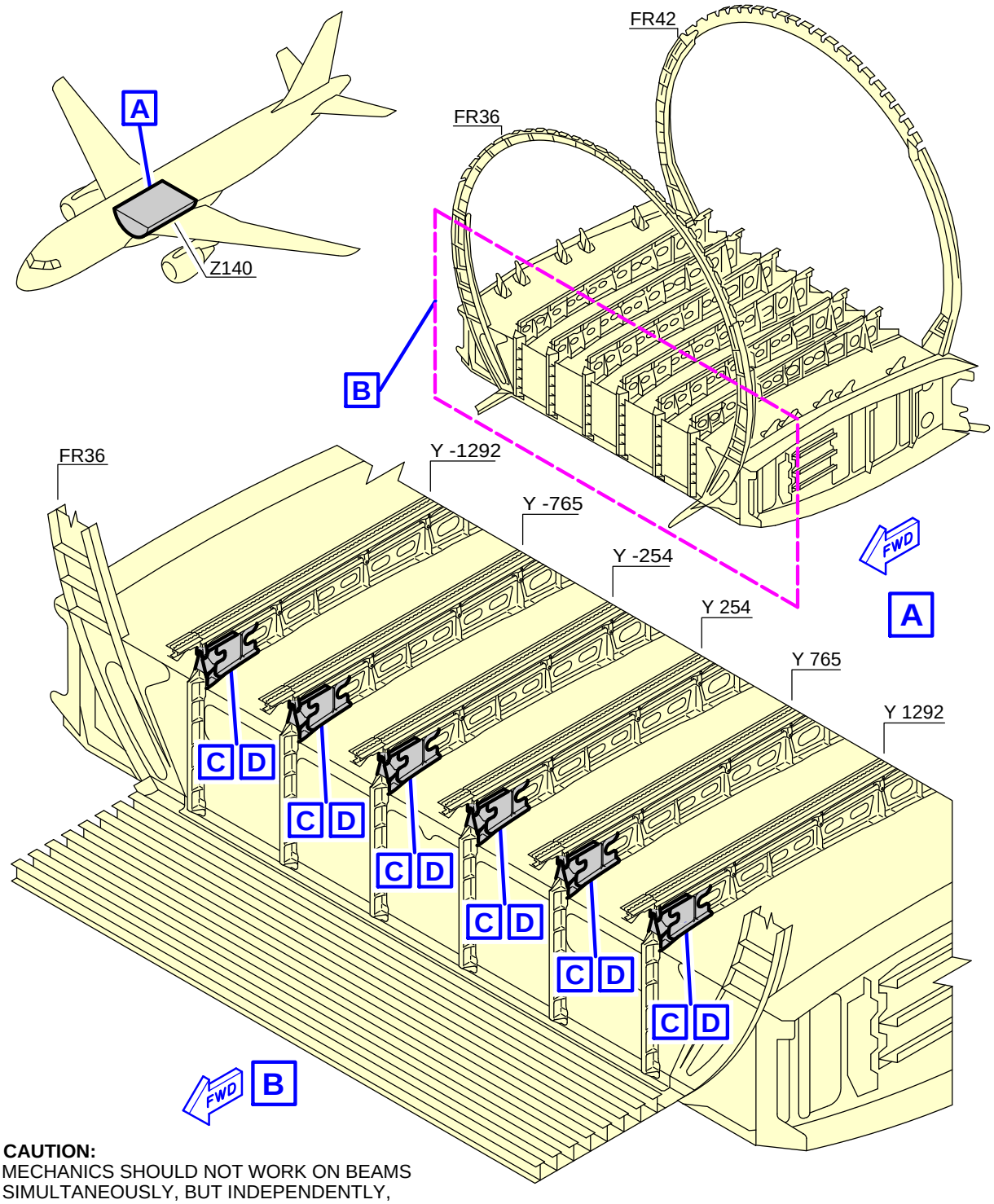
<b> Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

<5> Temporarily, re-install the parts removed.

NOTE: Make sure that the temporarily installed parts are fixed to prevent shifting.

CONF 002

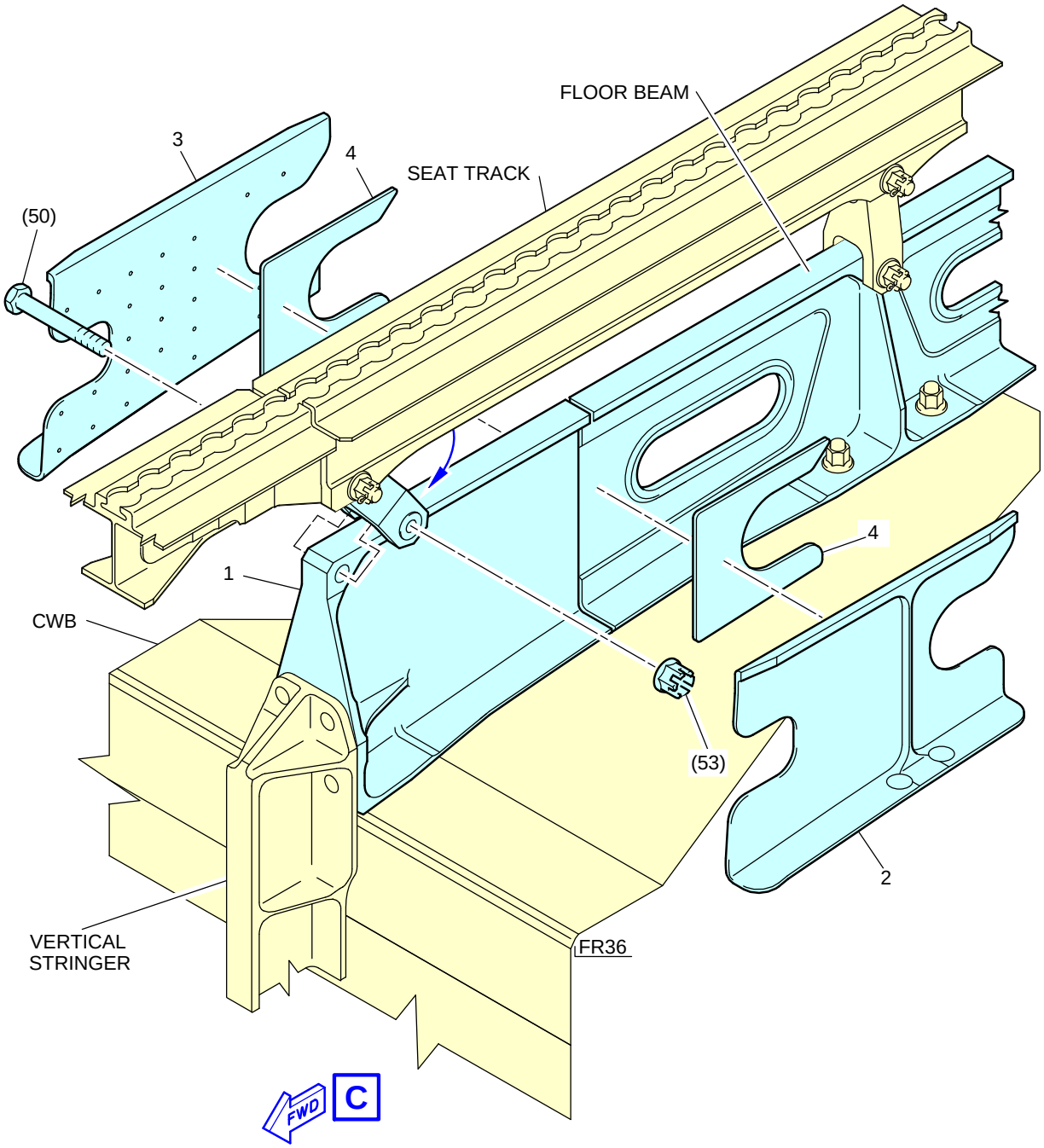


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU8-A-002-01 SHEET 1/3

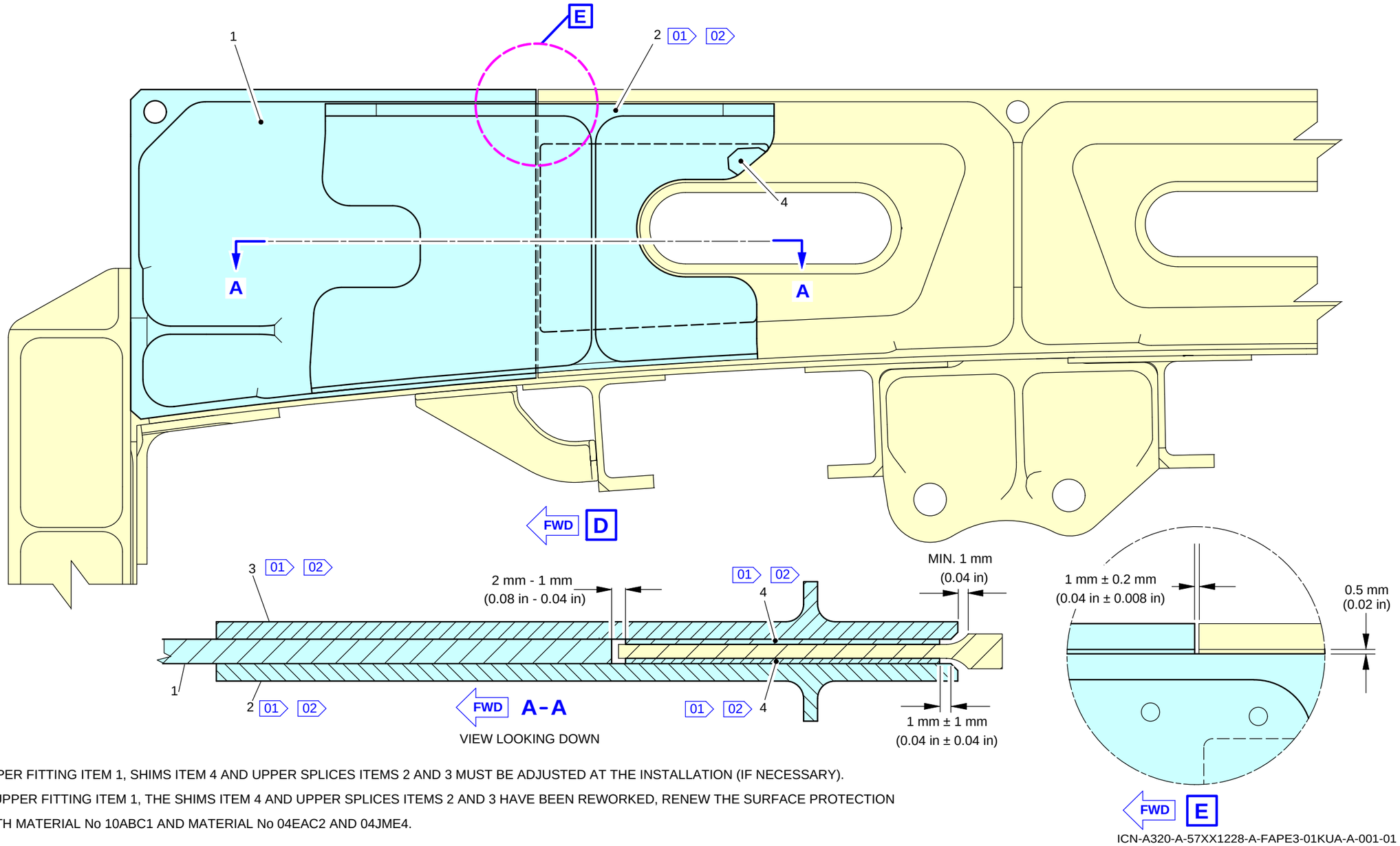
CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU9-A-001-01 SHEET 2/3

CONF 002



ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01

NOTE:

01 UPPER FITTING ITEM 1, SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 MUST BE ADJUSTED AT THE INSTALLATION (IF NECESSARY).

02 IF UPPER FITTING ITEM 1, THE SHIMS ITEM 4 AND UPPER SPLICES ITEMS 2 AND 3 HAVE BEEN REWORKED, RENEW THE SURFACE PROTECTION WITH MATERIAL No 10ABC1 AND MATERIAL No 04EAC2 AND 04JME4.

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUA-A-001-01 SHEET 3/3

Temporarily Installation of the New Parts for Adjustment at FR36

CONF 001 003 004

(82) Task A320-A-57-XX-1228-12001-900A-A - Drill the New Parts on Y-1292 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

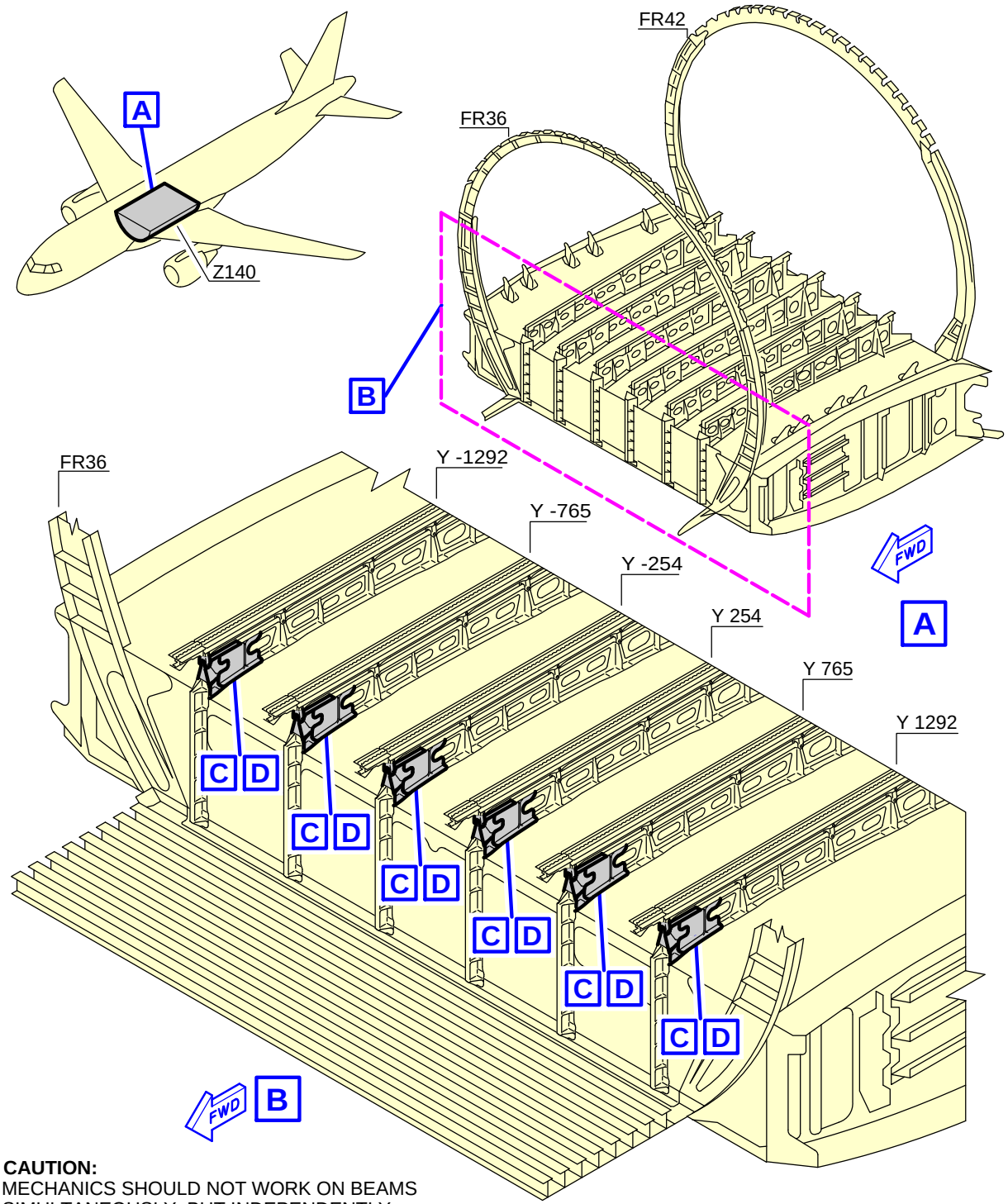
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

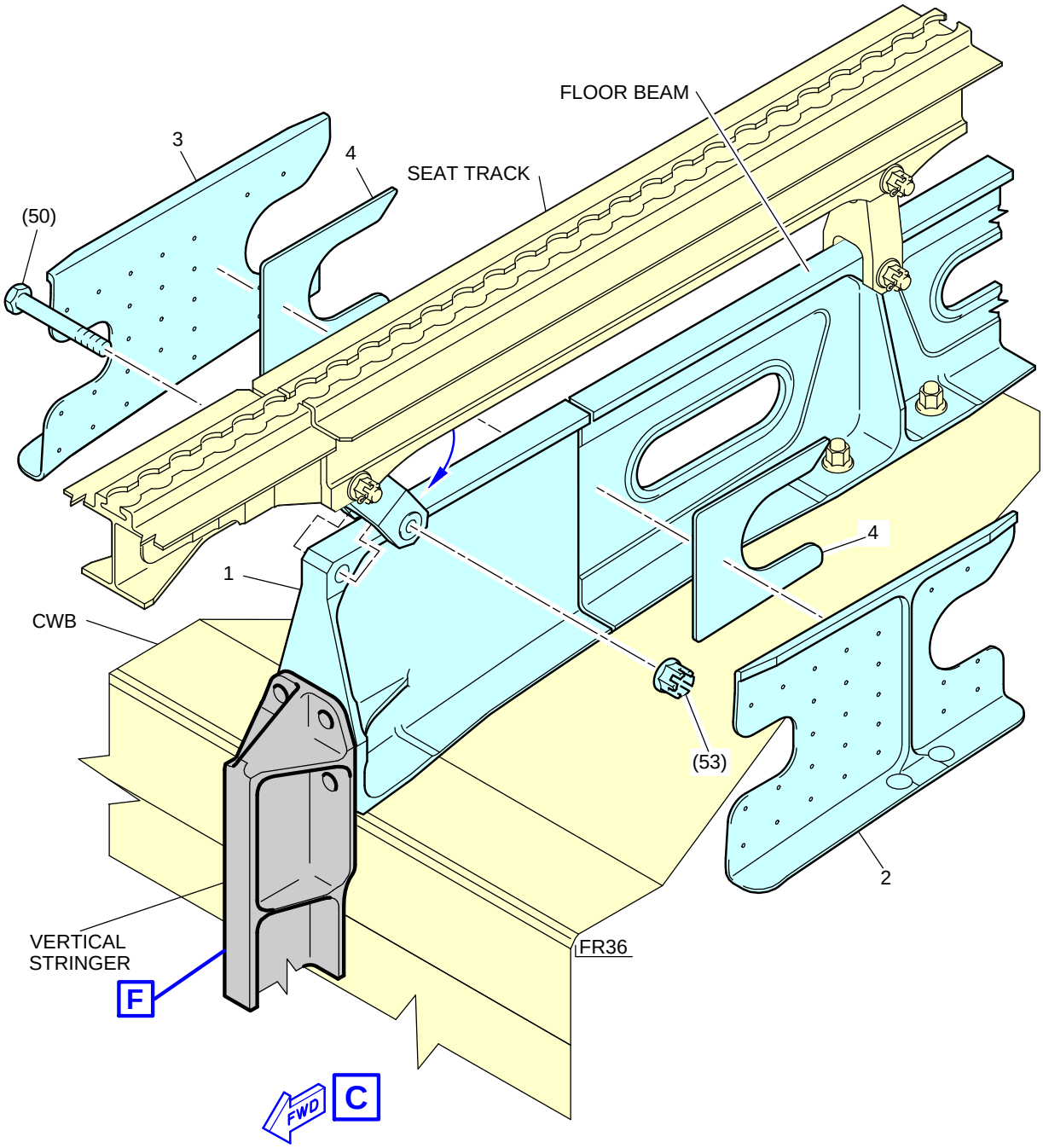


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

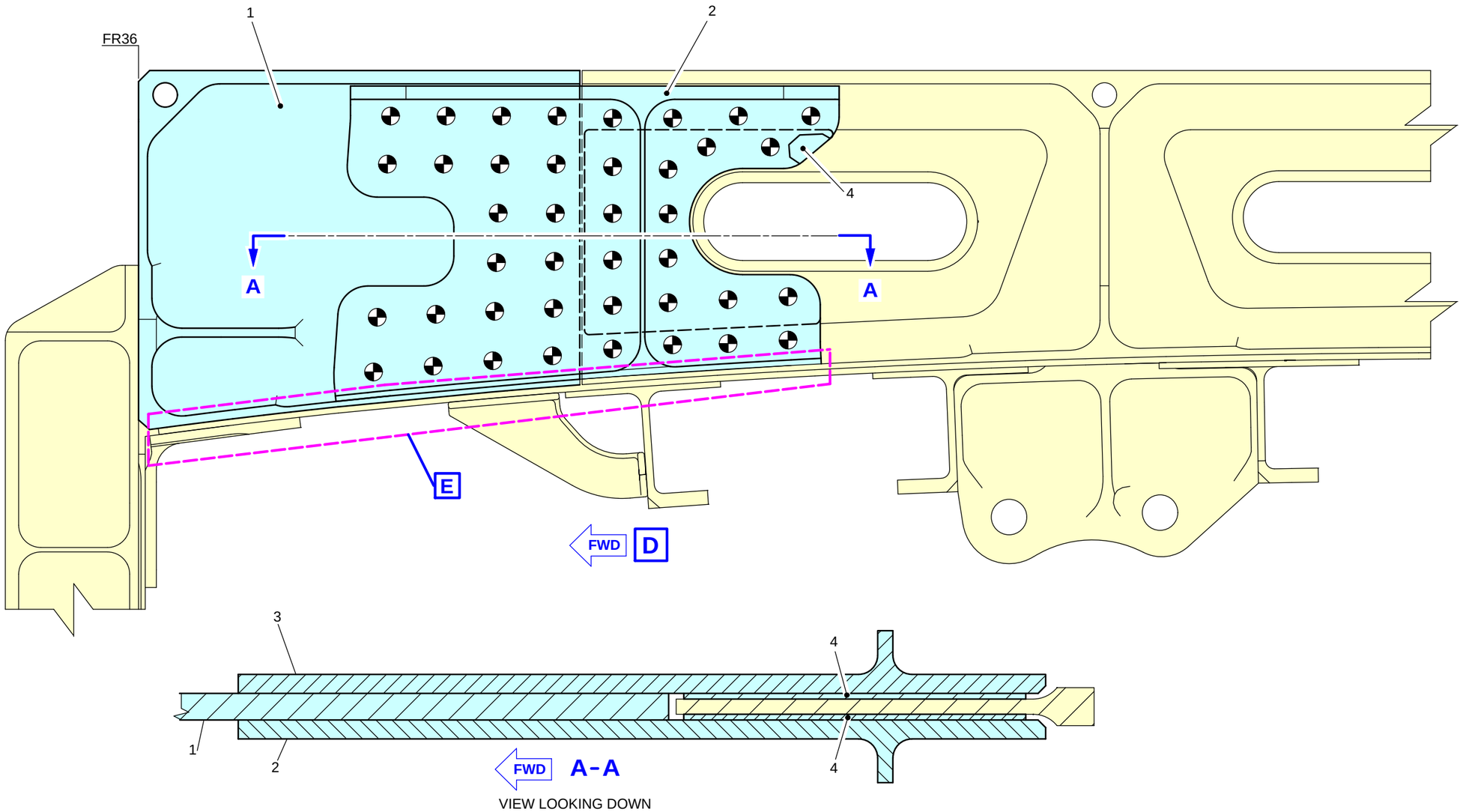
CONF 001 003 004



ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 001 003 004

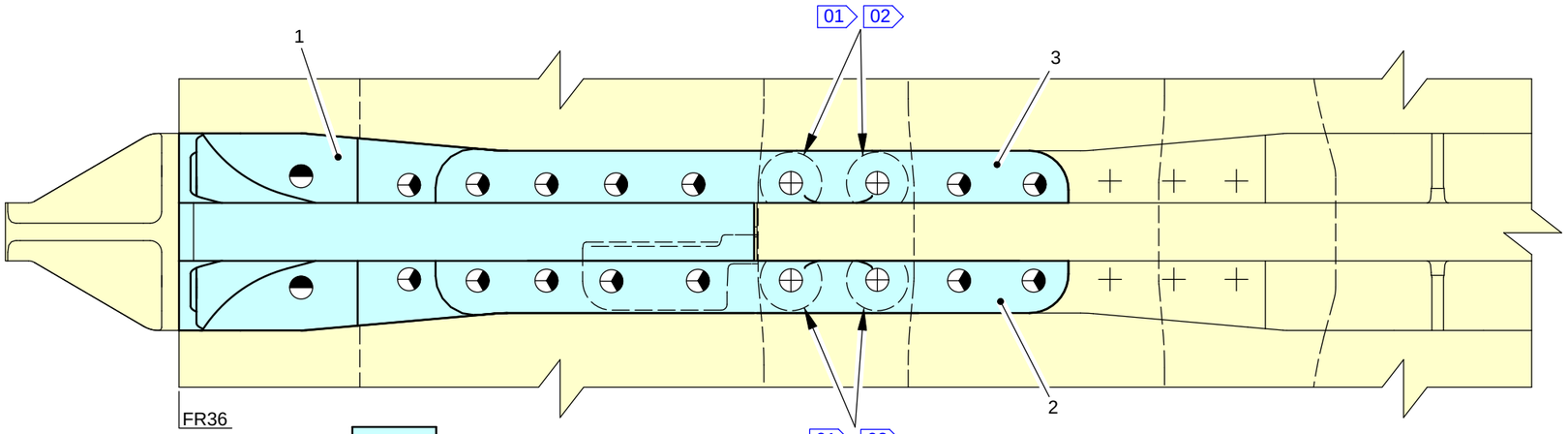


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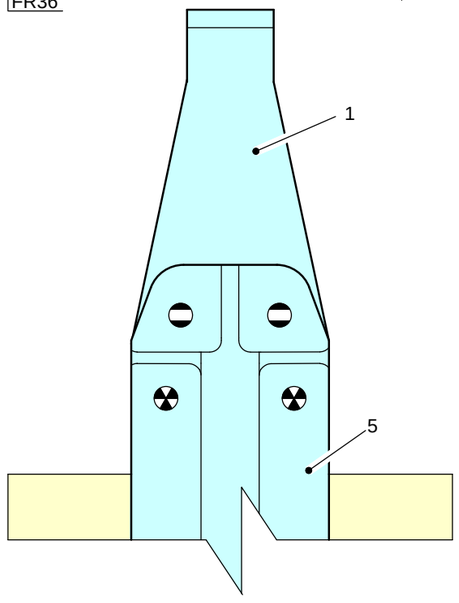
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 001 003 004



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 002

(82) Task A320-A-57-XX-1228-12002-900A-A - Drill the New Parts on Y-1292 at FR36

CAUTION: MAKE SURE THAT THE UPPER FITTING, THE UPPER SPLICES, AND THE SHIMS ARE FIXED AND DO NOT SLIP AWAY FROM THE CORRECT POSITION.

