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

ATA SYSTEM: 53

TITLE: FUSELAGE - GENERAL - IMPROVE RIVETING IN REAR FUSELAGE AREA AT SECTION 17 FROM FR57 TO FR59

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	None				
MINOR	203702D50759				

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

REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES

Prior to delivery of an A330-200F aircraft, fasteners were found missing at some locations in the rear fuselage area at Section 17, from Frame (FR)57 to FR59.

The fastener installation and condition at the affected locations are inspected by Inspection Service Bulletin No. A330-53-3212. In the event of findings at that inspection, this Modification Service Bulletin details the procedure to install the correct fasteners at the identified locations.

Accomplishment of this Service Bulletin will make sure that the aircraft will be restored to the original approved design integrity.

GENERAL EVALUATION

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

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

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MATERIAL PRICE INFORMATION

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533217D01R01	1	50.00	Fasteners

EFFECTIVITY

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

CRK ETD MAS MNB QTR THY TPA YZR

CONCURRENT REQUIREMENTS

Service Bulletin(s) to be accomplished previously or simultaneously:

Service Bulletin No. A330-53-3212

NOTE: - A330-53-3212 FUSELAGE - FORWARD FUSELAGE - INSPECTION FOR SUSPECTED MISSING/NON-CONFORMING FASTENERS AT SECTION 17 FROM FR57 TO FR59

REFERENCES / REPERCUSSIONS

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

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

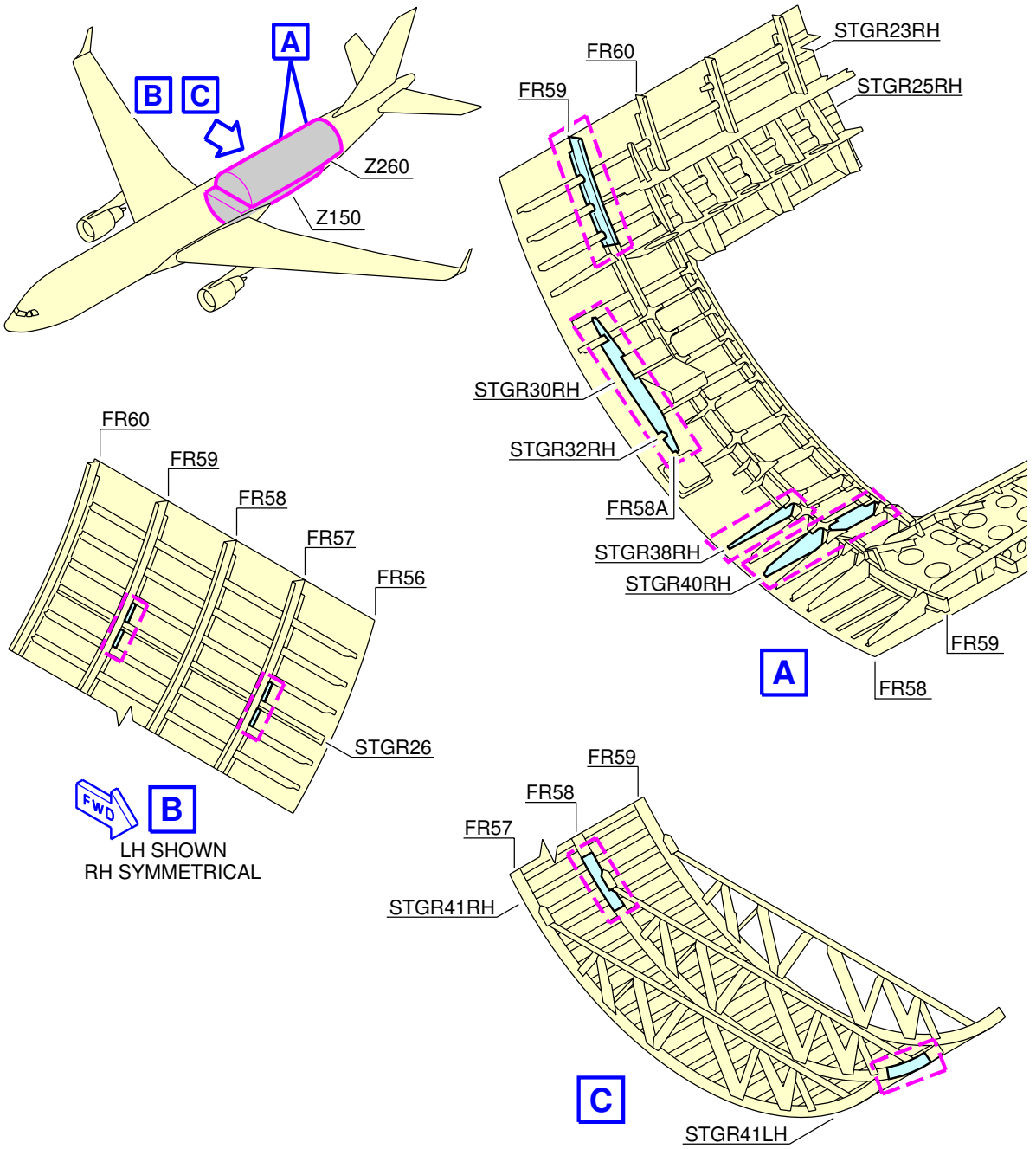
Task 533217-831-848-001: Modification	
TOTAL MANHOURS	10.00
ELAPSED TIME (HOURS)	10.00

APPENDICES

None

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**CONF ALL



NOTE:

MODIFICATION AREAS

G_SB_533217_6_SAAA_01_00

Figure A-GSAAA - Sheet 01

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ATA SYSTEM: 53

TITLE: FUSELAGE - GENERAL - IMPROVE RIVETING IN REAR FUSELAGE AREA AT SECTION 17 FROM FR57 TO FR59

MODIFICATION No.: 203702D50759

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: The intent of this modification is achieved in production on A330 aircraft with Manufacturer Serial Number (MSN) 1442 and subsequent through Modification Number 202674D50581.

(1) Models

330-223F 330-243F

(2) Effectivity by MSN

1004 1032 1051 1062 1070 1092 1115 1136 1148 1164 1175 1180 1320 1332 1344 1350 1368 1380 1386 1406 1414 1418 1428

(3) Effectivity by Operator

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

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OPERATOR	MSN
CRK	1051 1062 1115 1320
ETD	1032 1070 1414
MAS	1136 1148 1164 1180
MNB	1332
QTR	1350 1386 1406
THY	1004 1092 1344 1418
TPA	1368 1380 1428
YZR	1175

(4) Configuration by MSN

MSN	CONFIGURATION
1004 1032 1051 1062 1070 1092 1115 1136 1148 1164 1175 1180 1320 1332 1344 1350 1368 1380 1386 1406 1414 1418 1428	001

(5) Configuration definition

**CONF 001
Config. 001 is valid for all the aircraft given in the effectivity of this Service Bulletin as a standard configuration.

(6) Material Effectivity

MATERIAL	QTY PER A/C	SEE NOTES
Kit 533217D01R01	1	
Consumable CMLD01	As required	

B. CONCURRENT REQUIREMENTS

Service Bulletin(s) to be accomplished previously or simultaneously:

Service Bulletin No. A330-53-3212

NOTE: - A330-53-3212 FUSELAGE - FORWARD FUSELAGE - INSPECTION FOR SUSPECTED MISSING/NON-CONFORMING FASTENERS AT SECTION 17 FROM FR57 TO FR59

C. REASON

(1) History

Prior to delivery of an A330-200F aircraft, fasteners were found missing at some locations in the rear fuselage area at Section 17, from Frame (FR)57 to FR59.

