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ATA SYSTEM: 53

TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

MODIFICATION No.:

160876P15989

ATA SYSTEM: 53

TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

REVISION TRANSMITTAL SHEET

This page transmits Revision No. 02 of Service Bulletin No. A320-53-1381.

A. ADDITIONAL WORK

No additional work is required by this revision.

B. REASON

Revision No. 02 issued to:

- Add aircraft Manufacturer Serial Number (MSN) 00109 for operator 98W, MSN 01305 for operator 36R, MSN 03238 for operator KNE, MSN 03617 for operator 55J, MSN 03932 for operator S3R and MSN 04878 for operator HKJ
- Add internal views of the fastener holes in the rotating probe inspection illustration
- Correct the consumable reference 12ABD1 to 12ADB1
- Correct the AMM task reference from 25-23-45-000-002 to 25-23-45-000-005
- Update the cold working tools Part Number (PN) and quantity.

C. CHANGES

CONF 001

SERVICE BULLETIN	
General	Sentence updated.
SUMMARY	
MATERIAL PRICE INFORMATION	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Paragraph updated.
APPLICABILITY	Operators updated.
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
GENERAL OVERVIEW	
Fig.SA Sol.AA General Overview	Figure updated to update the latest standards.
PLANNING INFORMATION	
APPLICABILITY	
Configuration definition	Scrapped aircraft MSNs removed. Aircraft added.
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
APPROVAL	Sentence updated.
REFERENCES	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	AMM reference updated. Manual list rearranged and "Full content" is added in reference table for administrative reason with no technical impact. Concurrent Service Bulletin reference added.

PUBLICATION AFFECTED	"Full content" is added in reference table for administrative reason with no technical impact.
MATERIAL INFORMATION	
TOOLING	
Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification	Cold working tools PN and quantity updated. Notes updated.
CONSUMABLES	Consumable reference updated.
LIST OF NEW PARTS	
Part kit 531381A01R01	Cost and availability values updated.
ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Caution updated.
PREPARATION	
A320-A-53-XX-1381-01001-540A-A Job Set-up	Task updated to: - Change the note into work step - Correct the AMM task reference from 25-23-45-000-002 to 25-23-45-000-005 - Update the sentence - Add the note.
Fig.BD Sol.AA Location of the Area to be Modified	New figure created to show location of the area to be modified.
PROCEDURE	
A320-A-53-XX-1381-01001-520A-A Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	Task updated to: - Remove the item numbers - Update the fasteners PN description from lowercase to uppercase - Add the note.
Fig.BB Sol.AA Removal of the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the removal of the fasteners, without technical impact.
A320-A-53-XX-1381-01001-353A-A Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Manuals sequence interchanged in referenced information.
Fig.CA Sol.AA Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Add internal views of the fastener holes - Update the latest standards.
A320-A-53-XX-1381-01001-900A-A Do a Cold Working of the Fastener	Task updated to change the cold working tools PN.

Holes of the Frame 16 Double Joggle Area, on the LH Side	
Fig.BA Sol.AA Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Show only the cold working of the fastener holes, without technical impact - Update the latest standards.
A320-A-53-XX-1381-01001-720A-A Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	Task updated to update the consumable reference 12ABD1 to 12ADB1.
Fig.BC Sol.AA Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the installation of the fasteners, without technical impact.

CONF 002

SERVICE BULLETIN	
General	Sentence updated.
SUMMARY	
MATERIAL PRICE INFORMATION	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Paragraph updated.
APPLICABILITY	Operators updated.
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
GENERAL OVERVIEW	
Fig.SA Sol.AA General Overview	Figure updated to update the latest standards.
PLANNING INFORMATION	
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
APPROVAL	Sentence updated.
REFERENCES	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	AMM reference updated. Manual list rearranged and "Full content" is added in reference table for administrative reason with no technical impact. Concurrent Service Bulletin reference added.
PUBLICATION AFFECTED	"Full content" is added in reference table for administrative reason with no technical impact.
MATERIAL INFORMATION	
TOOLING	
Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification	Cold working tools PN and quantity updated. Notes updated.
CONSUMABLES	Consumable reference updated.
LIST OF NEW PARTS	
Part kit 531381A02R01	Cost and availability values updated.

ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Caution updated.
PREPARATION	
A320-A-53-XX-1381-01001-540A-A Job Set-up	Task updated to: - Change the note into work step - Correct the AMM task reference from 25-23-45-000-002 to 25-23-45-000-005 - Update the sentence - Add the note.
Fig.BD Sol.AA Location of the Area to be Modified	New figure created to show location of the area to be modified.
PROCEDURE	
A320-A-53-XX-1381-01001-520A-A Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	Task updated to: - Remove the item numbers - Update the fasteners PN description from lowercase to uppercase - Add the note.
Fig.BB Sol.AA Removal of the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the removal of the fasteners, without technical impact.
A320-A-53-XX-1381-01001-353A-A Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Manuals sequence interchanged in referenced information.
Fig.CA Sol.AA Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Add internal views of the fastener holes - Update the latest standards.
A320-A-53-XX-1381-01002-900A-A Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Task updated to change the cold working tools PN.
Fig.BA Sol.AB Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Show only the cold working of the fastener holes, without technical impact - Update the latest standards.
A320-A-53-XX-1381-01002-720A-A Install the Fasteners on the Frame 16	Task updated to update the consumable reference 12ABD1 to 12ADB1.

Double Joggle Area, on the LH Side	
Fig.BC Sol.AB Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the installation of the fasteners, without technical impact.

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SERVICE BULLETIN	
General	Sentence updated.
SUMMARY	
MATERIAL PRICE INFORMATION	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Paragraph updated.
APPLICABILITY	Operators updated.
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
GENERAL OVERVIEW	
Fig.SA Sol.AA General Overview	Figure updated to update the latest standards.
PLANNING INFORMATION	
CONCURRENT REQUIREMENTS	Concurrent Service Bulletin added.
APPROVAL	Sentence updated.
REFERENCES	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	AMM reference updated. Manual list rearranged and "Full content" is added in reference table for administrative reason with no technical impact. Concurrent Service Bulletin reference added.
PUBLICATION AFFECTED	"Full content" is added in reference table for administrative reason with no technical impact.
MATERIAL INFORMATION	
TOOLING	
Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification	Cold working tools PN and quantity updated. Notes updated.
CONSUMABLES	Consumable reference updated.
LIST OF NEW PARTS	
Part kit 531381A03R01	Cost and availability values updated.
ACCOMPLISHMENT INSTRUCTIONS	
Task set A320-A-53-XX-1381-01000-93AA-A Modification	Caution updated.
PREPARATION	
A320-A-53-XX-1381-01001-540A-A Job Set-up	Task updated to: - Change the note into work step - Correct the AMM task reference from 25-23-45-000-002 to 25-23-45-000-005

	- Update the sentence - Add the note.
Fig.BD Sol.AA Location of the Area to be Modified	New figure created to show location of the area to be modified.
PROCEDURE	
A320-A-53-XX-1381-01001-520A-A Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	Task updated to: - Remove the item numbers - Update the fasteners PN description from lowercase to uppercase - Add the note.
Fig.BB Sol.AA Removal of the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the removal of the fasteners, without technical impact.
A320-A-53-XX-1381-01001-353A-A Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Manuals sequence interchanged in referenced information.
Fig.CA Sol.AA Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Add internal views of the fastener holes - Update the latest standards.
A320-A-53-XX-1381-01003-900A-A Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Task updated to change the cold working tools PN.
Fig.BA Sol.AC Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	Figure updated to: - Show only the cold working of the fastener holes, without technical impact - Update the latest standards.
A320-A-53-XX-1381-01003-720A-A Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	Task updated to update the consumable reference 12ABD1 to 12ADB1.
Fig.BC Sol.AC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	New figure created to show only the installation of the fasteners, without technical impact.

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D. FILING INSTRUCTIONS

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

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

E. HISTORY OF PREVIOUS REVISIONS

Revision No. 01 issued to:

- Update the applicability
- Transform Service Bulletin data from ATA iSpec 2200 norm to ASD S1000D norm
- Remove the applicability note.

F. REVISION SEQUENCE

ORIGINAL: Jun 14/18

REVISION No. : 01 - Sep 18/19

REVISION No. : 02 - Apr 20/23

ATA SYSTEM: 53

TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

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	160876P15989

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	160876P15989

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	160876P15989

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

Following the amount and severity of in-service findings and the high finding rate in the double joggle area, the need for an in-service action has been identified.

Definition of a new harmonised and unique inspection program for both Frame 16 and Frame 20 double joggle area taking into account the in-service findings.

(2) Objective/Action

The modification consists in redesigning the double joggle area at Frame 16 Left Hand (LH) side. It implies to apply cold working at Frame 16 LH side and install moderate interference fit fasteners.

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

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

(3) Advantages

The modification will contribute to avoid new in-service findings in the double joggle area.

Accomplishment of this Service Bulletin cancels the requirements of Service Bulletin No. Ref. SB A320-53-1373 for LH side.

(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	NO
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

No specific aircraft maintenance configuration required.

CONF 002

No specific aircraft maintenance configuration required.

CONF 003

No specific aircraft maintenance configuration required.

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E. MATERIAL PRICE INFORMATION

CONF 001

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 531381A01R01	1	499.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

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

CONF 002

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 531381A02R01	1	499.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

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

CONF 003

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 531381A03R01	1	499.00 USD	Bolts, nuts
Aircraft standard tools	See SB	See Note	FTI cold working tools, WCI cold working tools

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):

01N 01V 01X 03Q 06R 08M 09J 10N 11K 11X 13Y 14F 14S 15S 15T 17J 18T 19R 1CE 20M 23R 26L 27L 28M 29S 31G 31P 31V 32O 32Q 34L 35K 35M 36R 36V 37N 39N 39V 40N 40S 41S 44W 46L 46O 46P 47P 48T 49J 49N 49O 50K 51L 52K 52L 55J 56K 56O 56S 57L 58H 58J 60U 61W 62J 64J 66X 68M 69J 69X 70M 72T 73W 76W 77L 78X 79L 81K 82J 82M 82U 82W 83O 83Q 83V 84O 84W 85M 85T 86K 86P 86Z 87Q 87U 87Z 89G 89Q 90J 90Q 90U 94J 95V 95W 96O 96Q 96U 98G 98W 98X 99W A1L A2E AAG AAL AAR AAW AAY ABL ABN ABQ ABR ABY ACA ACY ADY AEE AFL AFR AHY AIA AIC ALK AMC AMU AMV ANA ANK ANZ APJ ART ARU ASA ASL ASV AUA AUH AVA AVJ AWC AWG AWW AXM AZA B2V BAV BAW BBT BDJ BEC BEL BER BGF BGH BIX BKP BNL BSX BTK BTN BUC BVL C2C CBG CBJ CCA CCM CDC CEB CES CFG CGA CGH CHB CJL CLH CPA CQH CQN CRK CSA CSC CSN CSZ CTN CTU CTV CWN CYF CYP DAL DIR DKH DLH DML DNU DQA DRK DTL EAF EDW EFA EIN EOK ETD ETJ EVA EVE EWE EWG EWL EXS EXV EZY F2I FAD FDT FFT FHM FHY FIA FIE FIN FJL FLI FOE FRN G2X G8E GAF GAP GBB GCR GFA GJM GJT GLG GOW GSW GTR GWI GWR GXA GZQ HDA HES HFM HFY HIM HKE HKJ HOT HST HVN HXA HYM HYS IAC IAD IAE IAW IBE IBS IGO IND IPM IRA IRB IRC IRM ISR ITY IYE IZG JAD JAT JAV JBU JBW JCC JES JJP JOC JSA JST JZR KAC KHV KIS KME KNE KRP KZR LAA LAN LAO LBT LDA LFO LHT LIL LKE LLM LMJ LMU LVT LWA LYX LZB M6D M6S MAC MEA MGW MJN MKR MLD MLH MMA MMM MMO MNG MNS MRJ MSC MSR MYM MYX NDA NGN NIA NKS NMA NMB NVD NWK NWS O2X O8K OCN OHY OLY OMS ONE ORF OTC OYA OZW PAL PAS PGT PIA PIC PKZ PRX PVG QAF QDA QNT QQE QSM QTR R1T R7D RBA RBG RJA RJD RNA ROT RWZ RYL RZO S2A S3R SAA SAS SAW SBI SDM SDR SEH SEK SFJ SFW SHJ SHU SHY SIF

SJO SJV SNA SND SNG SOL STW SUD SUE SVA SVI SVR SWM SWR SYR SZN T2R TAH TAI TAM TAP TAR TBA TBZ TDR TGW THD THY TNA TNU TSC TTW UAL UEA ULS UZB UZP VAG VAW VIV VJC VKG VLG VOE VOI VRE VRG VTI VVC WHT WRC WZZ

G. CONCURRENT REQUIREMENTS

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

Service Bulletin(s)	Modification(s)
Ref. SB A320-53-1373	

NOTE: Service Bulletin No. Ref. SB A320-53-1373 (FUSELAGE - NOSE FORWARD FUSELAGE - INSPECTION DOUBLE JOGGLE AREA FR16).

NOTE: When an operator records the SB report, it is also the operator's responsibility to report all prerequisite Service Bulletin to AIRBUS.