CAUTION: MAKE SURE TO CLAMP THE NEW UPPER FITTING WITH REFERENCE HOLES TO THE NEW STRINGER FOR CORRECT INSTALLATION.

CAUTION: TRANSFER THE HOLES OF THE CWB TO THE UPPER FITTING BY USING A DRILL BUSHING.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	7.50 h
Minimum Number of person	2
Elapsed Time	4.25 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-44-00 51-46-12 51-47-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

6 Get fastener spacing and margin data in accordance with Ref. SRM 51-47-00.

7 Get spot facing data in accordance with Ref. SRM 51-46-12.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

9 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Drill the new parts, refer to Ref. Fig. Drilling of the New Parts at FR36.

1 Drill 4 holes in the upper fitting item 1 to align with the holes of the vertical stringer item 5.

2 Drill the holes with a drill bush in the upper fitting item 1 to align with the holes of the CWB.

NOTE: Install a screw pin in every 4th hole after drilling to prevent a shifting of the upper splices items 2 and 3 and the shims item 4 during the drilling process.

3 Drill the holes in the FWD end floor beam, the upper fitting item 1, the shims item 4 and the upper splice item 2 to align with the holes of the upper splice item 3.

4 Drill all the holes to the final diameter.

5 Do the spot facing as necessary on the upper splices items 2 and 3 to ensure a good seating of the fasteners.

6 Remove and retain all the parts items 1, 2, 3, 4, (50) and (53) from the CWB.

7 Deburr all drilled holes.

8 Clean the work area and the surfaces of the items 1, 2, 3, 4 and 5 with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

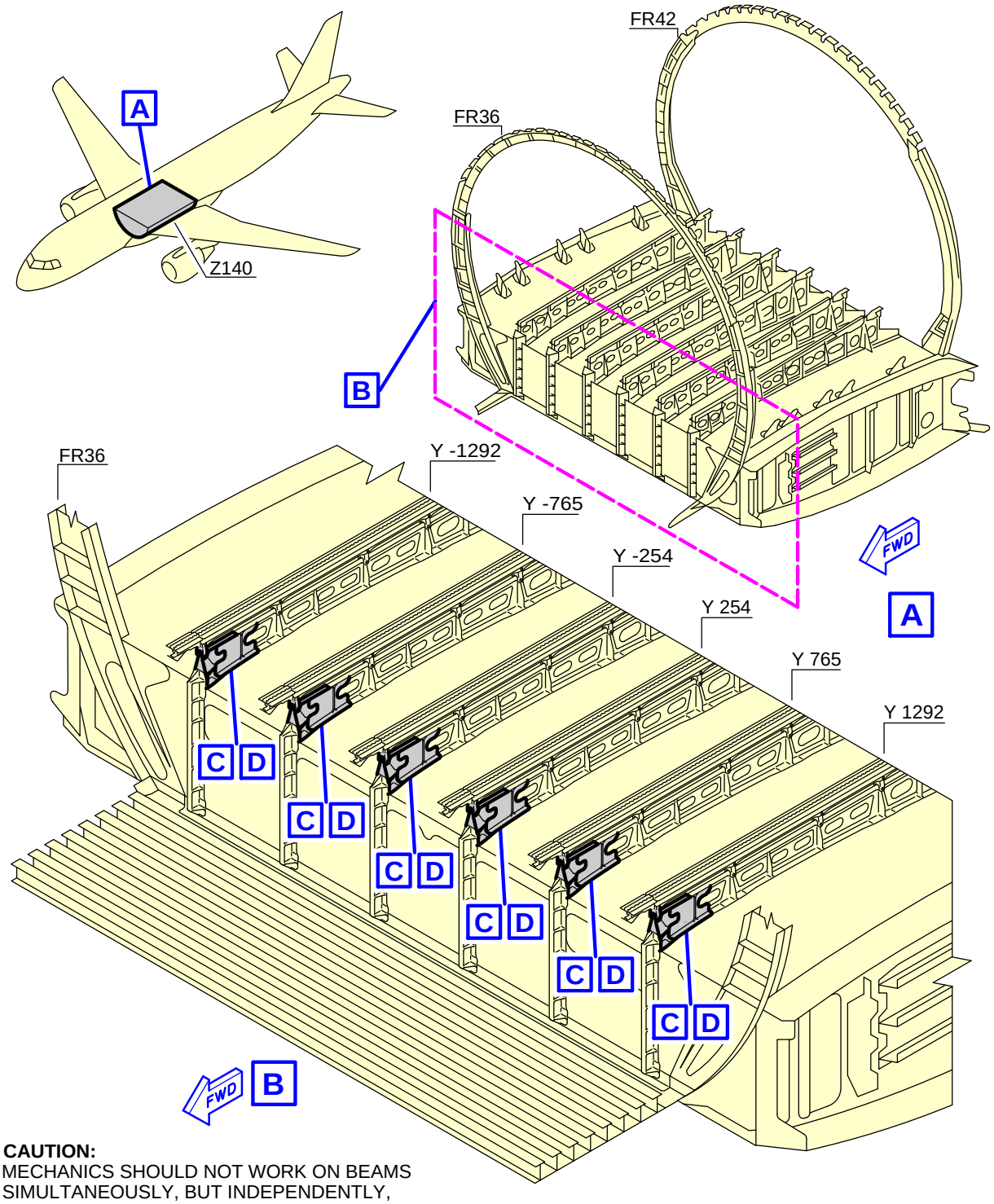
9 Protect the surface of the spot facing with :

Wash Primer - - - Structure	04CMA2

and renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 002

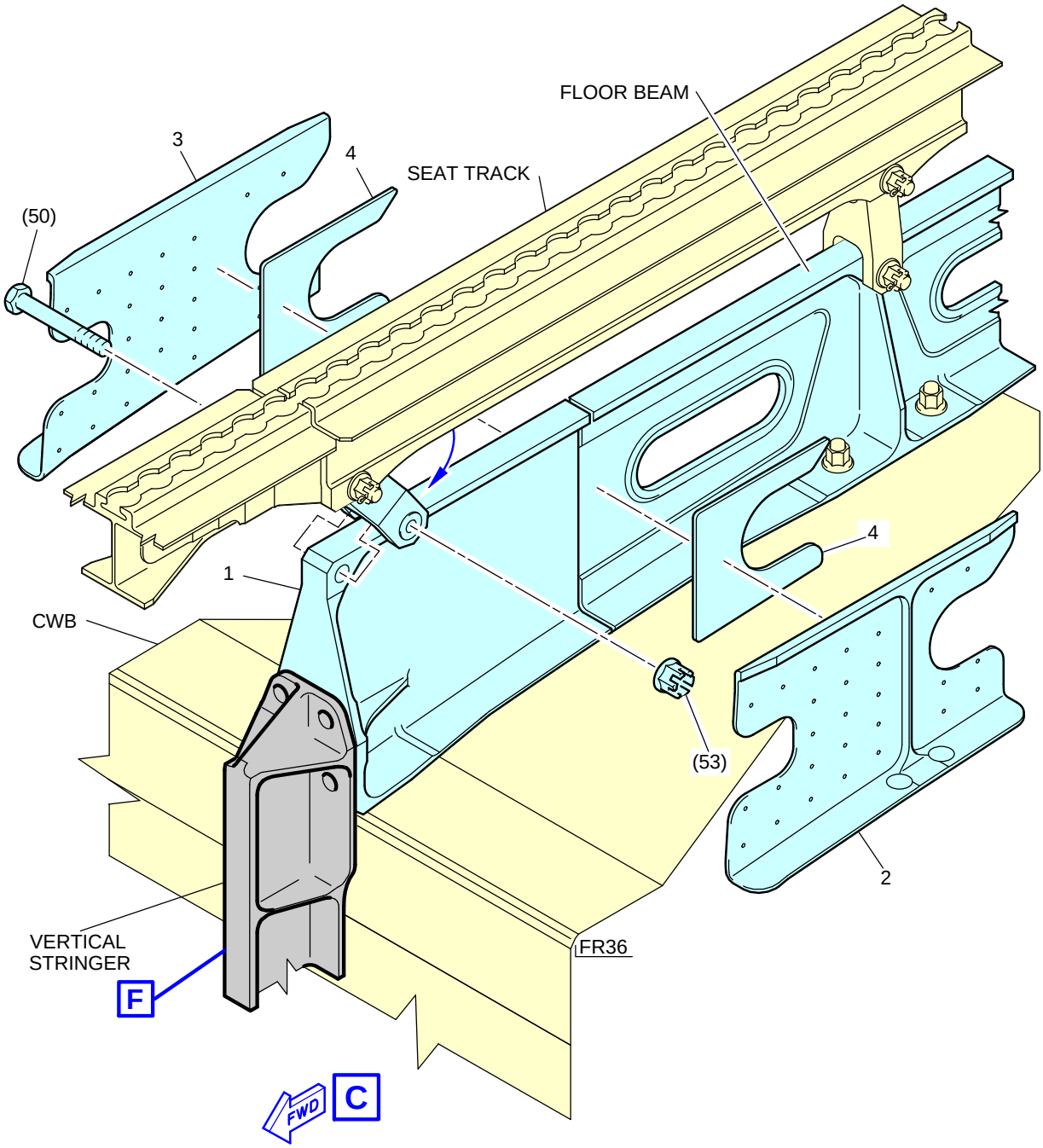


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTQ-A-002-01 SHEET 1/4

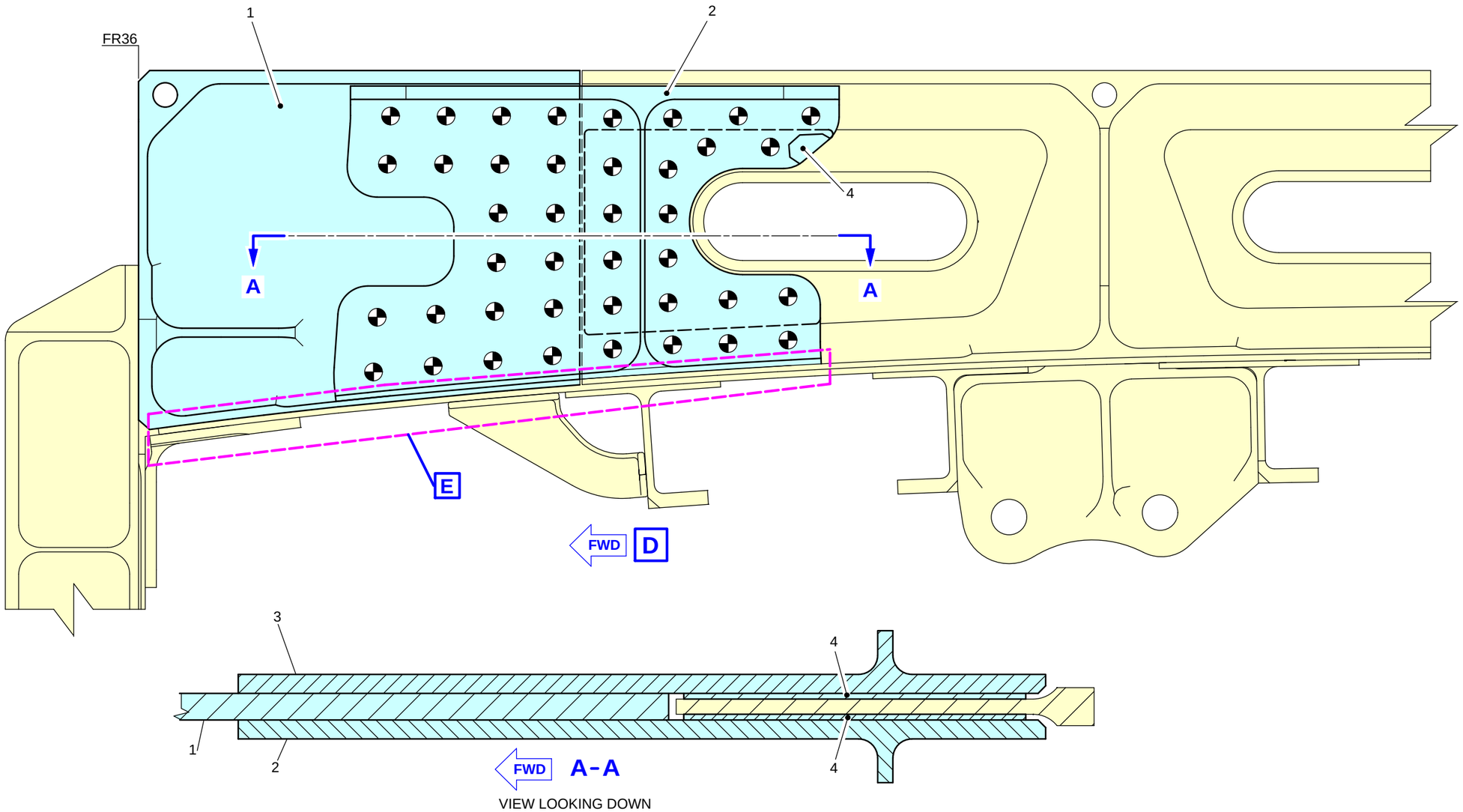
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ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTR-A-001-01 SHEET 2/4

CONF 002

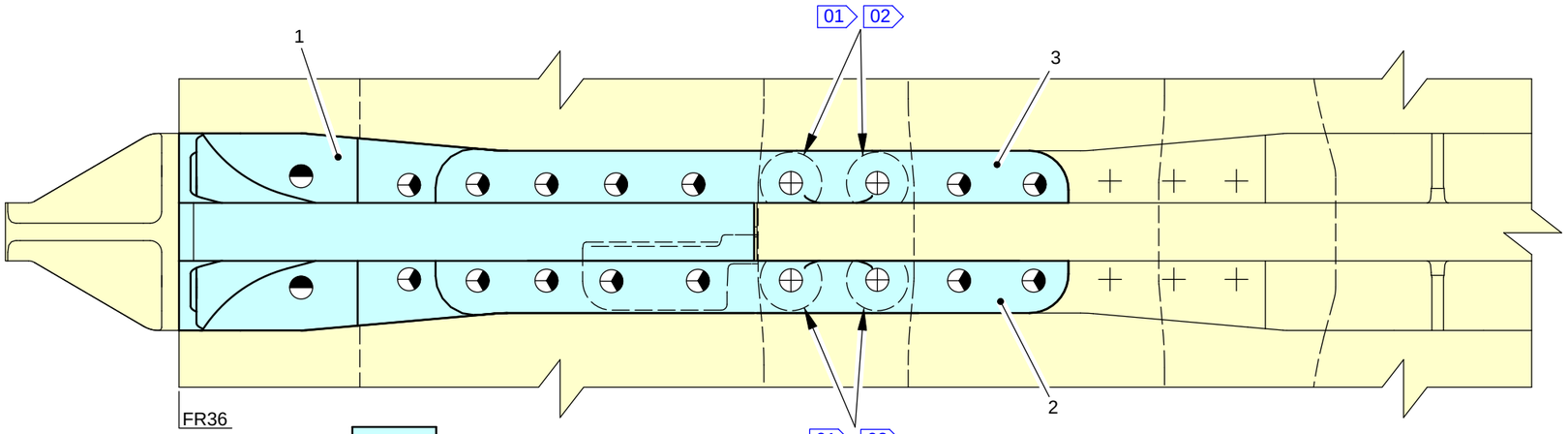


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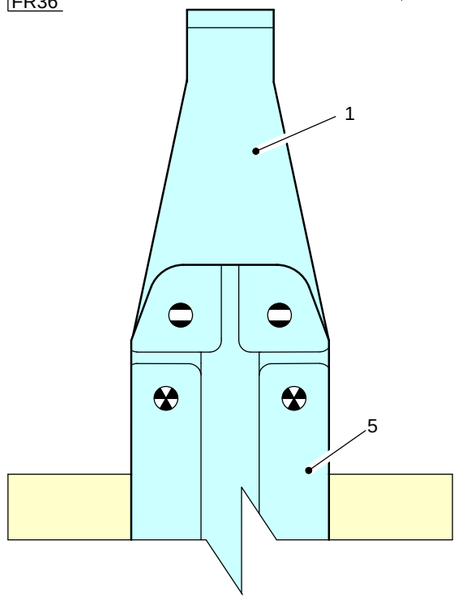
Figure ICN-A320-A-57XX1228-A-FAPE3-01KTS-A-001-01 SHEET 3/4

Drilling of the New Parts at FR36

CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT

HOLE SYMBOL	FINAL HOLE DIAMETER		SIZE / FIT TYPE
	MIN	MAX	
⊖	6.222 mm (0.2450 in)	6.262 mm (0.2465 in)	NOMINAL SIZE HIGH INTERFERENCE FIT
☢	7.900 mm (0.3111 in)	7.940 mm (0.3125 in)	NOMINAL SIZE TRANSITION FIT
◔	4.780 mm (0.1882 in)	4.820 mm (0.1897 in)	NOMINAL SIZE TRANSITION FIT
◓	8.296 mm (0.3267 in)	8.336 mm (0.3281 in)	FIRST OVERSIZE TRANSITION FIT
◕	5.113 mm (0.2013 in)	5.153 mm (0.2028 in)	FIRST OVERSIZE TRANSITION FIT
⊕	6.707 mm (0.2641 in)	6.747 mm (0.2656 in)	FIRST OVERSIZE TRANSITION FIT

NOTE:

01 DO 17 mm (0.6693 in) DIAMETER, 2 mm (0.0787 in) RADIUS WITH SPOT FACE TOOL (TO ENSURE A GOOD SEATING OF THE FASTENER).

02 PROTECT THE SURFACE OF THE SPOT FACING WITH MATERIAL No 04CMA2 AND APPLY MATERIAL No 04EAC2 AND 04JME4.

ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KTT-A-003-01 SHEET 4/4

Drilling of the New Parts at FR36

CONF 001 003 004

(83) Task A320-A-57-XX-1228-29001-720A-A - Install the New Parts on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A01R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A01R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
19	EN6115V3X4	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
24	EN6115V4X7	4	BOLT		
26	EN6115V5-7	2	BOLT		
27	EN6115V5X8	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT	EN6115V5X8	Item 27
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X4	Item 19
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X7	Item 24
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

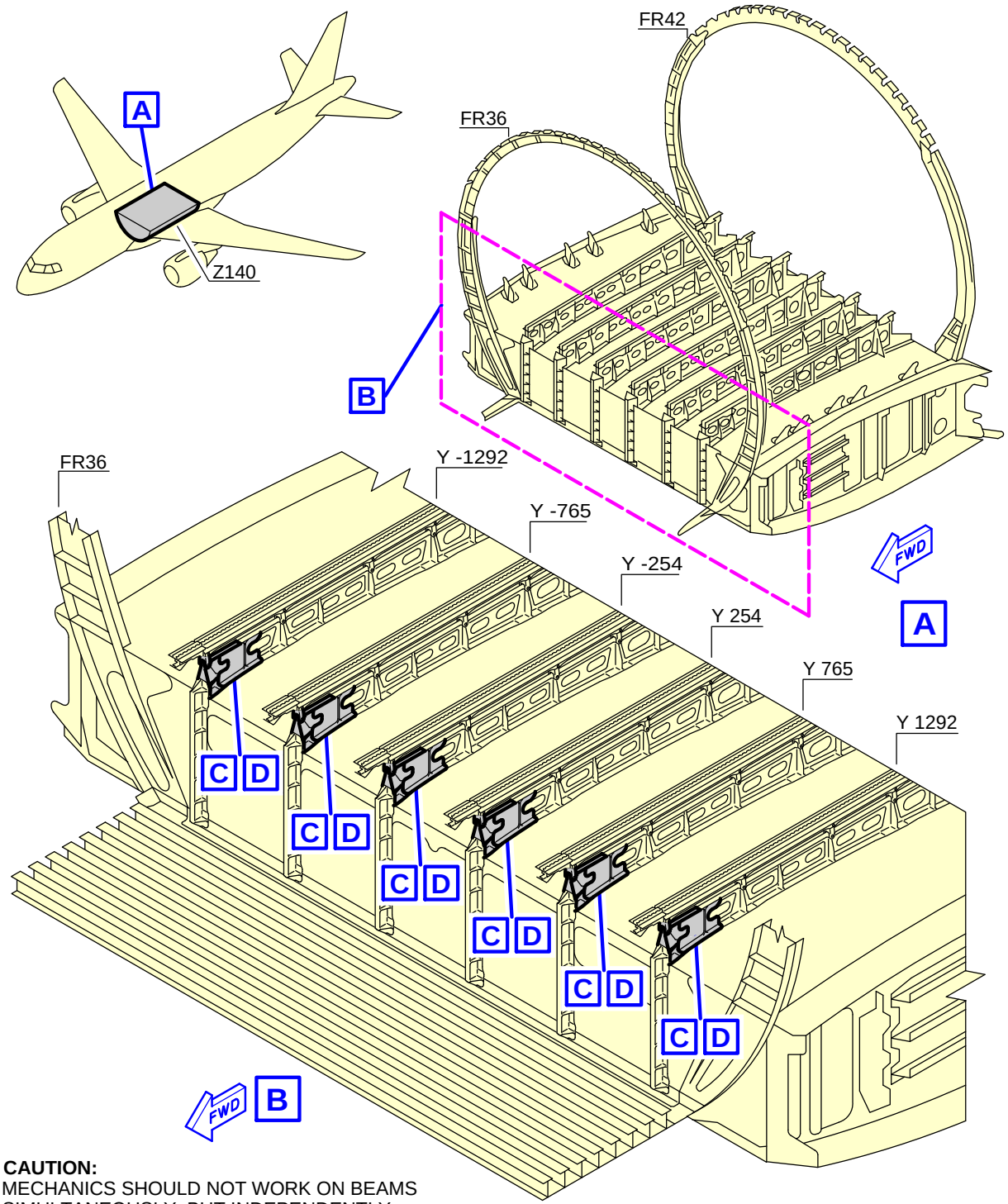
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF 001 003 004