(2) Objective/Action

The fastener installation and condition at the affected locations are inspected by Inspection Service Bulletin No. A330-53-3212. In the event of findings at that inspection, this Modification Service Bulletin details the procedure to install the correct fasteners at the identified locations.

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(3) Advantages

Accomplishment of this Service Bulletin will make sure that the aircraft will be restored to the original approved design integrity.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

Task 533217-831-848-001: Modification

(1) Install the Fasteners at FR57, STGR26 LH

(2) Install the Fasteners at FR57, STGR26 RH

(3) Install the Fasteners at FR58 to FR59, STGR38 RH

(4) Install the Fasteners at FR58, STGR41 LH

(5) Install the Fasteners at FR58, STGR41 RH

(6) Install the Fasteners at FR58A, between STGR29 RH and STGR30 RH

(7) Install the Fasteners at FR58A, between STGR31 RH and STGR33 RH

(8) Install the Fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH

(9) Install the Fasteners at FR59, STGR26 LH

(10) Install the Fasteners at FR59, STGR40 RH

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 to be performed, when applicable, immediately, when applicable, after inspection Service Bulletin No. A330-53-3212.

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

F. APPROVAL

The technical content of this document is approved under the authority of Design Organisation Approval No. EASA.21J.031.

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

G. MANPOWER

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

Task 533217-831-848-001: Modification	
Get Access	3.50
On Aircraft	
Install the Fasteners at FR57, STGR26 LH	0.25
Install the Fasteners at FR57, STGR26 RH	0.25
Install the Fasteners at FR58 to FR59, STGR38 RH	0.25
Install the Fasteners at FR58, STGR41 LH	0.25
Install the Fasteners at FR58, STGR41 RH	0.25
Install the Fasteners at FR58A, between STGR29 RH and STGR30 RH	0.25
Install the Fasteners at FR58A, between STGR31 RH and STGR33 RH	0.50
Install the Fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH	0.50
Install the Fasteners at FR59, STGR26 LH	0.25
Install the Fasteners at FR59, STGR40 RH	0.25
Close-Up	3.50
TOTAL MANHOURS	10.00
ELAPSED TIME (HOURS)	10.00

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

Aircraft Maintenance Manual (AMM)	06-20-00 12-34-24 25-55-22 52-30-00	06-31-53 20-21-11 25-80-00 53-00-00	06-41-53 25-53-00 52-10-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Service Bulletin (SB)	A330-53-3212		

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Standards Manual (SM)			
Structural Repair Manual (SRM)	51-24-00 51-43-00 51-47-00	51-40-00 51-44-11 51-75-12	51-42-00 51-46-11

K. PUBLICATION AFFECTED

None

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

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2. MATERIAL INFORMATION

****CONF ALL**

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

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

Kit 533217D01R01	AIRBUS Material, Logistics and Suppliers Weg beim Jaeger 150 D-22335 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by fax: +49 40 50 76 2590 For ordering by E-mail; airbus.kit@airbus.com

(2) Price and Availability

Kit 533217D01R01	
Cost	50.00 USD
Availability	30 calendar days from receipt of order

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

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

B. INDUSTRY SUPPORT INFORMATION

For aircraft under warranty at Jun 01/11, AIRBUS will credit the manhours indicated in this Service Bulletin at the agreed in-house warranty labor rate for claims received not later than 90 days after completion of the last affected aircraft of your fleet.

For aircraft under warranty at Jun 01/11, AIRBUS will share the costs of accomplishment of this Service Bulletin by providing the kits at no charge for orders placed before Dec 31/16.

C. LIST OF COMPONENTS

Kit 533217D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	ASNA2025-3	2	BUSH				
2	DAN5-6-3	4	PIN				
3	EN6069KE5-12	2	RIVET				
4	EN6069KE6-12	4	RIVET				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
5	EN6081D5-12	5	RIVET				
6	EN6081D5-14	17	RIVET				
7	MBBN4481-0503	2	RIVET				
8	NSA5075-6	4	COLLAR				

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

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLD01

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

(2) Components

None

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

None

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3. ACCOMPLISHMENT INSTRUCTIONS

Task 533217-831-848-001 - Modification

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

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

- PUT PROTECTION, SUCH AS PLASTIC SHEETING, CLOTHS, ETC; AS NECESSARY ON WIRING AND COMPONENTS.
- REGULARLY REMOVE ALL SHAVINGS, UNWANTED MATERIAL AND OTHER CONTAMINATION.

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

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

NOTE: The accomplishment instructions of this Service Bulletin refer to procedures included in other AIRBUS documents. When the words 'refer to' are used and the operator has an accepted alternative procedure, the accepted alternative procedure can be used. When the words 'in accordance with' are included in the instruction, the procedure in the AIRBUS document must be used.

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.

Task Associated Data

Zone	
150 260	
Access	
Door	822 831
Panel	151FC 151HW 151JW 151QW 151RW 152FC 152HW 152JW 152MW 152NW 152VK 152WK 262WW 262XW
Manpower	
TOTAL MANHOURS	10.00
ELAPSED TIME (HOURS)	10.00

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A. GENERAL

(1) Subtask 533217-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-21-11-911-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-11 51-46-11 51-47-00 51-75-12

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

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

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

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

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

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

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

(h) Obtain fastener hole diameters and drill and de-burr data in accordance with SRM 51-44-11.

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

(j) For the drilling of rivet holes:

- Use a soft lead pencil and make marks to show the position of the rivet holes.
- Make sure that you have the correct edge clearance before you drill the fastener holes.
- If not shown otherwise the tolerance for the rivet hole diameter is +0.1 mm (+0.004 in.).

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- If not shown otherwise the tolerance for the rivet hole position is +/-0.2 mm (+/-0.007 in.).
- Transfer-drill the existing holes with a pilot drill and a drill bush.
- Drill new fastener holes with a pilot drill of 2.5 mm (0.0984 in.) diameter. Increase the hole diameter to the correct size for the fastener which you must install.
- Deburr the holes.

(k) Cut the rivets to the necessary length.

(l) Countersink the fastener holes in accordance with SRM 51-46-11.

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

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

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

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

(2) Subtask 533217-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

B. PREPARATION

(1) Subtask 533217-941-201-001 - Job Set-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 151HW, Panel 151JW, Panel 151QW, Panel 151RW, Panel 152HW, Panel 152JW, Panel 152MW, Panel 152NW, Panel 152VK, Panel 152WK, Panel 151FC, Panel 152FC
	260	Access	Door 831 Panel 262WW, Panel 262XW

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802 Task 25-53-00-000-801 Task 25-55-22-000-801 Task 25-80-00-000-801 Task 52-30-00-010-801 Task 53-00-00-000-803

(a) The following items shall be considered as the basic Aircraft configuration before you start a maintenance task:

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

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

(c) Put access platform(s) in position below the AFT cargo-compartment door 822.

(d) Open the AFT cargo-compartment door 822, refer to AMM Task 52-30-00-010-801.

(e) In the Main-Deck Cargo Compartment (MDCC), remove the lining panels 262WW and 262XW, refer to AMM Task 25-55-22-000-801.

(f) In the AFT cargo-compartment, remove the floor panels 152VK and 152WK, refer to AMM Task 53-00-00-000-803.