H. NATURE OF THE WORK

CONF 001

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

CONF 002

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

CONF 003

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT	YES
EQUIPMENT	NO

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I. MANPOWER

CONF 001

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h
ELAPSED TIME (HOURS)	22.35 h

CONF 002

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h
ELAPSED TIME (HOURS)	22.35 h

CONF 003

(1) Modification

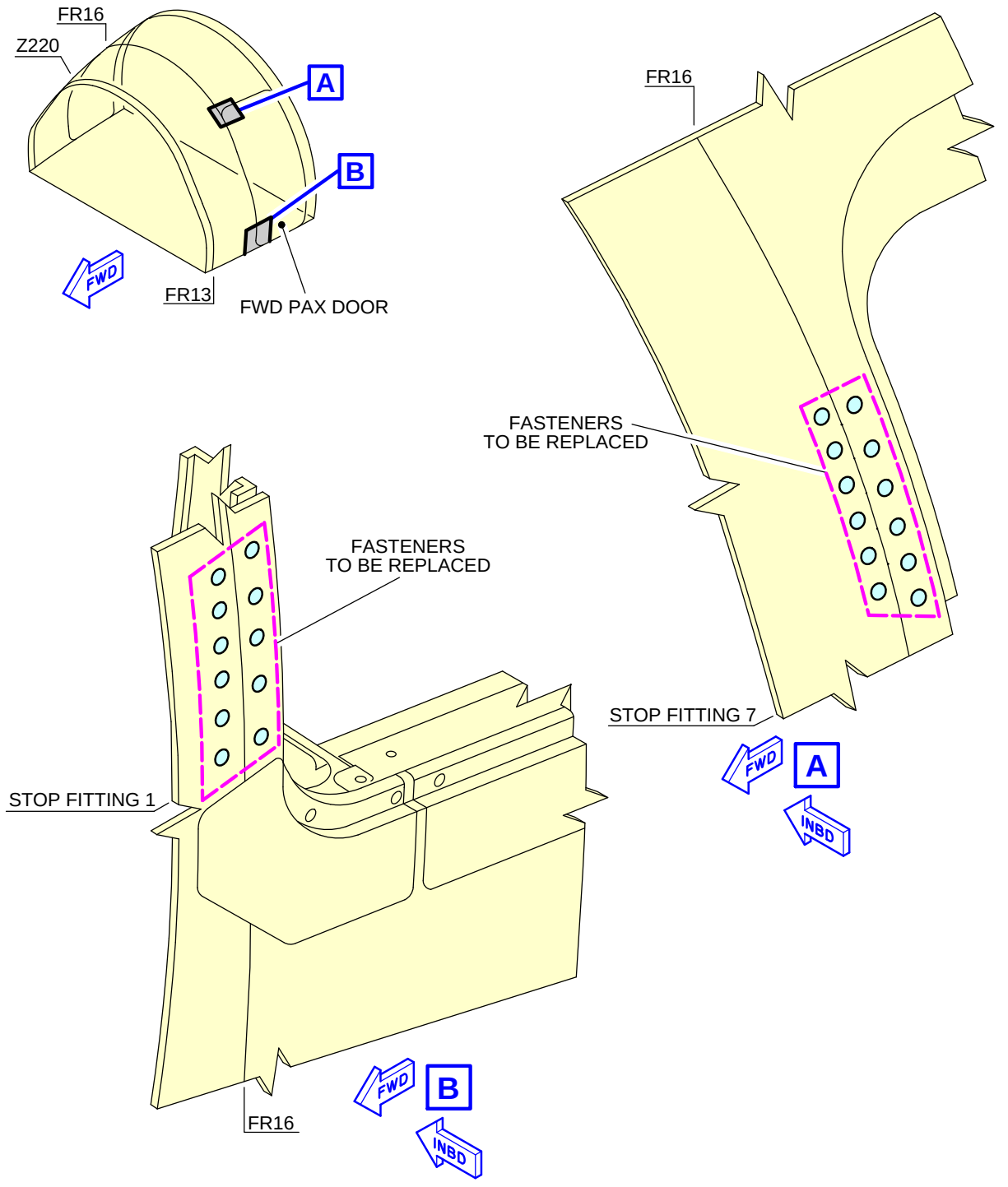
(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

MANPOWER	
TOTAL MAN-HOURS	22.35 h
ELAPSED TIME (HOURS)	22.35 h

CONF ALL

J. GENERAL OVERVIEW

CONF ALL



ICN-A320-A-53XX1381-A-FAPE3-00A39-A-003-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A39-A-003-01 Fig.SA Sol.AA SHEET 1/1

ATA SYSTEM: 53

TITLE: FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

1. PLANNING INFORMATION

A. APPLICABILITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: The intent of this modification is achieved in production on:
- A319 aircraft with MSN 09020 and subsequent
- A320 aircraft with MSN 08786 thru 08797, 08824 and subsequent
- A321 aircraft with MSN 08791, 08822 thru 08854, 08858 and subsequent

through modification No. 160917P15988.

NOTE: This Service Bulletin is only applicable to aircraft on which MOD No. 160917P15988 (FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN THE DOUBLE JOGGLE AREA FRAME 16 AND 20 (SERIAL SOLUTION)) is not embodied.

NOTE: This Service Bulletin is not applicable to A319 CORPO JET and A318 ELITE.

(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 02394, 02523, 02544, 02552, 02575, 03238, 03617, 03932, 04007, 04039, 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, 02129, 02170, 02176, 02179, 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, 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,

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(2) Applicability by MSN

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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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06394 06395 06396 06397 06398 06399 06400 06401 06402 06403 06404 06405 06406 06407 06408 06409 06410 06411 06412 06413 06414 06415 06416 06417 06418 06420 06421 06422 06423 06424 06425 06426 06427 06428 06429 06430 06431 06432 06433 06434 06435 06436 06437 06438 06439 06440 06441 06442 06443 06444 06445 06446 06447 06448 06449 06450 06451 06452 06453 06454 06455 06456 06457 06458 06459 06460 06461 06462 06463 06465 06466 06467 06468 06469 06470 06471 06472 06473 06474 06475 06476 06477 06478 06479 06480 06481 06482 06483 06484 06485 06486 06487 06488 06489 06490 06491 06492 06493 06494 06495 06496 06497 06498 06499 06501 06502 06503 06504 06505 06506 06507 06508 06509 06510 06511 06512 06513 06514 06515 06516 06517 06518 06519 06520 06521 06522 06523 06524 06525 06526 06527 06528 06529 06530 06531 06532 06533 06534 06535 06536 06537 06538 06539 06540 06541 06542 06543 06544 06545 06546 06547 06548 06549 06550 06551 06552 06553 06554 06555 06556 06557 06558 06559 06560 06561 06562 06563 06564 06565 06566 06567 06568 06569 06570 06571 06572 06573 06574 06575 06576 06577 06578 06579 06580 06581 06582 06583 06584 06585 06586 06587 06588 06589 06590 06591 06592 06593 06594 06595 06596 06597 06598 06599 06600 06601 06602 06603 06604 06605 06606 06607 06608 06609 06610 06611 06612 06613 06614 06615 06616 06617 06618 06619 06621 06622 06623 06624 06625 06626 06627 06628 06629 06630 06631 06632 06633 06634 06635 06636 06637 06638 06639 06640 06641 06643 06644 06645 06646 06647 06648 06649 06651 06652 06653 06654 06655 06656 06657 06658 06659 06660 06661 06662 06663 06664 06665 06666 06667 06668 06669 06670 06671 06672 06674 06675 06676 06677 06678 06679 06680 06681 06682 06683 06684 06685 06686 06687 06688 06689 06690 06691 06692 06693 06694 06695 06696 06697 06698 06699 06701 06702 06703 06704 06705 06706 06707 06708 06709 06710 06711 06712 06713 06714 06715 06716 06717 06718 06719 06721 06722 06723 06724 06725 06726 06728 06729 06730 06731 06732 06733 06734 06735 06736 06737 06738 06739 06740 06741 06742 06743 06745 06746 06747 06748 06749 06750 06751 06752 06753 06754 06755 06756 06757 06758 06759 06760 06761 06762 06763 06764 06765 06766 06767 06768 06769 06770 06771 06773 06774 06775 06776 06777 06778 06779 06780 06781 06782 06783 06784 06785 06786 06787 06788 06789 06790 06791 06792 06793 06794 06795 06796 06797 06798 06800 06802 06803 06804 06805 06806 06807 06808 06809 06810 06811 06812 06813 06814 06815 06816 06817 06818 06820 06821 06822 06823 06824 06825 06826 06827 06828 06830 06831 06832 06834 06835 06836 06837 06838 06840 06841 06842 06843 06844 06845 06846 06847 06848 06850 06851 06852 06853 06854 06855 06856 06857 06858 06859 06861 06862 06863 06865 06866 06867 06869 06870 06871 06872 06873 06874 06875 06876 06877 06878 06879 06880 06881 06882 06883 06884 06885 06886 06887 06888 06889 06890 06891 06892 06893 06894 06895 06896 06897 06898 06899 06900 06901 06902 06903 06905 06906 06908 06909 06910 06911 06912	

MSN	CONFIGURATION
06913 06915 06916 06917 06918 06919 06921 06922 06923 06924 06925 06926 06927 06928 06929 06930 06931 06932 06933 06934 06935 06936 06937 06938 06939 06940 06941 06942 06943 06944 06945 06947 06948 06949 06950 06951 06953 06954 06955 06956 06957 06958 06959 06960 06961 06962 06963 06964 06965 06966 06968 06969 06970 06971 06972 06973 06974 06976 06977 06978 06979 06980 06981 06982 06983 06984 06985 06986 06987 06988 06989 06990 06991 06992 06993 06994 06995 06996 06997 06998 06999 07000 07002 07003 07004 07005 07006 07007 07008 07009 07010 07012 07013 07014 07015 07016 07017 07018 07019 07020 07021 07022 07023 07024 07025 07026 07027 07028 07029 07030 07031 07032 07034 07035 07036 07037 07038 07039 07040 07041 07042 07043 07044 07045 07046 07048 07049 07050 07052 07054 07055 07056 07057 07058 07059 07061 07062 07063 07064 07065 07066 07067 07068 07069 07070 07071 07072 07073 07075 07076 07077 07079 07080 07081 07082 07084 07085 07086 07087 07088 07089 07090 07091 07092 07093 07095 07096 07097 07098 07099 07100 07101 07104 07105 07106 07108 07109 07110 07111 07112 07113 07114 07115 07116 07117 07118 07119 07120 07121 07122 07123 07125 07127 07128 07130 07131 07132 07133 07134 07135 07136 07137 07138 07139 07142 07143 07144 07145 07146 07148 07149 07151 07152 07153 07154 07155 07156 07157 07158 07159 07160 07161 07163 07164 07165 07166 07167 07168 07169 07170 07171 07173 07174 07176 07177 07178 07179 07180 07182 07183 07184 07187 07188 07189 07190 07191 07193 07194 07196 07197 07198 07199 07200 07201 07202 07203 07204 07206 07207 07208 07210 07211 07212 07213 07214 07215 07216 07217 07218 07219 07220 07221 07222 07223 07224 07225 07226 07227 07228 07229 07230 07231 07232 07233 07234 07235 07237 07238 07240 07243 07245 07246 07251 07253 07256 07261	

CONF 002

MSN	CONFIGURATION
06393 06500 06650 06700	002

CONF 003

MSN	CONFIGURATION
07239 07241 07242 07244 07247 07248 07250 07254 07255 07257 07258 07259 07260 07262 07263 07264 07265 07266 07267 07268 07270 07271 07272 07274 07275 07276 07278 07279 07280 07281 07282 07284 07285 07286 07287 07288 07289 07292 07293 07294 07295 07296 07297 07298 07299 07300 07301 07302 07303 07304 07305 07306 07307 07308 07310 07311 07312 07313 07314 07315 07316 07317 07318 07319 07320 07322 07324 07325 07326 07327 07328 07332 07335 07336 07337 07338 07339 07340 07342 07344 07345 07346 07347 07348 07349 07350 07351 07353 07355 07356 07357 07358 07360 07361 07362 07363 07364 07365 07366 07368 07369 07370 07371 07372 07373 07374 07375 07376 07377 07378 07379 07381 07382 07383 07384 07385 07388	003

