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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINT FRAME 53.3, STGR 13 LH TO STGR 13 RH - FATIGUE LIFE IMPROVEMENT

MODIFICATION No.: 49403S16334

This page transmits Revision No.02 of Service Bulletin No.A330-53-3127

ADDITIONAL WORK

****CONF ALL**

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

REASON

Revision No. 02 is issued to add the new thresholds and modify the Appendix 01.

CHANGES

SUMMARY		
MODIFICATIONS	Minor editorial or document structure change	N
REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES	Minor editorial or document structure change	N
GENERAL EVALUATION	Minor editorial or document structure change	N
MATERIAL PRICE INFORMATION	Minor editorial or document structure change	N
EFFECTIVITY	Minor editorial or document structure change	N
CONCURRENT REQUIREMENTS	Minor editorial or document structure change	N
REFERENCES / REPERCUSSIONS	Minor editorial or document structure change	N
NATURE OF THE WORK	Minor editorial or document structure change	N
MANPOWER	Minor editorial or document structure change	N
APPENDICES	Minor editorial or document structure change	N
Fig. A-FSAAA	Minor editorial or document structure change	N
Fig. A-FSAAA Sheet 01	Minor editorial or document structure change	N
PLANNING INFORMATION		
EFFECTIVITY	Minor editorial or document structure change	N

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Configuration definition	Minor editorial or document structure change	N
CONF 001	Minor editorial or document structure change	N
Material Effectivity	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
CONCURRENT REQUIREMENTS	Minor editorial or document structure change	N
REASON	Minor editorial or document structure change	N
History	Minor editorial or document structure change	N
Objective/Action	Minor editorial or document structure change	N
Advantages	Minor editorial or document structure change	N
Operational/Maintenance Consequences	Minor editorial or document structure change	N
DESCRIPTION	Minor editorial or document structure change	N
COMPLIANCE	Minor editorial or document structure change	N
Classification	Minor editorial or document structure change	N
Accomplishment Timescale	Threshold revised	N
APPROVAL	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
MANPOWER	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
WEIGHT AND BALANCE	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
ELECTRICAL LOAD DATA	Minor editorial or document structure change	N
REFERENCES	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
PUBLICATION AFFECTED	Minor editorial or document structure change	N
	Minor editorial or document structure change	N
INTERCHANGEABILITY/MIXABILITY	Minor editorial or document structure change	N
SPARES	Minor editorial or document structure change	N
MATERIAL INFORMATION		
MATERIAL - PRICE AND AVAILABILITY	Minor editorial or document structure change	N
Procurement Addresses	Minor editorial or document structure change	N
Price and Availability	Minor editorial or document structure change	N
INDUSTRY SUPPORT INFORMATION	Minor editorial or document structure change	N
LIST OF COMPONENTS	Minor editorial or document structure change	N
Kit 533127A01R05	Minor editorial or document structure change	N
LIST OF MATERIALS - OPERATOR SUPPLIED	Minor editorial or document structure change	N
Consumable Materials	Minor editorial or document structure change	N
Consumable CMLA01	Minor editorial or document structure change	N
Components	Minor editorial or document structure change	N
Equipment	Minor editorial or document structure change	N

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PARTS TO BE RE-IDENTIFIED BY OPERATOR	Minor editorial or document structure change	N
TOOLING	Minor editorial or document structure change	N
Tooling - Price and Availability	Minor editorial or document structure change	N
Tools	Minor editorial or document structure change	N
Special Tools	Minor editorial or document structure change	N
ACCOMPLISHMENT INSTRUCTIONS		
TASK 533127- 831-801-001-MODIFICATION	Minor editorial or document structure change	N
Task associated data - 001	Minor editorial or document structure change	N
Subtask 533127-910-001-001	Minor editorial or document structure change	N
Subtask 533127-839-001-001	Minor editorial or document structure change	N
Subtask 533127-941-001-001	Minor editorial or document structure change	N
Subtask 533127-831-004-001	Minor editorial or document structure change	N
Subtask 533127-831-005-001	Minor editorial or document structure change	N
Subtask 533127-831-006-001	Minor editorial or document structure change	N
Subtask 533127-831-007-001	Minor editorial or document structure change	N
Subtask 533127-831-008-001	Minor editorial or document structure change	N
Subtask 533127-700-009-001	Minor editorial or document structure change	N
Subtask 533127-942-010-001	Minor editorial or document structure change	N
Fig. A-FBAAA	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 01	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 02	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 03	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 04	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 05	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 06	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 07	Minor editorial or document structure change	N
Fig. A-FBAAA Sheet 08	Minor editorial or document structure change	N
Appendix - 01		
APPENDIX CONTENT	Minor editorial or document structure change	N
Fig. A-FAAAA	Minor editorial or document structure change	N
Fig. A-FAAAA Sheet 01	Minor editorial or document structure change	N
Fig. A-FABAA	Minor editorial or document structure change	N
Fig. A-FABAA Sheet 01	Minor editorial or document structure change	N
Fig. A-FACAA	Minor editorial or document structure change	N
Fig. A-FACAA Sheet 01	Minor editorial or document structure change	N
Appendix - 02		
APPENDIX CONTENT	Minor editorial or document structure change	N
Fig. A-FADAA	Minor editorial or document structure change	N
Fig. A-FADAA Sheet 01	Minor editorial or document structure change	N

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FILLING INSTRUCTIONS

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

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

HISTORY OF PREVIOUS REVISIONS

No previous revisions.