(g) In the AFT cargo-compartment, remove the sidewall panels 151HW, 151JW, 151QW, 151RW, 152HW, 152JW, 152MW and 152NW, refer to AMM Task 25-53-00-000-801.

(h) In the AFT cargo-compartment, remove the ceiling panels 151FC and 152FC, refer to AMM Task 25-53-00-000-801.

(i) Remove the insulation blankets as necessary to get access to the work areas, refer to AMM Task 25-80-00-000-801.

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C. PROCEDURE

(1) Subtask 533217-831-201-001 - Install the Fasteners at FR57, STGR26 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 151JW, Panel 151FC
		Work location	Frame 57 Stringer 26LH

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

Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	EN6069KE6-12	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBAAA Installation of the fasteners at FR57, STGR26 LH and RH	Sheet 01

(a) Install the fasteners at FR57, STGR26 LH.

1 As shown in Fig. A-GBAAA Sheet 01:

a Mark the fastener hole positions and pilot drill the holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.85 mm and 4.95 mm (0.191 in. and 0.195 in.) diameter and countersink.

2 As shown in Fig. A-GBAAA Sheet 01, wet install:

2 Rivet EN6069KE6-12 Item 4

with:

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(2) Subtask 533217-831-209-001 - Install the Fasteners at FR57, STGR26 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152FC, Panel 152JW
		Work location	Frame 57 Stringer 26RH

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

Material necessary to do the job

Kit 533217D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
4	EN6069KE6-12	2	RIVET	

Consumable CMLD01

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

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBAAA Installation of the fasteners at FR57, STGR26 LH and RH	Sheet 01

(a) Install the fasteners at FR57, STGR26 RH.

1 As shown in Fig. A-GBAAA Sheet 01:

a Mark the fastener hole positions and pilot drill the holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the pilot holes to between 4.85 mm and 4.95 mm (0.191 in. and 0.195 in.) diameter and countersink.

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2 As shown in Fig. A-GBAAA Sheet 01, wet install:

2	Rivet	EN6069KE6-12	Item 4

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(3) Subtask 533217-831-202-001 - Install the Fasteners at FR58 to FR59, STGR38 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152WK
		Work location	from Frame 58 to Frame 59 Stringer 38RH

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

Material necessary to do the job

Kit 533217D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	ASNA2025-3	2	BUSH	
7	MBBN4481-0503	2	RIVET	

Consumable CMLD01

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

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBBAA Installation of the fasteners at FR58 to FR59, STGR38 RH	Sheet 01

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(a) Install the fasteners at FR58 to FR59 to STGR38 RH.

1 As shown in Fig. A-GBBAA Sheet 01:

a Mark the fastener hole positions and pilot drill the holes to 2.5 mm (0.984 in.) diameter in the structure.

b Open the pilot holes to between 4.85 mm and 4.95 mm (0.191 in. and 0.195 in.) diameter and countersink.

2 As shown in Fig. A-GBBAA Sheet 01, wet install:

2	Rivet	MBBN4481-0503	Item 7
2	Collar	ASNA2025-3	Item 1

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(4) Subtask 533217-831-203-001 - Install the Fasteners at FR58, STGR41 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 151HW, Panel 151QW
		Work location	Frame 58 Stringer 41LH

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

Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	DAN5-6-3	2	PIN	
8	NSA5075-6	2	COLLAR	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBCAA Installation of the fasteners at FR58, STGR41 LH and RH	Sheet 01

(a) Install the fasteners at FR58, STGR41 LH.

1 As shown in Fig. A-GBCAA Sheet 01:

a Mark the fastener hole positions and pilot drill the holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.780 mm and 4.821 mm (0.1882 in. and 0.1898 in.) diameter.

2 As shown in Fig. A-GBCAA Sheet 01, wet install:

2	Pin	DAN5-6-3	Item 2
2	Collar	NSA5075-6	Item 8

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(5) Subtask 533217-831-210-001 - Install the Fasteners at FR58, STGR41 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152HW, Panel 152MW
		Work location	Frame 58 Stringer 41RH

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

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Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	DAN5-6-3	2	PIN	
8	NSA5075-6	2	COLLAR	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBCAA Installation of the fasteners at FR58, STGR41 LH and RH	Sheet 01

(a) Install the fasteners at FR58, STGR41 RH.

1 As shown in Fig. A-GBCAA Sheet 01:

a Mark the fastener hole positions and pilot drill the holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.780 mm and 4.821 mm (0.1882 in. and 0.1898 in.) diameter.

2 As shown in Fig. A-GBCAA Sheet 01, wet install:

2	Pin	DAN5-6-3	Item 2
2	Collar	NSA5075-6	Item 8

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

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(6) Subtask 533217-831-204-001 - Install the Fasteners at FR58A, between STGR29 RH and STGR30 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152MW, Panel 152NW
		Work location	Frame 58A from Stringer 29RH to Stringer 30RH

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

Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
6	EN6081D5-14	3	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBDAA Installation of the fasteners at FR58A, between STGR29 RH and STGR30 RH	Sheet 01

(a) Install the fasteners at FR58A, STGR29 RH to STGR30 RH.

1 As shown in Fig. A-GBDAA Sheet 01:

a Transfer drill the pilot holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.06 mm and 4.17 mm (0.160 in. to 0.164 in.) diameter.

2 As shown in Fig. A-GBDAA Sheet 01, wet install:

3 Rivet EN6081D5-14 Item 6

with:

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(7) Subtask 533217-831-205-001 - Install the Fasteners at FR58A, between STGR31 RH and STGR33 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152MW, Panel 152NW
		Work location	Frame 58A from Stringer 31RH to Stringer 33RH

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

Material necessary to do the job

Kit 533217D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
6	EN6081D5-14	8	RIVET	

Consumable CMLD01

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

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBEAA Installation of the fasteners at FR58A, between STGR31 RH and STGR33 RH	Sheet 01

(a) Install the fasteners at FR58A, STGR31 RH to STGR33 RH.

1 As shown in Fig. A-GBEAA Sheet 01:

a Mark the two omitted fastener hole positions and pilot drill the two holes to 2.5 mm (0.09844 in.) diameter in the structure.

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b Transfer drill the six pre-existing pilot holes to 2.5 mm (0.0984 in.) diameter in the structure.

c As shown in Fig. A-GBEAA Sheet 01, open the eight pilot holes to between 4.06 mm and 4.17 mm (0.160 in. to 0.164 in.) diameter.

2 As shown in, wet install:

8	Rivet	EN6081D5-14	Item 6

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(8) Subtask 533217-831-206-001 - Install the Fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Access	Door 831 Panel 262WW, Panel 262XW
		Work location	Frame 59 Stringer 23RH Stringer 24RH Stringer 25RH

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

Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
6	EN6081D5-14	6	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBFAA Installation of the fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH	Sheet 01

(a) Install the fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH.

1 As shown in Fig. A-GBFAA Sheet 01:

a Transfer drill the pilot holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.06 mm and 4.17 mm (0.160 in. and 0.164 in.) diameter.

2 As shown in Fig. A-GBFAA Sheet 01, wet install:

6 Rivet EN6081D5-14 Item 6

with:

Polysulfide Sealant - General Purpose Brushable 06AAA1 As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(9) Subtask 533217-831-207-001 - Install the Fasteners at FR59, STGR26 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 151RW
		Work location	Frame 59 Stringer 26LH

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

Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
3	EN6069KE5-12	2	RIVET	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBGAA Installation of the fasteners at FR59, STGR26 LH	Sheet 01

(a) Install the fasteners at FR59, STGR26 LH.