MSN	CONFIGURATION
07389 07390 07392 07393 07394 07395 07397 07398 07400 07402 07403 07404 07405 07406 07407 07408 07410 07411 07412 07413 07414 07415 07416 07418 07419 07420 07421 07422 07423 07424 07425 07426 07427 07430 07431 07432 07433 07434 07435 07436 07437 07438 07439 07440 07441 07442 07443 07444 07445 07446 07447 07448 07450 07451 07452 07453 07454 07455 07456 07457 07458 07460 07461 07462 07463 07464 07465 07467 07468 07469 07471 07473 07474 07476 07478 07479 07481 07482 07485 07487 07488 07490 07491 07492 07493 07496 07497 07498 07500 07502 07503 07506 07509 07511 07513 07515 07516 07518 07519 07520 07522 07524 07525 07527 07528 07529 07531 07532 07534 07536 07537 07539 07541 07542 07543 07545 07546 07549 07550 07551 07552 07556 07557 07558 07561 07562 07564 07566 07569 07570 07572 07573 07574 07575 07578 07580 07582 07583 07584 07585 07586 07590 07592 07593 07595 07596 07597 07599 07601 07604 07605 07607 07608 07609 07611 07613 07614 07615 07617 07619 07620 07621 07622 07623 07624 07625 07627 07628 07630 07631 07632 07633 07635 07636 07637 07640 07641 07643 07644 07645 07646 07647 07650 07651 07652 07653 07654 07655 07656 07657 07658 07659 07660 07661 07664 07665 07666 07667 07668 07669 07670 07672 07673 07674 07675 07678 07679 07680 07681 07683 07684 07685 07686 07687 07689 07690 07691 07692 07693 07695 07696 07699 07700 07701 07702 07704 07706 07707 07708 07709 07711 07712 07713 07714 07715 07716 07717 07718 07720 07722 07724 07725 07726 07728 07729 07730 07732 07734 07736 07738 07739 07740 07741 07742 07743 07745 07747 07748 07749 07750 07752 07754 07756 07758 07759 07760 07761 07762 07763 07765 07766 07767 07769 07771 07772 07773 07774 07775 07777 07779 07780 07781 07782 07783 07784 07785 07787 07789 07790 07792 07793 07796 07797 07798 07801 07805 07806 07808 07809 07810 07814 07815 07816 07817 07818 07819 07820 07821 07823 07825 07826 07827 07829 07830 07831 07832 07833 07836 07838 07840 07843 07845 07846 07852 07855 07857 07863 07865 07866 07867 07868 07869 07870 07872 07873 07874 07876 07878 07879 07880 07882 07883 07884 07885 07886 07888 07889 07890 07893 07894 07896 07898 07900 07901 07902 07903 07904 07905 07906 07907 07908 07909 07910 07911 07913 07915 07916 07919 07922 07923 07924 07926 07927 07929 07932 07933 07934 07935 07937 07938 07940 07943 07947 07948 07953 07954 07955 07956 07957 07958 07962 07963 07964 07966 07969 07970 07971 07973 07974 07975 07976 07977 07978 07981 07982 07985 07987 07988 07989 07993 07994 07998 08006 08007 08009 08010 08011 08012 08013 08018 08019 08021 08022 08024 08026 08027 08028 08029 08032 08033 08034 08035 08036 08037 08040 08041 08042 08044 08045 08046 08047 08049 08053 08054 08055 08057 08060 08061 08062 08063 08064 08065 08066 08067 08068 08069 08070 08071 08072 08073 08075 08076 08078 08080 08081 08082 08083 08097 08104 08111 08114 08115 08116 08119 08124 08125 08127 08128 08130 08132 08133 08134 08141 08143 08147 08149 08151 08153 08159 08160 08161 08162 08163 08165 08169	

MSN	CONFIGURATION
08171 08174 08176 08177 08178 08179 08180 08183 08185 08188 08189 08190 08191 08192 08200 08201 08205 08207 08210 08211 08213 08215 08216 08220 08222 08223 08227 08230 08232 08233 08234 08236 08238 08241 08244 08245 08250 08251 08252 08254 08258 08263 08269 08271 08276 08279 08281 08283 08285 08287 08293 08295 08296 08298 08299 08305 08311 08313 08315 08316 08317 08319 08321 08322 08324 08325 08327 08328 08329 08332 08334 08336 08339 08342 08343 08344 08346 08347 08352 08354 08355 08358 08359 08362 08363 08370 08376 08378 08379 08381 08384 08385 08388 08390 08391 08393 08394 08396 08398 08400 08401 08407 08410 08418 08422 08423 08424 08427 08428 08429 08434 08435 08437 08438 08439 08442 08447 08448 08450 08452 08457 08462 08463 08466 08473 08477 08479 08481 08485 08493 08499 08500 08502 08504 08509 08519 08522 08525 08530 08532 08534 08536 08538 08539 08548 08549 08550 08555 08561 08574 08577 08579 08581 08582 08585 08590 08592 08595 08597 08599 08600 08604 08605 08606 08611 08614 08615 08616 08625 08632 08634 08640 08641 08644 08646 08651 08652 08657 08659 08663 08664 08667 08670 08671 08672 08673 08676 08677 08680 08694 08695 08696 08697 08709 08713 08716 08724 08730 08734 08746 08748 08763 08765 08778 08784 08798 08808 08809 08810 08812 08841 08856	

CONF ALL

(4) Configuration definition

CONF 001

Configuration 001

CONF 001 is applicable for all the aircraft on which MOD No. 155093P13407 and MOD No. 158520P15531 are not embodied.

CONF 001 retrofits following modifications: 160876P15989.

CONF 002

Configuration 002

CONF 002 is applicable for all the aircraft on which MOD No. 155093P13407 is embodied and on which MOD No. 158520P15531 is not embodied.

CONF 002 retrofits following modifications: 160876P15989.

CONF 003

Configuration 003

CONF 003 is applicable for all the aircraft on which MOD No. 155093P13407 is not embodied and on which MOD No. 158520P15531 is embodied.

CONF 003 retrofits following modifications: 160876P15989.

CONF ALL

B. CONCURRENT REQUIREMENTS

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

Service Bulletin(s)	Modification(s)
Ref. SB A320-53-1373	

NOTE: Service Bulletin No. Ref. SB A320-53-1373 (FUSELAGE - NOSE FORWARD FUSELAGE - INSPECTION DOUBLE JOGGLE AREA FR16).

NOTE: When an operator records the SB report, it is also the operator's responsibility to report all prerequisite Service Bulletin to AIRBUS.

C. REASON

(1) History

Following the amount and severity of in-service findings and the high finding rate in the double joggle area, the need for an in-service action has been identified.

Definition of a new harmonised and unique inspection program for both Frame 16 and Frame 20 double joggle area taking into account the in-service findings.

(2) Objective/Action

The modification consists in redesigning the double joggle area at Frame 16 Left Hand (LH) side. It implies to apply cold working at Frame 16 LH side and install moderate interference fit fasteners.

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

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

(3) Advantages

The modification will contribute to avoid new in-service findings in the double joggle area.

Accomplishment of this Service Bulletin cancels the requirements of Service Bulletin No. Ref. SB A320-53-1373 for LH side.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to:

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

1 Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

2 Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

CONF 001

3 Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

CONF 002

3 Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

CONF 003

3 Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

CONF 001

4 Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

CONF 002

4 Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

CONF 003

4 Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

CONF ALL

E. COMPLIANCE

(1) Classification

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

(2) Accomplishment Timescale

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

F. APPROVAL

The technical content of this document is approved under the authority of the Design Organisation Approval ref. 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

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

PREPARATION		
Job Set-up	1.50 h	
PROCEDURE		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
PREPARATION FOR TEST		

None		
TEST		
Testing	0.10 h	
CLOSE-UP		
Close-up	4.00 h	
TOTAL MAN-HOURS	22.35 h	
ELAPSED TIME (HOURS)	22.35 h	

NOTE: If galleys or lavatories must be removed for access, additional man-hours can apply.

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

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

PREPARATION		
Job Set-up	1.50 h	
PROCEDURE		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
PREPARATION FOR TEST		
None		
TEST		
Testing	0.10 h	
CLOSE-UP		
Close-up	4.00 h	
TOTAL MAN-HOURS	22.35 h	
ELAPSED TIME (HOURS)	22.35 h	

NOTE: If galleys or lavatories must be removed for access, additional man-hours can apply.

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

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

PREPARATION		
Job Set-up	1.50 h	
PROCEDURE		
Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	1.00 h	
Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side	4.00 h	
Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side	7.75 h	
PREPARATION FOR TEST		
None		
TEST		
Testing	0.10 h	
CLOSE-UP		
Close-up	4.00 h	
TOTAL MAN-HOURS	22.35 h	
ELAPSED TIME (HOURS)	22.35 h	

NOTE: If galleys or lavatories must be removed for access, additional man-hours can apply.

CONF ALL

H. WEIGHT AND BALANCE

Not changed

I. ELECTRICAL LOAD DATA

Not changed

J. REFERENCES

CONCURRENT SERVICE BULLETIN (SB)
A320-53-1373

CONF 001

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-005	25-31-00

AIRCRAFT MAINTENANCE MANUAL (AMM)	
Task 25-23-45-400-006	
25-41-00	Task 25-80-00-000-001 Task 25-80-00-400-001
Task 52-10-00-010-001 Task 52-10-00-410-001	

CONSUMABLE MATERIAL LIST (CML)
Full content

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

IN SERVICE INFORMATION (ISI)
51.48.00001

NON DESTRUCTIVE TEST MANUAL (NTM)
Task 51-10-01-250-801

SERVICE BULLETIN (SB)
A320-53-1373

STANDARDS MANUAL (SM)
Full content

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12

TECHNICAL FOLLOW UP (TFU)
53.11.00.022

CONF 002

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-005 Task 25-23-45-400-006	25-31-00
25-41-00	Task 25-80-00-000-001 Task 25-80-00-400-001
Task 52-10-00-010-001	

AIRCRAFT MAINTENANCE MANUAL (AMM)
Task 52-10-00-410-001

CONSUMABLE MATERIAL LIST (CML)
Full content

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

IN SERVICE INFORMATION (ISI)
51.48.00001

NON DESTRUCTIVE TEST MANUAL (NTM)
Task 51-10-01-250-801

SERVICE BULLETIN (SB)
A320-53-1373

STANDARDS MANUAL (SM)
Full content

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12

TECHNICAL FOLLOW UP (TFU)
53.11.00.022

CONF 003

(1) Modification

(a) Task set A320-A-53-XX-1381-01000-93AA-A Modification

AIRCRAFT MAINTENANCE MANUAL (AMM)	
06-20-00, Page Block 001	06-31-53, Page Block 001
Task 12-34-24-869-002	Task 20-21-11-911-001
Task 25-23-45-000-005 Task 25-23-45-400-006	25-31-00
25-41-00	Task 25-80-00-000-001 Task 25-80-00-400-001
Task 52-10-00-010-001 Task 52-10-00-410-001	

CONSUMABLE MATERIAL LIST (CML)
Full content

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

IN SERVICE INFORMATION (ISI)
51.48.00001

NON DESTRUCTIVE TEST MANUAL (NTM)
Task 51-10-01-250-801

SERVICE BULLETIN (SB)
A320-53-1373

STANDARDS MANUAL (SM)
Full content

STRUCTURAL REPAIR MANUAL (SRM)	
51-24-00	51-40-00
51-42-00	51-43-00
51-44-00	51-46-00
51-48-00	51-75-12

TECHNICAL FOLLOW UP (TFU)
53.11.00.022

CONF ALL

K. PUBLICATION AFFECTED

STRUCTURAL REPAIR MANUAL (SRM)
Full content

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-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A01R01	1	
Referenced parts	See SB	

CONF 002

Material for task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A02R01	1	
Referenced parts	See SB	

CONF 003

Material for task set A320-A-53-XX-1381-01000-93AA-A Modification

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Referenced tools	See SB	
Consumables	See SB	
Part kit 531381A03R01	1	
Referenced parts	See SB	

CONF ALL

B. TOOLING

CONF 001

Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: http://www.fatiguetech.com
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: info@coldwork.com

NOTE(S)
Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit part numbers listed below should contact FTI at the address given above.
Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above. WCI contact for Europe, Middle-East, Africa, India and Russia: Phone: +33 5 61 92 04 91 (France) E-mail: customer@capaero.com

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	FTIT00LKIT (51439)	1	TOOLKIT		(1) (2)
	WCIT00LKIT (66136)	1	TOOLKIT		(3) (4)

NOTE(S)	
(1):	Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.
(2):	To get the FTI tool kit, use the tool kit part number reference FTIA320531381 in the purchase order.
(3):	West Coast Industries (WCI) has allocated this tool kit part number for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.
(4):	To get the WCI tool kit, use the tool kit part number reference WCIA320531381 in the purchase order.

CONF 002

Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: http://www.fatiguetech.com
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: info@coldwork.com

NOTE(S)
Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit part numbers listed below should contact FTI at the address given above.
Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above. WCI contact for Europe, Middle-East, Africa, India and Russia: Phone: +33 5 61 92 04 91 (France) E-mail: customer@capaero.com

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	FTIT00LKIT (51439)	1	TOOLKIT		(1) (2)
	WCIT00LKIT (66136)	1	TOOLKIT		(3) (4)

NOTE(S)

(1): Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion:

For the tooling definition, refer to Ref. ISI 51.48.00001.

(2): To get the FTI tool kit, use the tool kit part number reference FTIA320531381 in the purchase order.

(3): West Coast Industries (WCI) has allocated this tool kit part number for cold expansion:

For the tooling definition, refer to Ref. ISI 51.48.00001.

(4): To get the WCI tool kit, use the tool kit part number reference WCIA320531381 in the purchase order.

CONF 003

Aircraft standard tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

Procurement address	51439	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Phone: (206) 2462010 Fax: (206) 2449886 Internet: http://www.fatiguetech.com
	66136	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 E-mail: info@coldwork.com

NOTE(S)

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Operators interested in obtaining the West Coast Industries (WCI) tool kit part numbers listed below should contact WCI at the address given above.