Revision No. 01 issued to supersede Airworthiness Directive (Consigne de Navigabilite) No. 2002-529(B) by No. F-2003-415(B), to modify the manpower and Kit 533127A01R05 further to validation of this Service Bulletin on MSN 0059.

Also, Mat. No. 09-013 has been added.

REVISION SEQUENCE

ORIGINAL: Oct 30/02

REVISION No. : 02 - Dec 07/11

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

MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINT FRAME 53.3, STGR 13 LH TO STGR 13 RH - FATIGUE LIFE IMPROVEMENT

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	49403S16334				
MINOR	None				

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

Further to damages occurred during fatigue tests, it has been decided to install an external stiffener of butt strap type at the upper part of the circumferential joint at Frame 53.3, in order to improve fatigue life.

This Service Bulletin requires the reinforcement of the circumferencial joint at the upper part at Frame 53.3 by installing external stiffeners between LH and RH STGR13.

Accomplishment of this Service Bulletin will allow improving fatigue life of the circumferencial joint at Frame 53.3 and will thus postpone the next inspection to beyond the design service goal.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	MANDATORY (1)	CANCELS INSPECTION SB	NO
POTENTIAL AD	YES	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 must be accomplished.

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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 533127A01R05	1	13,390.00	Butt Straps, Shims

EFFECTIVITY

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

BEL CPA G8E HDA HFY MAS OHY THA TSC VLK XAX

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

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

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

Task 533127-831-801-001: MODIFICATION	
TOTAL MANHOURS	314.50
ELAPSED TIME (HOURS)	56.25

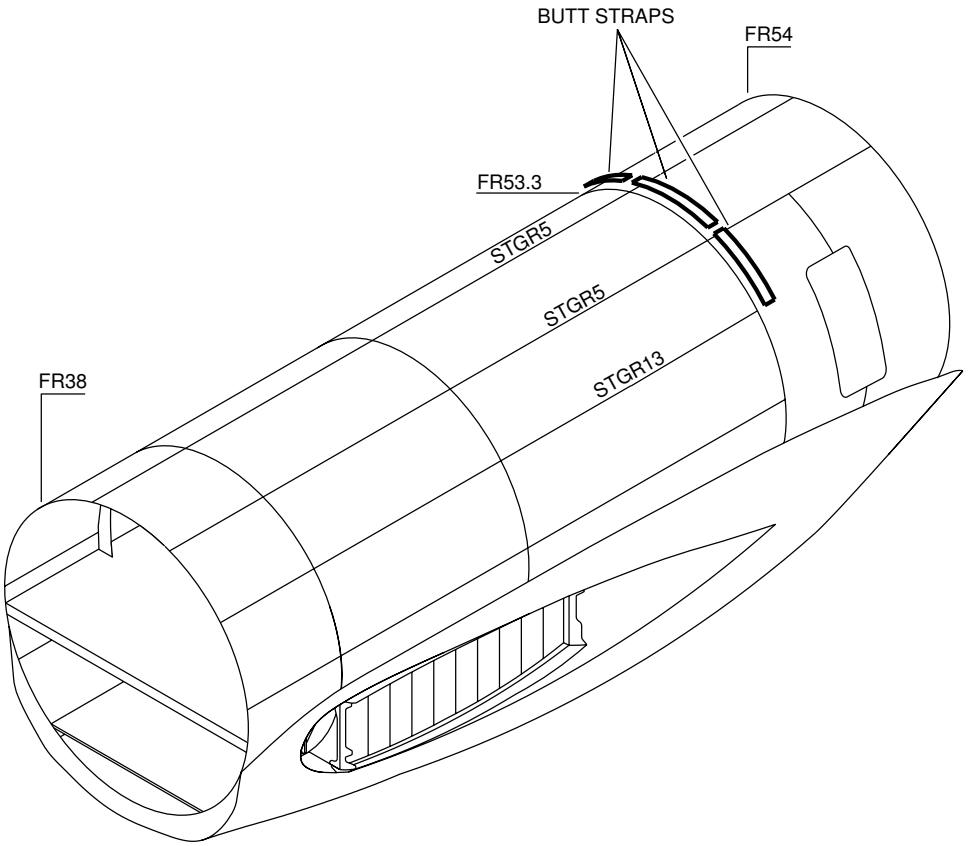
APPENDICES

Appendix - 01

Appendix - 02

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****CONF ALL**



G_SB_533127_5_SAAA_01_00

Figure A-FSAAA - Sheet 01

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINT FRAME 53.3, STGR 13 LH TO STGR 13 RH - FATIGUE LIFE IMPROVEMENT

MODIFICATION No.: 49403S16334

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is only applicable to aircraft on which Mod. No. 41652S11819 (FUSELAGE-STRUCTURE-INTRODUCE A340 COMMONALITY ITEMS) is not embodied.