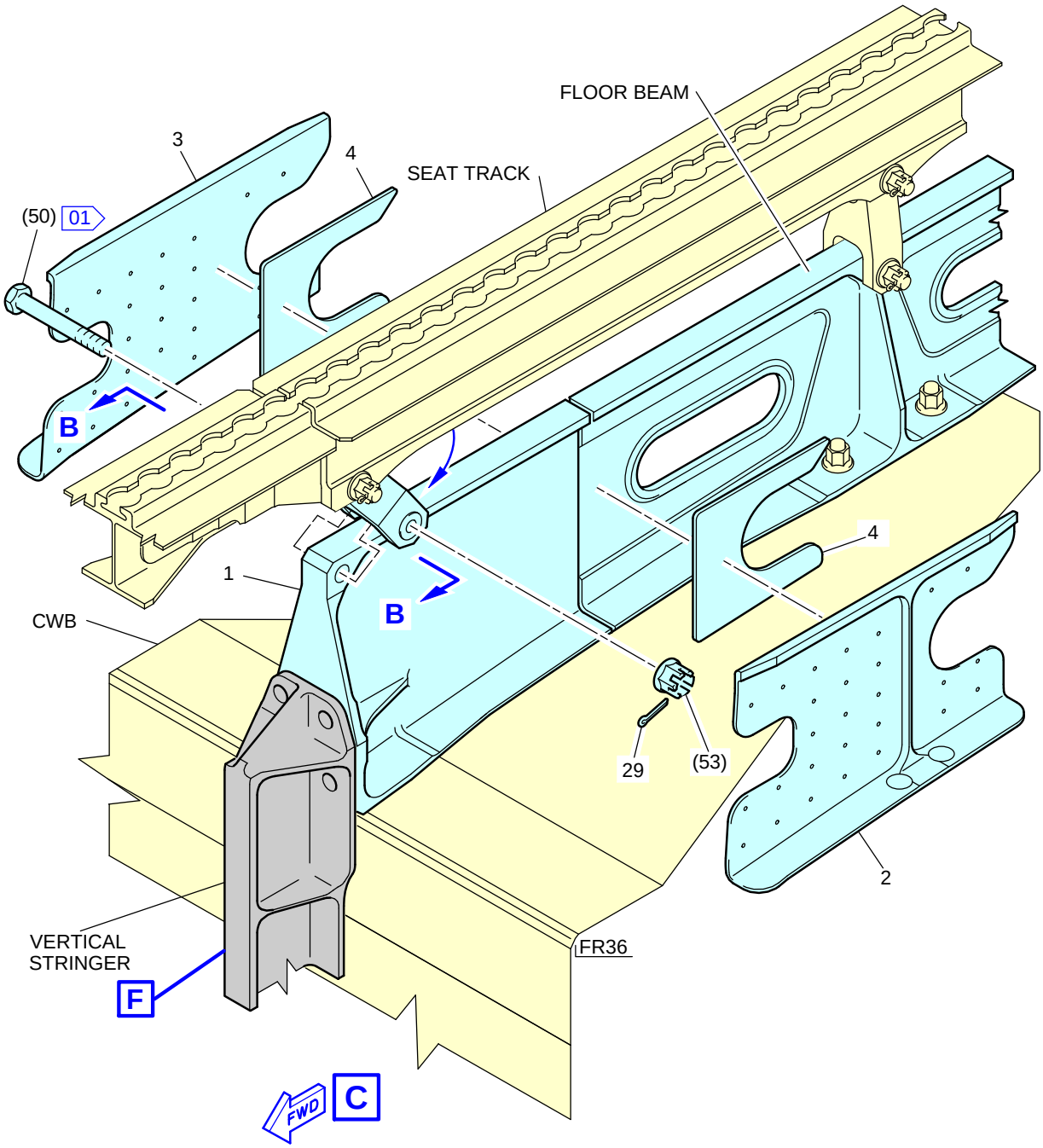


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSQ-A-002-01 SHEET 1/4

CONF 001 003 004



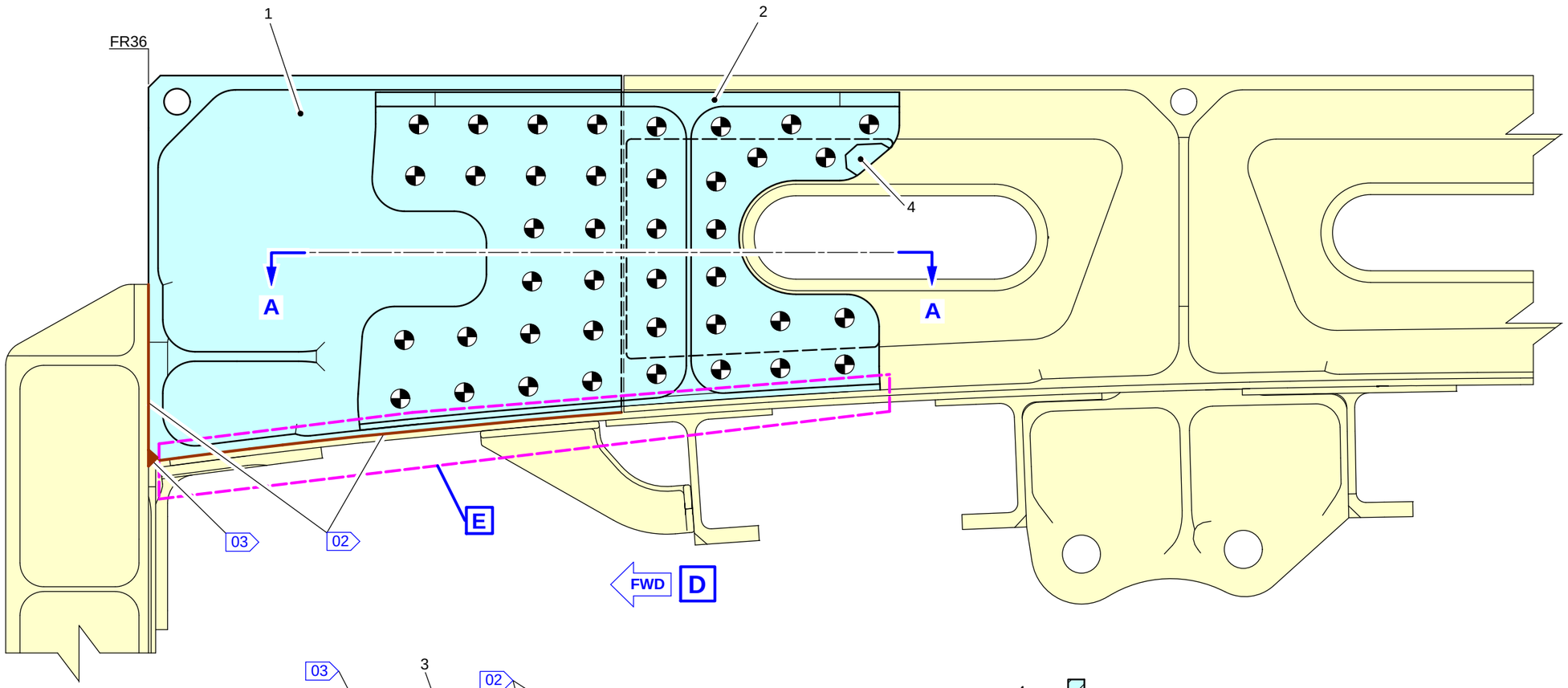
NOTE:

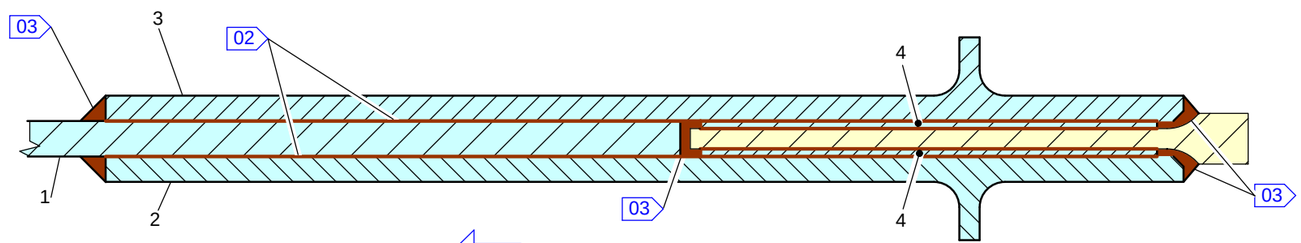
01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSR-A-001-01 SHEET 2/4

CONF 001 003 004





VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

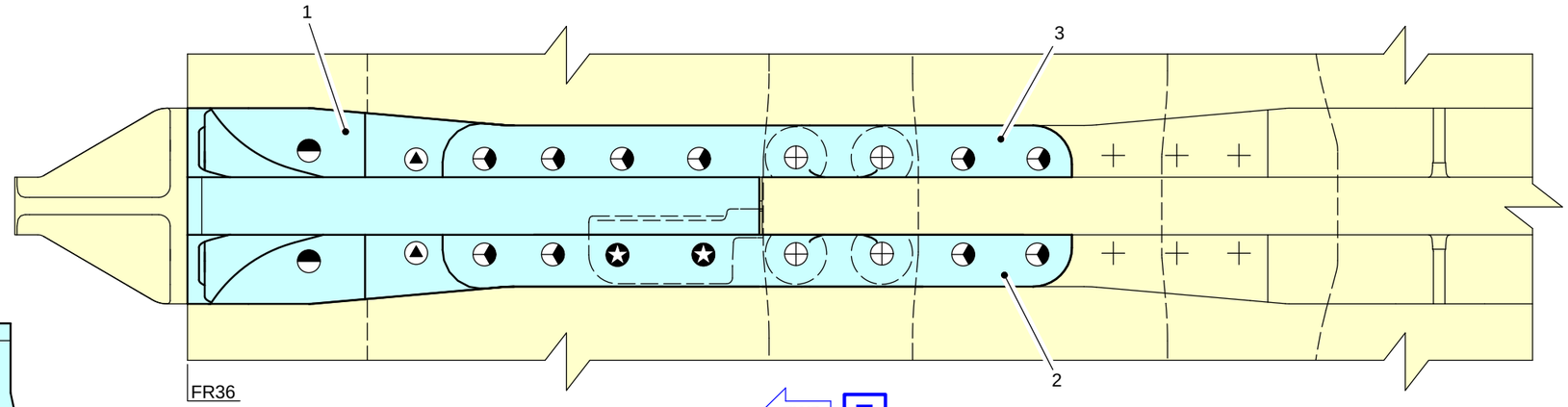
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KSS-A-001-01 SHEET 3/4

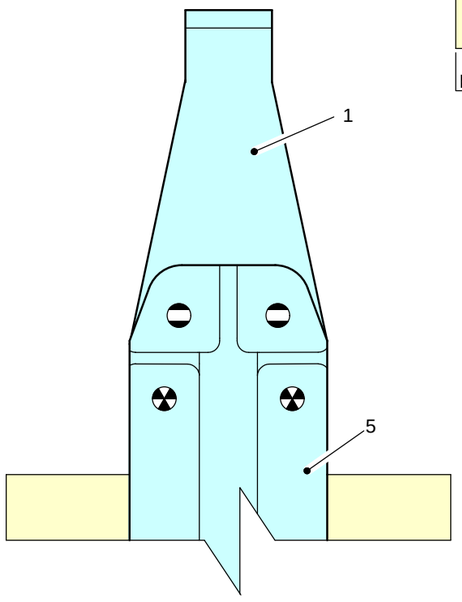
Installation of the New Parts at FR36

CONF 001 003 004



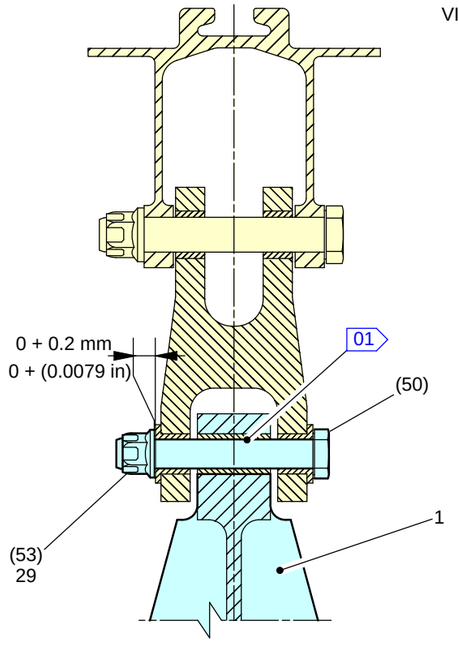


VIEW LOOKING DOWN



F

VIEW LOOKING AFT



B–B

VIEW LOOKING FORWARD

NOTE:

- ┼ FASTENER NOT AFFECTED
- ┼N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE:
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	27	EN6115V5X8	BOLT	04
	15	ASNA2536-5	NUT	
N	19	EN6115V3X4	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	24	EN6115V4X7	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

ICN-A320-A-57XX1228-A-FAPE3-01KST-A-001-01

CONF 002

(83) Task A320-A-57-XX-1228-29002-720A-A - Install the New Parts on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
140	Access	Panel 147AZ, Panel 148AZ
	Work location	Frame 36
240		

Manpower/Resources/Skills

Man-hours	4.25 h
Minimum Number of person	2
Elapsed Time	2.75 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06ABC1	Polysulfide Sealant - Fuel Tank Interfay		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	06AEB2	Polysulfide Sealant - Low Adhesion Fillet Structure		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A02R00

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
1	D0041005320000	1	FITTING		
2	D0041005420000	1	SPLICE		
3	D0041005420200	1	SPLICE		
4	D0041005520000	2	SHIM		
10	ASNA2528-3	14	NUT		
12	ASNA2529-3	40	NUT		
14	ASNA2536-4	6	NUT		
15	ASNA2536-5	4	NUT		
16	EN6115K4-8	2	BOLT		
18	EN6115V3-6	40	BOLT		

Part kit 571228A02R00					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
20	EN6115V3X5	2	BOLT		
21	EN6115V3X6	10	BOLT		
22	EN6115V3X8	2	BOLT		
25	EN6115V4X8	4	BOLT		
26	EN6115V5-7	2	BOLT		
28	EN6115V5X9	2	BOLT		
29	MS24665-136	1	PIN		
	ASNA2050DCJ3215	10	RIVET		
	ASNA2050DXJ4020	10	RIVET		

Referenced Information

Manuals/Drawings	References/Sheets
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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Get fastener hole diameters and drill data in accordance with Ref. SRM 51-44-00.

8 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

9 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

10 Renew the protective finish in accordance with Ref. SRM 51-75-12.

11 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

12 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with Ref. SRM 51-40-00 ‘Mating Part’ column.

13 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.

(b) Install the new parts, refer to Ref. Fig. Installation of the New Parts at FR36.

1 Install:

1	FITTING	D0041005320000	Item 1
2	SHIM	D0041005520000	Item 4
1	SPLICE	D0041005420000	Item 2
1	SPLICE with:	D0041005420200	Item 3
	Polysulfide Sealant - Fuel Tank Interfay to the mating surface of all the parts.	06ABC1	

2 Wet install the link attachment:

1	AXLE		Item (50)	Retained
1	NUT		Item (53)	Retained
1	PIN-COTTER with:	MS24665-136	Item 29	
	Polysulfide Sealant - Low Adhesion Fillet Structure	06AEB2		

3 Wet install the fasteners:

2	BOLT,PRTD	EN6115V5X9	Item 28
4	NUT	ASNA2536-5	Item 15
2	BOLT	EN6115V3X5	Item 20
14	NUT	ASNA2528-3	Item 10
10	BOLT	EN6115V3X6	Item 21
2	BOLT	EN6115V3X8	Item 22
4	BOLT	EN6115V4X8	Item 25
6	NUT	ASNA2536-4	Item 14
2	BOLT	EN6115K4-8	Item 16
2	BOLT	EN6115V5-7	Item 26
40	BOLT	EN6115V3-6	Item 18

40	NUT with:	ASNA2529-3	Item 12
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1	

4 Clean the work area with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

5 Fill all the cavities and do the seal bead with:

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

(c) If removed, install the secondary structure brackets on the new upper fitting (secondary structure brackets removed from the old FWD end floor beam).

1 Temporarily, put the brackets in position in accordance with the dimensions recorded during the removal.

2 Drill holes in the new upper fitting to align with the holes of the brackets.

3 Remove the brackets.

4 Deburr the parts.

5 Clean the surface with:

Textile - Lint free Cotton and	14SBA1
Non Aqueous Cleaner - General	08BAA9

6 Install the brackets with:

Polysulfide Sealant - Fuel Tank Interfay	06ABC1

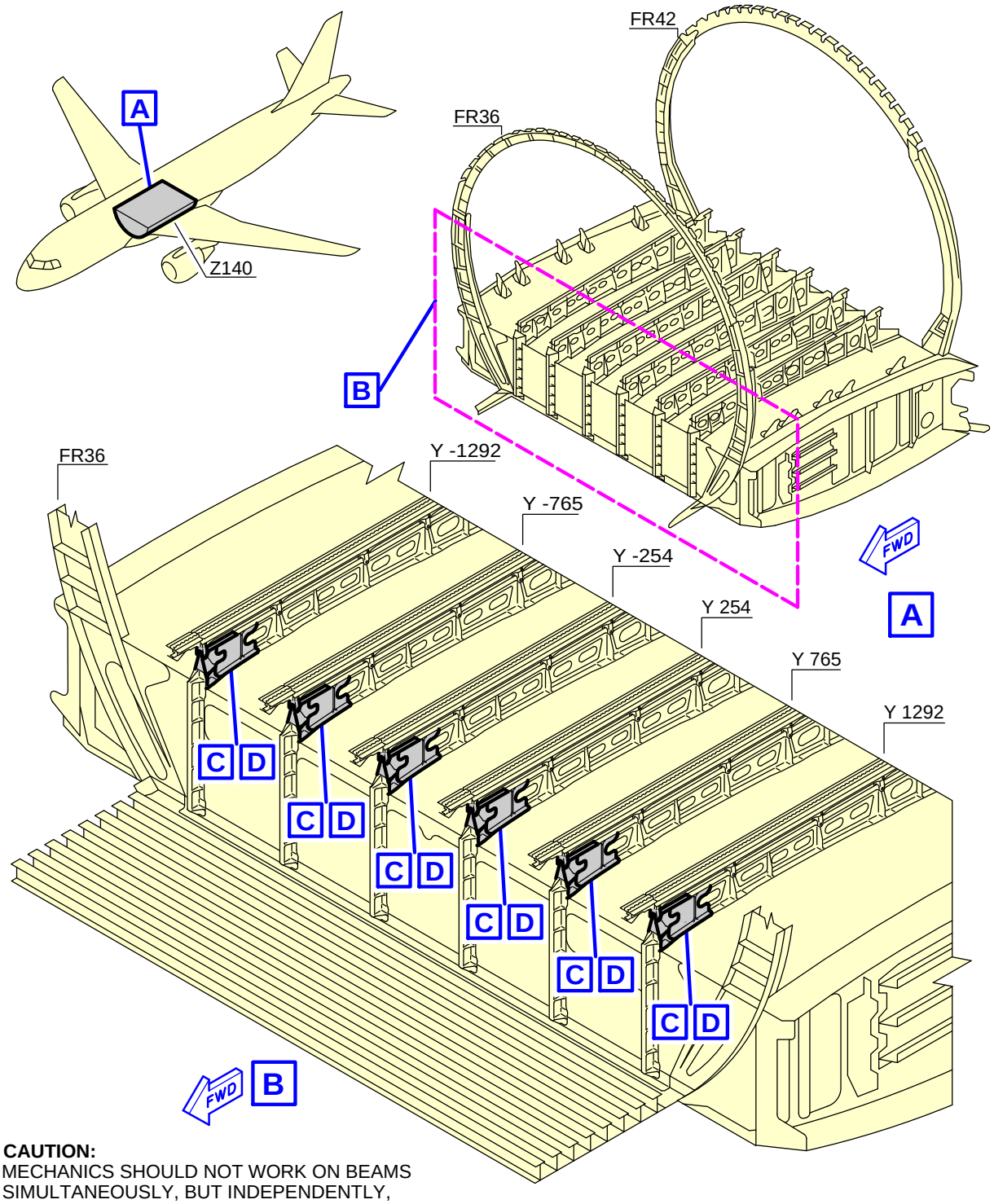
7 Wet install the fasteners:

10	RIVET or/and	ASNA2050DCJ3215
10	RIVET with:	ASNA2050DXJ4020
	Polysulfide Sealant - Fuel Tank Interfay	06ABC1

8 Renew the protective finish with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

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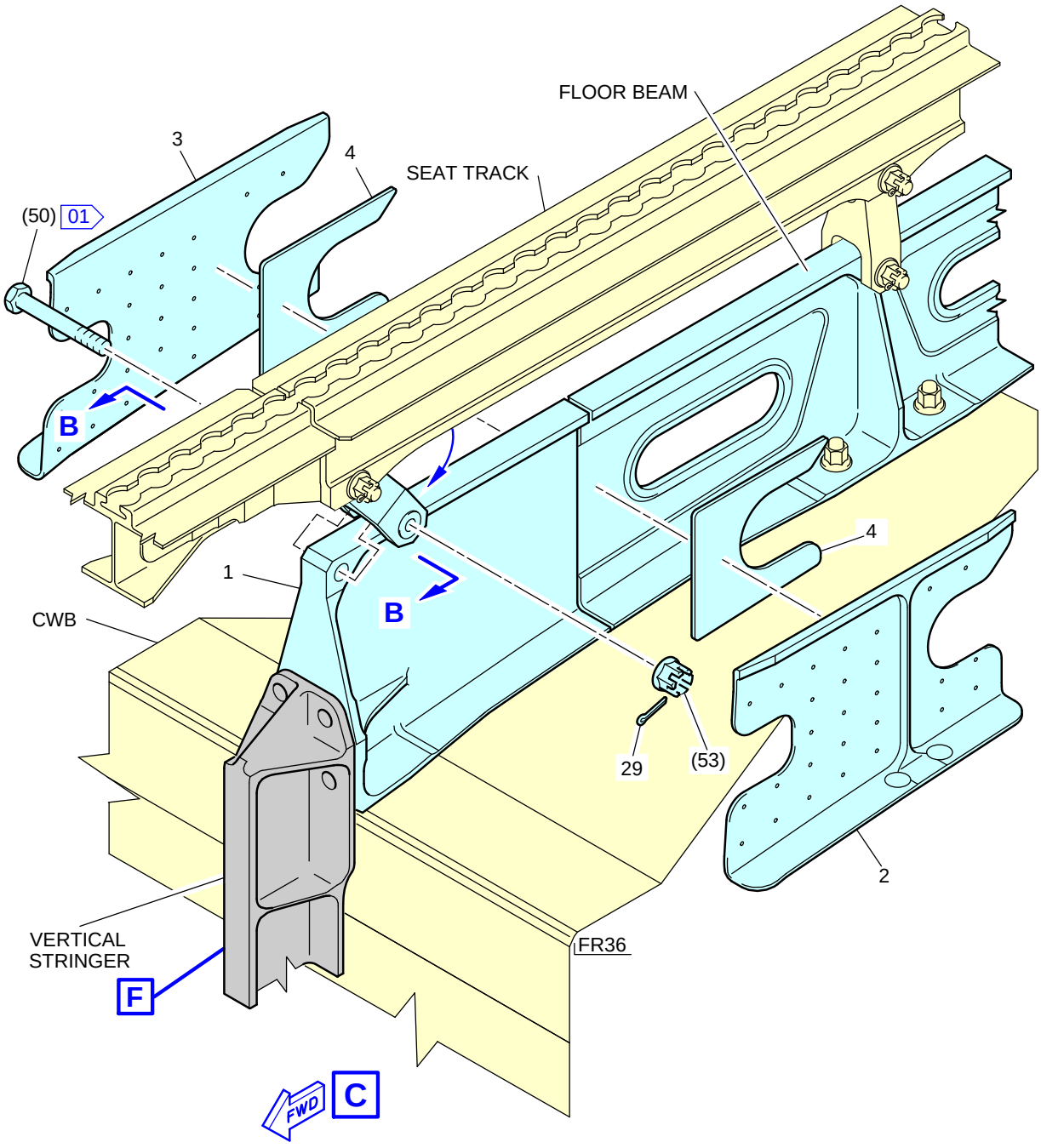


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUB-A-002-01 SHEET 1/4

CONF 002



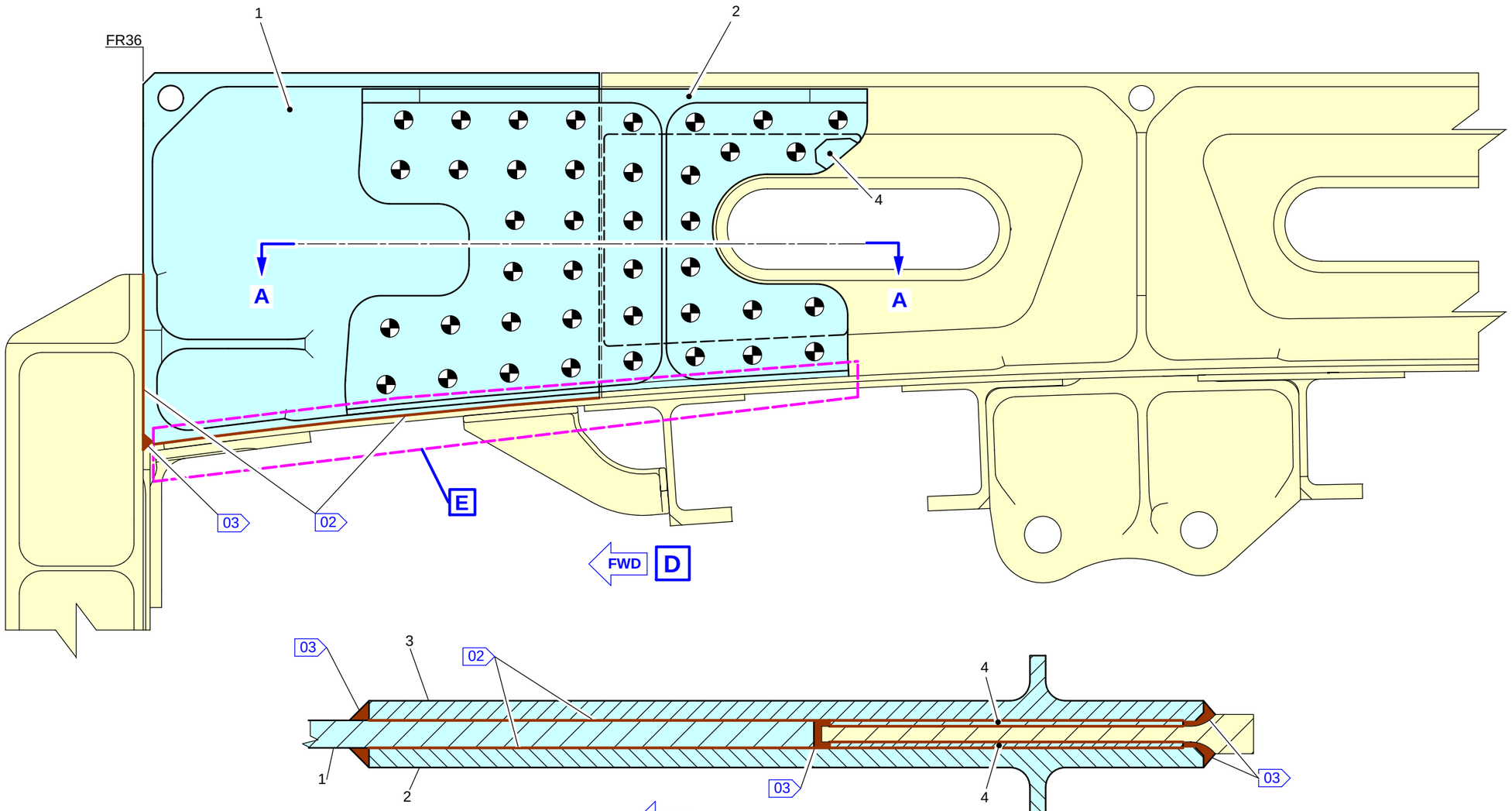
NOTE:

01 APPLY MATERIAL No 06AEB2.

ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUC-A-001-01 SHEET 2/4

CONF 002



VIEW LOOKING DOWN

NOTE:
FOR THE AFFECTED FASTENERS, REFER TO SHEET 4.