WCI contact for Europe, Middle-East, Africa, India and Russia:

Phone: +33 5 61 92 04 91 (France)

E-mail: customer@capaero.com

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	FTIT00LKIT (51439)	1	TOOLKIT		(1) (2)
	WCIT00LKIT (66136)	1	TOOLKIT		(3) (4)

NOTE(S)

(1): Fatigue Technology Incorporated (FTI) has allocated this tool kit part number for cold expansion:

For the tooling definition, refer to Ref. ISI 51.48.00001.

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
(2): To get the FTI tool kit, use the tool kit part number reference FTIA320531381 in the purchase order.					
(3): West Coast Industries (WCI) has allocated this tool kit part number for cold expansion: For the tooling definition, refer to Ref. ISI 51.48.00001.					
(4): To get the WCI tool kit, use the tool kit part number reference WCIA320531381 in the purchase order.					

CONF 001

Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

CONF 002

Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

CONF 003

Referenced tools for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM Task 52-10-00-010-001

Ref. NTM Task 51-10-01-250-801

CONF ALL

C. CONSUMABLES

CONF 001

Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF 002

Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF 003

Consumables for task set A320-A-53-XX-1381-01000-93AA-A Modification

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04CMA2	Wash Primer - - - Structure		
	04EAC2	Primer Polyurethane Paint - - CorrosionInhibiting Structure		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

CONF ALL

D. LIST OF NEW PARTS

CONF 001

Part kit 531381A01R01

Cost	499.00 USD
Availability	250 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	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	4	BOLT		
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 531381A02R01

Cost	499.00 USD
Availability	250 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	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
9	EN6114K4Y10	1	BOLT		
12	EN6114K4Y9	3	BOLT		

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 003

Part kit 531381A03R01

Cost	499.00 USD
Availability	250 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	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		
12	EN6114K4Y9	4	BOLT		

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

Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM 25-31-00

Ref. AMM 25-41-00

The expendable parts mentioned above are only necessary if galleys or closets/ stowages or lavatories are removed/installed for access, refer to paragraph “Component Location” in the applicable ATA 25 “Description/Operation”: for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/ installation task.

CONF 002

Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM 25-31-00

Ref. AMM 25-41-00

The expendable parts mentioned above are only necessary if galleys or closets/ stowages or lavatories are removed/installed for access, refer to paragraph “Component Location” in the

applicable ATA 25 “Description/Operation”: for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/ installation task.

CONF 003

Referenced parts for task set A320-A-53-XX-1381-01000-93AA-A Modification

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

Ref. AMM 25-31-00

Ref. AMM 25-41-00

The expendable parts mentioned above are only necessary if galleys or closets/ stowages or lavatories are removed/installed for access, refer to paragraph “Component Location” in the applicable ATA 25 “Description/Operation”: for the galleys, closets/stowages, refer to AMM 25-31-00; for the lavatories, refer to AMM 25-41-00. In this paragraph, you will find the cross references of the removal/ installation task.

CONF ALL

E. LIST OF EXISTING PARTS

No parts

3. ACCOMPLISHMENT INSTRUCTIONS

Task set A320-A-53-XX-1381-01000-93AA-A (A320-A-53-XX-1381-01ZZZ-93AZ-A)
Modification

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

CAUTION: ALWAYS OBEY THE PRECAUTIONS THAT FOLLOW TO KEEP ELECTRICAL WIRING IN A SATISFACTORY CONDITION (ELECTRICALLY AND MECHANICALLY SERVICEABLE). WHEN YOU DO A 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 contains the instructions for the on-aircraft maintenance necessary to ensure the continued airworthiness of the aircraft.
For any deviations to the instructions, contact AIRBUS for further instructions and approval.

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

A. TASK SET ASSOCIATED INFORMATION

Task Manpower

CONF 001	TOTAL MAN-HOURS	22.35 h
CONF 002	TOTAL MAN-HOURS	22.35 h
CONF 003	TOTAL MAN-HOURS	22.35 h
CONF 001	ELAPSED TIME (HOURS)	22.35 h
CONF 002	ELAPSED TIME (HOURS)	22.35 h
CONF 003	ELAPSED TIME (HOURS)	22.35 h

CONF ALL

B. PREPARATION

(1) Task A320-A-53-XX-1381-01001-540A-A (A320-A-53-XX-1381-01ZZZ-540Z-A) Job Set-up

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	1.50 h
Minimum Number of person	1
Elapsed Time	1.50 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 12-34-24-869-002 Task 25-23-45-000-005 25-31-00 25-41-00 Task 25-80-00-000-001 Task 52-10-00-010-001
SB	A320-53-1373

Procedure

NOTE: If Service Bulletin No. Ref. SB A320-53-1373 has been performed in the same layover period, it is not necessary to do the following workstep.

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

(a) 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.BD Location of the Area to be Modified, 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 a Repair and Design Approval Form (RDAF) 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.

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

(c) Put an access platform in position at Door 831.

(d) Open the passenger/crew Door 831, refer to Ref. AMM Task 52-10-00-010-001.

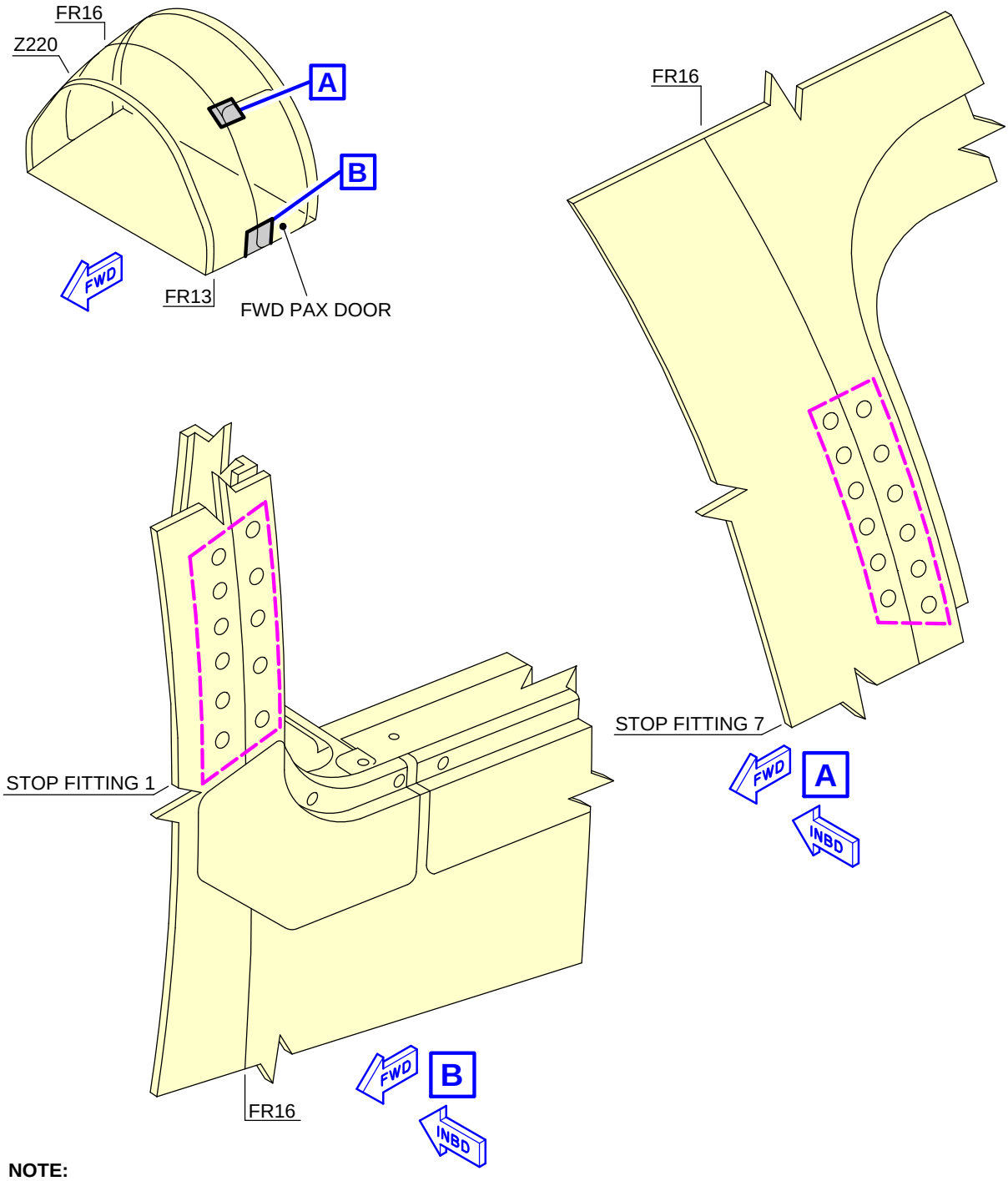
(e) If installed, remove or displace the Forward (FWD) galleys and lavatories between Frame 15 and Frame 16. To do this, refer to the paragraph 'Component Location' in the applicable Air Transport Association (ATA) 25 'Description/ Operation': for the galleys, refer to Ref. AMM 25-31-00; for the lavatories, refer to Ref. AMM 25-41-00. In this paragraph you will find the cross-references of the removal task.

(f) Remove the necessary lining panels at Frame 16 to get access to the modification areas, refer to Ref. AMM Task 25-23-45-000-005.

(g) Remove the necessary insulation blankets at Frame 16 to get access to the modification areas, refer to Ref. AMM Task 25-80-00-000-001.

(h) Remove or displace the necessary electrical wire harnesses at Frame 16 without unplugging the connections.

CONF ALL



NOTE:

AREA IMPACTED BY THE STRUCTURAL MODIFICATION

ICN-A320-A-53XX1381-A-FAPE3-02KH5-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH5-A-001-01 Fig.BD Sol.AA SHEET 1/1

C. PROCEDURE

(1) Task A320-A-53-XX-1381-01001-520A-A (A320-A-53-XX-1381-01ZZZ-520Z-A) Remove the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	4.00 h
Minimum Number of person	1
Elapsed Time	4.00 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		

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
CML	CONSUMABLE MATERIAL LIST (CML)
SB	A320-53-1373
SRM	51-42-00

Procedure

NOTE: If Service Bulletin No. Ref. SB A320-53-1373 has been performed in the same layover period, it is not necessary to do the following workstep.

(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.

(b) Remove the fasteners from the Frame 16 double joggle area:
Refer to Ref. Fig.BB Removal of the Fasteners from the Frame 16 Double Joggle Area, on the LH Side

23	BOLT	Discard

23		NUT	Discard

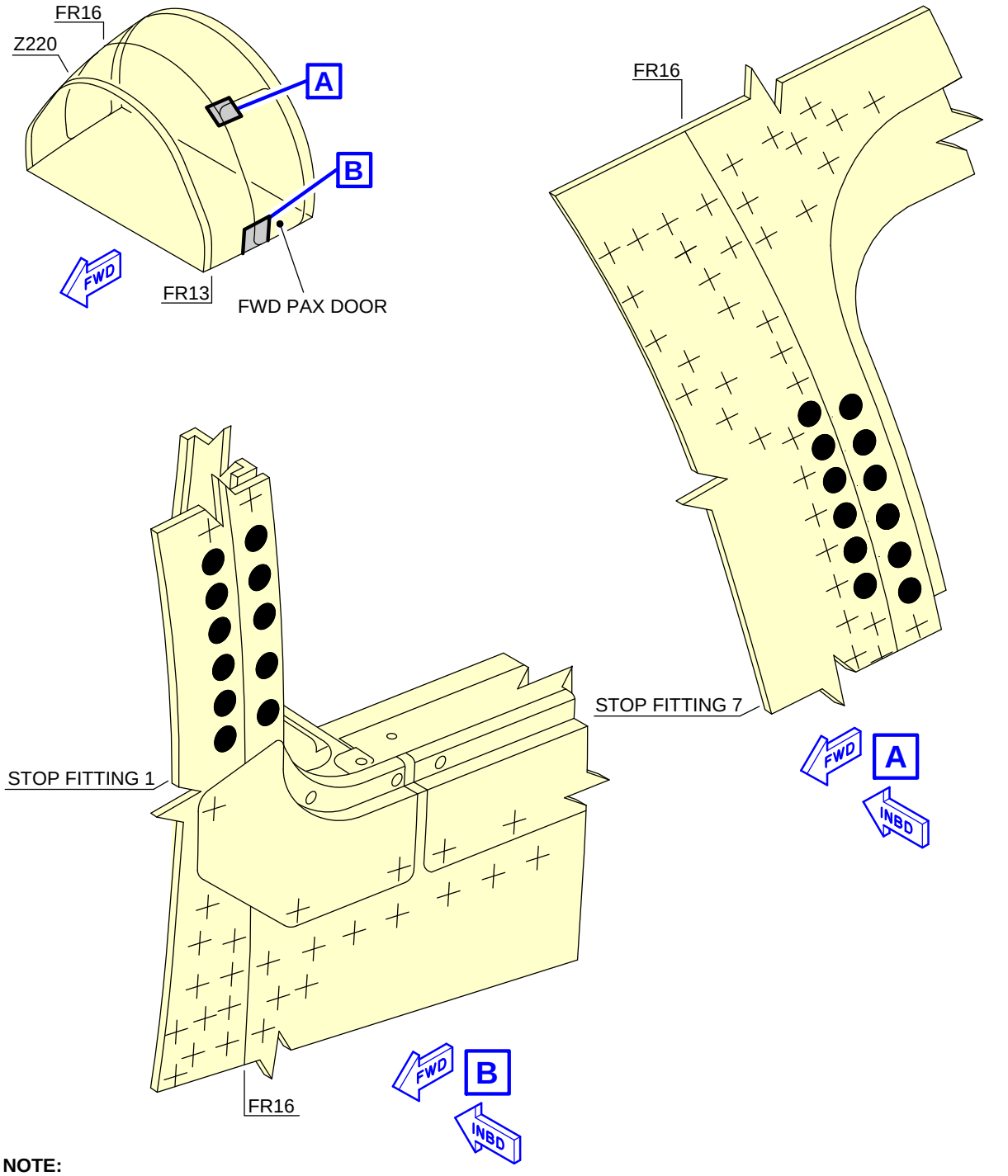
(c) Remove the old sealant with a non metallic spatula.