This Service Bulletin has been validated on A330 aircraft 0059.

(1) Models

330-301 330-321 330-322 330-342

(2) Effectivity by MSN

0012 0017 0030 0037 0045 0050 0054-0055 0059-0060 0062 0064-0067 0069-0073 0077 0082-0083 0086-0087 0095-0096 0098-0100 0102 0106-0107 0109-0112

(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
BEL	0030 0037 0045 0082 0095
CPA	0012 0017 0071 0102
G8E	0059
HDA	0083 0099 0106 0109
HFY	0096
MAS	0067 0069 0073 0077 0100 0107 0110
OHY	0072 0087 0098
THA	0050 0060 0062 0064 0065 0066 0112
TSC	0111
VLK	0055 0070 0086
XAX	0054

(4) Configuration by MSN

MSN	CONFIGURATION
0012 0017 0030 0037 0045 0050 0054 0055 0059 0060 0062 0064 0065 0066 0067 0069 0070 0071 0072 0073 0077 0082 0083 0086 0087 0095 0096 0098 0099 0100 0102 0106 0107 0109 0110 0111 0112	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 533127A01R05	1	
Consumable CMLA01	1	

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

Further to damages occurred during fatigue tests, it has been decided to install an external stiffener of butt strap type at the upper part of the circumferential joint at Frame 53.3, in order to improve fatigue life.

(2) Objective/Action

This Service Bulletin requires the reinforcement of the circumferencial joint at the upper part at Frame 53.3 by installing external stiffeners between LH and RH STGR13.

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(3) Advantages

Accomplishment of this Service Bulletin will allow improving fatigue life of the circumferencial joint at Frame 53.3 and will thus postpone the next inspection to beyond the design service goal.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

Task 533127-831-801-001: MODIFICATION

(1) Install the butt strap Item 6 and the shims Item 12 at FR53.3, on the fuselage skin between LH and RH STGR5.

(2) Install the butt strap Item 7 and the shim Item 9 at FR53.3, on the fuselage skin between LH STGR5 and LH STGR13

(3) Install the butt strap Item 8 and the shim Item 10 at FR53.3, on the fuselage skin between RH STGR5 and RH STGR13

(4) Apply sealant around the butt straps

(5) Paint the modified area

E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

Condition	Action	Compliance Times (Whichever occurs first)		Interval
		Threshold	Grace Period	
Config. 001	Do the TASK 533127-831-801 001 MODIFICATION	For the Short Range (SR) Mission : 15,300FC / 46,100FH	None	None
		For the Long Range (LR) Mission : 13,200FC / 79,300FH	None	

Accomplishment Timescale Table

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One set of threshold (Short Range, Threshold (SR) and Long Range, Threshold (LR)) has been established. This set ensure continued airworthiness and could be used to cover any type of A/C utilization. This approach is an equivalent damage approach corresponding to a trade off between FC/FH to better suit the fleet utilization. As the set of thresholds ensure continued airworthiness and could be used to cover any type of utilization, for the 1st inspection, operators may select either SR (Threshold) or LR (Threshold) (depending of the A/C utilization evolution). If a non optimal set of threshold is selected, airworthiness will be ensured, but will penalize the operator because the inspection will be performed sooner than necessary. As a consequence, the selection of SR or LR threshold can be changed whenever. Threshold is whichever occurs first between FC and FH for a set of threshold between SR and LR. This means that the set FC/FH must be considered jointly (ie FCSR cannot be used with FHLR and vice versa).

This Service Bulletin has been classified Mandatory by the issue of an Airworthiness Directive (AD) published by the European Aviation Safety Agency (EASA). The AD must be used as the reference document for the mandated accomplishment timescale.

F. APPROVAL

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

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

G. MANPOWER

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

Task 533127-831-801-001: MODIFICATION	
Get Access	66.00
On Aircraft	
Install the butt strap Item 6 and the shims Item 12 at FR53.3, on the fuselage skin between LH and RH STGR5.	57.00
Install the butt strap Item 7 and the shim Item 9 at FR53.3, on the fuselage skin between LH STGR5 and LH STGR13	57.00
Install the butt strap Item 8 and the shim Item 10 at FR53.3, on the fuselage skin between RH STGR5 and RH STGR13	57.00
Apply sealant around the butt straps	4.00
Paint the modified area	4.50
Tests	3.00
Close-Up	66.00

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Task 533127-831-801-001: MODIFICATION	
TOTAL MANHOURS	314.50
ELAPSED TIME (HOURS)	56.25

NOTE: For the elapsed time assumptions, refer to Appendix - 02 .