02 APPLY MATERIAL No 06ABC1 TO THE MATING SURFACE OF ALL THE PARTS.

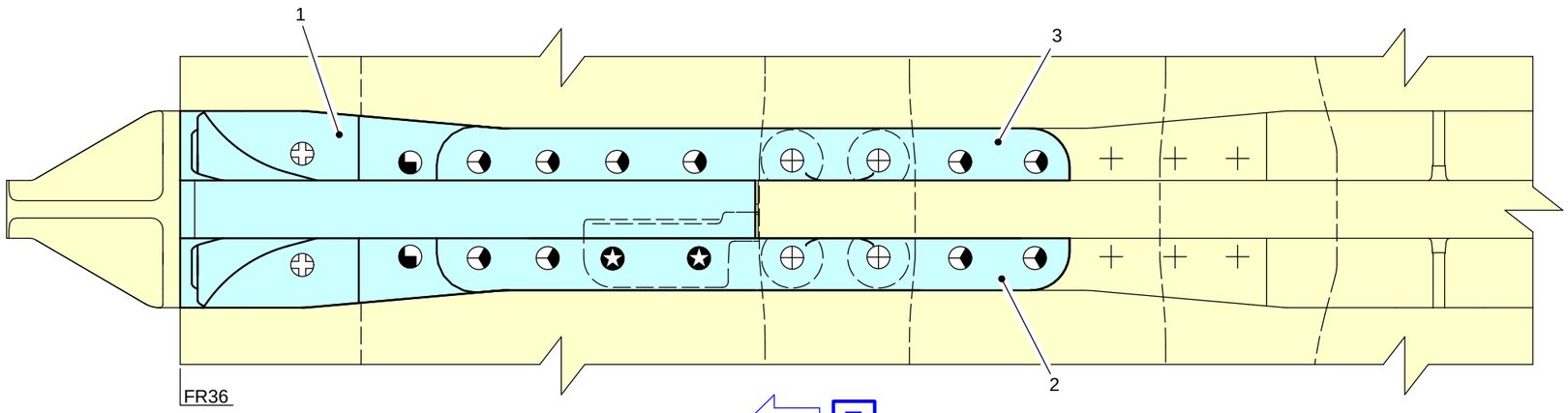
03 APPLY MATERIAL No 06ACB1 (SEAL BEAD AND FILLING OF CAVITIES).

ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01

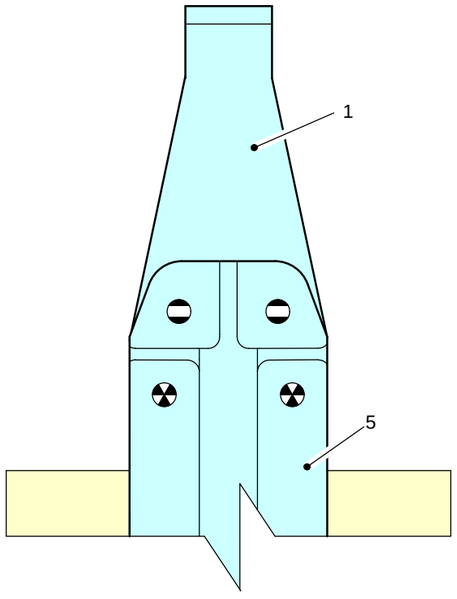
Figure ICN-A320-A-57XX1228-A-FAPE3-01KUD-A-001-01 SHEET 3/4

Installation of the New Parts at FR36

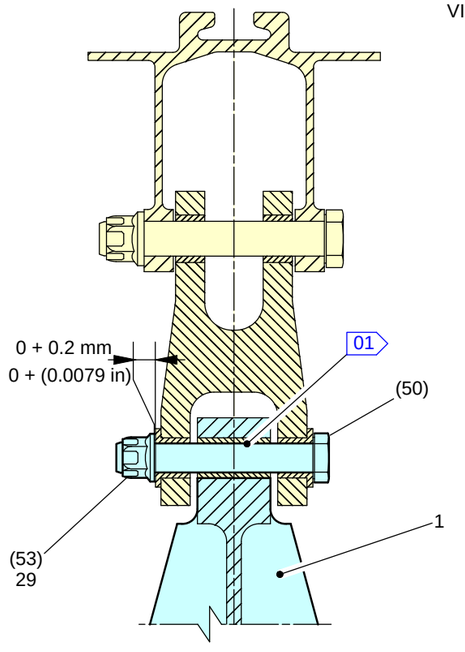
CONF 002



VIEW LOOKING DOWN



VIEW LOOKING AFT



VIEW LOOKING FORWARD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	NOTE
N	18	EN6115V3-6	BOLT	04
	12	ASNA2529-3	NUT	
N	28	EN6115V5X9	BOLT	04
	15	ASNA2536-5	NUT	
N	20	EN6115V3X5	BOLT	04
	10	ASNA2528-3	NUT	
N	21	EN6115V3X6	BOLT	04
	10	ASNA2528-3	NUT	
N	22	EN6115V3X8	BOLT	04
	10	ASNA2528-3	NUT	
N	25	EN6115V4X8	BOLT	04
	14	ASNA2536-4	NUT	
N	16	EN6115K4-8	BOLT	04
	14	ASNA2536-4	NUT	
N	26	EN6115V5-7	BOLT	04
	15	ASNA2536-5	NUT	

NOTE:

- FASTENER NOT AFFECTED
- N HEAD ON NEAR SIDE
- 01 APPLY MATERIAL No 06AEB2.
- 04 WET INSTALL THE FASTENERS WITH MATERIAL No 06ABC1.

ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUE-A-001-01 SHEET 4/4

Installation of the New Parts at FR36

CONF 001 003 004

(84) Task A320-A-57-XX-1228-06001-250A-A - Protect the Fasteners and the New Parts on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

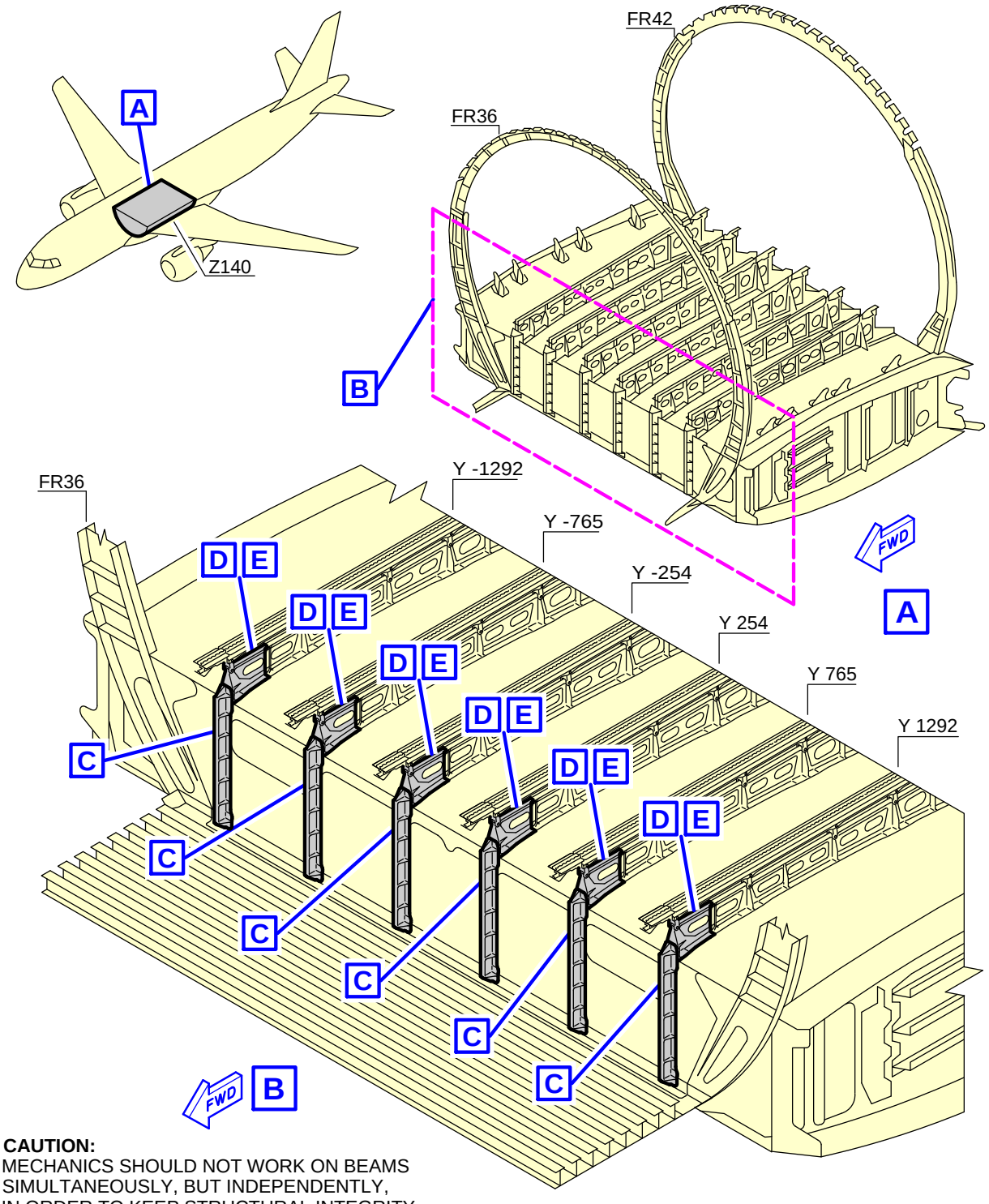
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 001 003 004

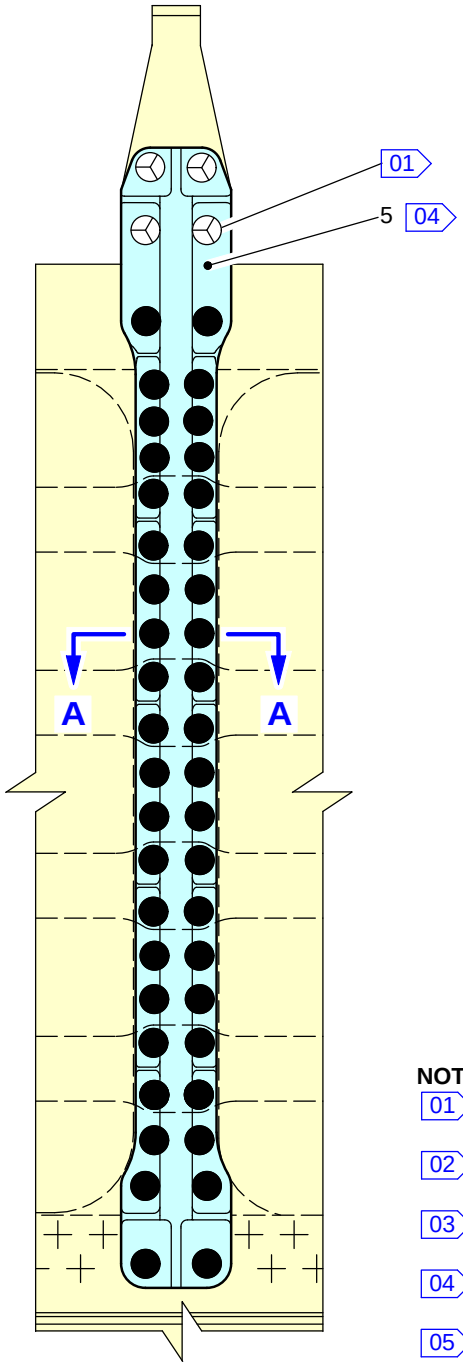


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

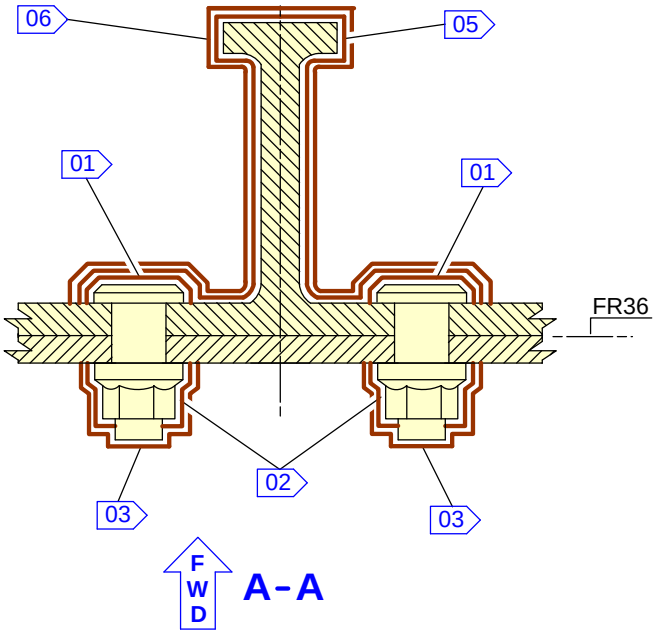
ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU4-A-002-01 SHEET 1/4

CONF 001 003 004



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

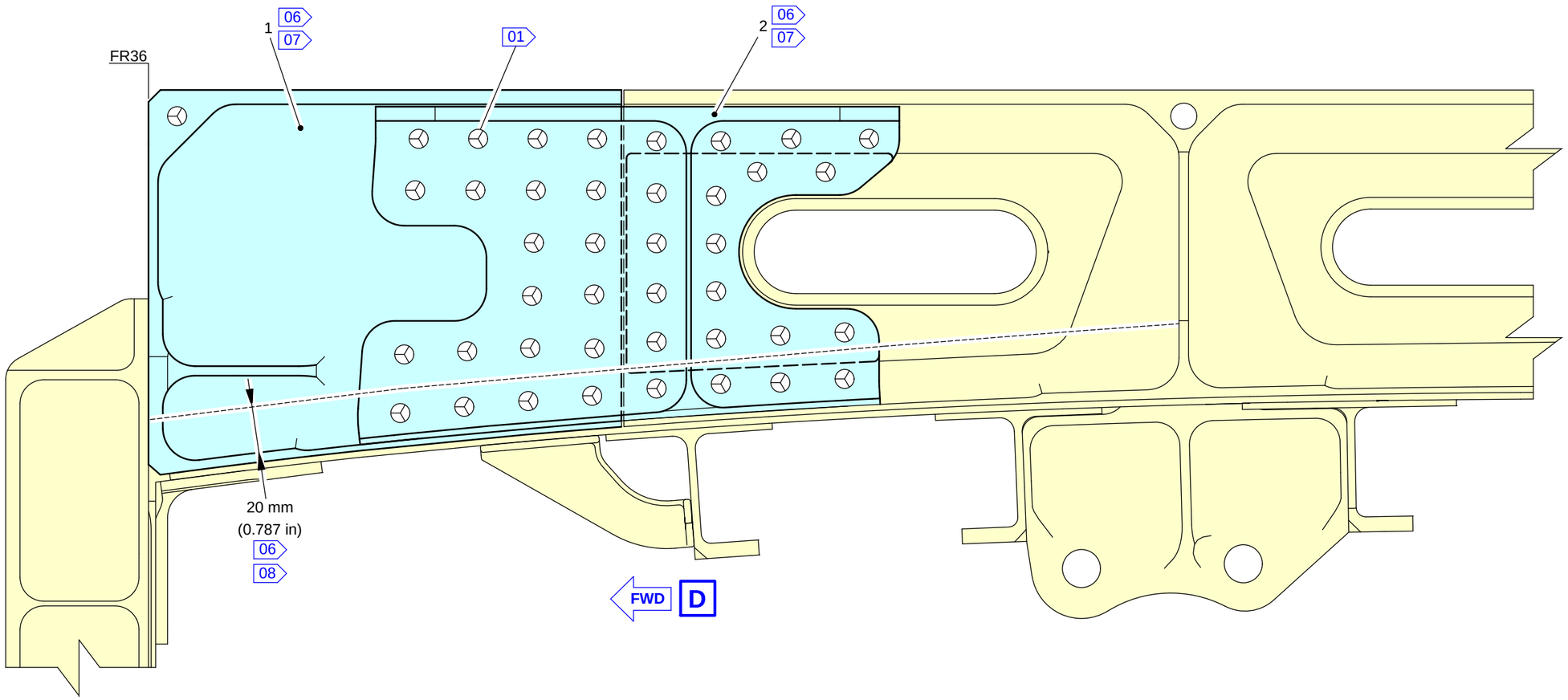
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU5-A-001-01 SHEET 2/4

CONF 001 003 004



HOLE SYMBOL	NOTE
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

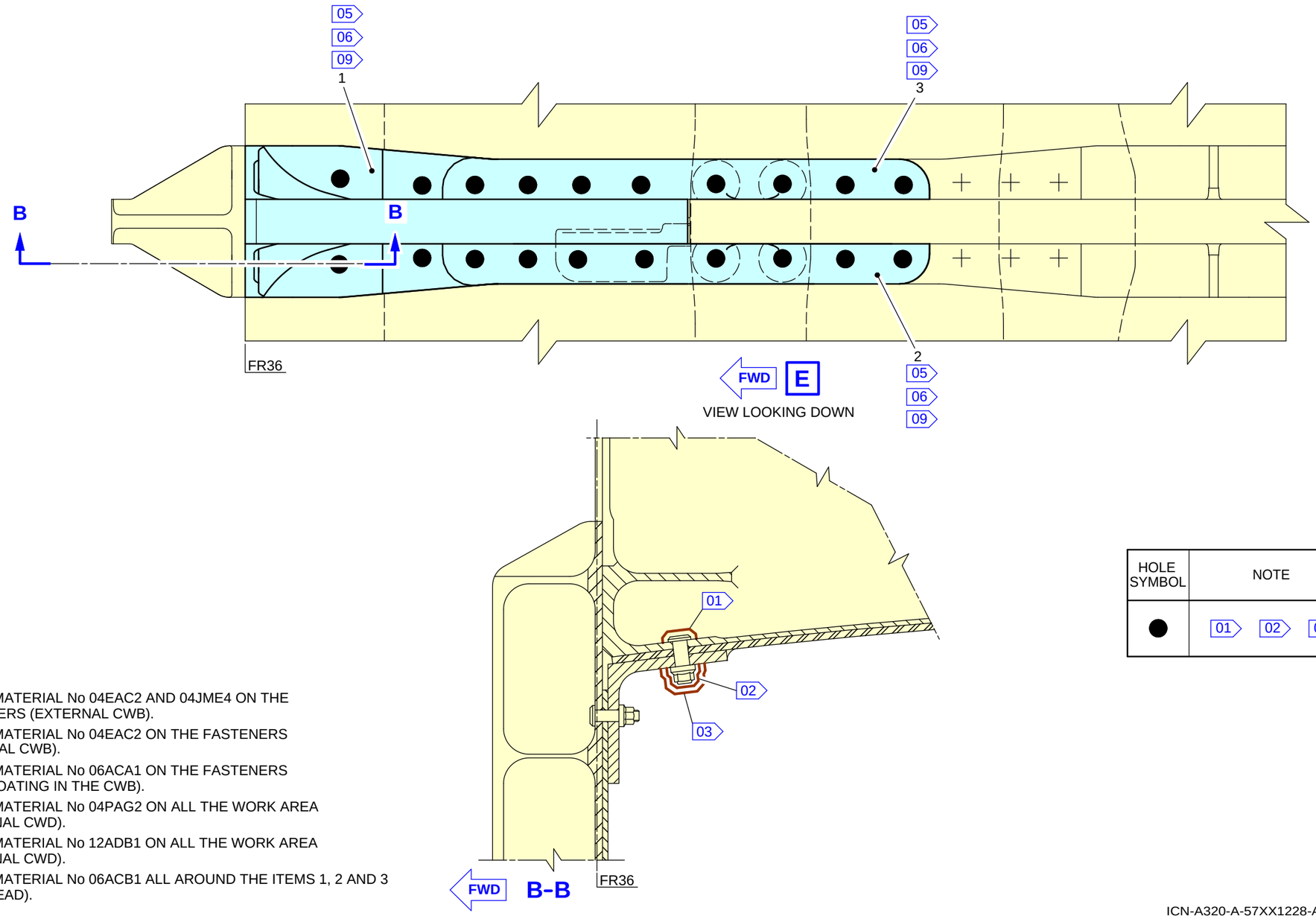
08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU6-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 001 003 004



HOLE SYMBOL	NOTE
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KU7-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF 002

(84) Task A320-A-57-XX-1228-06002-250A-A - Protect the Fasteners and the New Parts on Y-1292 at FR36

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	Frame 36
140	Access	Panel 147AZ, Panel 148AZ
240		

Manpower/Resources/Skills

Man-hours	7.00 h
Minimum Number of person	2
Elapsed Time	3.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	04PAG2	Polyurethane Coating - - Fuel Vapour Barrier Structure		
	06ACA1	Polysulfide Sealant - Low Density MultiPurpose Brushable		
	06ACB1	Polysulfide Sealant - Low Density MultiPurpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00

Manuals/Drawings	References/Sheets
	51-75-12 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

6 Apply sealant in accordance with Ref. SRM 51-24-00.

7 Renew the protective finish in accordance with Ref. SRM 51-75-12.

(b) Do the protection of the fasteners and the new parts, refer to Ref. Fig. Protection of the New Parts at FR36.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Protection in the internal CWB.

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

b Overcoat the fasteners with:

Polysulfide Sealant - Low Density MultiPurpose Brushable 06ACA1

3 Protection in the external CWB

a Protect the fasteners with:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2

Top Coat Polyurethane - - Grey InternalStructure 04JME4

b Do a seal bead all around the new parts items 1, 2, 3 and 5.