(d) Clean the holes and area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

CONF ALL



NOTE:

┼ FASTENERS NOT AFFECTED

● REMOVE AND DISCARD

ICN-A320-A-53XX1381-A-FAPE3-02KHA-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KHA-A-001-01 Fig.BB Sol.AA SHEET 1/1

(2) Task A320-A-53-XX-1381-01001-353A-A (A320-A-53-XX-1381-01ZZZ-353Z-A) Do a Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	1.00 h
Minimum Number of person	1
Elapsed Time	1.00 h
Skills	Non-Destructive Testing

Referenced Information

Manuals/Drawings	References/Sheets
AMM	06-20-00, Page Block 001 06-31-53, Page Block 001
NTM	Task 51-10-01-250-801
SB	A320-53-1373

Procedure

NOTE: If Service Bulletin No. Ref. SB A320-53-1373 has been performed in the same layover period, it is not necessary to do the following workstep.

(a) Standard practices given in this procedure:

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

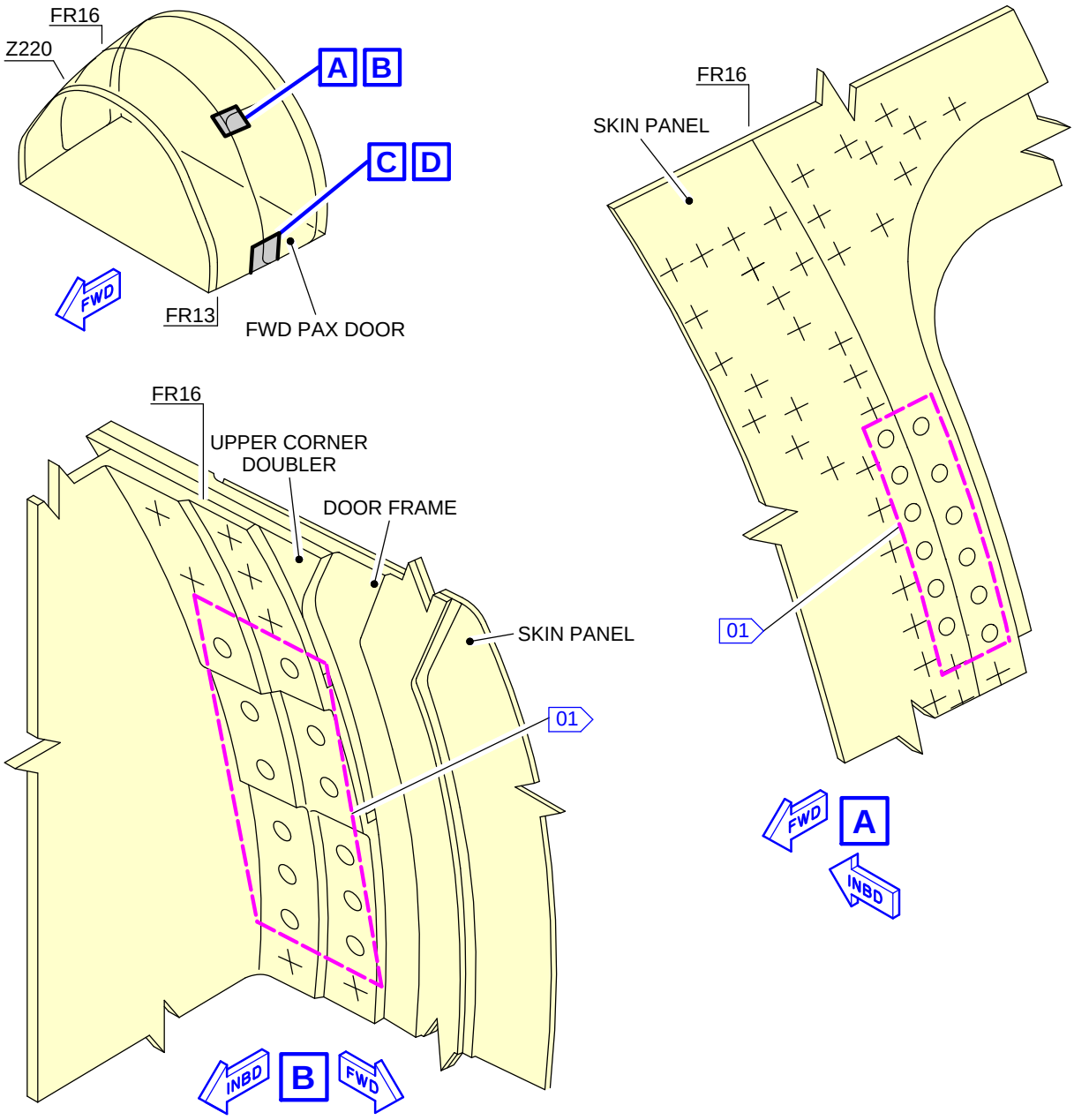
2 For the identification of zones, refer to Ref. AMM 06-20-00, Page Block 001.

(b) Do a rotating probe inspection of the fastener holes of the Frame 16 double joggle area:
Refer to Ref. Fig.CA Rotating Probe Inspection of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side
Refer to Ref. NTM Task 51-10-01-250-801

1 If cracks are detected, contact AIRBUS before next flight and follow their instructions.

2 If no cracks are detected, do the cold working of the fastener holes, refer to Ref. Task A320-A-53-XX-1381-01ZZZ-900Z-A.

CONF ALL



NOTE:

FASTENERS NOT AFFECTED

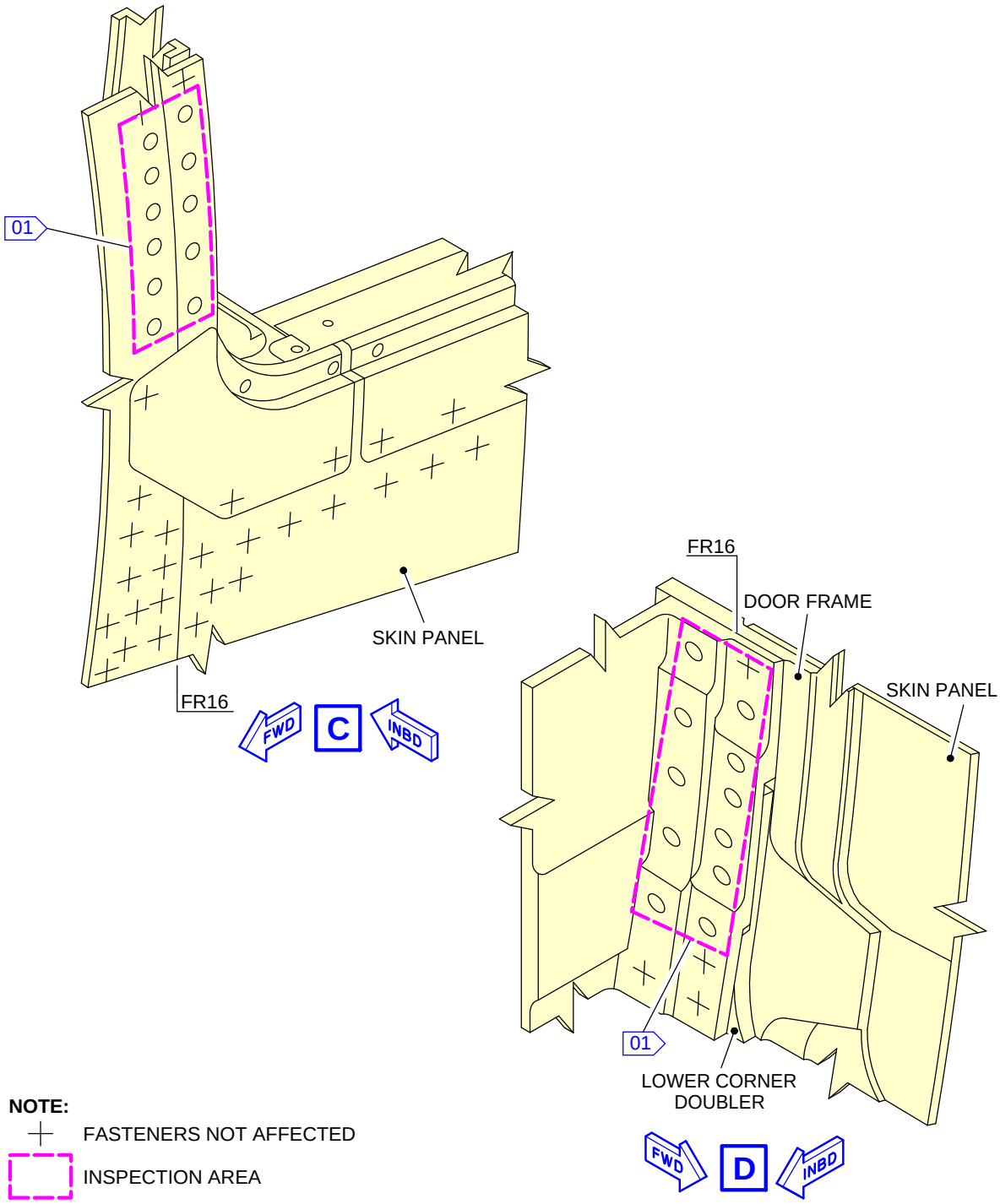
INSPECTION AREA

01 DO A ROTATING PROBE INSPECTION OF THE FASTENER HOLES IN ACCORDANCE WITH NTM 51-10-01-250-801

ICN-A320-A-53XX1381-A-FAPE3-00A38-A-004-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A38-A-004-01 Fig.CA Sol.AA SHEET 1/2

CONF ALL



NOTE:

FASTENERS NOT AFFECTED

INSPECTION AREA

01 DO A ROTATING PROBE INSPECTION OF THE FASTENER HOLES IN ACCORDANCE WITH NTM 51-10-01-250-801

ICN-A320-A-53XX1381-A-FAPE3-02K7R-A-003-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02K7R-A-003-01 Fig.CA Sol.AA SHEET 2/2

CONF 001

(3) Task A320-A-53-XX-1381-01001-900A-A (A320-A-53-XX-1381-01ZZZ-900Z-A) Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	4.00 h
Minimum Number of person	1
Elapsed Time	4.00 h
Skills	Airframe

Material necessary to do the job

Aircraft standard tools					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	FTIT00LKIT	1	TOOLKIT		
	WCIT00LKIT	1	TOOLKIT		

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)
SRM	51-44-00 51-46-00 51-48-00

Procedure

(a) Standard practices given in this procedure:

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

5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.

6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.

(b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig.BA Sol.AA SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side:

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

2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.