1 As shown in Fig. A-GBGAA Sheet 01:

a Mark the hole positions and pilot drill the holes to 2.5 mm (0.984 in.) diameter in the structure.

b Open the fastener holes to between 4.06 mm and 4.17 mm (0.160 in. and 0.164 in.) diameter and countersink.

2 As shown in Fig. A-GBGAA Sheet 01, wet install:

2 Rivet EN6069KE5-12 Item 3

with:

Polysulfide Sealant - General Purpose Brushable 06AAA1 As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

(10) Subtask 533217-831-208-001 - Install the Fasteners at FR59, STGR40 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 152VK
		Work location	Frame 59 Stringer 40RH

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

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Material necessary to do the job

Kit 533217D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	EN6081D5-12	5	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

References	
Structural Repair Manual (SRM)	51-75-12
Fig. A-GBHAA Installation of the fasteners at FR59, STGR40 RH	Sheet 01

(a) Install the fasteners at FR59, STGR40 RH.

1 As shown in Fig. A-GBHAA Sheet 01:

a Transfer drill the pilot holes to 2.5 mm (0.0984 in.) diameter in the structure.

b Open the fastener holes to between 4.06 mm and 4.17 mm (0.160 in. and 0.164 in.) diameter.

2 As shown in Fig. A-GBHAA Sheet 01, wet install:

5 Rivet EN6081D5-12 Item 5

with:

Polysulfide Sealant - General Purpose Brushable 06AAA1 As required

3 Apply surface protection to the fasteners which you have installed in accordance with SRM 51-75-12.

D. TEST

None

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E. CLOSE-UP

(1) Subtask 533217-942-201-001 - Close-up

Work Zones and Access Panels			
	Zone	Access/Work location	
	150	Access	Door 822 Panel 151HW, Panel 151JW, Panel 151QW, Panel 151RW, Panel 152HW, Panel 152JW, Panel 152MW, Panel 152NW, Panel 152VK, Panel 152WK, Panel 151FC, Panel 152FC
	260	Access	Door 831 Panel 262WW, Panel 262XW

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 25-53-00-400-801 Task 25-55-22-400-801 Task 25-80-00-400-001 Task 52-10-00-410-801 Task 52-30-00-410-801 Task 53-00-00-400-803

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

(b) Install the insulation blankets which you removed to get access to the work areas, refer to AMM Task 25-80-00-400-001.

(c) In the AFT cargo-compartment, install the ceiling panels 151FC and 152FC, refer to AMM Task 25-53-00-400-801.

(d) In the AFT cargo-compartment, install the sidewall panels 151HW, 151JW, 151QW, 151RW, 152HW, 152JW, 152MW and 152NW, refer to AMM Task 25-53-00-400-801.

(e) In the AFT cargo-compartment, install the floor panels 152VK and 152WK, refer to AMM Task 53-00-00-400-803.

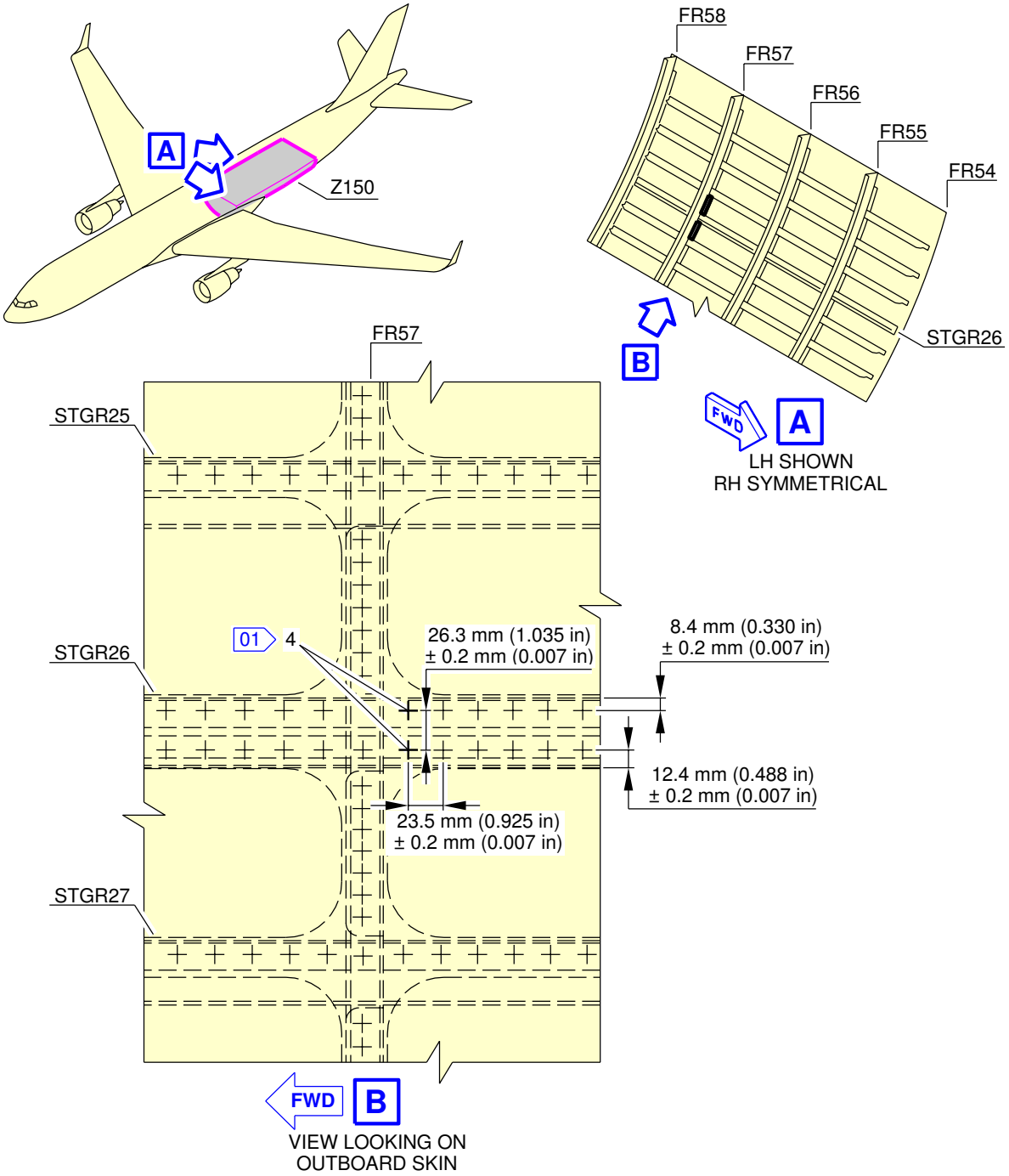
(f) In the Main-Deck Cargo Compartment (MDCC), install the lining panels 262WW and 262XW, refer to AMM Task 25-55-22-400-801.

(g) Close the AFT cargo-compartment door 822, refer to AMM Task 52-30-00-410-801.

(h) Remove the access platform(s).