H. WEIGHT AND BALANCE

The weight and balance estimates given in this Service Bulletin are based on the Manufacturer's Empty Weight (MEW) and do not include operator item's. For the definition of MEW and operator's items refer to Weight and Balance Manual (WBM) Chapter 1-00-07.

Manufacturers Empty Weight	+4.3 KG	(+9.4797 LB)
Effect on Balance	+173.982 KGM	(+1258.411 LB.FT)

I. ELECTRICAL LOAD DATA

Not Changed

J. REFERENCES

Aircraft Maintenance Manual (AMM)	05-53-00 21-20-00 25-24-61	12-34-24 25-23-41 25-80-00	20-21-11 25-24-51 52-10-00
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-21-11 51-43-00 51-76-11	51-23-11 51-46-11	51-42-11 51-48-00
Weight and Balance Manual (WBM)	Chapter 1-00-07		

Aircraft Maintenance Manual (AMM)	07-11-00
Structural Repair Manual (SRM)	51-51-00

K. PUBLICATION AFFECTED

Structural Repair Manual (SRM)	53-31-11

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 533127A01R05	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 533127A01R05	
Cost	13,390.00 USD
Availability	90 calendar days from receipt of order

The Kit availability given above is the standard lead time from the date of your purchase order. If you require Kits 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 at the issue date of the Service Bulletin.

B. INDUSTRY SUPPORT INFORMATION

This Service bulletin is subject to the Fatigue Test Integration Program. Refer to the FTIP policy.

C. LIST OF COMPONENTS

Kit 533127A01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	ASNA2528-4	744	Nut				
2	ASNA2026V4-8	284	Bolt				
3	ASNA2026V4-11	432	Bolt				
5	ASNA2026V4-13	88	Bolt				
6	F5332579020096	1	Strap				
7	F5332579120096	1	Strap				
8	F5332579120196	1	Strap				
9	F5332579220096	1	Shim				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
10	F5332579220196	1	Shim				
11	ASNA2531-4	60	Nut				
12	F5332578120095	2	Shim				

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 CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Inhibiting Brush Consistency	09-013	As required	
	Sealant	09-016	As required	
	Solvent General Purpose	11-026	As required	
	Chemical Conversion Coating	13-002	As required	
	Anti-Corrosion Primer	16-001	As required	
	Polyurethane Top Coat Grey	16-002	As required	
	External Decoration Paint	16-016	As required	
	External Top Coat	16-018	As required	
	Wash Primer	16-020	As required	

(2) Components

None

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

None

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(2) Tools

- Fatigue Technology Incorporated (FTI) has allocated tool kit number FTI-A330-53-3127-1 for accomplishment of this Service Bulletin. Operators interested in obtaining the FTI tool kit should contact :

Fatigue Technology Inc.
401 Andover Park East
SEATTLE WA 98188-7605
USA
Tel : (206) 246-2010
Telex : 321004
Fax : (206) 244-9886

To accomplish this Service Bulletin, it is necessary to use the following tools and equipment :

- Equipment and materials for check of holes as per NTM 51-10-01, Part 6, Procedure A.

- Equipment and materials for the jacking procedure (Refer to Appendix - 01).

(3) Special Tools

None

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3. ACCOMPLISHMENT INSTRUCTIONS

Task 533127-831-801-001 - 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.

IN CASE OF CONTAMINATION REFER TO ESPM 20-55-00.

Task Associated Data

Zone	
250	
Manpower	
TOTAL MANHOURS	314.50
ELAPSED TIME (HOURS)	56.25

A. GENERAL

(1) Subtask 533127-910-001-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Solvent General Purpose	11-026	As required	
	Chemical Conversion Coating	13-002	As required	
	Anti-Corrosion Primer	16-001	As required	
	Polyurethane Top Coat Grey	16-002	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	External Decoration Paint	16-016	As required	
	External Top Coat	16-018	As required	
	Wash Primer	16-020	As required	

References	
Aircraft Maintenance Manual (AMM)	20-21-11, Page Block 201
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-21-11 51-23-11 51-42-11 51-43-00 51-46-11 51-48-00 51-76-11

(a) For the specification of the material numbers (Mat. No.), refer to the CML.

(b) Remove and install the fasteners, (Refer to SRM 51-42-11).

(c) For the cold expansion of the fastener holes, (Refer to SRM 51-48-00).

(d) Countersink the holes, (Refer to SRM 51-46-11).