(c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig.BA Sol.AA SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(d) Clean the drilled areas with:

Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(e) Do a cold working of the fastener holes:

1 Install the sleeves in accordance with the orientation given in Ref. Fig.BA Sol.AA SHEET 1 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

2 Do the cold expansion of the fastener holes.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

3 Remove the sleeves.

(f) Ream the fastener holes to the final hole diameters given in Ref. Fig.BA Sol.AA SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or

Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(g) Clean the drilled areas with:

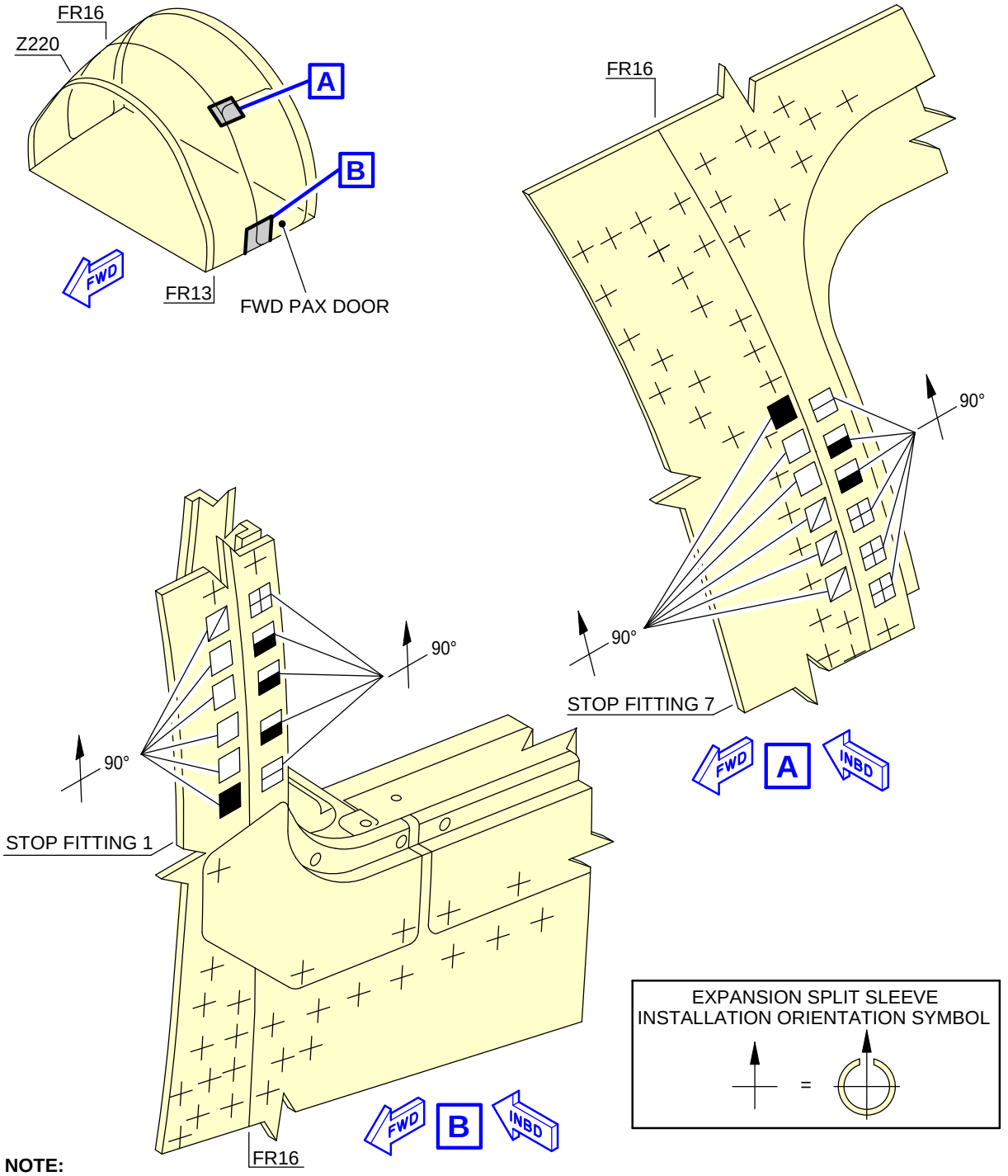
Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(h) Do a countersink to the related fastener head depth.

CONF 001



NOTE:

┼ FASTENERS NOT AFFECTED

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-00A32-A-005-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A32-A-005-01 Fig.BA Sol.AA SHEET 1/2

CONF 001

HOLE SYMBOL	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
		MIN	MAX	MIN	MAX		
■	8-1-N	6.400 mm (0.2520 in)	6.450 mm (02539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
□	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⧄	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	01
⊟	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
▬	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⊞	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01

NOTE:
01 4% COLD WORKING

ICN-A320-A-53XX1381-A-FAPE3-00A33-A-003-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A33-A-003-01 Fig.BA Sol.AA SHEET 2/2

CONF 002

(3) Task A320-A-53-XX-1381-01002-900A-A (A320-A-53-XX-1381-01ZZZ-900Z-A) Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	4.00 h
Minimum Number of person	1
Elapsed Time	4.00 h
Skills	Airframe

Material necessary to do the job

Aircraft standard tools					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	FTIT00LKIT	1	TOOLKIT		
	WCIT00LKIT	1	TOOLKIT		

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)
SRM	51-44-00 51-46-00 51-48-00

Procedure

(a) Standard practices given in this procedure:

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

5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.

6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.

(b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig.BA Sol.AB SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side:

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

2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.

(c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig.BA Sol.AB SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(d) Clean the drilled areas with:

Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(e) Do a cold working of the fastener holes:

1 Install the sleeves in accordance with the orientation given in Ref. Fig.BA Sol.AB SHEET 1 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

2 Do the cold expansion of the fastener holes.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

3 Remove the sleeves.

(f) Ream the fastener holes to the final hole diameters given in Ref. Fig.BA Sol.AB SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or

Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(g) Clean the drilled areas with:

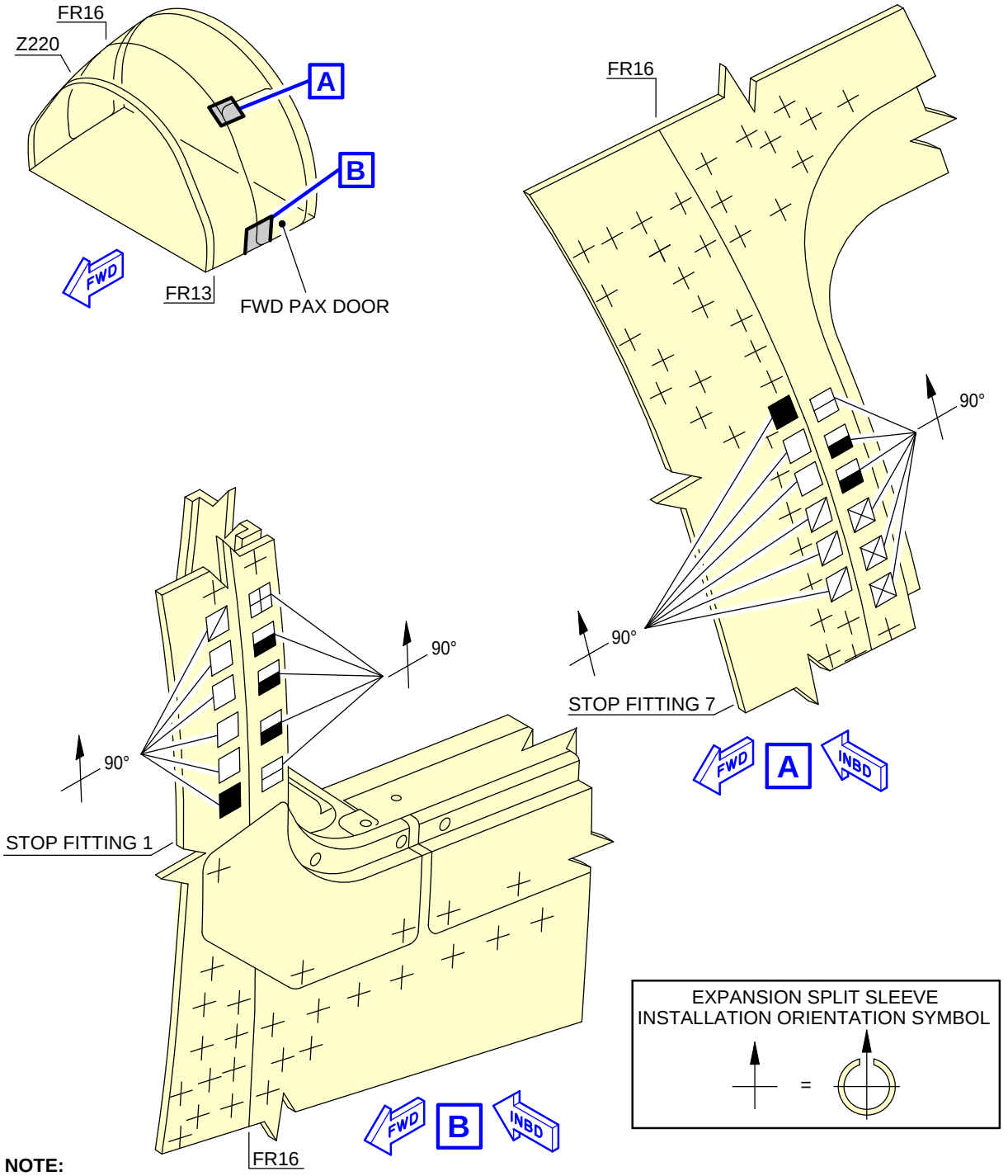
Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(h) Do a countersink to the related fastener head depth.

CONF 002



NOTE:

┼ FASTENERS NOT AFFECTED

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-00A34-A-005-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A34-A-005-01 Fig.BA Sol.AB SHEET 1/2

CONF 002

HOLE SYMBOL	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
		MIN	MAX	MIN	MAX		
■	8-1-N	6.400 mm (0.2520 in)	6.450 mm (02539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
□	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⧄	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	01
⊟	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⬓	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⊞	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
☒	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01

NOTE:

01 4% COLD WORKING

ICN-A320-A-53XX1381-A-FAPE3-00A35-A-003-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A35-A-003-01 Fig.BA Sol.AB SHEET 2/2

CONF 003

(3) Task A320-A-53-XX-1381-01003-900A-A (A320-A-53-XX-1381-01ZZZ-900Z-A) Do a Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	4.00 h
Minimum Number of person	1
Elapsed Time	4.00 h
Skills	Airframe

Material necessary to do the job

Aircraft standard tools					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	FTIT00LKIT	1	TOOLKIT		
	WCIT00LKIT	1	TOOLKIT		

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)
SRM	51-44-00 51-46-00 51-48-00

Procedure

(a) Standard practices given in this procedure:

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

5 Do the cold working of the fastener holes in accordance with Ref. SRM 51-48-00.

6 Get the fasteners holes countersink data in accordance with Ref. SRM 51-46-00.

(b) Do a check of the existing hole diameters and compare with the values of the starting hole diameters as shown in Ref. Fig.BA Sol.AC SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side:

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

2 In case the existing hole diameter is less than the minimum starting hole diameter, do the next step.

(c) Oversize the fastener holes to the correct starting hole diameters given in Ref. Fig.BA Sol.AC SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(d) Clean the drilled areas with:

Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(e) Do a cold working of the fastener holes:

1 Install the sleeves in accordance with the orientation given in Ref. Fig.BA Sol.AC SHEET 1 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

2 Do the cold expansion of the fastener holes.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or
Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

3 Remove the sleeves.

(f) Ream the fastener holes to the final hole diameters given in Ref. Fig.BA Sol.AC SHEET 2 Cold Working of the Fastener Holes of the Frame 16 Double Joggle Area, on the LH Side.
Use FTI tools list No:

1	TOOLING KIT	FTIT00LKIT

or

Use WCI tools list No:

1	TOOLING KIT	WCIT00LKIT

(g) Clean the drilled areas with:

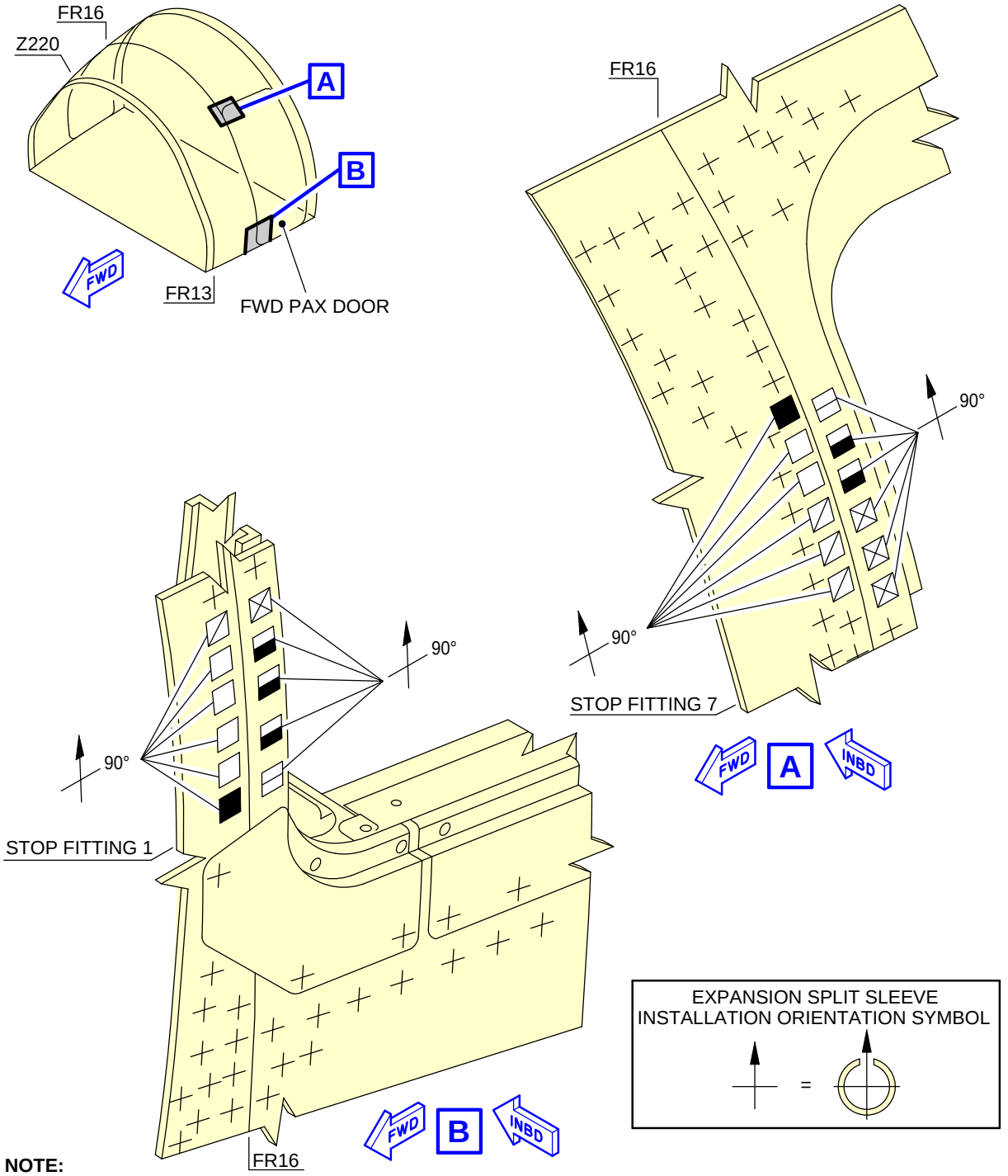
Textile - Lint free Cotton	14SBA1

and

Non Aqueous Cleaner - General	08BAA9

(h) Do a countersink to the related fastener head depth.