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**CONF ALL



NOTE:

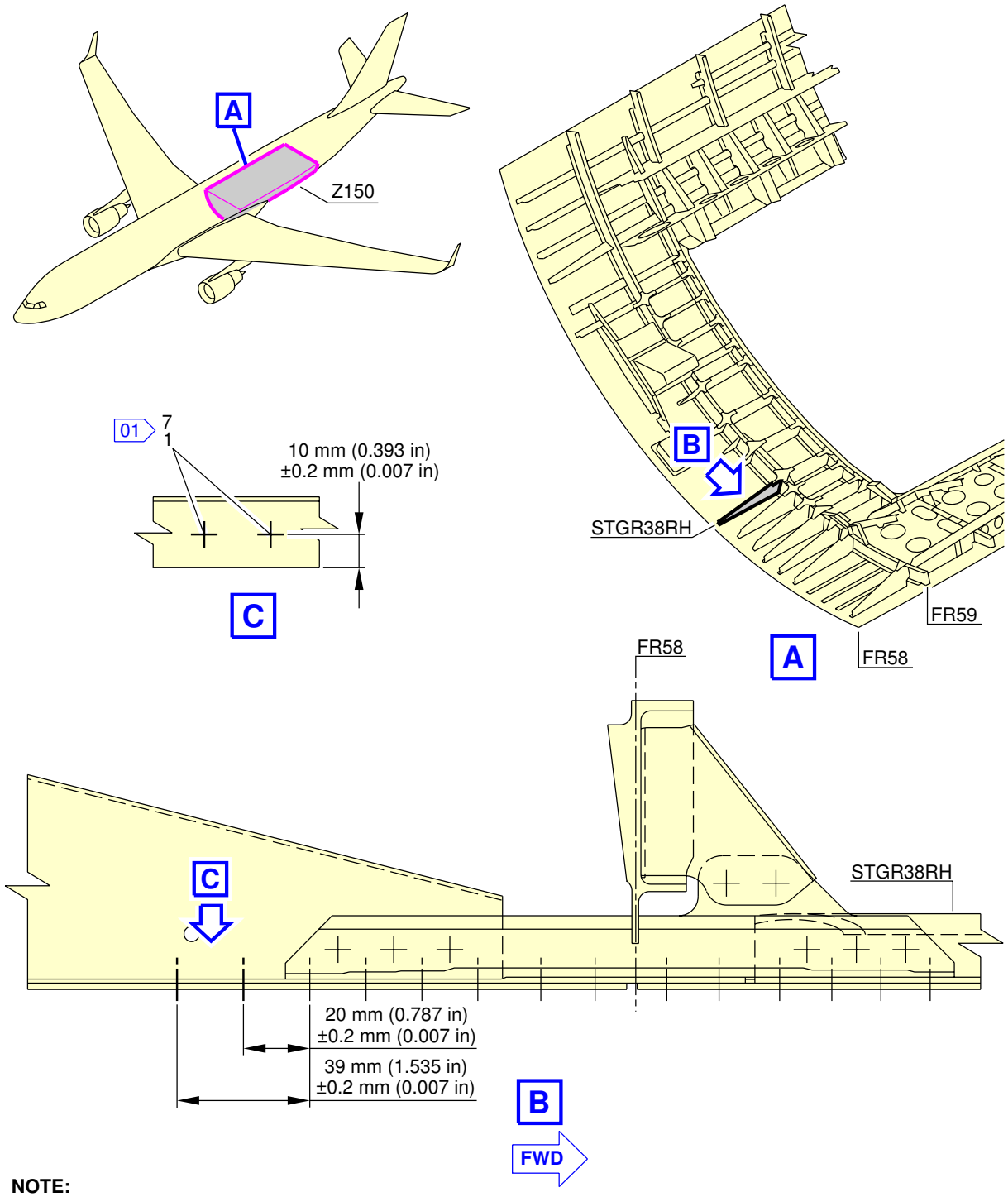
01 DIMENSIONS ARE GIVEN IN CASE HOLES DO NOT PRE–EXIST.

G_SB_533217_6_BAAA_01_01

Figure A-GBAAA - Sheet 01
Installation of the fasteners at FR57, STGR26 LH and RH

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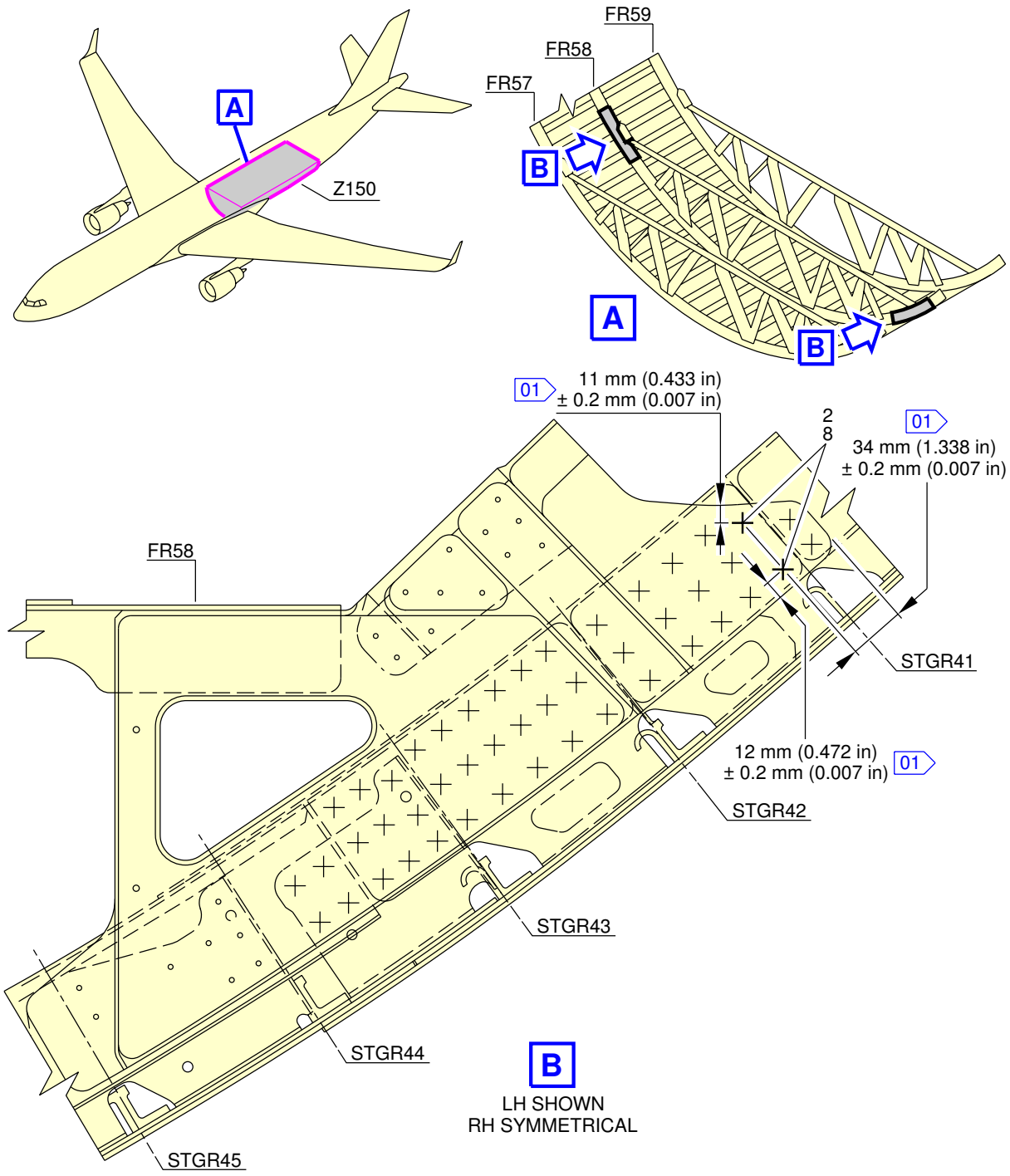
NOTE:
01 DIMENSIONS ARE GIVEN IN CASE HOLES DO NOT PRE–EXIST.