Polysulfide Sealant - Low Density MultiPurpose Fillet	06ACB1

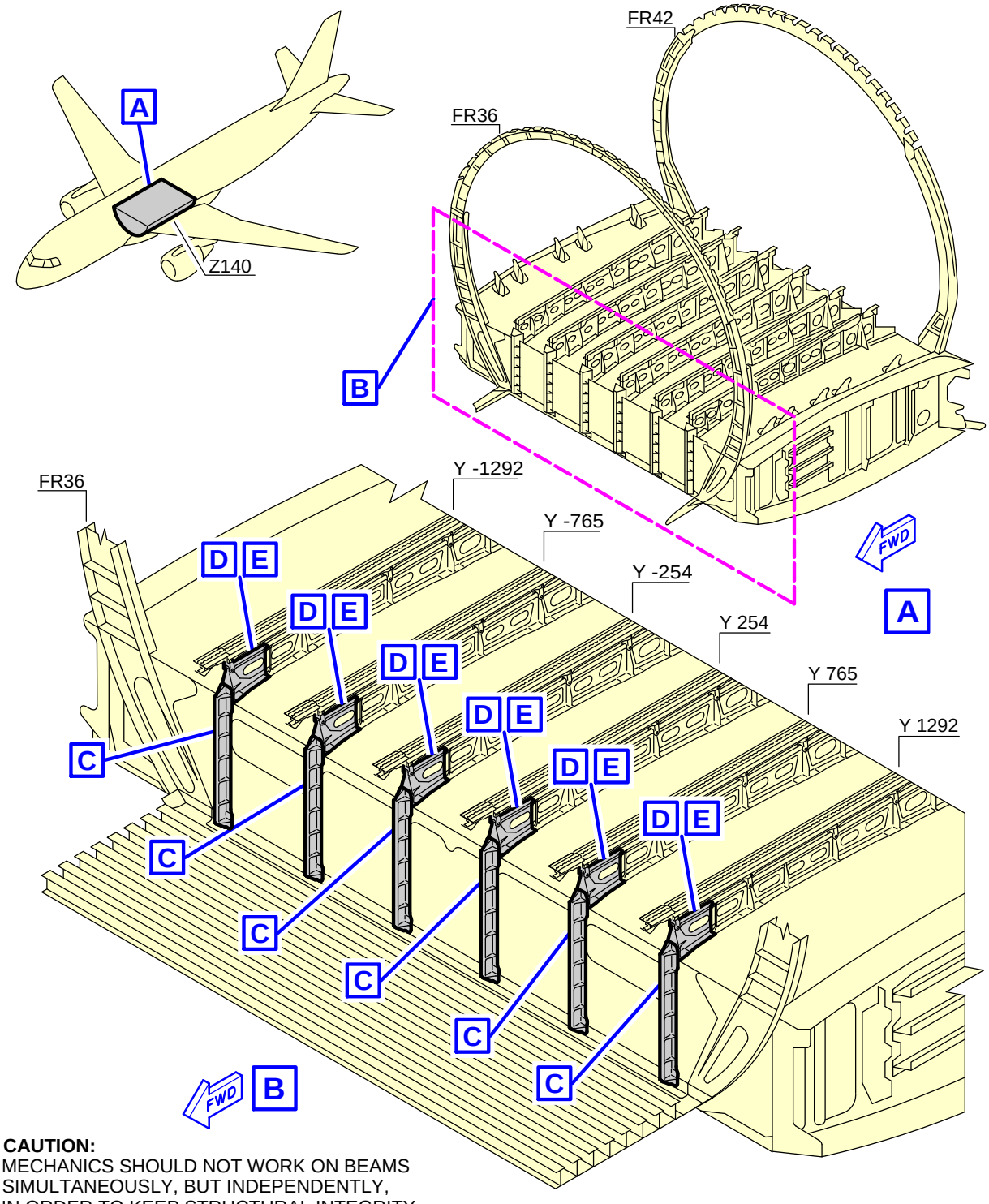
c In the specific work area apply:

Polyurethane Coating - - Fuel Vapour Barrier Structure	04PAG2

d In all the work areas apply:

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

CONF 002

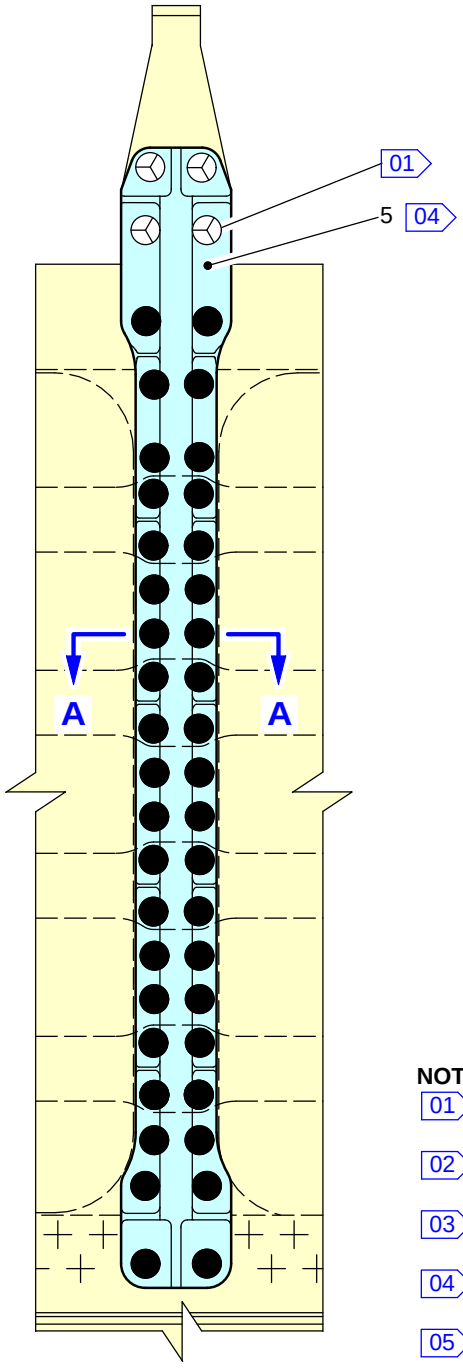


CAUTION:
MECHANICS SHOULD NOT WORK ON BEAMS SIMULTANEOUSLY, BUT INDEPENDENTLY, IN ORDER TO KEEP STRUCTURAL INTEGRITY

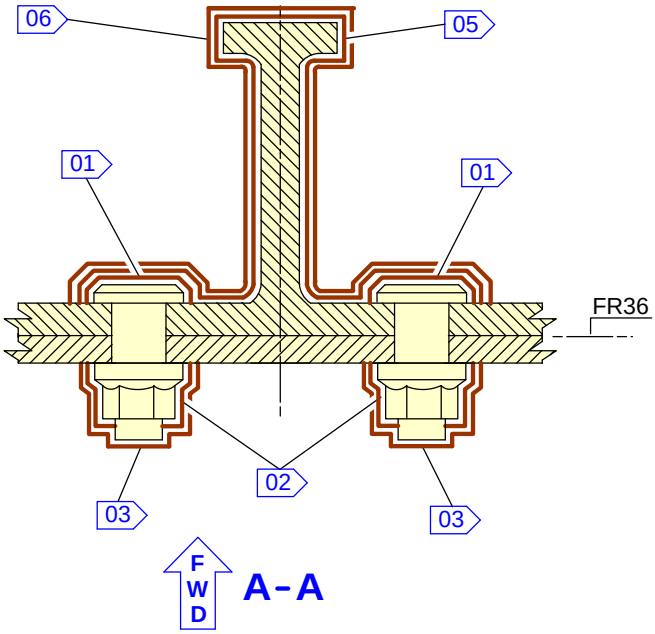
ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUF-A-002-01 SHEET 1/4

CONF 002



VIEW LOOKING AFT



VIEW LOOKING DOWN

HOLE SYMBOL	NOTE:
●	01 02 03
⊗	01

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

04 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEM 5 (SEAL BEAD).

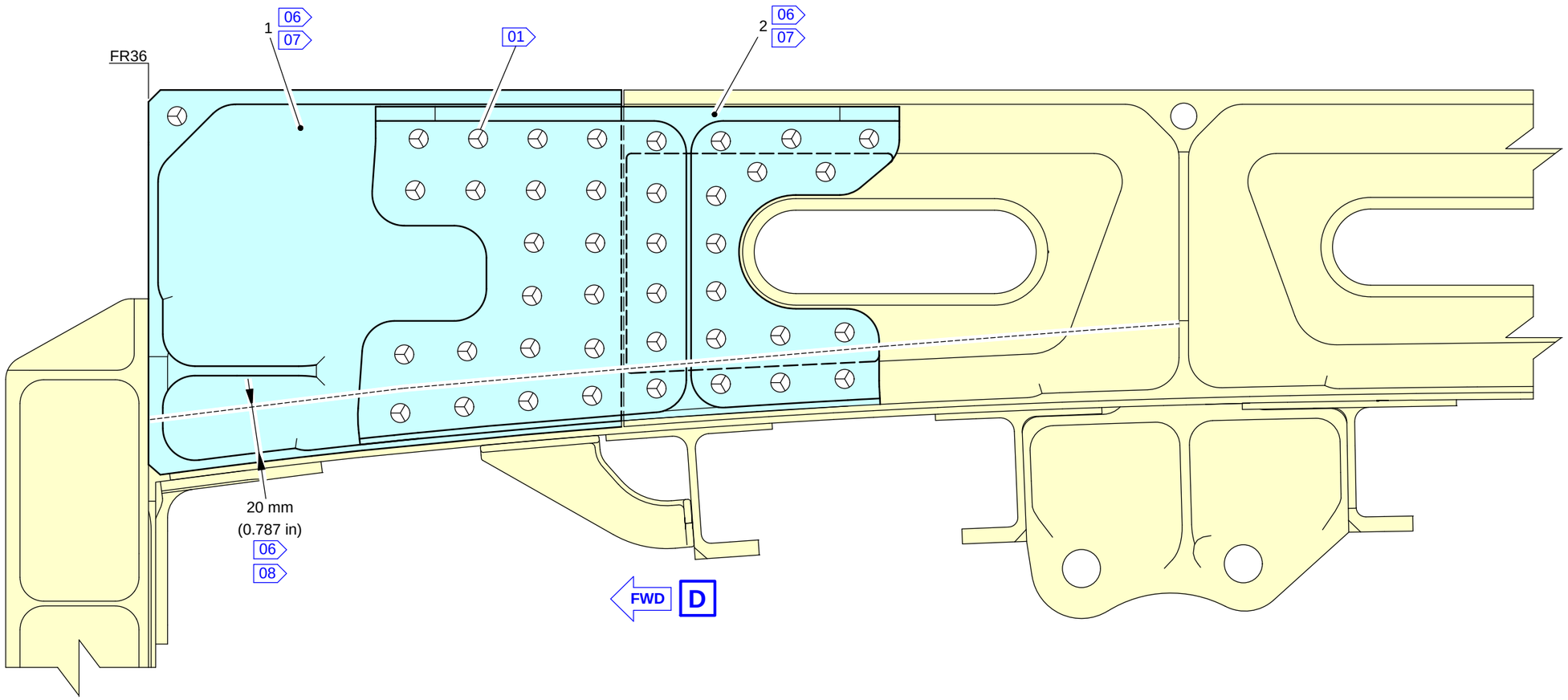
05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUG-A-001-01 SHEET 2/4

CONF 002



NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

07 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1 AND 2 (SEAL BEAD).

08 APPLY MATERIAL No 04PAG2 ON ALL THE SPECIFIC AREA (EXTERNAL CWD).

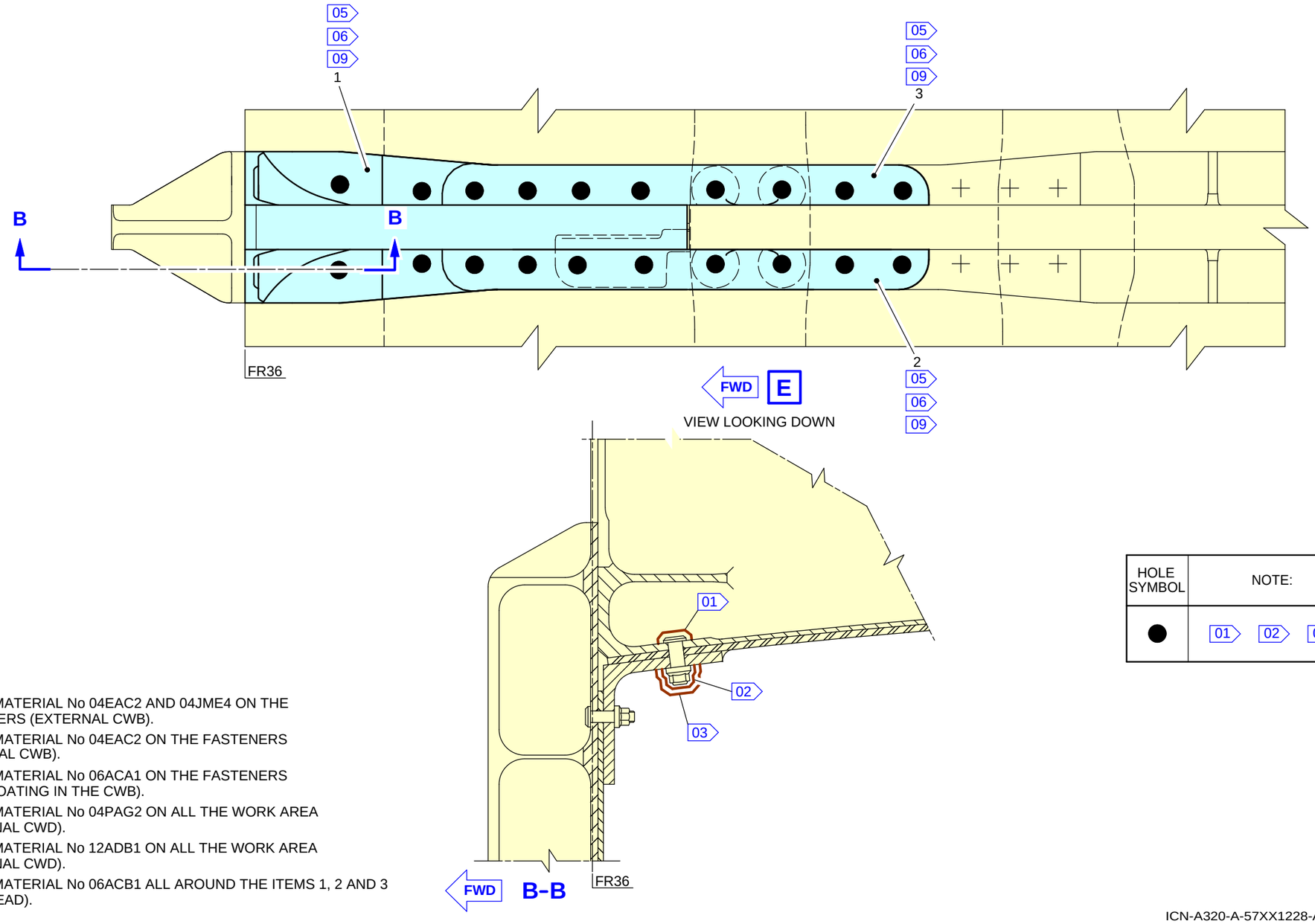
HOLE SYMBOL	NOTE
⊗	01

ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUH-A-001-01 SHEET 3/4

Protection of the New Parts at FR36

CONF 002



HOLE SYMBOL	NOTE:
●	01 02 03

NOTE:

01 APPLY MATERIAL No 04EAC2 AND 04JME4 ON THE FASTENERS (EXTERNAL CWB).

02 APPLY MATERIAL No 04EAC2 ON THE FASTENERS (INTERNAL CWB).

03 APPLY MATERIAL No 06ACA1 ON THE FASTENERS (OVERCOATING IN THE CWB).

05 APPLY MATERIAL No 04PAG2 ON ALL THE WORK AREA (EXTERNAL CWD).

06 APPLY MATERIAL No 12ADB1 ON ALL THE WORK AREA (EXTERNAL CWD).

09 APPLY MATERIAL No 06ACB1 ALL AROUND THE ITEMS 1, 2 AND 3 (SEAL BEAD).

ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01KUI-A-001-01 SHEET 4/4

Protection of the New Parts at FR36

CONF ALL

D. PREPARATION FOR TEST

(1) Task A320-A-57-XX-1228-04001-720A-A - Do the Preparation Before Forward Center Wing Box Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	From Frame 34 to Frame 36

Manpower/Resources/Skills

Man-hours	15.25 h
Minimum Number of person	2
Elapsed Time	8.25 h
Skills	Airframe

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A03R01

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
114	ABS5800D028A	1	SEAL		
118	NSA8206-014	1	ORING		

Components

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	ABS1133C025	As req. (m)	TAPE		(1)
	ABS1133D025	As req. (m)	TAPE		(1)

NOTE(S)

(1): The components listed above are not an AIRBUS Kit, the required parts must be ordered as necessary through the given channel.

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-12-911-001 Task 21-20-00-410-001 Task 21-21-41-400-001 Task 21-21-43-400-002 Task 21-63-51-400-001 Task 21-63-52-400-001 Task 25-80-00-400-001 Task 38-11-41-400-002

Manuals/Drawings	References/Sheets
	Task 38-41-41-400-001 Task 38-41-42-400-001 Task 38-41-43-400-001 Task 38-41-44-400-001 Task 38-42-16-400-001 Task 38-42-42-400-001 Task 38-42-43-400-001 Task 38-42-51-400-001
CML	CONSUMABLE MATERIAL LIST (CML)
ESPM	20-33-00
SRM	51-42-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 To torque tighten pipe unions, refer to Ref. AMM Task 20-21-12-911-001.

6 To torque tighten clamps for air conditioning systems, refer to Ref. AMM Task 20-21-12-911-001.

7 For the general installation of electrical wire harnesses, refer to Ref. ESPM 20-33-00.

8 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Clean all the work areas with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Install insulations blankets between Frame 35 and Frame 36, refer to Ref. AMM Task 25-80-00-400-001.

1 Do the install of the insulation blankets with:

As required	TAPE-HOOK	ABS1133C025
As required	TAPE-LOOP	ABS1133D025

(d) Remove the protection and install the electrical wiring between Frame 35 and Frame 36.

(e) If removed, install the compressor (FIN 8MD), refer to Ref. AMM Task 38-42-51-400-001.

(f) Install the pressure regulating valve (FIN 14HK), refer to Ref. AMM Task 21-63-52-400-001.

(g) Install the trim air valves (FIN 11HK, FIN 12HK and FIN 13HK), refer to Ref. AMM Task 21-63-51-400-001.

(h) Install the insulated hot air collector between Frame 35 and Frame 36, refer to Ref. Fig. Installation of the Hot Air Collector at FR36.

1 Install the insulated hot air collector.

1	HOT AIR COLLECTOR		Item (110)	Retained

2 Connect the insulated hot air collector onto the flange.

1	CLAMP		Item (115)	Retained
1	SEAL	ABS5800D028A	Item 114	

3 Connect the connector on the pressure switch (FIN 26HK).

1	CONNECTOR		Item (120)	Retained

4 Connect the insulated hot air collector onto the control tube.

1	ADAPTER		Item (119)	Retained
1	O-RING	NSA8206-014	Item 118	

(i) Install the mixer unit for access, refer to Ref. AMM Task 21-21-43-400-002.

(j) Install the potable water tank (FIN 3000MM), refer to Ref. AMM Task 38-11-41-400-002.

(k) Install the LH and RH recirculation filters (FIN 4012HM and FIN 4013HM), refer to Ref. AMM Task 21-21-41-400-001.

(l) Install the air conditioning distribution ducts, refer to Ref. AMM Task 21-20-00-410-001.

(m) Install the check valve (FIN 4205MM), refer to Ref. AMM Task 38-41-41-400-001.

(n) Install the air filter (FIN 4210MM), refer to Ref. AMM Task 38-41-42-400-001.

(o) Install the pressure reducing valve (FIN 4200MM), refer to Ref. AMM Task 38-41-43-400-001.

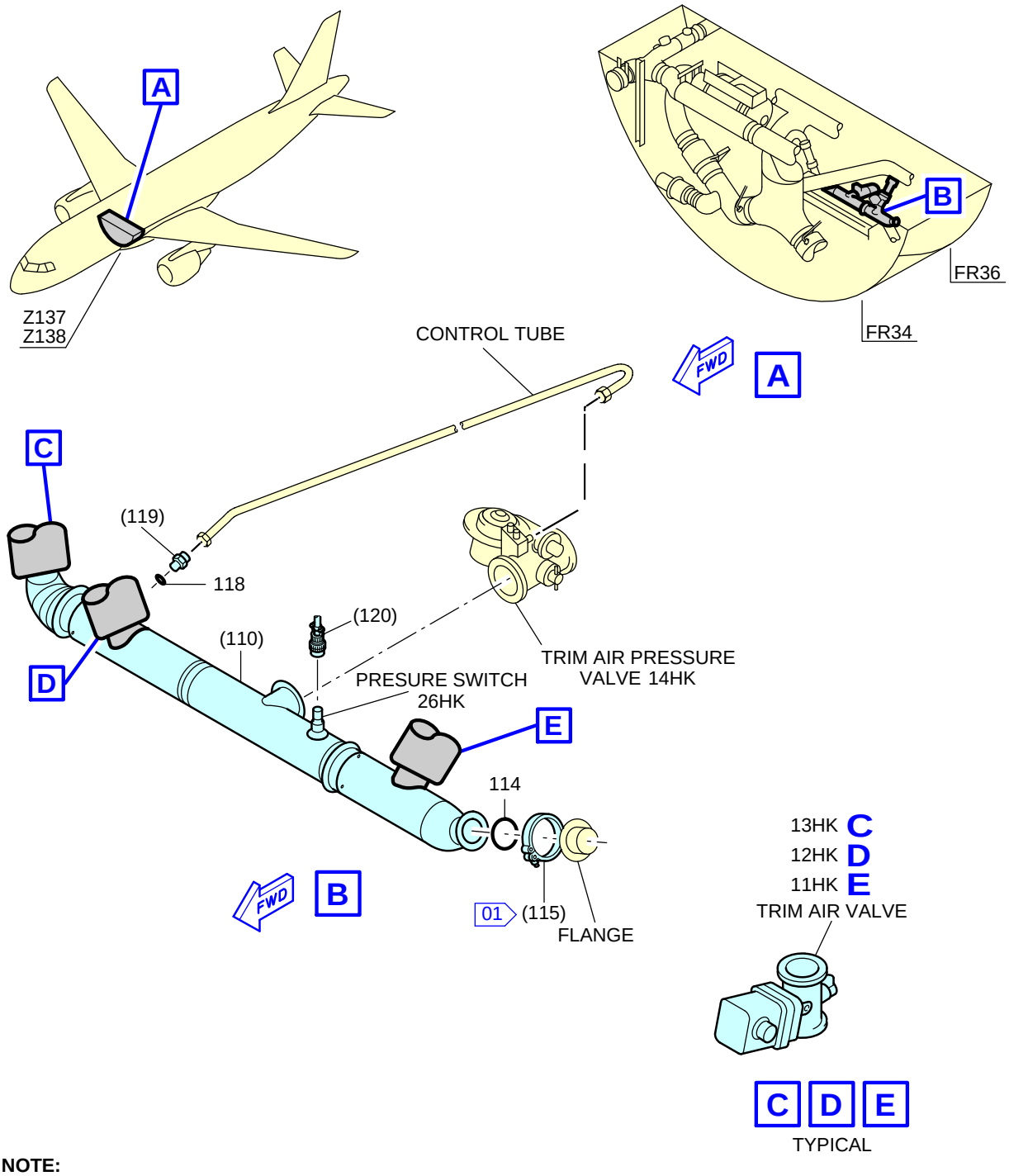
(p) Install the shuttle valve (FIN 4215MM), refer to Ref. AMM Task 38-41-44-400-001.

(q) If removed, install the pressure switch (FIN 10MD), refer to Ref. AMM Task 38-42-16-400-001.

(r) If removed, install the air filter (FIN 4212MM), refer to Ref. AMM Task 38-42-42-400-001.

(s) If removed, install the check valve (FIN 4206MM), refer to Ref. AMM Task 38-42-43-400-001.

CONF ALL



NOTE:

01 TORQUE TO 0.546 m.daN (48.318 lbf.in) + 0.0 m.daN (0.0 lbf.in)
- 0.055 m.daN (4.867 lbf.in)

ICN-A320-A-57XX1228-A-FAPE3-01MMD-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMD-A-002-01 SHEET 1/1

(2) Task A320-A-57-XX-1228-05001-720A-A - Do the Preparation Before Center Wing Box Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
147	
148	

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	2
Elapsed Time	0.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 57-17-11-400-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Clean all the work areas with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) Install the access covers (Panel 147AZ and Panel 148AZ), refer to Ref. AMM Task 57-17-11-400-001.

(3) Task A320-A-57-XX-1228-06001-720A-A - Do the preparation Before Cabin Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	From Frame 35 to Frame 42

Manpower/Resources/Skills

Man-hours	9.00 h
Minimum Number of person	2
Elapsed Time	4.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A03R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
67	MS21042-3	8	NUT		
71	NAS1726-3E	16	NUT		

Referenced Information

Manuals/Drawings	References/Sheets
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 Task 25-21-41-400-001 Task 53-32-12-400-002
CML	CONSUMABLE MATERIAL LIST (CML)
ESPM	20-33-00
SRM	51-40-00 51-42-00 51-43-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

7 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with refer to Ref. SRM 51-40-00 ‘Mating Part’ column.

8 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

9 For the general installation of electrical wire harnesses, refer to Ref. ESPM 20-33-00.

10 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the bridge brackets, refer to Ref. Fig. Installation of the Bridge Brackets and the Hydraulic Clamps between the FR36 and FR38.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install the bridge brackets between Y254 and Y765.

a Install the bridge bracket at Frame 36.

1	BRIDGE BRACKET		Item (68)	Retained
4	SCREW		Item (70)	Retained
4	WASHER FLAT		Item (69)	Retained
2	PLATE		Item (72)	Retained
2	PLATE		Item (73)	Retained
4	NUT	NAS1726-3E	Item 71	

b Install the bridge bracket at Frame 37.

1	BRIDGE BRACKET		Item (68)	Retained
4	SCREW		Item (70)	Retained
4	WASHER FLAT		Item (69)	Retained
2	PLATE		Item (72)	Retained
2	PLATE		Item (73)	Retained
4	NUT	NAS1726-3E	Item 71	

3 Install the bridge brackets between Y765 and Y1292.

a Install the bridge bracket at Frame 36.

1	BRIDGE BRACKET		Item (63)	Retained
2	SCREW		Item (64)	Retained
3	WASHER		Item (65)	Retained
4	WASHER HOLDING		Item (66)	Retained
2	NUT	MS21042-3	Item 67	

b Install the bridge bracket at Frame 37.

1	BRIDGE BRACKET		Item (63)	Retained
2	SCREW		Item (64)	Retained
3	WASHER		Item (65)	Retained
4	WASHER HOLDING		Item (66)	Retained
2	NUT	MS21042-3	Item 67	

4 Install the bridge brackets between Y–1292 and Y–765.

a Install the bridge bracket at Frame 36.

1	BRIDGE BRACKET		Item (63)	Retained
2	SCREW		Item (64)	Retained
3	WASHER		Item (65)	Retained
4	WASHER HOLDING		Item (66)	Retained
2	NUT	MS21042-3	Item 67	

b Install the bridge bracket at Frame 37.

1	BRIDGE BRACKET		Item (63)	Retained
2	SCREW		Item (64)	Retained
3	WASHER		Item (65)	Retained
4	WASHER HOLDING		Item (66)	Retained
2	NUT	MS21042-3	Item 67	

5 Install the air pressure system clamps.

a Remove the protection from the air pressure system between Frame 35 and Frame 37.

b Install the air pressure system clamps onto the bridge bracket at Frame 36.

1	SCREW		Item (82)	Retained
1	WASHER FLAT		Item (83)	Retained
1	CLAMP		Item (81)	Retained
1	NUT	NAS1726-3E	Item 71	

c Install the air pressure system clamps onto the bridge bracket at Frame 37.

1	SCREW	Item (82)	Retained
1	WASHER FLAT	Item (83)	Retained
1	CLAMP	Item (81)	Retained
1	NUT NAS1726-3E	Item 71	

6 Install the toilet vacuum system clamps.

a Remove the protection from the toilet vacuum system between Frame 35 and Frame 37.

b Install the toilet vacuum system clamps onto the bridge at Frame 36.

2	SCREW	Item (78)	Retained
2	WASHER FLAT	Item (79)	Retained
1	CLAMP	Item (76)	Retained
2	NUT NAS1726-3E	Item 71	

c Install the toilet vacuum system clamps onto the bridge at Frame 37.