(e) Clean the surface to seal with :

Solvent General Purpose	11-026	As required

(f) To apply sealant, (Refer to SRM 51-76-11).

(g) Torque the standard threaded fasteners, (Refer to AMM 20-21-11 Page Block 201).

(h) For alternative and substitute fasteners (Refer to SRM 51-43-00).

(i) Renew the protective finish with :

(Refer to SRM 51-21-11 and SRM 51-23-11)

Chemical Conversion Coating	13-002	As required
or		
Wash Primer	16-020	As required
and		
Anti-Corrosion Primer	16-001	As required

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Polyurethane Top Coat Grey	16-002	As required
and		
External Top Coat	16-018	As required
or		
External Decoration Paint	16-016	As required

(j) 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 fasteners grip length in accordance with SRM Chapter 51.

(2) Subtask 533127-839-001-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

B. PREPARATION

(1) Subtask 533127-941-001-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	12-34-24, Page Block 201 21-20-00, Page Block 401 25-23-41, Page Block 401 25-24-51, Page Block 401 25-24-61, Page Block 401 25-80-00, Page Block 201 52-10-00, Page Block 201

(a) Electrically ground the aircraft, (Refer to AMM 12-34-24 Page Block 201).

(b) Put the access platform(s) in position.

(c) Open the passenger/crew door 831, (Refer to AMM 52-10-00 Page Block 201).

(d) Remove the ceiling panels 251PC, 251QC, 252PC and 252QC, (Refer to AMM 25-23-41 Page Block 401).

(e) Remove the center stowage compartment at Frame 53.3, (Refer to AMM 25-24-61 Page Block 401).

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(f) Remove the LH and RH lateral overhead stowage compartments at Frame 53.3, (Refer to AMM 25-24-51 Page Block 401).

(g) Remove the air distribution ducts for an easier access to the work area, (Refer to AMM 21-20-00 Page Block 401).

(h) Disengage the electrical wires and the insulation blankets from the work area, (Refer to AMM 25-80-00 Page Block 201).

NOTE: If necessary, disengage the support plates of the decoder/encoder units 200RH17 and 200RH18 to get access to the work area. Hold the support plates because you must not pull the electrical wires. Retain the fasteners.

(i) Do the jacking procedure, (Refer to Appendix - 01).

C. PROCEDURE

WARNING: WEAR AND ATTACH A SAFETY HARNESS WHEN YOU WORK ON HIGH SECTIONS. A FALL CAN KILL OR INJURE YOU.

NOTE: Do not remove all the fasteners from the fuselage at the same time. First, remove the fasteners between the LH and RH STGR 5 and install the upper butt strap Item 6 and the shims Item 12. Then you can remove the other fasteners and install the butt strap Items 7 and 8, and the shims Items 9 and 10 at the same time.

(1) Subtask 533127-831-004-001 - Install the butt strap Item 6 and the shims Item 12 at FR53.3, on the fuselage skin between LH and RH STGR5.

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 53.3 from Stringer 5 LH to Stringer 5 RH

Manpower Resources	
Manhours	57.00
Minimum number of person	4
Subtask elapsed time	14.25
Skills	AIRFRAME

Material necessary to do the job

Kit 533127A01R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	ASNA2528-4	264	Nut	
2	ASNA2026V4-8	96	Bolt	
3	ASNA2026V4-11	160	Bolt	
5	ASNA2026V4-13	36	Bolt	
6	F5332579020096	2	Strap	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	ASNA2531-4	28	Nut	
12	F5332578120095	4	Shim	

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Inhibiting Brush Consistency	09-013	As required	
	Sealant	09-016	As required	
	Chemical Conversion Coating	13-002	As required	
	Anti-Corrosion Primer	16-001	As required	
	Polyurethane Top Coat Grey	16-002	As required	

References	
Non Destructive Test Manual (NTM)	51-10-01 Part 6, Procedure A
Fig. A-FBAAA Butt Strap Installation	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) Remove the fasteners between LH and RH STGR5

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 02 and Fig. A-FBAAA Sheet 05

1 From the LH side, remove :

Refer to Fig. A-FBAAA Sheet 02

140	Nut	Item (1)	Discard
48	Bolt	Item (2)	Discard
78	Bolt	Item (3)	Discard
14	Bolt	Item (5)	Discard

Refer to Fig. A-FBAAA Sheet 05

6	Nut	Item (1)	Discard
2	Bolt	Item (3)	Discard

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4	Bolt	Item (5)	Discard

2 From the RH side, remove :

Refer to Fig. A-FBAAA Sheet 02

140	Nut	Item (1)	Discard
48	Bolt	Item (2)	Discard
78	Bolt	Item (3)	Discard
14	Bolt	Item (5)	Discard

Refer to Fig. A-FBAAA Sheet 05

6	Nut	Item (1)	Discard
2	Bolt	Item (3)	Discard
4	Bolt	Item (5)	Discard

(b) Do an inspection of the holes

1 Do a rototest in the 152 holes of the removed bolts, (Refer to NTM 51-10-01 Part 6, Procedure A), (Refer to Fig. A-FBAAA Sheet 02).