G_SB_533217_6_BBAA_01_00

Figure A-GBBAA - Sheet 01
Installation of the fasteners at FR58 to FR59, STGR38 RH

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NOTE:

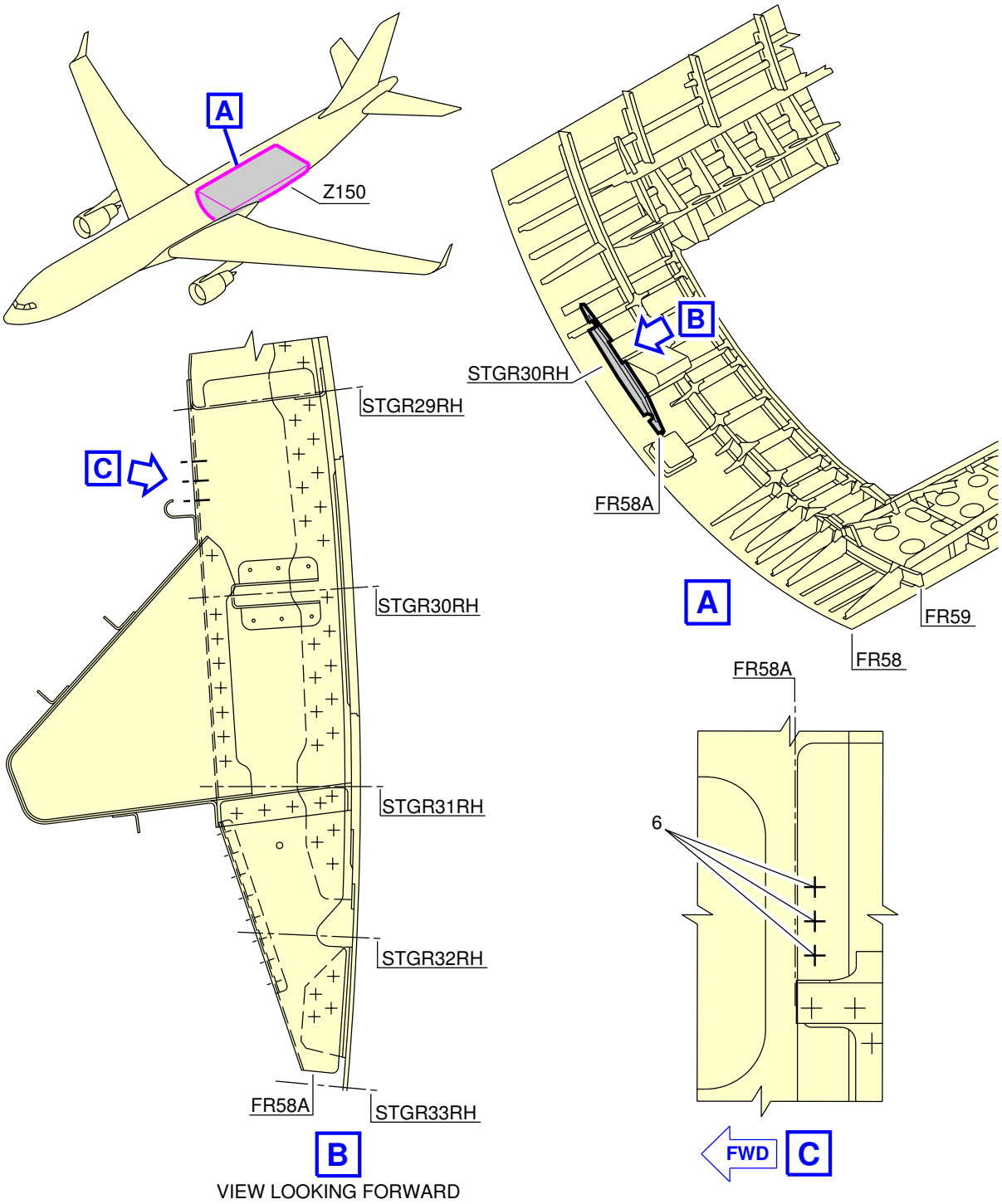
01 DIMENSIONS ARE GIVEN IF HOLES DO NOT EXIST.

G_SB_533217_6_BCAA_01_01

Figure A-GBCAA - Sheet 01
Installation of the fasteners at FR58, STGR41 LH and RH

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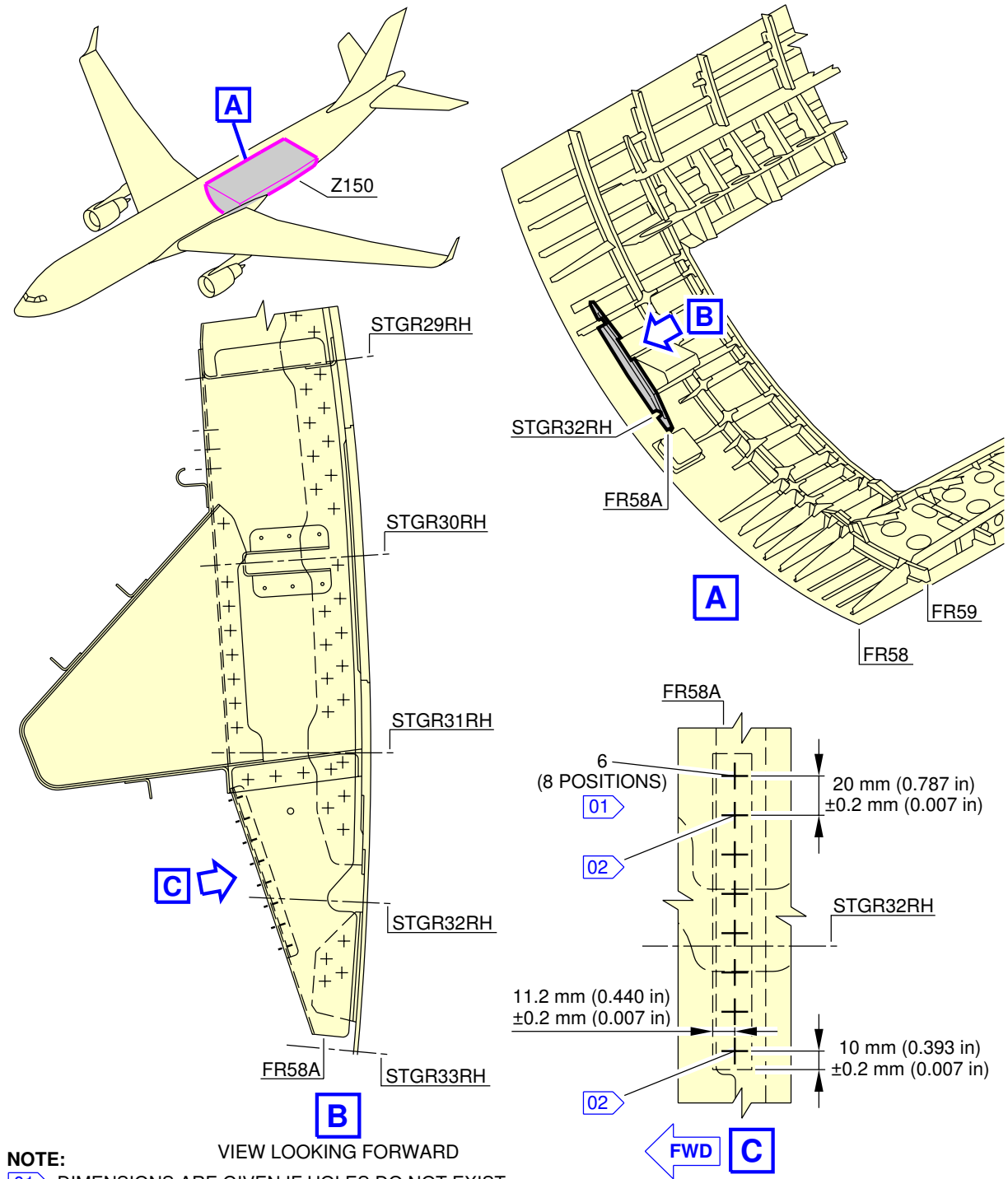