2	SCREW	Item (78)	Retained
2	WASHER FLAT	Item (79)	Retained
1	CLAMP	Item (76)	Retained
2	SPACER	Item (80)	Retained
2	NUT NAS1726-3E	Item 71	

7 Install the potable water distribution system clamps.

a Remove the protection from the potable water distribution system between Frame 35 and Frame 37.

b Install the potable water distribution system clamps onto the bridge at Frame 36.

1	SCREW	Item (70)	Retained
1	WASHER FLAT	Item (69)	Retained
1	CLAMP	Item (74)	Retained
1	DISTANCE PIECE	Item (75)	Retained
1	NUT NAS1726-3E	Item 71	

c Install the potable water distribution system clamps onto the bridge at Frame 37.

1	SCREW	Item (70)	Retained
1	WASHER FLAT	Item (69)	Retained
1	CLAMP	Item (74)	Retained
1	DISTANCE PIECE	Item (75)	Retained

1	NUT	NAS1726-3E	Item 71	

8 Install the hydraulic system clamps between Y–1292 and outboard, refer to Ref. Fig. Installation of the Bridge Brackets and the Hydraulic Clamps between the FR36 and FR38.

a Install the hydraulic system clamps at Frame 36.

1	HYDRAULIC CLAMP	Item (95)	Retained
2	BOLT	Item (96)	Retained
2	WASHER	Item (97)	Retained

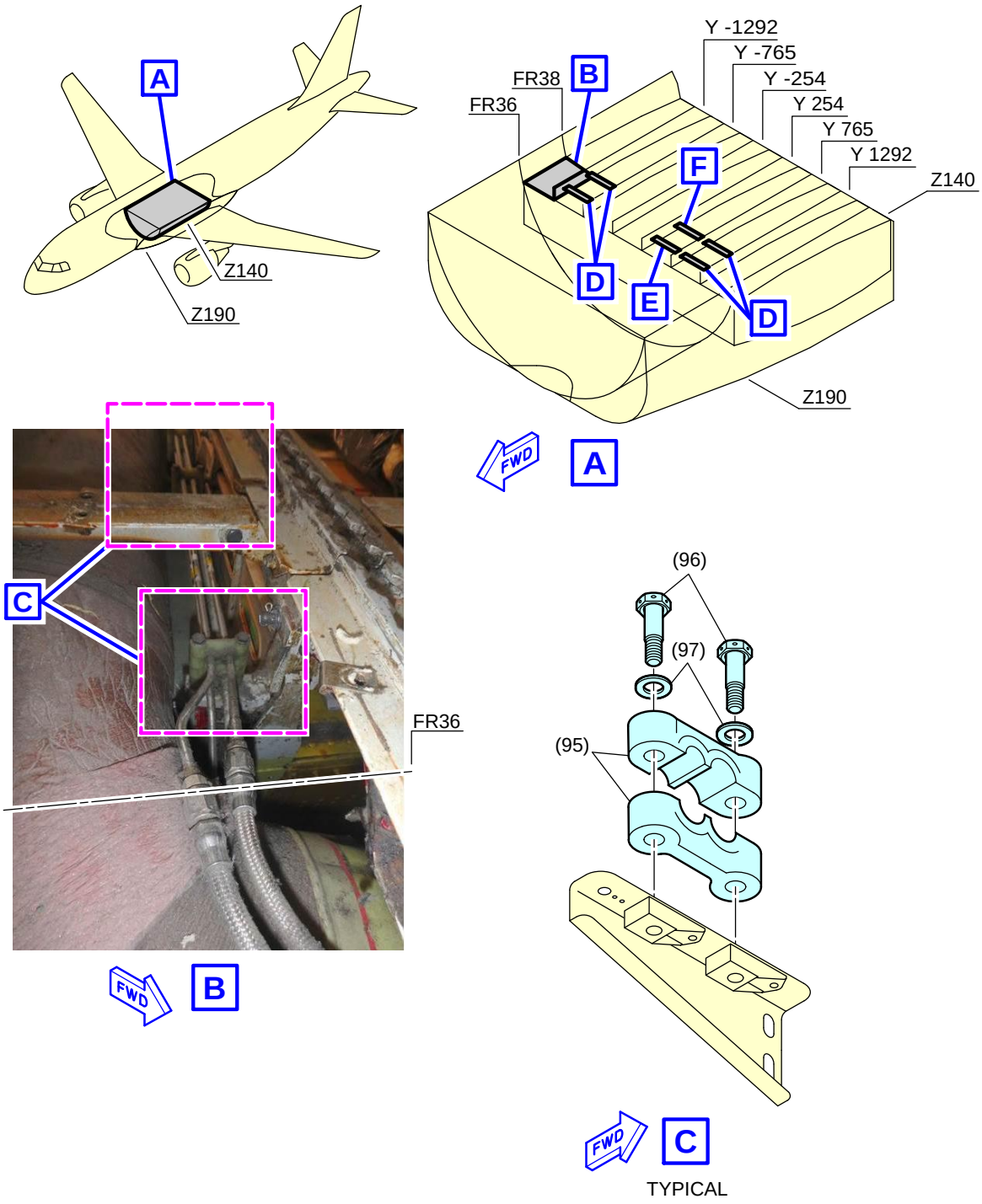
b Install the hydraulic system clamps at Frame 37.

1	HYDRAULIC CLAMP	Item (95)	Retained
2	BOLT	Item (96)	Retained
2	WASHER	Item (97)	Retained

(c) Install the floor panels between Frame 35 and Frame 42, refer to Ref. AMM Task 53-32-12-400-002.

(d) Install the passenger seats between Frame 35 and Frame 42, refer to Ref. AMM Task 25-21-41-400-001.

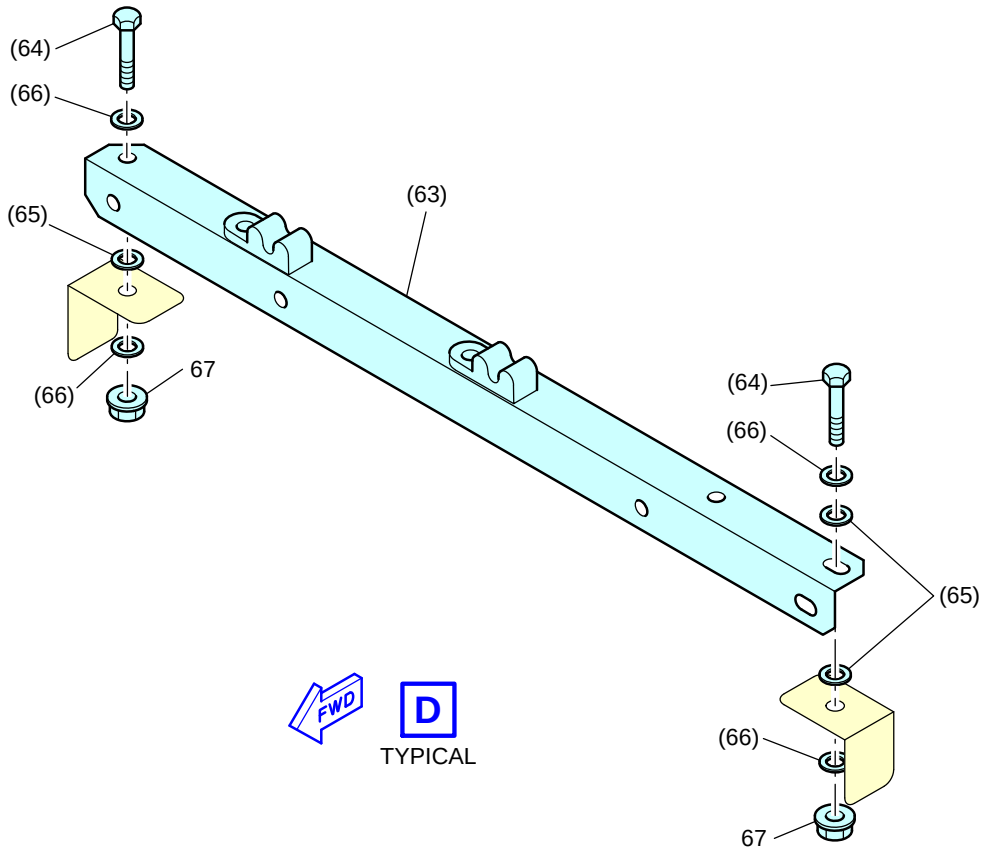
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MM4-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM4-A-001-01 SHEET 1/4

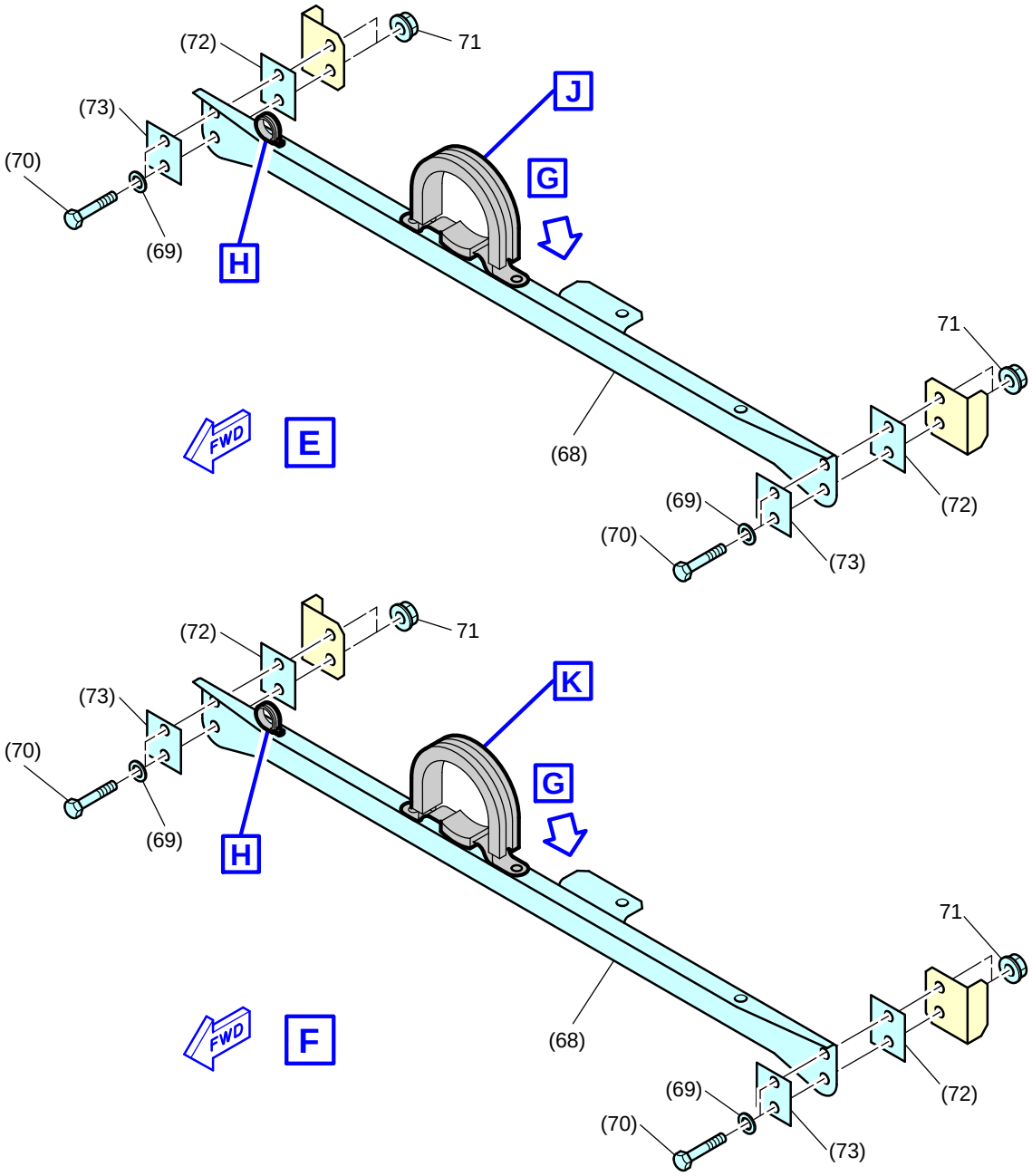
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MM5-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM5-A-001-01 SHEET 2/4

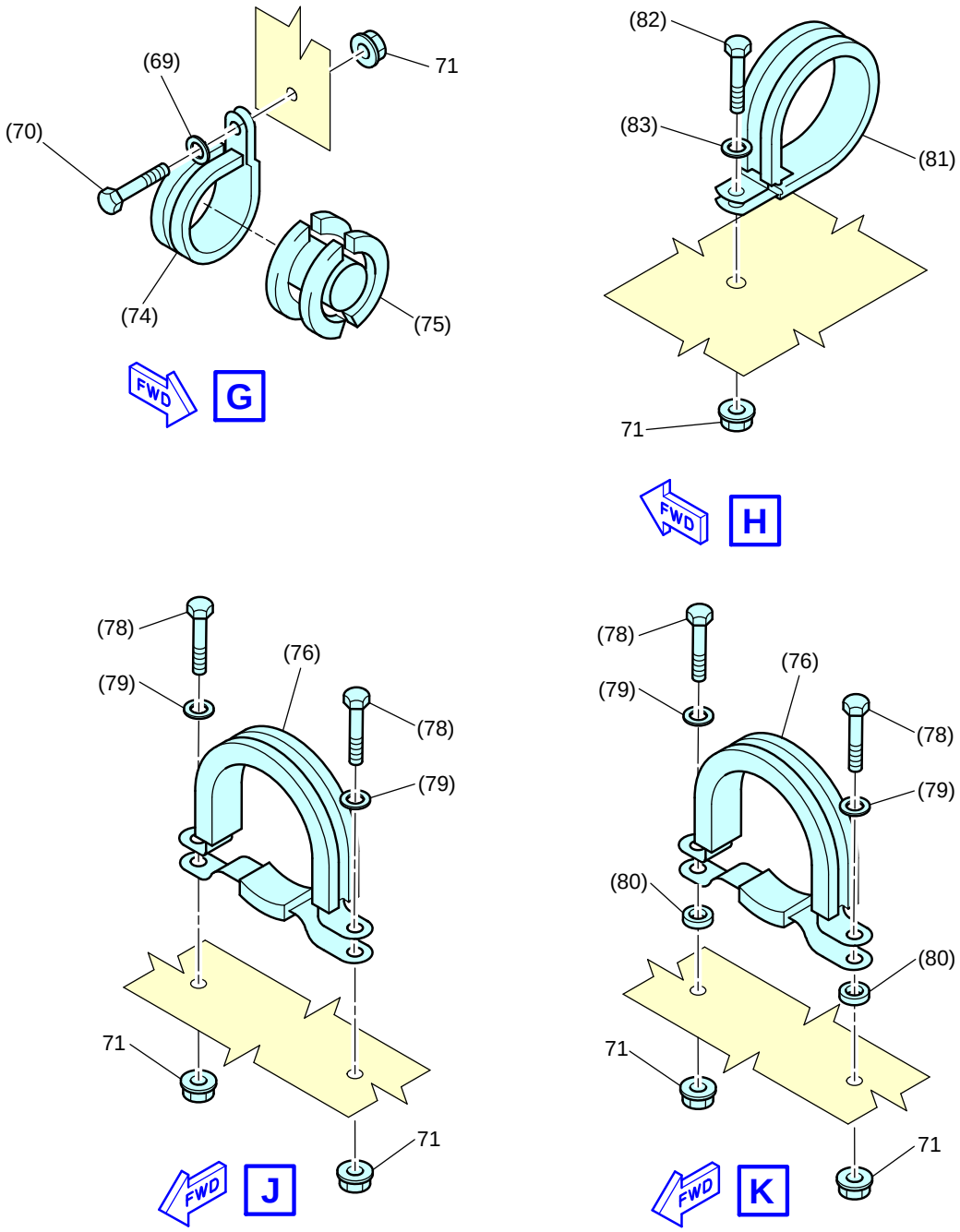
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MM6-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM6-A-001-01 SHEET 3/4

CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MM7-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM7-A-001-01 SHEET 4/4

(4) Task A320-A-57-XX-1228-30001-720A-A - If Removed, Install the Bridge of the Inerting System between FR35 and FR37 and between Y254 and Y-254

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
240	

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	1
Elapsed Time	1.00 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A03R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
71	NAS1726-3E	4	NUT		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 20-21-11-911-001 Task 20-28-00-912-802
CML	CONSUMABLE MATERIAL LIST (CML)
ESPM	20-33-00 20-51-20
SRM	51-40-00 51-42-00 51-43-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

5 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

6 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with refer to Ref. SRM 51-40-00 ‘Mating Part’ column.

7 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

8 For the general installation of electrical wire harnesses, refer to Ref. ESPM 20-33-00.

9 For the electrical bonding, refer to Ref. ESPM 20-51-20 and Ref. AMM Task 20-28-00-912-802.

10 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) If removed, install the bridge bracket, refer to Ref. Fig. Depending of the Aircraft Configuration, Installation of the Bridge of the Inerting System between FR36 and FR38 and between Y254 and Y-254 .

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Remove the protection from the inerting system between Frame 35 and Frame 37.

3 Install the bridge bracket at Frame 36.

1	BRIDGE BRACKET		Item (90)	Retained
4	SCREW		Item (88)	Retained
8	WASHER		Item (87)	Retained
4	NUT	NAS1726-3E	Item 71	

4 Install the inerting system clamp at Frame 36 between Y254 and Y– 254.

2	BOLT	Item (91)	Retained
2	WASHER	Item (87)	Retained
1	CLAMP	Item (93)	Retained

5 Install the bonding lead at Frame 36 between Y254 and Y– 254.

1	BOLT	Item (92)	Retained
1	WASHER	Item (87)	Retained

CONF ALL

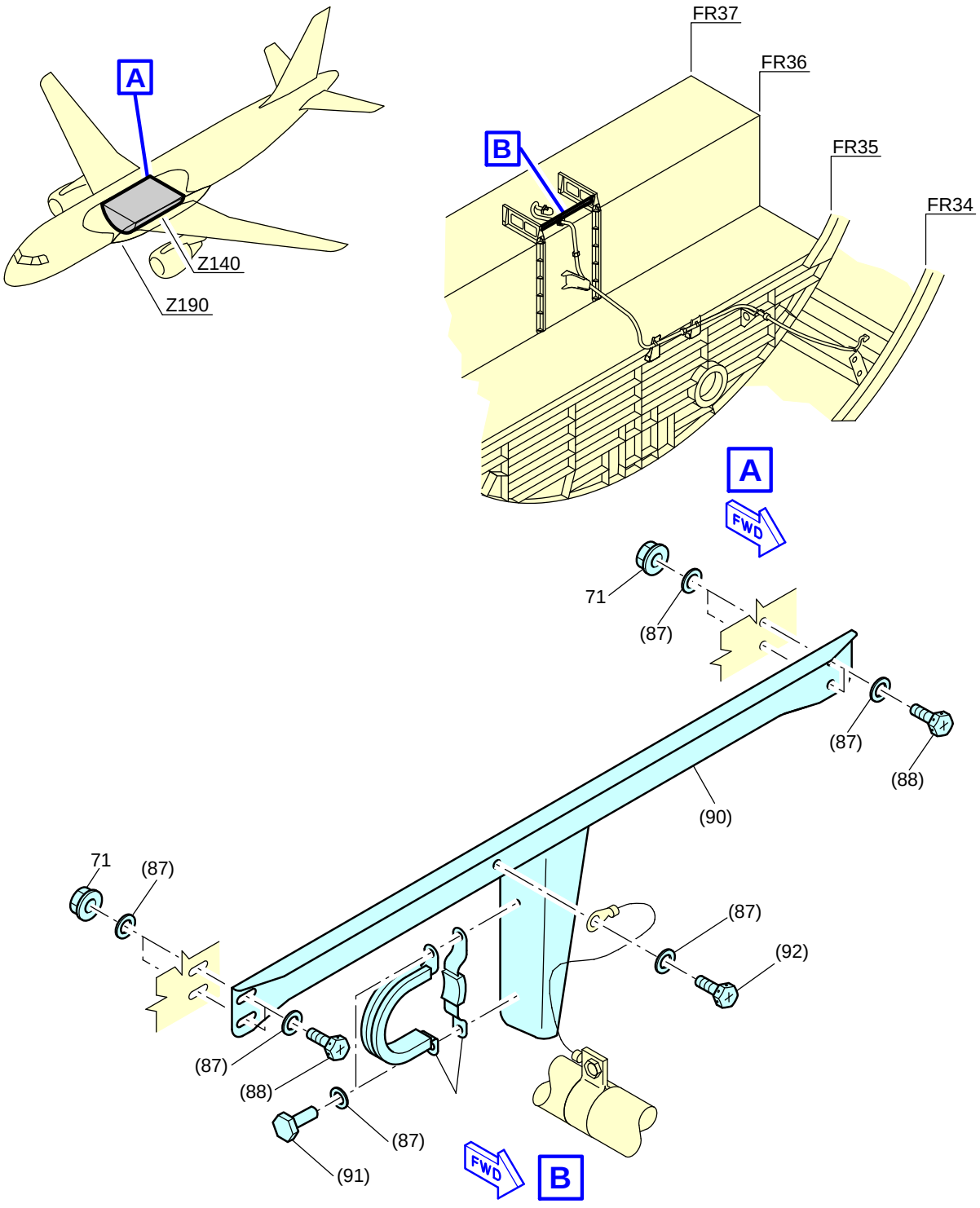


Figure ICN-A320-A-57XX1228-A-FAPE3-01MM8-A-001-01 SHEET 1/1
Depending of the Aircraft Configuration, Installation of the Bridge of the Inerting System between FR36 and FR38 and between Y254 and Y-254

(5) Task A320-A-57-XX-1228-31001-720A-A - If Removed, Install the Additional Center Tank No.4

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
130	

Manpower/Resources/Skills

Man-hours	3.00 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 28-11-27-400-005
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Clean all the work areas with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

(c) If removed, install the ACT4, refer to Ref. AMM Task 28-11-27-400-005.

(6) Task A320-A-57-XX-1228-32001-720A-A - If Removed, Install the Additional Center Tank No.6

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
130	

Manpower/Resources/Skills

Man-hours	3.00 h
Minimum Number of person	2
Elapsed Time	1.50 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001 Task 28-11-27-400-007
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

4 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) If removed, install the ACT6, refer to Ref. AMM Task 28-11-27-400-007.

E. TEST

(1) Task A320-A-57-XX-1228-01001-345A-A - Do the Forward Center Wing Box Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Access	Panel 131NW, Panel 131PW, Panel 132PW
	Work location	From Frame 34 to Frame 36

Manpower/Resources/Skills

Man-hours	6.00 h
Minimum Number of person	1
Elapsed Time	6.00 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 21-20-00-410-001 Task 21-21-41-400-001 Task 21-21-43-400-002 Task 21-63-51-400-001 Task 21-63-52-400-001 Task 28-11-27-400-005 Task 28-11-27-400-007 Task 38-10-00-614-001 Task 38-10-00-614-002 Task 38-11-41-400-002 Task 38-41-41-400-001 Task 38-41-42-400-001 Task 38-41-43-400-001 Task 38-41-44-400-001 Task 38-42-16-400-001 Task 38-42-42-400-001 Task 38-42-43-400-001 Task 38-42-51-400-001

Procedure

(a) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the compressor (FIN 8MD), refer to Ref. AMM Task 38-42-51-400-001.

(b) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the pressure regulating valve (FIN 14HK), refer to Ref. AMM Task 21-63-52-400-001.

(c) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the trim air valves (FIN 11HK, FIN 12HK and FIN 13HK), refer to Ref. AMM Task 21-63-51-400-001.

(d) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the check valve (FIN 4206MM), refer to Ref. AMM Task 38-42-43-400-001.

(e) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the air filter (FIN 4212MM), refer to Ref. AMM Task 38-42-42-400-001.

(f) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the pressure switch (FIN 10MD), refer to Ref. AMM Task 38-42-16-400-001.

(g) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the air conditioning distribution ducts, refer to Ref. AMM Task 21-20-00-410-001.

(h) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the mixer unit, refer to Ref. AMM Task 21-21-43-400-002.

(i) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the potable water tank (FIN 3000MM), refer to Ref. AMM Task 38-11-41-400-002.

(j) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the LH and RH recirculation filters (FIN 4012HM and FIN 4013HM), refer to Ref. AMM Task 21-21-41-400-001.

(k) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the ACT4, refer to Ref. AMM Task 28-11-27-400-005.

(l) If existing on aircraft, remove the safety clips and tags and close the circuit breakers as specified after the installation of the ACT6, refer to Ref. AMM Task 28-11-27-400-007.

(m) If existing on aircraft, do the test procedure as specified in the installation of the compressor (FIN 8MD), refer to Ref. AMM Task 38-42-51-400-001.

(n) Do the test procedure as specified in the installation of the pressure regulating valve (FIN 14HK), refer to Ref. AMM Task 21-63-52-400-001.

(o) Do the test procedure as specified in the installation of the trim air valves (FIN 11HK, FIN 12HK and FIN 13HK), refer to Ref. AMM Task 21-63-51-400-001.

(p) If existing on aircraft, do the test procedure as specified in the installation of the check valve (FIN 4206MM), refer to Ref. AMM Task 38-42-43-400-001.

(q) If existing on aircraft, do the test procedure as specified in the installation of the air filter (FIN 4212MM), refer to Ref. AMM Task 38-42-42-400-001.