2 If a crack is found, contact AIRBUS.

3 If no crack is found, do the steps that follow.

(c) Put the butt strap and the shims in position on the skin between LH and RH STGR5

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

1 As shown in View E, Section AA and Section DD, put in position and hold :

1	Butt Strap	F5332579020096	Item 6
2	Shim	F5332578120095	Item 12

NOTE (1): Put the shims Item 12 in position between the fuselage skin and the butt strap Item 6 to fill the clearance between the skin and the butt strap.

(d) Counter-drill the fastener holes in the butt strap Item 6 and the shims Item 12

(Refer to Fig. A-FBAAA Sheet 01 and Fig. A-FBAAA Sheet 02

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CAUTION: DO NOT DRILL THE 12 HOLES AT LH AND RH STGR5 AT THIS TIME. YOU WILL DRILL THESE HOLES DURING THE COLD EXPANSION STEP.

1 In the butt strap Item 6 and in the shims Item 12 , counter-drill 280 holes, temporarily attach the butt strap at the same time.

(e) Deburr the holes.

(f) For the cold expansion of the 12 holes at LH and RH STGR5 do the steps that follow :

Refer to Fig. A-FBAAA Sheet 05

1 For the cold expansion, use the tools supplied in Kit FTI-A330-53-3127-1.

2 On the LH and the RH sides, counter-drill 12 holes in the butt strap Item 6 and in the shims Item 12.

3 Ream the 12 holes to the start hole diameter between 5.75 mm and 5.79 mm (0.22638 in. and 0.22795 in.).

4 Deburr the holes.

5 Identify with a mark the LH and RH sides on the butt strap Item 6 before removal, to prevent a wrong position when you install it.

NOTE: If necessary, adjust the length of the butt strap Item 6 and the shims Item 12.

Renew the protective finish on the reworked surfaces with :

Chemical Conversion Coating	13-002	As required
Anti-Corrosion Primer	16-001	As required
Polyurethane Top Coat Grey	16-002	As required

6 Remove the butt strap Item 6 and the shims Item 12.

7 Do the cold expansion of the holes in the fuselage.

(g) Apply to the attachment areas between the butt strap, the shims and the fuselage :

Sealant	09-016	As required

(h) Install the butt strap Item 6 and the shims Item 12

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 02, Fig. A-FBAAA Sheet 05, Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

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1 Put the butt strap and the shims in position on the skin, between LH and RH STGR5 :

1	Butt Strap	F5332579020096	Item 6
2	Shim	F5332578120095	Item 12

NOTE: Temporarily attach the parts.

Smooth the burr of sealant.

Let the sealant dry as necessary.

(i) Ream the fastener holes in the butt strap and the shims

NOTE: Ream the holes from the inner side of the fuselage.

To prevent butt strap debonding during reaming, do not remove all the temporary fasteners at the same time. Install the new fasteners in the reamed holes one after the other as specified in the steps that follow.

1 Ream the 12 cold expanded holes to the finish hole diameter between 6.227 mm. and 6.262 mm (0.24516 in. and 0.24654 in.).

Refer to Fig. A-FBAAA Sheet 05

2 Ream the 280 holes to a diameter between 6.310 mm and 6.350 mm (0.24842 in. and 0.25000 in.).

Refer to Fig. A-FBAAA Sheet 02

(j) Countersink the 292 holes in the butt strap Item 6 for the bolts Items 2, 3 and 4.

(k) Deburr the holes.

(l) Attach the butt strap Item 6 and the shims Item 12 with :

Refer to Fig. A-FBAAA Sheet 02 and Fig. A-FBAAA Sheet 06

96	Bolt	ASNA2026V4-8	Item 2
156	Bolt	ASNA2026V4-11	Item 3
28	Bolt	ASNA2026V4-13	Item 5
264	Nut	ASNA2528-4	Item 1
16	Nut	ASNA2531-4	Item 11

Refer to Fig. A-FBAAA Sheet 05 and Fig. A-FBAAA Sheet 06

4	Bolt	ASNA2026V4-11	Item 3

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8	Bolt	ASNA2026V4-13	Item 5
12	Nut	ASNA2531-4	Item 11

NOTE: Apply to the countersunk holes before fastener installation :

Corrosion Inhibiting Brush Consistency	09-013	As required

(2) Subtask 533127-831-005-001 - Install the butt strap Item 7 and the shim Item 9 at FR53.3, on the fuselage skin between LH STGR5 and LH STGR13