G_SB_533217_6_BDAA_01_00

Figure A-GBDAA - Sheet 01
Installation of the fasteners at FR58A, between STGR29 RH and STGR30 RH

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NOTE:

01 DIMENSIONS ARE GIVEN IF HOLES DO NOT EXIST.

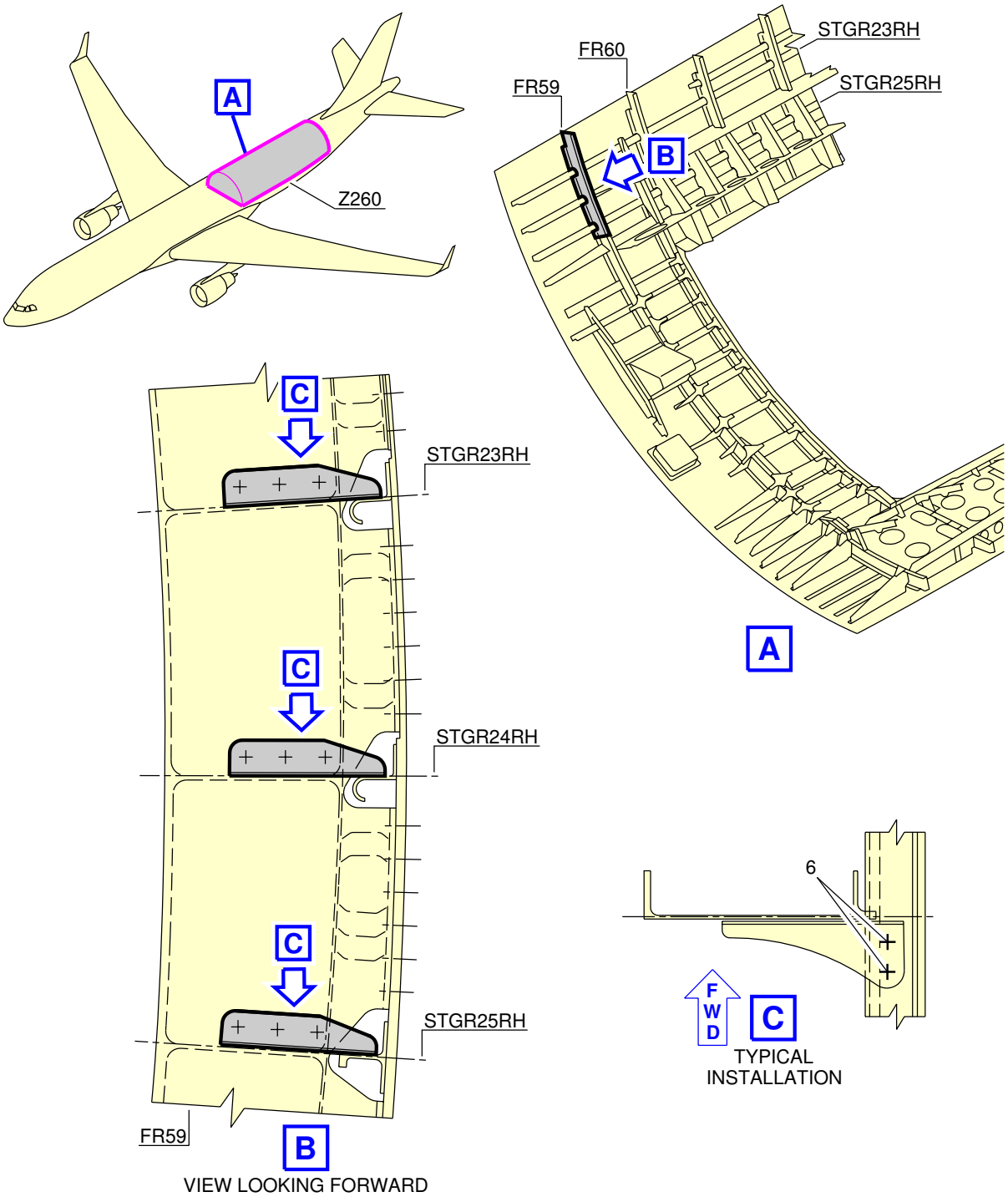
02 PILOT HOLE POSITIONS OMITTED, HOLE POSITIONS ARE DIMENSIONED.

G_SB_533217_6_BEAA_01_01

Figure A-GBEAA - Sheet 01
Installation of the fasteners at FR58A, between STGR31 RH and STGR33 RH

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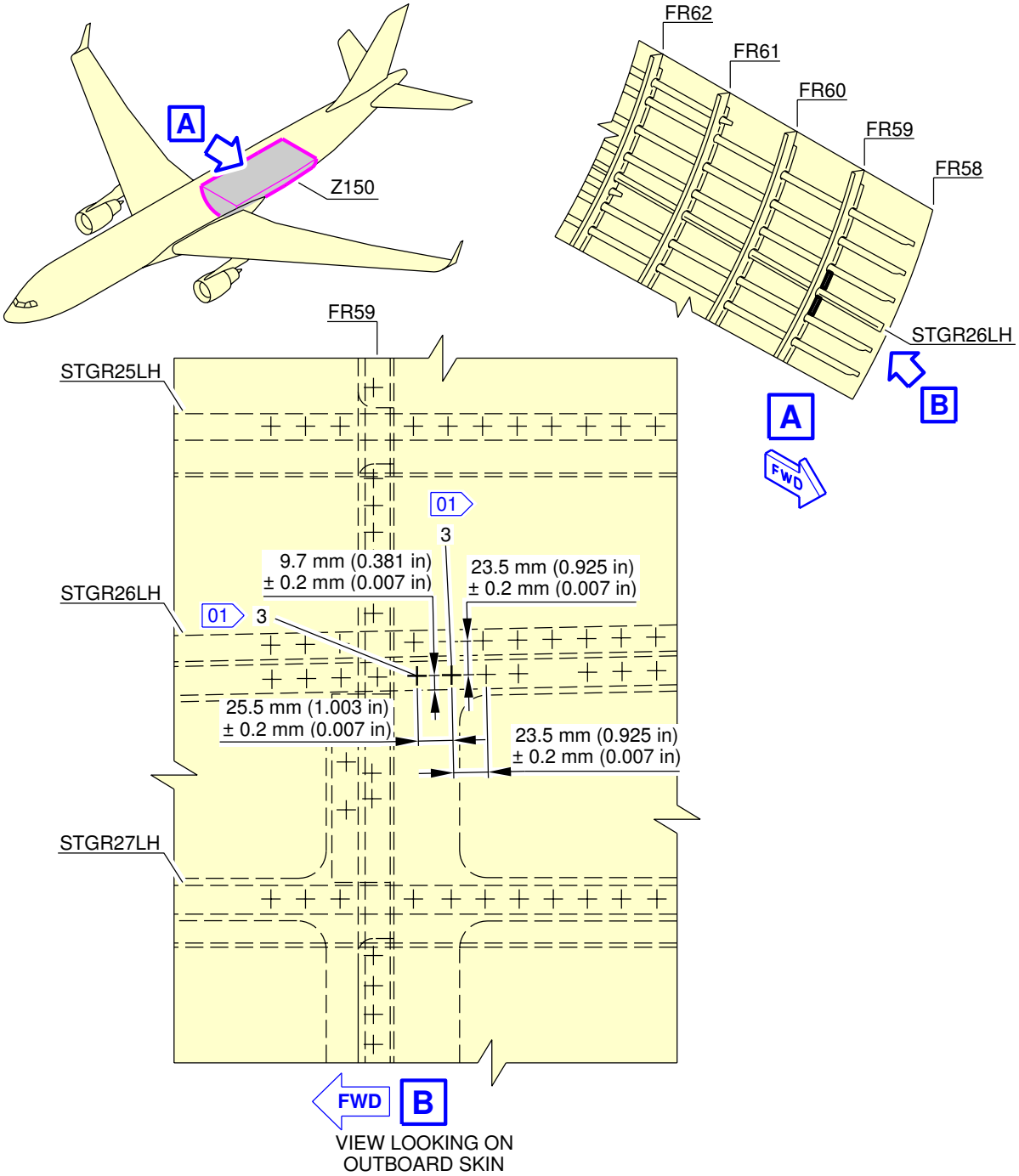