(r) If existing on aircraft, do the test procedure as specified in the installation of the pressure switch (FIN 10MD), refer to Ref. AMM Task 38-42-16-400-001.

(s) Do the test procedure as specified in the installation of the shuttle valve (FIN 4215MM), refer to Ref. AMM Task 38-41-44-400-001.

(t) Do the test procedure as specified in the installation of the pressure reducing valve (FIN 4200MM), refer to Ref. AMM Task 38-41-43-400-001.

(u) Do the test procedure as specified in the installation of the air filter (FIN 4210MM), refer to Ref. AMM Task 38-41-42-400-001.

(v) Do the test procedure as specified in the installation of the check valve (FIN 4205MM), refer to Ref. AMM Task 38-41-41-400-001.

(w) Do the test procedure as specified in the installation of the potable water tank (FIN 3000MM), refer to Ref. AMM Task 38-11-41-400-002.

(x) Do the test procedure as specified in the installation of the air conditioning distribution ducts, refer to Ref. AMM Task 21-20-00-410-001.

(y) Do the test procedure as specified in the installation of the mixer unit, refer to Ref. AMM Task 21-21-43-400-002.

(z) If existing on aircraft, do the test procedure as specified in the installation of the ACT4, refer to Ref. AMM Task 28-11-27-400-005.

(aa) If existing on aircraft, do the test procedure as specified in the installation of the ACT6, refer to Ref. AMM Task 28-11-27-400-007.

(ab) Do the test of potable water pipe system:

1 Tests to do after removing a potable water pipe system:

a Pressurize the potable water system, refer to Ref. AMM Task 38-10-00-614-001.

b Do a check for leaks at the duct connections.

NOTE: Leaks are not allowed.

c Do the release of the pressure from the potable water system, refer to Ref. AMM Task 38-10-00-614-002.

(2) Task A320-A-57-XX-1228-01001-364A-A - Do Center Wing Box Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location
140	

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	1
Elapsed Time	1.00 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 57-17-11-400-001

Procedure

(a) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the access covers (Panel 147AZ and Panel 148AZ), refer to Ref. AMM Task 57-17-11-400-001.

(b) Do the test procedure as specified in the installation of the access covers (Panel 147AZ and Panel 148AZ), refer to Ref. AMM Task 57-17-11-400-001.

(3) Task A320-A-57-XX-1228-01001-346A-A - Do the Cabin Testing

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
240	Work location	From Frame 35 to Frame 42

Manpower/Resources/Skills

Man-hours	6.00 h

Minimum Number of person	1
Elapsed Time	6.00 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 25-21-41-400-001

Procedure

(a) Remove the safety clips and tags and close the circuit breakers as specified after the installation of the passengers seats, refer to Ref. AMM Task 25-21-41-400-001.

(b) Do the test procedure as specified in the installation of the passengers seats, refer to Ref. AMM Task 25-21-41-400-001.

F. CLOSE-UP

(1) Task A320-A-57-XX-1228-07001-720A-A - Close the Access to the Forward Center Wing Box

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
130	Work location	From Frame 34 to Frame 36

Manpower/Resources/Skills

Man-hours	1.50 h
Minimum Number of person	2
Elapsed Time	0.75 h
Skills	Airframe

Material necessary to do the job

Consumables				
ITEM	**REFERENCE CML**	**DESCRIPTION**	**DRAWING**	**SEE NOTES**
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 571228A03R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
71	NAS1726-3E	6	NUT		

Referenced Information

Manuals/Drawings	References/Sheets
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 Task 25-54-12-400-001
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-40-00

Manuals/Drawings	References/Sheets
	51-42-00 51-43-00 51-78-00

Procedure

(a) Standard Practices given in this procedure:

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

2 For identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

3 For identification of access panels, refer to Ref. AMM 06-41-53, Page Block 001.

4 For the specification of Material application codes given in this Service Bulletin, refer to Ref. CML.

5 Remove and install fasteners in accordance with Ref. SRM 51-42-00.

6 To torque tighten the standard threaded fasteners, refer to Ref. AMM Task 20-21-11-911-001.

7 If alternative and substitute fasteners have to be used, you must make sure that the associated nut/collar are compatible in accordance with refer to Ref. SRM 51-40-00 ‘Mating Part’ column.

8 Get alternative and substitute fastener data in accordance with Ref. SRM 51-43-00.

9 Do the cleaning process in accordance with Ref. SRM 51-78-00.

(b) Install the FWD cargo compartment partition beams, refer to Ref. Fig. Installation of the Partition Beams at FR34 or FR35.5.

1 Clean all the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

2 Install the left FWD cargo compartment partition beam.

1	PARTITION BEAM ASSY		Item (101)	Retained
3	BOLT		Item (102)	Retained
3	WASHER		Item (103)	Retained
1	RING		Item (104)	Retained
3	NUT	NAS1726-3E	Item 71	

3 Install the right FWD cargo compartment partition beam.

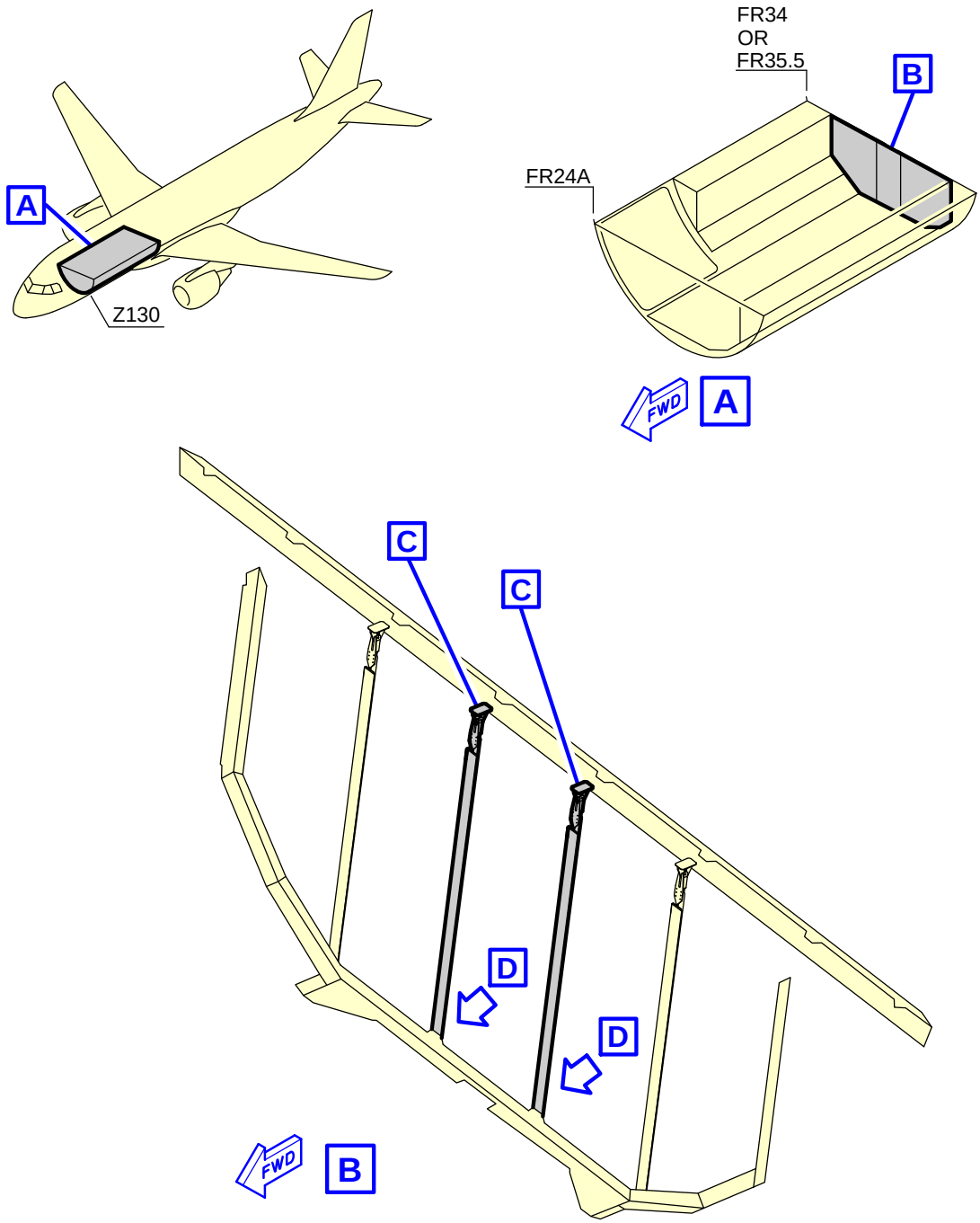
1	PARTITION BEAM ASSY	Item (101)	Retained
3	BOLT	Item (102)	Retained
3	WASHER	Item (103)	Retained
1	RING	Item (104)	Retained

3	NUT	NAS1726-3E	Item 71

(c) Install the FWD cargo compartment partition panels (Panel 131PW, Panel 131NW and Panel 132PW), refer to Ref. AMM Task 25-54-12-400-001.

(d) Remove the safety clips and tags and close the circuit breakers as specified after the installation FWD cargo compartment partition panels (Panel 131PW, Panel 131NW and Panel 132PW), refer to Ref. AMM Task 25-54-12-400-001.

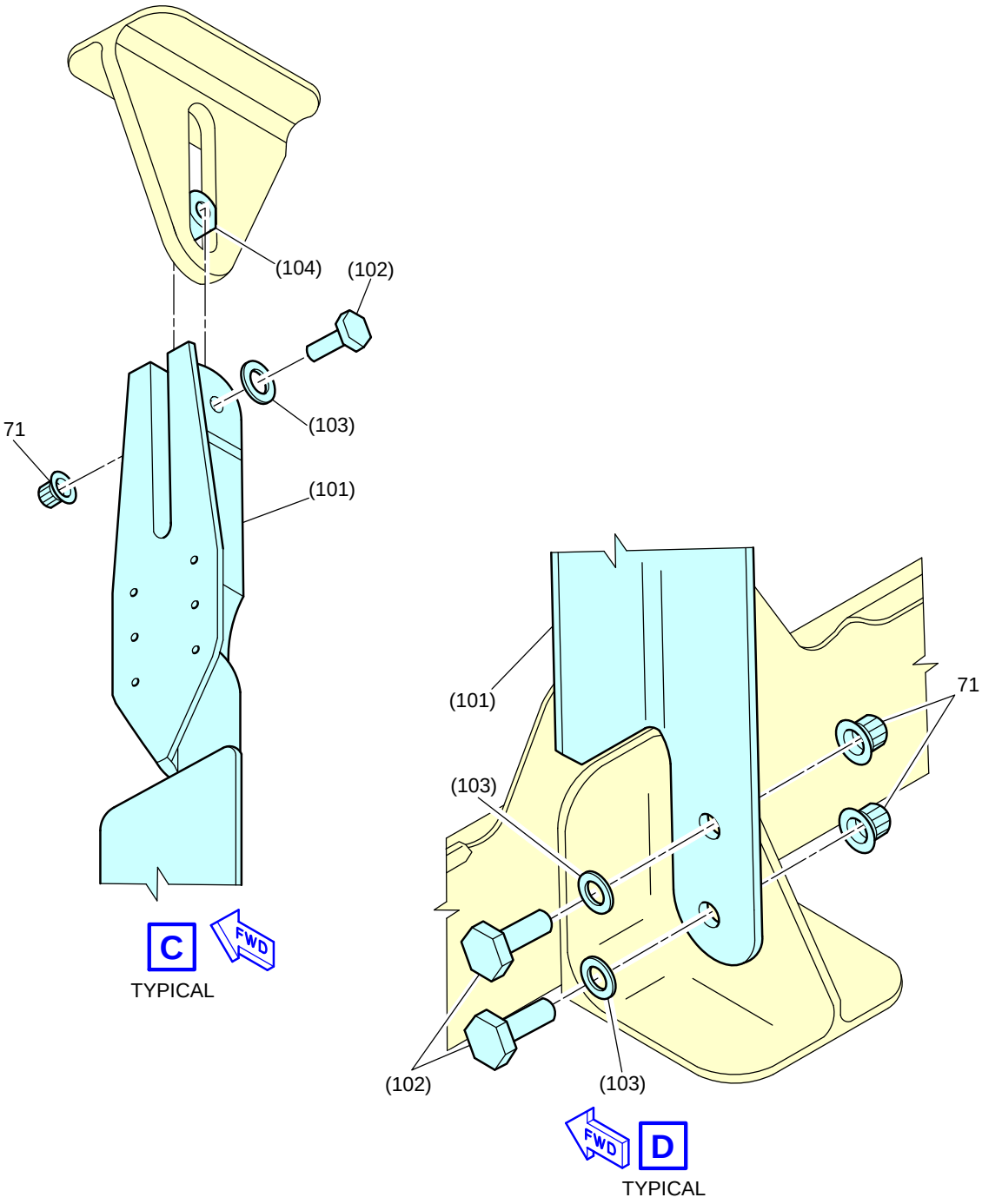
CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MM9-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MM9-A-002-01 SHEET 1/2

CONF ALL



ICN-A320-A-57XX1228-A-FAPE3-01MMA-A-001-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01MMA-A-001-01 SHEET 2/2

(2) Task A320-A-57-XX-1228-01001-740A-A - Close-up

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	1
Elapsed Time	1.00 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 32-12-00-410-001 Task 52-30-00-860-002

Procedure

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

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

(c) Close the main landing gear doors, refer to Ref. AMM Task 32-12-00-410-001.

(d) Remove the access platform(s).

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

G. ADMINISTRATIVE

(1) Task A320-A-57-XX-1228-01001-90AA-A - Administrative

Procedure

Confirm in the applicable aircraft records that you have completed all the work defined in this Service Bulletin task set as required.

APPENDIX

A. 01 - Manpower Gantt Chart

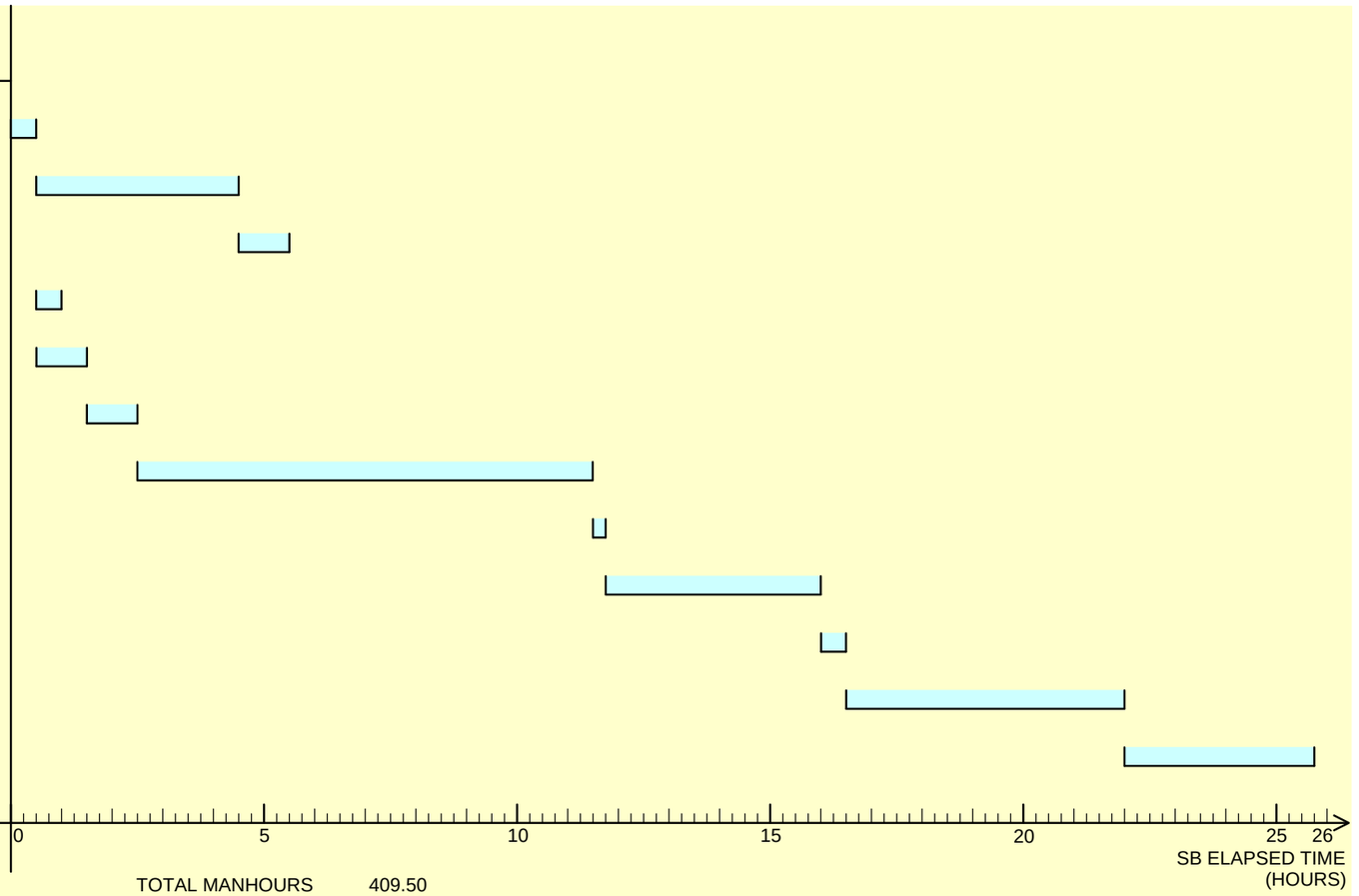
01- Manpower Gantt Chart

For an explanation of the man-hours and elapsed time, refer to the next page.

CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
JOB SET-UP	1.00	2	0.50
GET ACCESS TO THE FORWARD END FLOOR BEAMS	8.00	2	4.00
IF INSTALLED, REMOVAL OF THE BRIDGE OF THE INERTING SYSTEM	1.00	1	1.00
GET ACCESS TO THE CENTER WING BOX INTERIOR	1.00	2	0.50
IF INSTALLED, REMOVAL OF THE ADDITIONAL CENTER TANK No 6	2.00	2	1.00
IF INSTALLED, REMOVAL OF THE ADDITIONAL CENTER TANK No 4	2.00	2	1.00
GET ACCESS TO THE FORWARD CENTER WING BOX	16.75	2	9.00
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y 1292	0.25	1	0.25
REMOVAL OF THE VERTICAL STRINGER ON Y 1292	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y 1292	0.50	1	0.50
DRILLING OF THE NEW VERTICAL STRINGER ON Y 1292	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y 1292	6.25	2	3.75



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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

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.

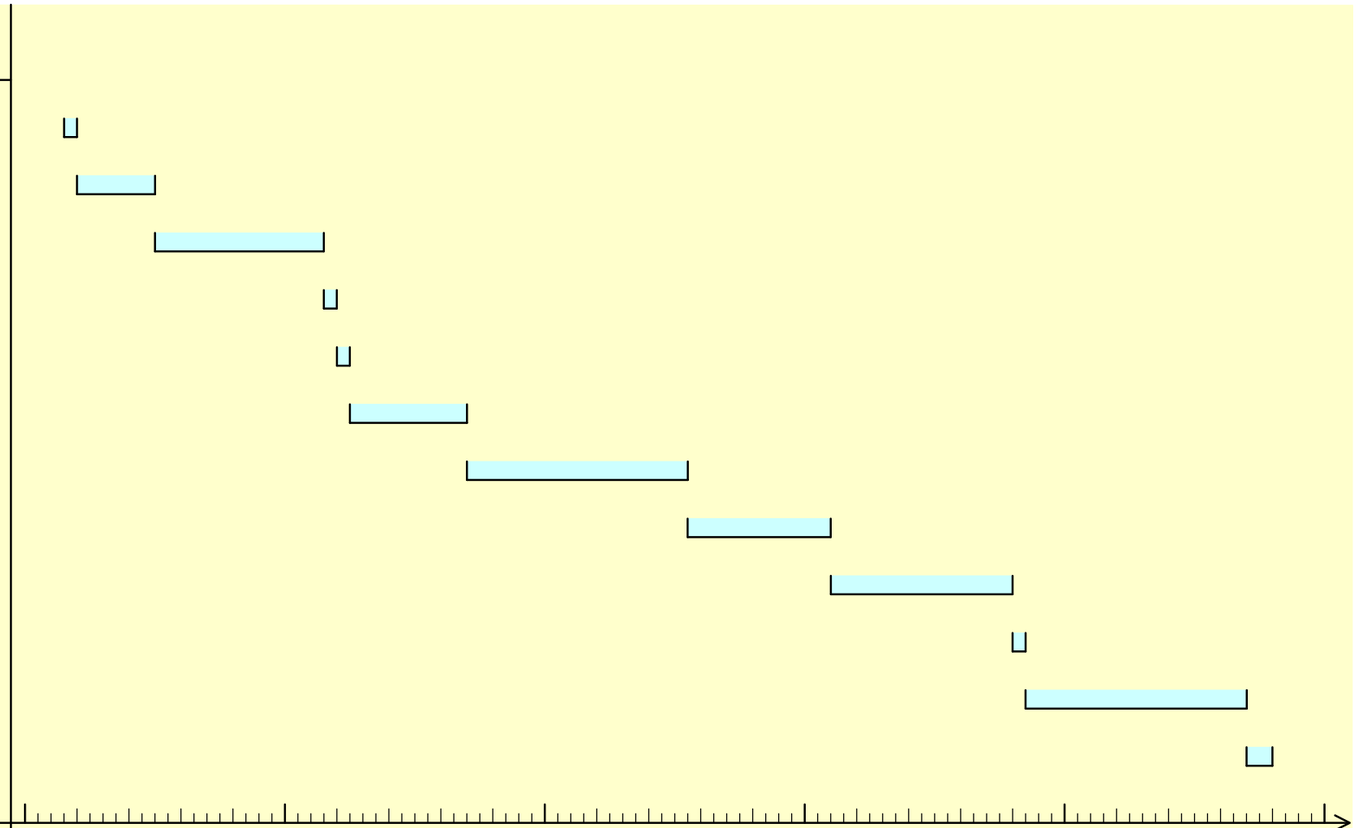
ICN-A320-A-57XX1228-A-FAPE3-01L0K-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01L0K-A-002-01 SHEET 1/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y 1292	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y 1292	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y 1292	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y 1292	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y 1292	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y 1292	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y 1292	4.25	2	2.75
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y 1292	7.00	2	3.50
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y 765	0.25	1	0.25
REMOVAL OF THE VERTICAL STRINGER ON Y 765	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y 765	0.50	1	0.50



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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

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.

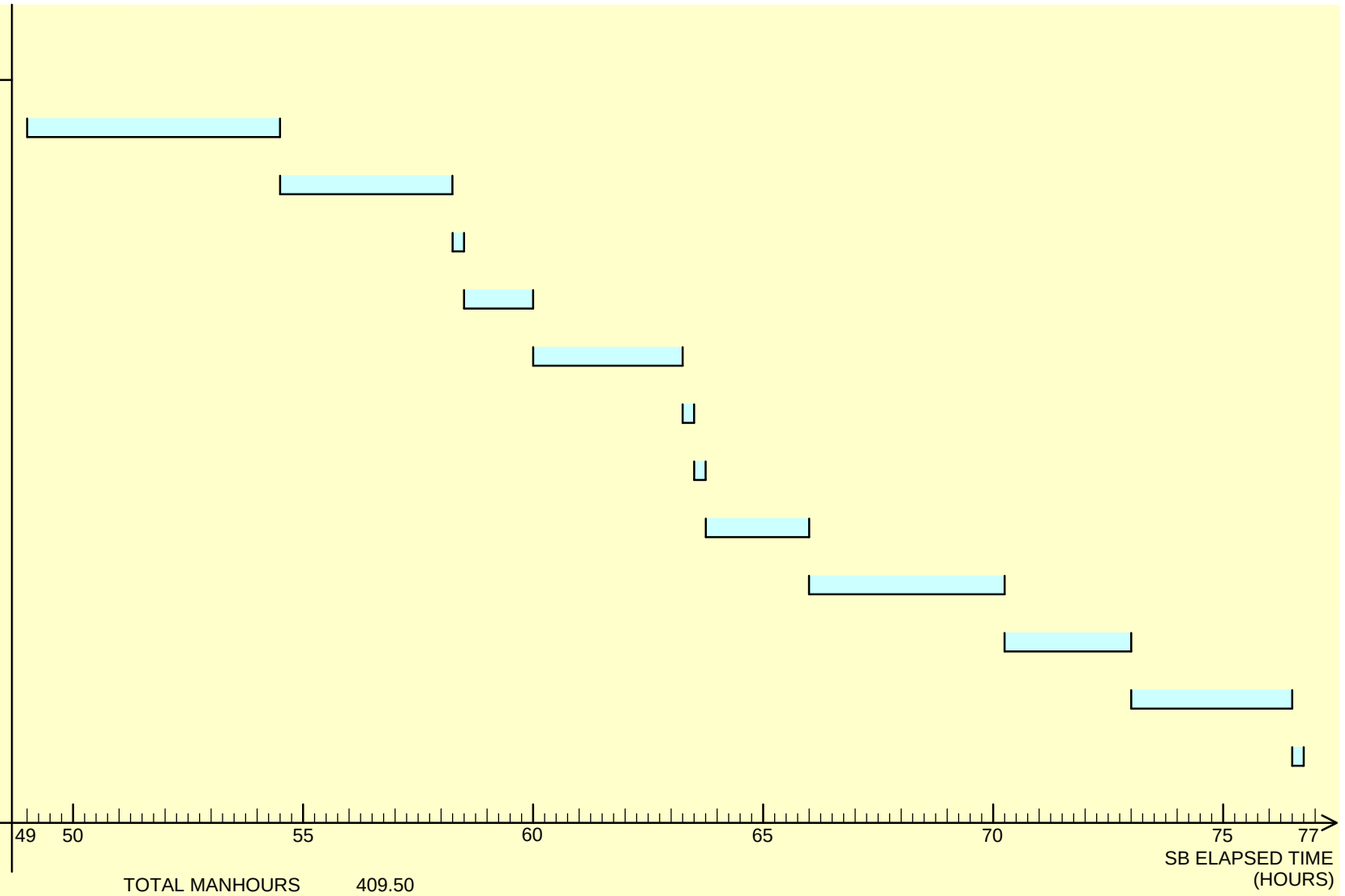
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Figure ICN-A320-A-57XX1228-A-FAPE3-01L0L-A-002-01 SHEET 2/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
DRILLING OF THE NEW VERTICAL STRINGER ON Y 765	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y 765	6.25	2	3.75
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y 765	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y 765	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y 765	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y 765	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y 765	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y 765	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y 765	4.25	2	2.75
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y 765	7.00	2	3.50
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y 254	0.25	1	0.25



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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

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.