CONF 003



NOTE:

┼ FASTENERS NOT AFFECTED

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-00A36-A-005-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A36-A-005-01 Fig.BA Sol.AC SHEET 1/2

CONF 003

HOLE SYMBOL	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTE
		MIN	MAX	MIN	MAX		
■	8-1-N	6.400 mm (0.2520 in)	6.450 mm (02539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
□	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⧄	6-1-N	4.920 mm (0.1937 in)	4.960 mm (0.1952 in)	5.467 mm (0.2153 in)	5.507 mm (0.2168 in)	NOMINAL SIZE INTERFERENCE FIT	01
⊟	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
⬓	10-1-N	7.950 mm (0.3130 in)	8.030 mm (0.3161 in)	8.636 mm (0.3400 in)	8.676 mm (0.3415 in)	SECOND OVERSIZE INTERFERENCE FIT	01
☒	8-1-N	6.400 mm (0.2520 in)	6.450 mm (0.2539 in)	7.050 mm (0.2776 in)	7.089 mm (0.2790 in)	SECOND OVERSIZE INTERFERENCE FIT	01

NOTE:
01 4% COLD WORKING

ICN-A320-A-53XX1381-A-FAPE3-00A37-A-003-01

Figure ICN-A320-A-53XX1381-A-FAPE3-00A37-A-003-01 Fig.BA Sol.AC SHEET 2/2

CONF 001

(4) Task A320-A-53-XX-1381-01001-720A-A (A320-A-53-XX-1381-01ZZZ-720Z-A) Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	7.75 h
Minimum Number of person	1
Elapsed Time	7.75 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		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A01R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		

Part kit 531381A01R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
9	EN6114K4Y10	4	BOLT		

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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

Procedure

(a) Standard practices given in this procedure:

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

6 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.

7 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.

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

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.

(b) Install the fasteners on the Frame 16 double joggle area:

1 Wet install the fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

2	BOLT	EN6114K4Y13	Item 1
6	BOLT	EN6114K4Y11	Item 3
4	BOLT	EN6114K3A8	Item 4

2	BOLT	EN6114K5Y14	Item 6
5	BOLT	EN6114K5Y12	Item 8
4	BOLT	EN6114K4Y10	Item 9
12	NUT	ASNA2531-4	Item 2
7	NUT	ASNA2531-5	Item 7
4	NUT-HEXAGONAL with:	ASNA2531-3A	Item 5
	Polysulfide Sealant - General Purpose Fillet	06AAB1	

2 Clean the work areas with:

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

(c) Apply protective finish on the new fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

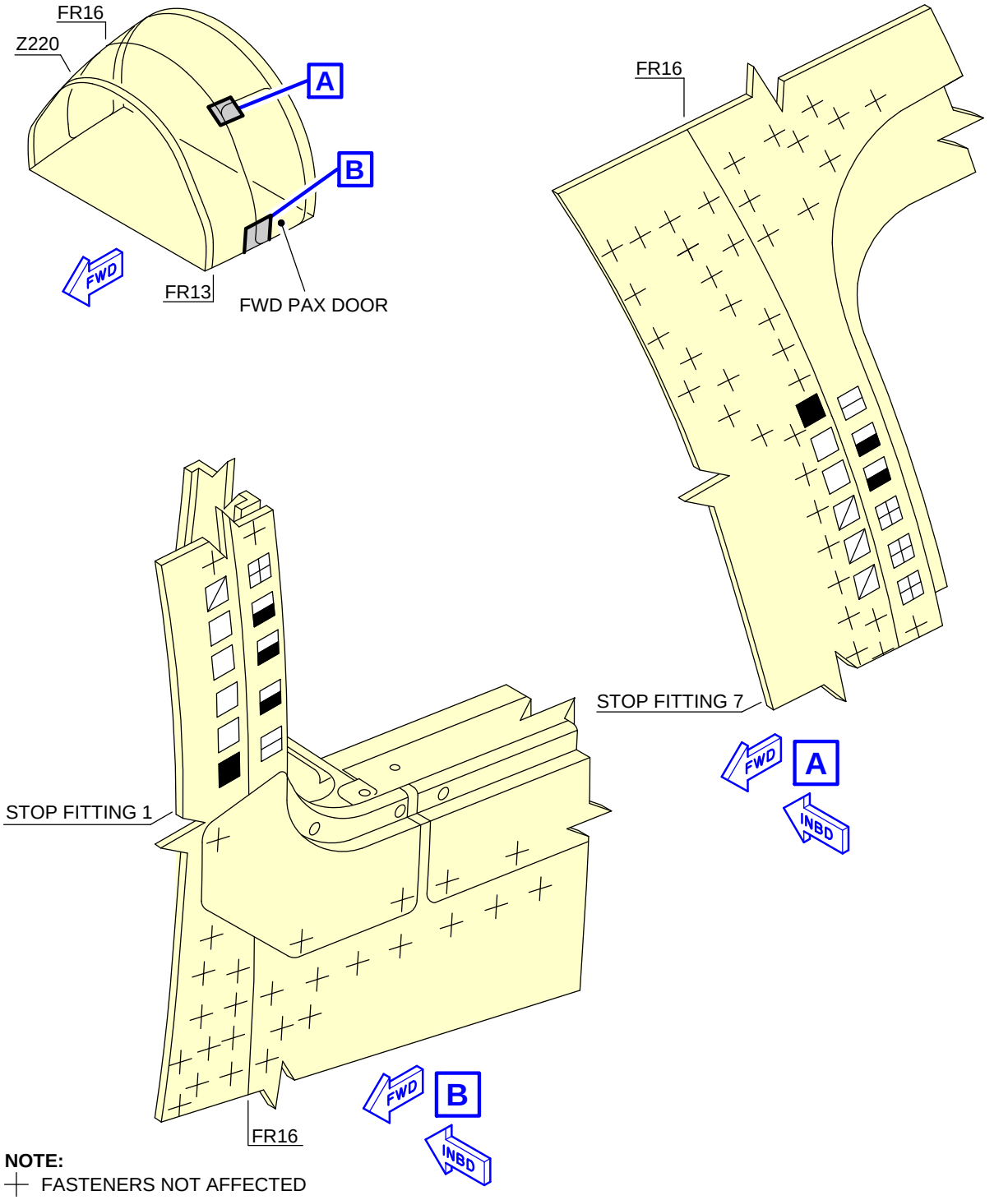
1 For the internal protective finish, apply:

Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
and	
Top Coat Polyurethane - - Grey InternalStructure	04JME4
and	
Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil	12ADB1

2 For the external protective finish, apply:

Wash Primer - - - Structure	04CMA2
and	
Primer Polyurethane Paint - - CorrosionInhibiting Structure	04EAC2
and	
Top Coat Polyurethane - - - External Structure	04JAA3

CONF 001



NOTE:

┼ FASTENERS NOT AFFECTED

REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-02KH3-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH3-A-001-01 Fig.BC Sol.AA SHEET 1/2

CONF 001

HOLE SYMBOL	NEW ITEM	PART NUMBER	DESCRIPTION	SIZE/FIT TYPE	NOTE
N	1	EN6114K4Y13	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	3	EN6114K4Y11	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	4	EN6114K3A8	BOLT	NOMINAL SIZE INTERFERENCE FIT	01 02 03
	5	ASNA2531-3A	NUT		
N	6	EN6114K5Y14	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	8	EN6114K5Y12	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	9	EN6114K4Y10	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		

NOTE:

N HEAD ON NEAR SIDE

01 WET INSTALL WITH MATERIAL No 06AAB1

02 APPLY INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. APPLY ON THE TOP OF THE INTERNAL PROTECTIVE FINISH MATERIAL No 12ADB1

03 APPLY EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3

ICN-A320-A-53XX1381-A-FAPE3-02KH4-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH4-A-001-01 Fig.BC Sol.AA SHEET 2/2

CONF 002

(4) Task A320-A-53-XX-1381-01002-720A-A (A320-A-53-XX-1381-01ZZZ-720Z-A) Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	7.75 h
Minimum Number of person	1
Elapsed Time	7.75 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		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A02R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		

Part kit 531381A02R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
9	EN6114K4Y10	1	BOLT		
12	EN6114K4Y9	3	BOLT		

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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

Procedure

(a) Standard practices given in this procedure:

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

6 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.

7 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.

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

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.

(b) Install the fasteners on the Frame 16 double joggle area:

1 Wet install the fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

2	BOLT	EN6114K4Y13	Item 1
6	BOLT	EN6114K4Y11	Item 3
4	BOLT	EN6114K3A8	Item 4

2	BOLT	EN6114K5Y14	Item 6
5	BOLT	EN6114K5Y12	Item 8
1	BOLT	EN6114K4Y10	Item 9
3	BOLT	EN6114K4Y9	Item 12
12	NUT	ASNA2531-4	Item 2
4	NUT-HEXAGONAL	ASNA2531-3A	Item 5
7	NUT with:	ASNA2531-5	Item 7
	Polysulfide Sealant - General Purpose Fillet	06AAB1	

2 Clean the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Apply protective finish on the new fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

1 For the internal protective finish, apply:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2
and

Top Coat Polyurethane - - Grey InternalStructure 04JME4
and

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil 12ADB1

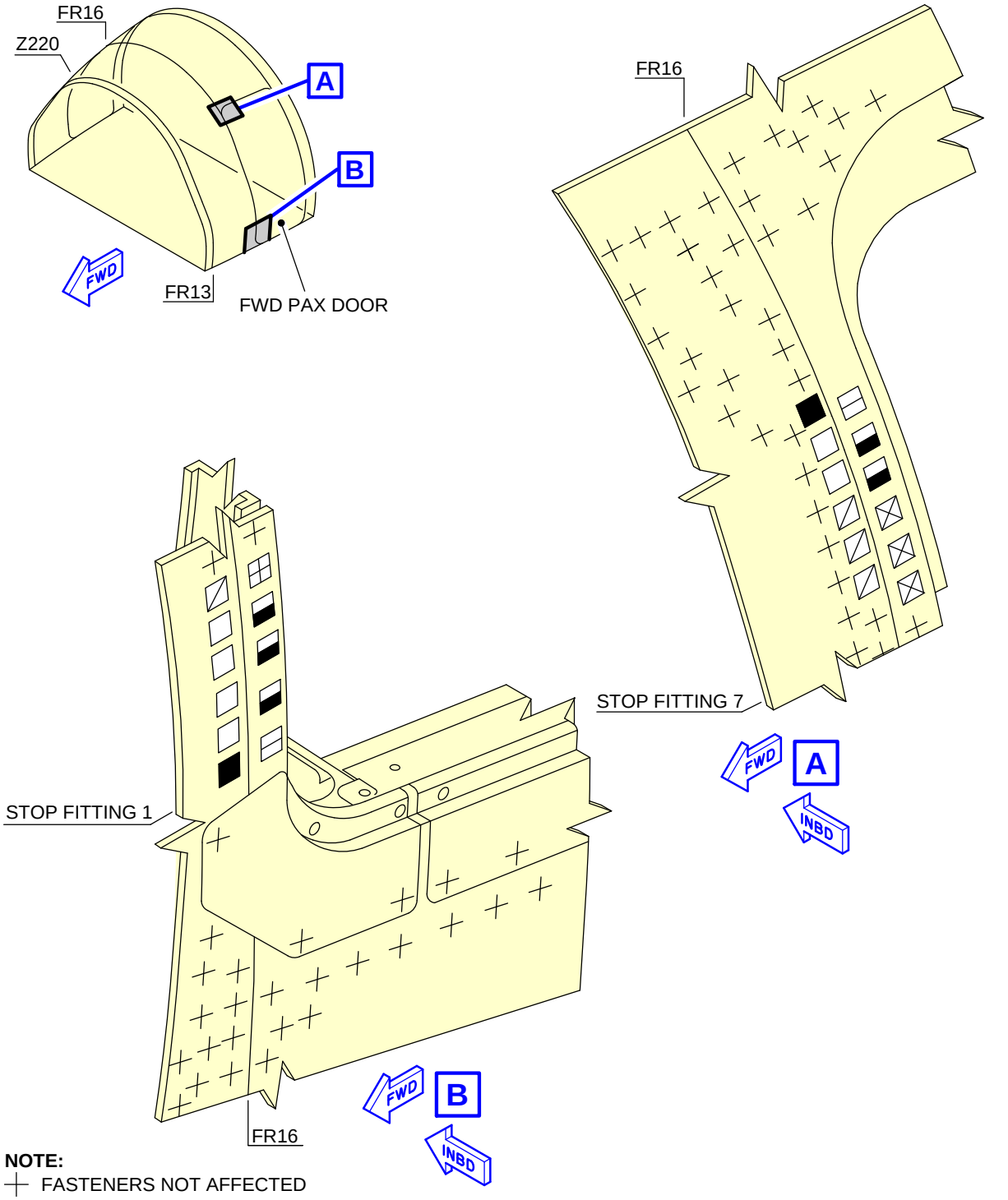
2 For the external protective finish, apply:

Wash Primer - - - Structure 04CMA2
and

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2
and

Top Coat Polyurethane - - - External Structure 04JAA3

CONF 002



NOTE:
┼ FASTENERS NOT AFFECTED
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-02KH6-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH6-A-001-01 Fig.BC Sol.AB SHEET 1/2

CONF 002

HOLE SYMBOL	NEW ITEM	PART NUMBER	DESCRIPTION	SIZE/FIT TYPE	NOTE
N	1	EN6114K4Y13	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	3	EN6114K4Y11	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	4	EN6114K3A8	BOLT	NOMINAL SIZE INTERFERENCE FIT	01 02 03
	5	ASNA2531-3A	NUT		
N	6	EN6114K5Y14	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	8	EN6114K5Y12	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	9	EN6114K4Y10	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	12	EN6114K4Y9	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		

NOTE:

N HEAD ON NEAR SIDE

01 WET INSTALL WITH MATERIAL No 06AAB1

02 APPLY INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. APPLY ON THE TOP OF THE INTERNAL PROTECTIVE FINISH MATERIAL No 12ADB1

03 APPLY EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3

ICN-A320-A-53XX1381-A-FAPE3-02KH7-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH7-A-001-01 Fig.BC Sol.AB SHEET 2/2

CONF 003

(4) Task A320-A-53-XX-1381-01003-720A-A (A320-A-53-XX-1381-01ZZZ-720Z-A) Install the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
220	Access	Door 831
	Work location	Frame 16

Manpower/Resources/Skills

Man-hours	7.75 h
Minimum Number of person	1
Elapsed Time	7.75 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		
	04JAA3	Top Coat Polyurethane - - - External Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAB1	Polysulfide Sealant - General Purpose Fillet		
	08BAA9	Non Aqueous Cleaner - General		
	12ADB1	Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil		
	14SBA1	Textile - Lint free Cotton		

Part kit 531381A03R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
1	EN6114K4Y13	2	BOLT		
2	ASNA2531-4	12	NUT		
3	EN6114K4Y11	6	BOLT		
4	EN6114K3A8	4	BOLT		
5	ASNA2531-3A	4	NUT		
6	EN6114K5Y14	2	BOLT		
7	ASNA2531-5	7	NUT		
8	EN6114K5Y12	5	BOLT		

Part kit 531381A03R01					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
12	EN6114K4Y9	4	BOLT		

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
CML	CONSUMABLE MATERIAL LIST (CML)
SRM	51-24-00 51-40-00 51-42-00 51-43-00 51-75-12

Procedure

(a) Standard practices given in this procedure:

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

6 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.

7 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.

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

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.

(b) Install the fasteners on the Frame 16 double joggle area:

1 Wet install the fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

2	BOLT	EN6114K4Y13	Item 1
6	BOLT	EN6114K4Y11	Item 3
4	BOLT	EN6114K3A8	Item 4

2	BOLT	EN6114K5Y14	Item 6
5	BOLT	EN6114K5Y12	Item 8
4	BOLT	EN6114K4Y9	Item 12
12	NUT	ASNA2531-4	Item 2
4	NUT-HEXAGONAL	ASNA2531-3A	Item 5
7	NUT with:	ASNA2531-5	Item 7
	Polysulfide Sealant - General Purpose Fillet	06AAB1	

2 Clean the work areas with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

(c) Apply protective finish on the new fasteners:
Refer to Ref. Fig.BC Installation of the Fasteners on the Frame 16 Double Joggle Area, on the LH Side

1 For the internal protective finish, apply:

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2
and

Top Coat Polyurethane - - Grey InternalStructure 04JME4
and

Corrosion Preventive Compound - Water Displacing & Heavy Duty Hard Fil 12ADB1

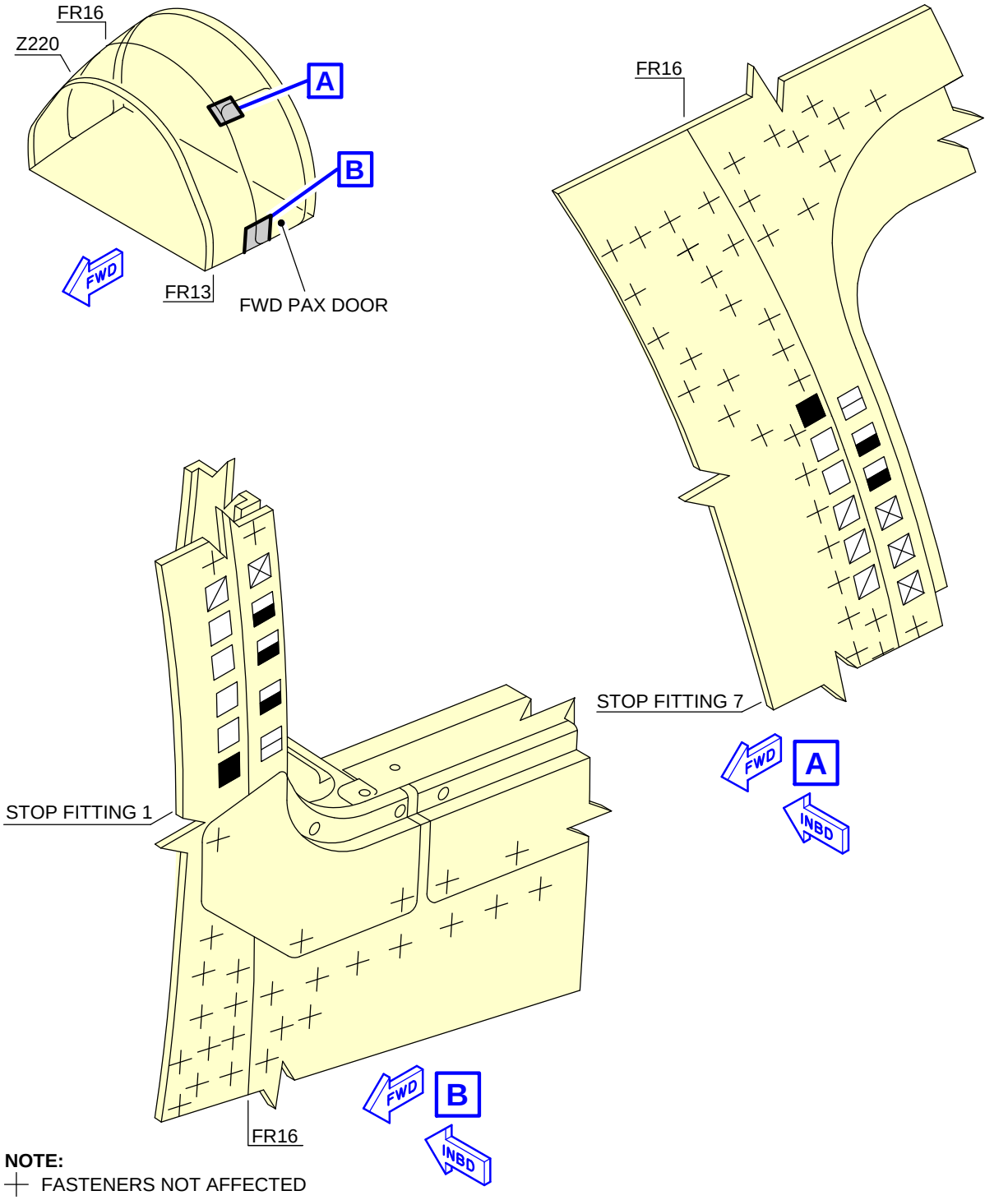
2 For the external protective finish, apply:

Wash Primer - - - Structure 04CMA2
and

Primer Polyurethane Paint - - CorrosionInhibiting Structure 04EAC2
and

Top Coat Polyurethane - - - External Structure 04JAA3

CONF 003



NOTE:
┼ FASTENERS NOT AFFECTED
REFER TO SHEET 02 FOR THE APPLICABLE FASTENERS

ICN-A320-A-53XX1381-A-FAPE3-02KH8-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH8-A-001-01 Fig.BC Sol.AC SHEET 1/2

CONF 003

HOLE SYMBOL	NEW ITEM	PART NUMBER	DESCRIPTION	SIZE/FIT TYPE	NOTE
N	1	EN6114K4Y13	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	3	EN6114K4Y11	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		
N	4	EN6114K3A8	BOLT	NOMINAL SIZE INTERFERENCE FIT	01 02 03
	5	ASNA2531-3A	NUT		
N	6	EN6114K5Y14	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	8	EN6114K5Y12	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	7	ASNA2531-5	NUT		
N	12	EN6114K4Y9	BOLT	SECOND OVERSIZE INTERFERENCE FIT	01 02 03
	2	ASNA2531-4	NUT		

NOTE:

N HEAD ON NEAR SIDE

01 WET INSTALL WITH MATERIAL No 06AAB1

02 APPLY INTERNAL PROTECTIVE FINISH WITH MATERIAL No 04EAC2 AND MATERIAL No 04JME4. APPLY ON THE TOP OF THE INTERNAL PROTECTIVE FINISH MATERIAL No 12ADB1

03 APPLY EXTERNAL PROTECTIVE FINISH WITH MATERIAL No 04CMA2, MATERIAL No 04EAC2 AND MATERIAL No 04JAA3

ICN-A320-A-53XX1381-A-FAPE3-02KH9-A-001-01

Figure ICN-A320-A-53XX1381-A-FAPE3-02KH9-A-001-01 Fig.BC Sol.AC SHEET 2/2

CONF ALL

D. PREPARATION FOR TEST

None

E. TEST

(1) Task A320-A-53-XX-1381-01001-390A-A (A320-A-53-XX-1381-01ZZZ-390Z-A) Testing

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.10 h
Minimum Number of person	1
Elapsed Time	0.10 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 25-23-45-400-006 25-31-00 25-41-00

Procedure

This Service Bulletin requires the accomplishment of Tests given in other topics which are referenced in the table below:

Paragraph	Task
Ref. Task A320-A-53-XX-1381-01ZZZ-740Z-A	Ref. AMM Task 25-23-45-400-006
	Ref. AMM 25-31-00 NOTE: If removed, do the test after the installation of the FWD galleys between Frame 15 and Frame 16. To do this, refer to Ref. AMM 25-31-00. In this paragraph, you will find the cross-references of the installation task.
	Ref. AMM 25-41-00 NOTE: If removed, do the test after the installation of the FWD lavatories between Frame 15 and Frame 16. To do this, refer to Ref. AMM 25-41-00. In this paragraph, you will find the cross-references of the installation task.

F. CLOSE-UP

(1) Task A320-A-53-XX-1381-01001-740A-A (A320-A-53-XX-1381-01ZZZ-740Z-A) Close-up

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	4.00 h
Minimum Number of person	1

Elapsed Time	4.00 h

Referenced Information

Manuals/Drawings	References/Sheets
AMM	Task 25-23-45-400-006 25-31-00 25-41-00 Task 25-80-00-400-001 Task 52-10-00-410-001

Procedure

(a) If removed, install the electrical wire harnesses at Frame 16.

(b) Install the insulation blankets at Frame 16, refer to Ref. AMM Task 25-80-00-400-001.

(c) Install the removed lining panels at Frame 16, refer to Ref. AMM Task 25-23-45-400-006.

(d) If removed, install the FWD galleys and lavatories between Frame 15 and Frame 16. To do this, refer to the paragraph 'Component Location' in the applicable ATA 25 'Description/Operation': for the galleys, refer to Ref. AMM 25-31-00; for the lavatories, Ref. AMM 25-41-00. In this paragraph, you will find the cross-references of the installation task.

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

(f) Close the passenger/crew Door 831, refer to Ref. AMM Task 52-10-00-410-001.

(g) Remove the access platform(s).

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

G. ADMINISTRATIVE

(1) Task A320-A-53-XX-1381-01001-90AA-A (A320-A-53-XX-1381-01ZZZ-90AZ-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. REPORTING SHEET

TITLE:	FUSELAGE - NOSE FORWARD FUSELAGE - REDESIGN OF THE DOUBLE JOGGLE AREA FRAME 16 LHS

MODIFICATION No.:	160876P15989

(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.

B. 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
2, ROND POINT EMILE DEWOITINE
31700 BLAGNAC
FRANCE

Or via your Resident Customer Support Office.