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 53.3 from Stringer 5 LH to Stringer 13 LH

Manpower Resources	
Manhours	57.00
Minimum number of person	4
Subtask elapsed time	14.25
Skills	AIRFRAME

Material necessary to do the job

Kit 533127A01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	ASNA2528-4	240	Nut	
2	ASNA2026V4-8	94	Bolt	
3	ASNA2026V4-11	136	Bolt	
5	ASNA2026V4-13	26	Bolt	
7	F5332579120096	2	Strap	
9	F5332579220096	2	Shim	
11	ASNA2531-4	16	Nut	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Inhibiting Brush Consistency	09-013	As required	
	Sealant	09-016	As required	
	Chemical Conversion Coating	13-002	As required	
	Anti-Corrosion Primer	16-001	As required	
	Polyurethane Top Coat Grey	16-002	As required	

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References	
Non Destructive Test Manual (NTM)	51-10-01 Part 6, Procedure A
Fig. A-FBAAA Butt Strap Installation	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) Remove the fasteners between LH STGR5 and LH STGR13

Refer to Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

1 Between LH STGR5 and LH STGR13, remove :

Refer to Fig. A-FBAAA Sheet 03

128	Nut	Item (1)	Discard
56	Bolt	Item (2)	Discard
72	Bolt	Item (3)	Discard

Refer to Fig. A-FBAAA Sheet 04

128	Nut	Item (1)	Discard
38	Bolt	Item (2)	Discard
64	Bolt	Item (3)	Discard
26	Bolt	Item (5)	Discard

(b) Do an inspection of the holes

1 Do a rototest in the 128 holes of the removed bolts, (Refer to NTM 51-10-01 Part 6, Procedure A), (Refer to Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04).

2 If a crack is found, contact AIRBUS.

3 If no crack is found, do the steps that follow.

(c) Put the butt strap in position on the skin between LH STGR5 and LH STGR13

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

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1 As shown in View E, Section BB, Section CC and Section DD, put in position and hold :

1	Butt Strap	F5332579120096	Item 7
1	Shim	F5332579220096	Item 9

NOTE (1): Put the shim Item 9 in position between the fuselage skin and the butt strap Item 7 to fill the clearance between the skin and the butt strap.

(d) Counter-drill the fastener holes in the butt strap Item 7 and shim Item 9

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

1 In the butt strap Item 7 and the shim Item 9, counter-drill 256 holes, temporarily attach the butt strap at the same time.

(e) Deburr the holes.

(f) Identify with a mark the upper and lower sides on the butt strap Item 7 before removal, to prevent a wrong position when you install it.

NOTE: If necessary, adjust the length of the butt strap Item 7 and the shims Item 9.

Renew the protective finish on the reworked surfaces with :

Chemical Conversion Coating	13-002	As required
Anti-Corrosion Primer	16-001	As required
Polyurethane Top Coat Grey	16-002	As required

(g) Remove the butt strap Item 7 and the shim Item 9.

(h) Apply to the attachment areas between the butt strap, the shim and the fuselage :

Sealant	09-016	As required

(i) Install the butt strap Item 7 and the shim Item 9

Refer to Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

1 Put the butt strap and the shim in position on the skin, between LH STGR5 and LH STGR13 :

1	Butt Strap	F5332579120096	Item 7

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1	Shim	F5332579220096	Item 9

NOTE: Temporarily attach the parts.

Smooth the burr of sealant.

Let the sealant dry as necessary.

(j) Ream the 256 holes to a diameter between 6.310 mm and 6.350 mm (0.24842 in. and 0.25000 in.).

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

NOTE: Ream the holes from the inner side of the fuselage.

To prevent butt strap debonding during reaming, do not remove all the temporary fasteners at the same time. Install the new fasteners in the reamed holes one after the other as specified in the steps that follow.

(k) Countersink the 256 holes in the butt strap Item 7 for the bolts Items 2, 3, 4 and 5.

(l) Deburr the holes.

(m) Attach the butt strap Item 7 and the shim Item 9 with :

Refer to Fig. A-FBAAA Sheet 03, Fig. A-FBAAA Sheet 04 and Fig. A-FBAAA Sheet 06

94	Bolt	ASNA2026V4-8	Item 2
136	Bolt	ASNA2026V4-11	Item 3
26	Bolt	ASNA2026V4-13	Item 5
240	Nut	ASNA2528-4	Item 1
16	Nut	ASNA2531-4	Item 11

NOTE: Apply to the countersunk holes before fastener installation :

Corrosion Inhibiting Brush Consistency	09-013	As required

(3) Subtask 533127-831-006-001 - Install the butt strap Item 8 and the shim Item 10 at FR53.3, on the fuselage skin between RH STGR5 and RH STGR13

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 53.3 from Stringer 5 RH to Stringer 13 RH