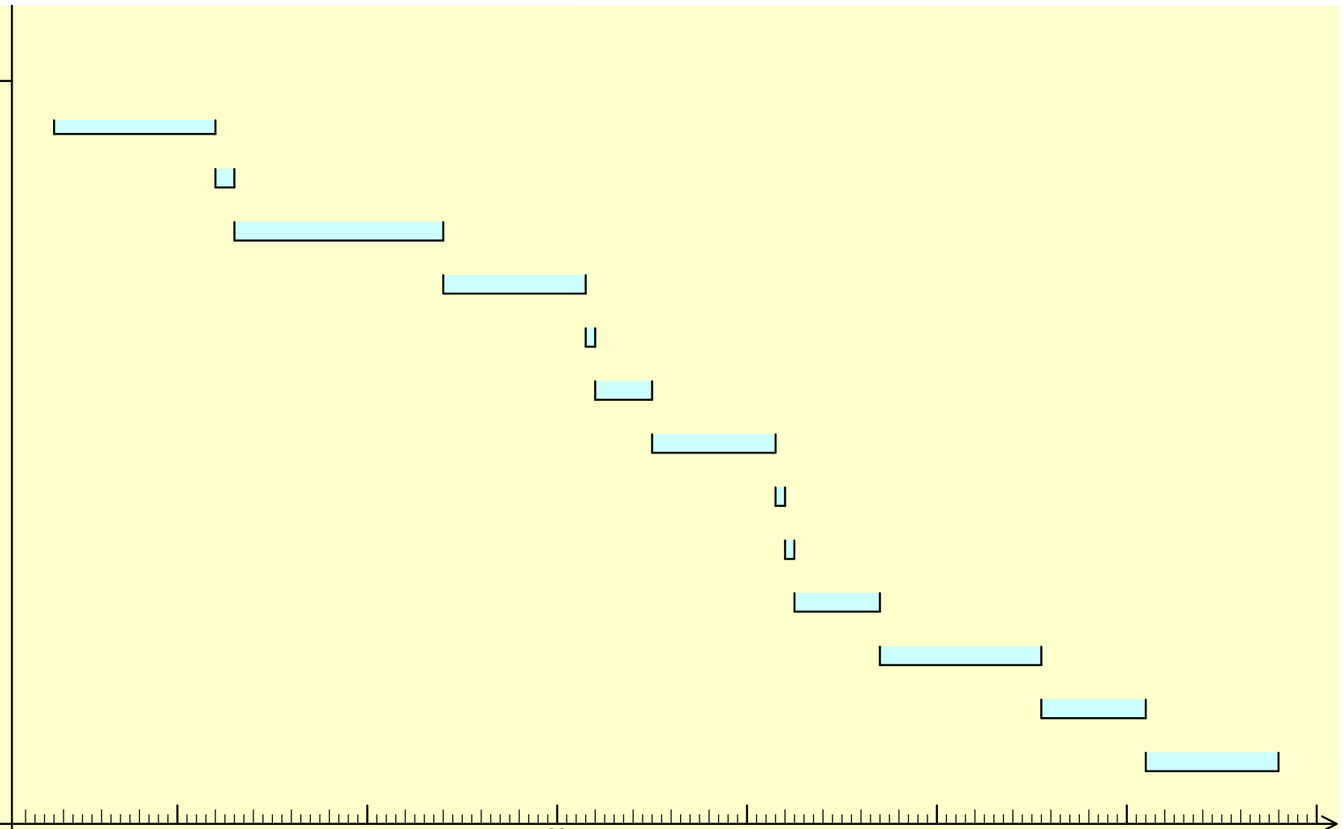
ICN-A320-A-57XX1228-A-FAPE3-01L0M-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01L0M-A-002-01 SHEET 3/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
REMOVAL OF THE VERTICAL STRINGER ON Y 254	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y 254	0.50	1	0.50
DRILLING OF THE NEW VERTICAL STRINGER ON Y 254	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y 254	6.25	2	3.75
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y 254	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y 254	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y 254	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y 254	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y 254	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y 254	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y 254	4.25	2	2.75
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y 254	7.00	2	3.50
TOTAL MANHOURS	409.50		
SB ELAPSED TIME	128.00		



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

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.

ICN-A320-A-57XX1228-A-FAPE3-01L0N-A-002-01

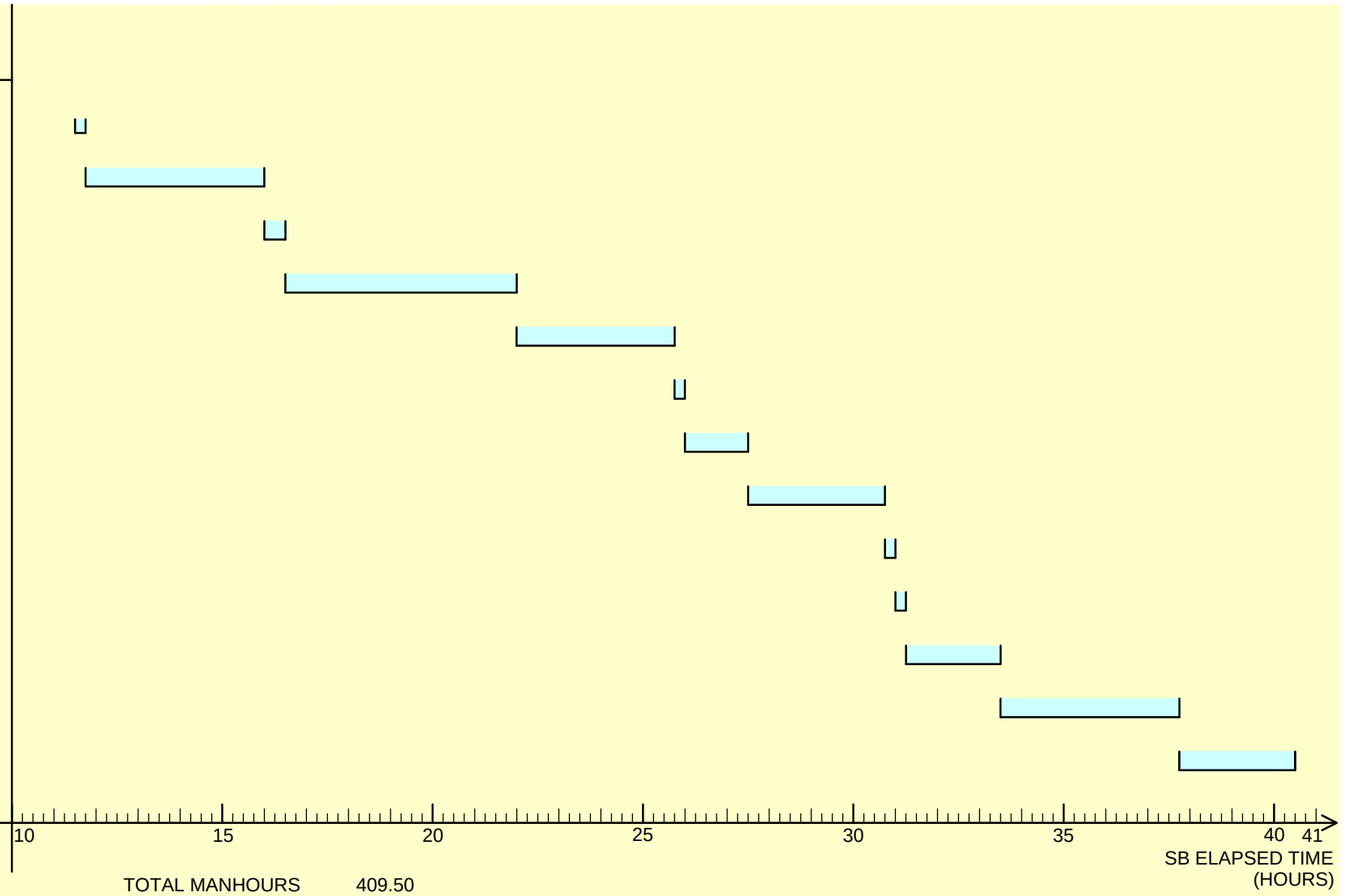
Figure ICN-A320-A-57XX1228-A-FAPE3-01L0N-A-002-01 SHEET 4/8

Manpower Gantt Chart

CONF ALL

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y -254	0.25	1	0.25
REMOVAL OF THE VERTICAL STRINGER ON Y -254	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y -254	0.50	1	0.50
DRILLING OF THE NEW VERTICAL STRINGER ON Y -254	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y -254	6.25	2	3.75
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y -254	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y -254	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y -254	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y -254	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y -254	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y -254	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y -254	4.25	2	2.75



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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

NOTE:

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

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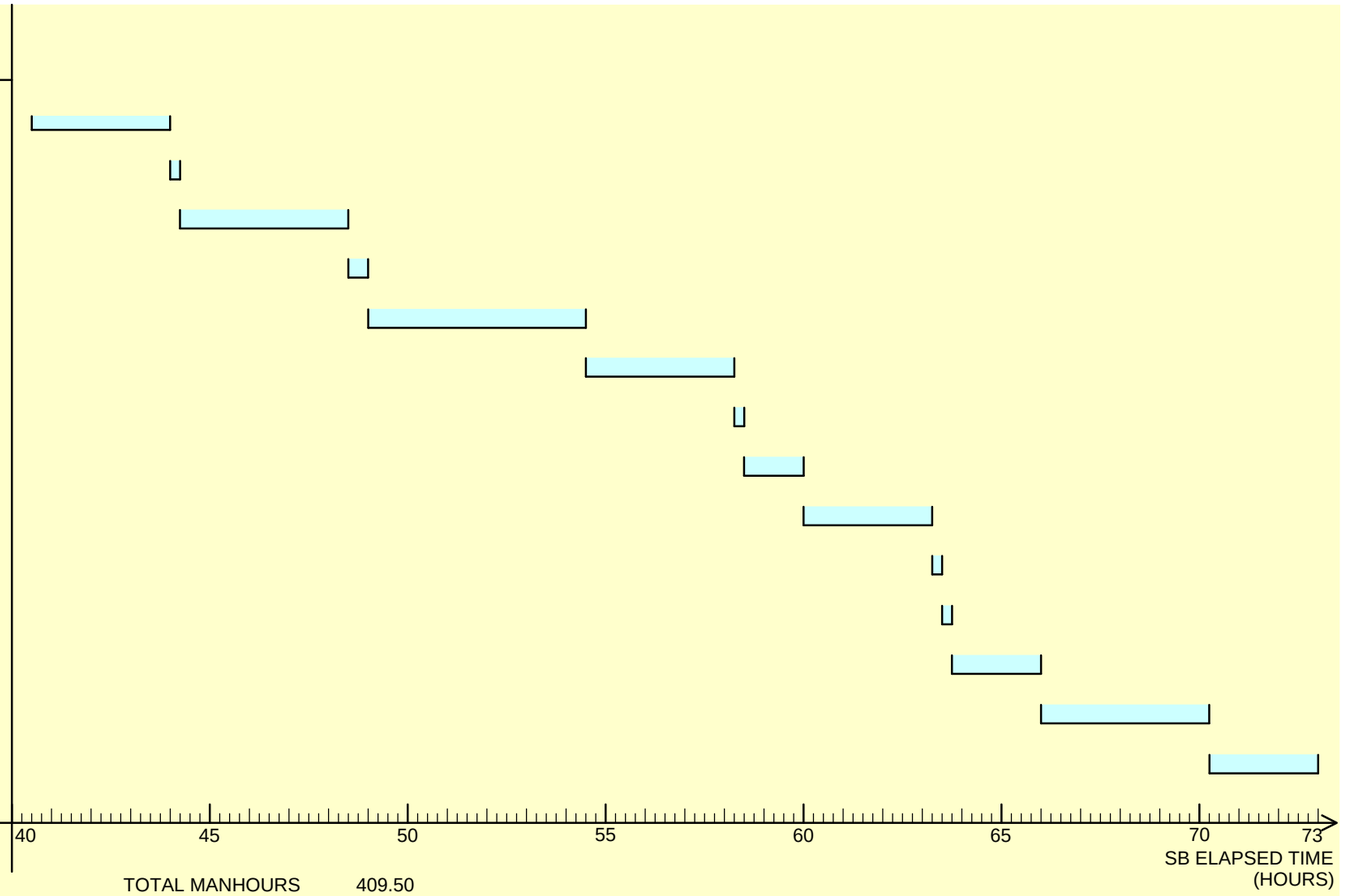
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Figure ICN-A320-A-57XX1228-A-FAPE3-01L0O-A-002-01 SHEET 5/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y -254	7.00	2	3.50
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y -765	0.25	1	0.25
REMOVAL OF THE VERTICAL STRINGER ON Y -765	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y -765	0.50	1	0.50
DRILLING OF THE NEW VERTICAL STRINGER ON Y -765	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y -765	6.25	2	3.75
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y -765	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y -765	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y -765	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y -765	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y -765	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y -765	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y -765	4.25	2	2.75



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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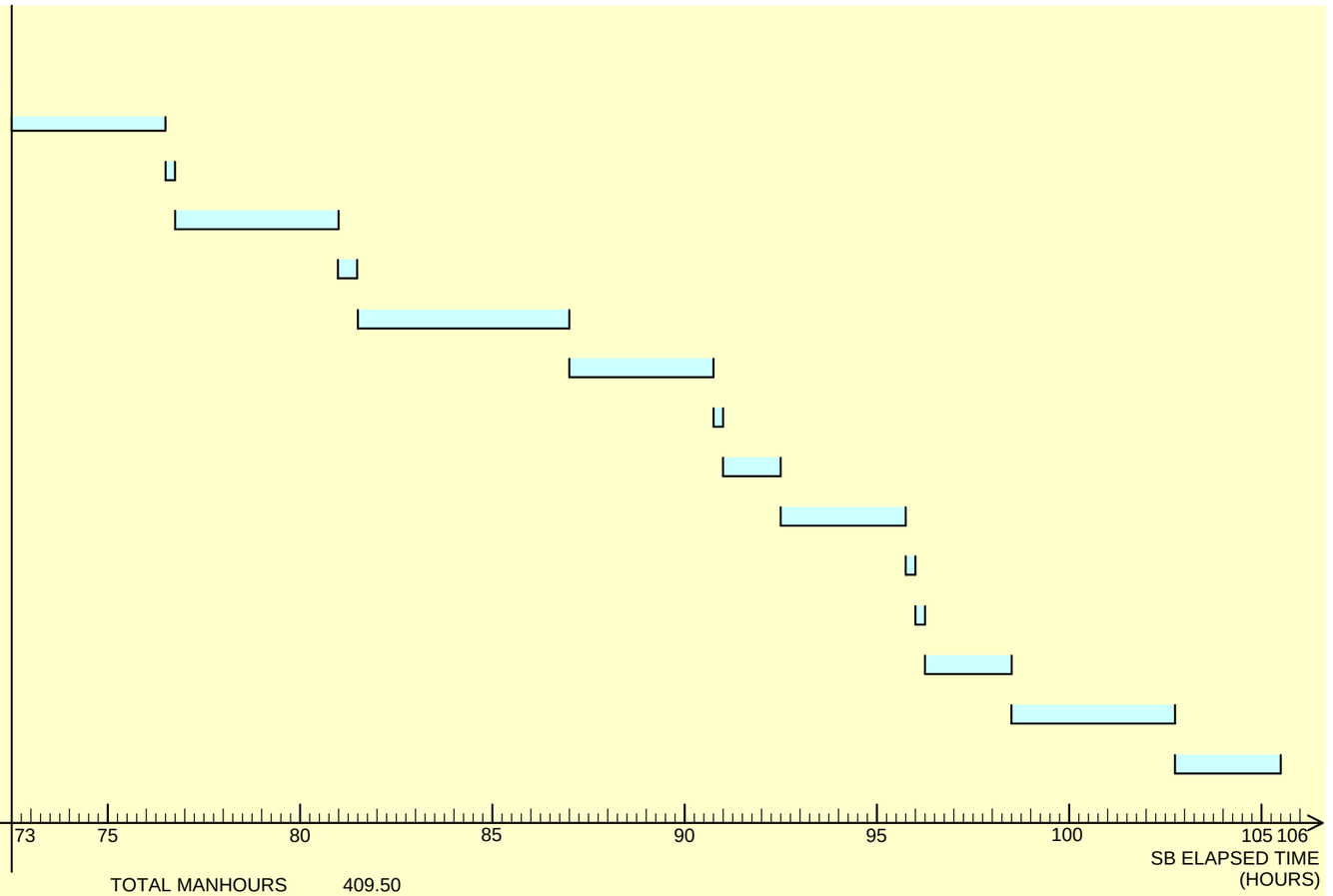
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Figure ICN-A320-A-57XX1228-A-FAPE3-01L0P-A-002-01 SHEET 6/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y -765	7.00	2	3.50
REMOVAL OF THE STRUT LOWER ATTACHMENT ON Y -1292	0.25	1	0.25
REMOVAL OF THE VERTICAL STRINGER ON Y -1292	7.25	2	4.25
DO THE INSPECTION ON THE CWB OF THE VERTICAL STRINGER FASTENER HOLES ON Y -1292	0.50	1	0.50
DRILLING OF THE NEW VERTICAL STRINGER ON Y -1292	10.00	2	5.50
INSTALLATION OF THE NEW VERTICAL STRINGER ON Y -1292	6.25	2	3.75
INSTALLATION OF THE STRUT LOWER ATTACHMENT ON Y -1292	0.25	1	0.25
REMOVAL OF THE FASTENERS OF THE FORWARD END FLOOR BEAMS ON Y -1292	2.75	2	1.50
CUT OUT OF THE FORWARD END FLOOR BEAM ON Y -1292	4.25	2	3.25
DO THE INSPECTION OF THE FORWARD END FLOOR BEAM AND FASTENER HOLES ON Y -1292	0.25	1	0.25
ON BENCH, INSTALLATION OF THE BUSH IN THE NEW UPPER FITTING	0.25	1	0.25
TEMPORARILY, INSTALLATION OF THE NEW PARTS FOR ADJUSTMENT ON Y -1292	4.25	2	2.25
DRILLING OF THE NEW PARTS ON Y -1292	7.50	2	4.25
INSTALLATION OF THE NEW PARTS ON Y -1292	4.25	2	2.75



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

MH : MANHOURS
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ET/S: ELAPSED TIME PER STEP

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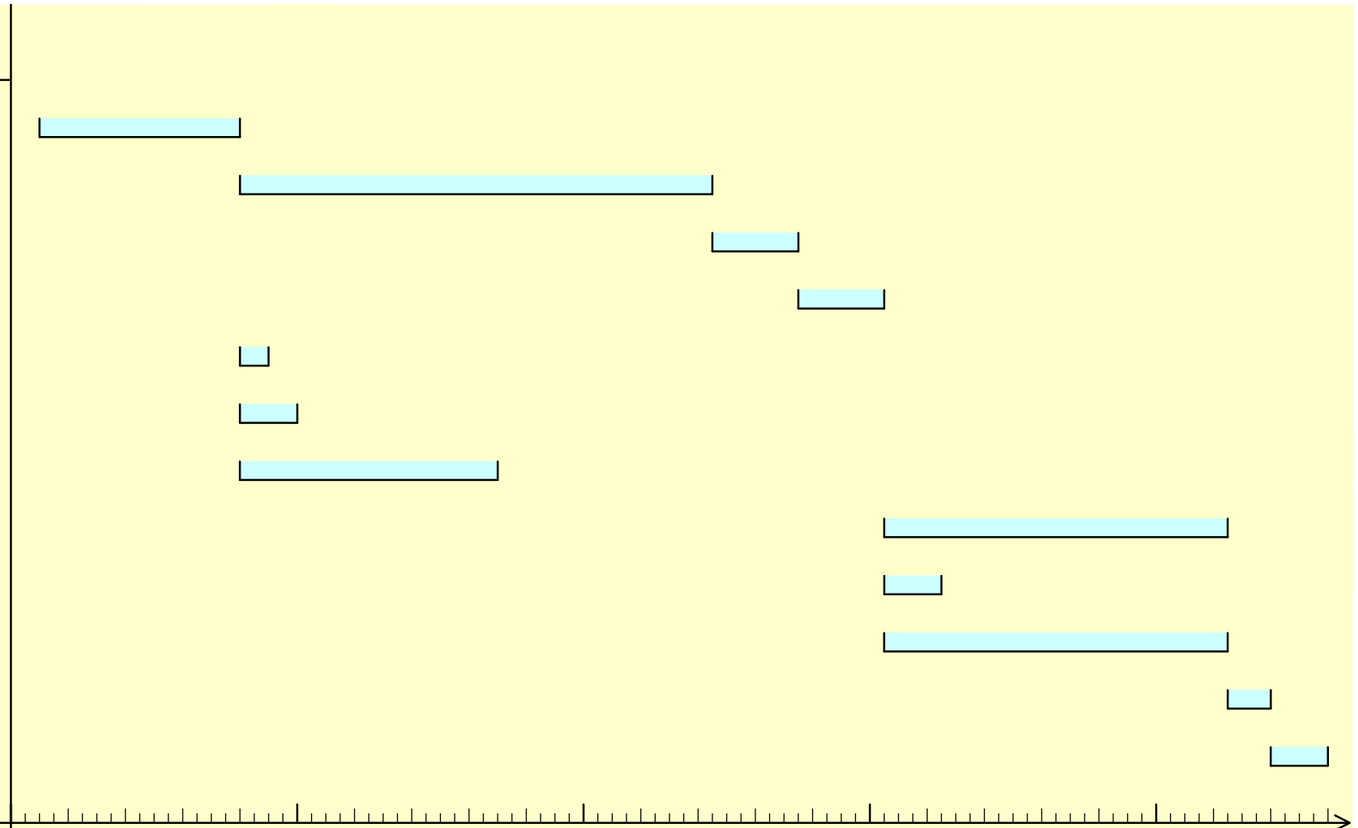
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Figure ICN-A320-A-57XX1228-A-FAPE3-01L0Q-A-002-01 SHEET 7/8

Manpower Gantt Chart

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A320-57-1228 01 02

STEPS	MH	PER	ET/S
PROTECTION OF THE FASTENERS AND THE NEW PARTS ON Y -1292	7.00	2	3.50
DO THE PREPARATION BEFORE FORWARD CENTER WING BOX TESTING	15.25	2	8.25
IF REMOVED, INSTALLATION OF THE ADDITIONAL CENTER TANK No 6	3.00	2	1.50
IF REMOVED, INSTALLATION OF THE ADDITIONAL CENTER TANK No 4	3.00	2	1.50
DO THE PREPARATION BEFORE CENTER WING BOX TESTING	1.00	2	0.50
IF REMOVED, INSTALLATION OF THE BRIDGE OF THE INERTING SYSTEM	1.00	1	1.00
DO THE PREPARATION BEFORE CABIN TESTING	9.00	2	4.50
DO THE FORWARD CENTER WING BOX TESTING	6.00	1	6.00
DO THE CENTER WING BOX TESTING	1.00	1	1.00
DO THE CABIN TESTING	6.00	1	6.00
CLOSE THE ACCESS TO THE FORWARD CENTER WING BOX	1.50	2	0.75
CLOSE-UP	1.00	1	1.00



TOTAL MANHOURS 409.50
SB ELAPSED TIME 128.00

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ICN-A320-A-57XX1228-A-FAPE3-01L0R-A-002-01

Figure ICN-A320-A-57XX1228-A-FAPE3-01L0R-A-002-01 SHEET 8/8

Manpower Gantt Chart

B. REPORTING SHEET

TITLE:	WINGS - CENTER WING - REPLACE CURRENT END OF FLOOR BEAMS AND VERTICAL STRINGERS BY REINFORCED ONES

MODIFICATION No.:	164698P20635

(1) 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.

(2) 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.

(3) 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 Bulletins?"

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

C. QUALITY PERCEPTION FORM

Use this form to tell us what is your perception of the quality of this Service Bulletin.

The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletin.

We thank you for the time you have taken in completing this form.

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			

NOTE: Please rate on a scale of 1 to 4, with 4 being the highest score

If you have 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	Applicability	X	Tooling	X	Preparation
X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Kit content	X	Test
X	References	X	Re-identification	X	Close-up
X	Publication			X	Illustrations
X	Industry Support				

Comments :

Operator : Date :

Name/Title

Please return this form to :

AIRBUS
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31700 BLAGNAC
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Or via your Resident Customer Support Office.