G_SB_533217_6_BFAA_01_00

Figure A-GBFAA - Sheet 01
Installation of the fasteners at FR59, STGR23 RH, STGR24 RH and STGR25 RH

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NOTE:

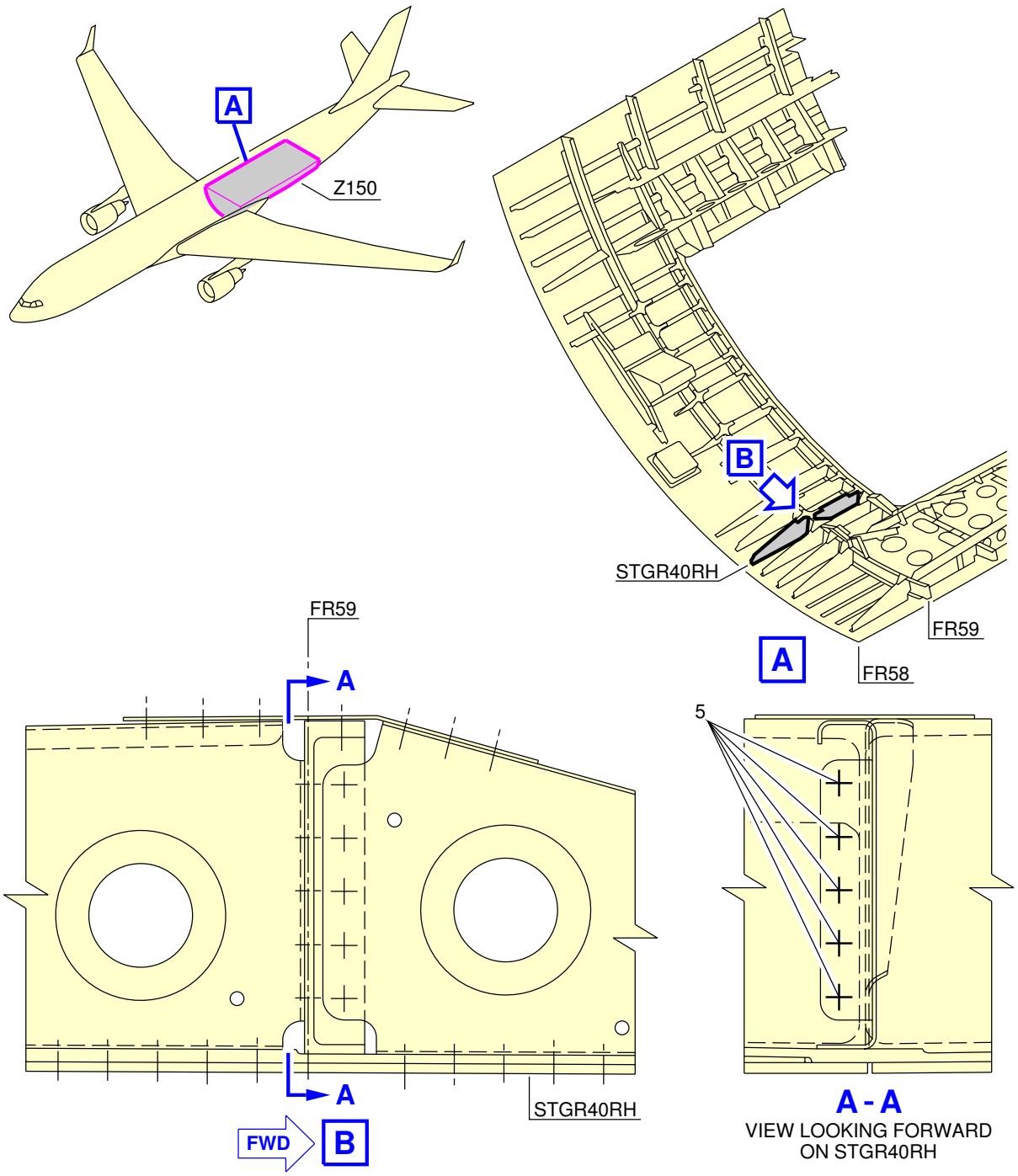
01 DIMENSIONS ARE GIVEN IF HOLES DO NOT EXIST.

G_SB_533217_6_BGAA_01_01

Figure A-GBGAA - Sheet 01
Installation of the fasteners at FR59, STGR26 LH

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G_SB_533217_6_BHAA_01_00

Figure A-GBHAA - Sheet 01
Installation of the fasteners at FR59, STGR40 RH

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SERVICE BULLETIN
REPORTING SHEET

TITLE: FUSELAGE - GENERAL - IMPROVE RIVETING IN REAR FUSELAGE AREA AT SECTION 17 FROM FR57 TO FR59

MODIFICATION No.: 203702D50759

Please complete the appropriate item (A or B):
A - SB WILL BE embodied YES/NO (if NO please comment)
If YES, aircraft concerned (as per SB effectivity by default) and planned dates (month/year) of embodiment:

B - SB HAS BEEN embodied on aircraft:

Operator comments:

From Airline:
Name/Title:
Signature: Date:

If operational documentation is affected (see Paragraph 1.K of this SB): If information is needed prior to next normal revision or prior to SB embodiment, please indicate required service(s):
Either: Modification Operational Impact (MOI), if available YES/NO
Or : Intermediate revision YES/NO

Important Information: This SB will only be incorporated in your maintenance and operational documentation if this sheet is returned to Airbus and signed by a duly authorised representative. With the next feasible revision, this will result in

- Updating of maintenance documentation to show pre and post SB data.
- Updating of maintenance and operational documentation to show post SB data after embodiment.

If this SB requires previous or simultaneous accomplishment of other SBs, Airbus shall automatically include them in the manual revisions. Refer to SIL 00-037 for detailed information.

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- 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			

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X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Industry support	X	Test
X	References	X	Re-identification	X	Close-Up
X	Publication	X	Tooling	X	Illustrations

Comments:

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