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Manpower Resources	
Manhours	57.00
Minimum number of person	4
Subtask elapsed time	14.25
Skills	AIRFRAME

Material necessary to do the job

Kit 533127A01R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	ASNA2528-4	240	Nut	
2	ASNA2026V4-8	94	Bolt	
3	ASNA2026V4-11	136	Bolt	
5	ASNA2026V4-13	26	Bolt	
8	F5332579120196	1	Strap	
10	F5332579220196	2	Shim	
11	ASNA2531-4	16	Nut	

Consumable CMLA01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Inhibiting Brush Consistency	09-013	As required	
	Sealant	09-016	As required	
	Chemical Conversion Coating	13-002	As required	
	Anti-Corrosion Primer	16-001	As required	
	Polyurethane Top Coat Grey	16-002	As required	

References	
Non Destructive Test Manual (NTM)	51-10-01 Part 6, Procedure A
Fig. A-FBAAA Butt Strap Installation	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) Remove the fasteners between RH STGR5 and RH STGR13

Refer to Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

1 Between RH STGR5 and RH STGR13, remove :

Refer to Fig. A-FBAAA Sheet 03

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128	Nut	Item (1)	Discard
56	Bolt	Item (2)	Discard
72	Bolt	Item (3)	Discard

Refer to Fig. A-FBAAA Sheet 04

128	Nut	Item (1)	Discard
38	Bolt	Item (2)	Discard
64	Bolt	Item (3)	Discard
26	Bolt	Item (5)	Discard

(b) Do an inspection of the holes

1 Do a rototest in the 128 holes of the removed bolts, (Refer to NTM 51-10-01 Part 6, Procedure A), (Refer to Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04).

2 If a crack is found, contact AIRBUS.

3 If no crack is found, do the steps that follow.

(c) Put the butt strap in position on the skin between RH STGR5 and RH STGR13

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

1 As shown in View E, Section BB, Section CC and Section DD, put in position and hold :

1	Butt Strap	F5332579120196	Item 8
1	Shim	F5332579220196	Item 10

NOTE (1): Put the shim Item 10 in position between the fuselage skin and the butt strap Item 8 to fill the clearance between the skin and the butt strap.

(d) Counter-drill the fastener holes in the butt strap Item 8 and shim Item 10

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

1 In the butt strap Item 8 and the shim Item 10, counter-drill 256 holes, temporarily attach the butt strap at the same time.

(e) Deburr the holes.

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(f) Identify with a mark the upper and lower sides on the butt strap Item 8 before removal, to prevent a wrong position when you install it.

NOTE: If necessary, adjust the length of the butt strap Item 8 and the shims Item 10.

Renew the protective finish on the reworked surfaces with :

Chemical Conversion Coating	13-002	As required
Anti-Corrosion Primer	16-001	As required
Polyurethane Top Coat Grey	16-002	As required

(g) Remove the butt strap Item 8 and the shim Item 10.

(h) Apply to the attachment areas between the butt strap, the shim and the fuselage :

Sealant	09-016	As required

(i) Install the butt strap Item 8 and the shim Item 10

Refer to Fig. A-FBAAA Sheet 06, Fig. A-FBAAA Sheet 07 and Fig. A-FBAAA Sheet 08

1 Put the butt strap and the shim in position on the skin, between RH STGR5 and RH STGR13 :

1	Butt Strap	F5332579120196	Item 8
1	Shim	F5332579220196	Item 10

NOTE: Temporarily attach the parts.

Smooth the burr of sealant.

Let the sealant dry as necessary.

(j) Ream the 256 holes to a diameter between 6.310 mm and 6.350 mm (0.24842 in. and 0.25000 in.).

Refer to Fig. A-FBAAA Sheet 01, Fig. A-FBAAA Sheet 03 and Fig. A-FBAAA Sheet 04

NOTE: Ream the holes from the inner side of the fuselage.

To prevent butt strap debonding during reaming, do not remove all the temporary fasteners at the same time. Install the new fasteners in the reamed holes one after the other as specified in the steps that follow.

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(k) Countersink the 256 holes in the butt strap Item 8 for the bolts Items 2, 3, 4 and 5.

(l) Deburr the holes.

(m) Attach the butt strap Item 8 and the shim Item 10 with :

Refer to Fig. A-FBAAA Sheet 03, Fig. A-FBAAA Sheet 04 and Fig. A-FBAAA Sheet 06

94	Bolt	ASNA2026V4-8	Item 2
136	Bolt	ASNA2026V4-11	Item 3
26	Bolt	ASNA2026V4-13	Item 5
240	Nut	ASNA2528-4	Item 1
16	Nut	ASNA2531-4	Item 11

NOTE: Apply to the countersunk holes before fastener installation :

Corrosion Inhibiting Brush Consistency 09-013 As required

(4) Subtask 533127-831-007-001 - Apply sealant around the butt straps

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 53.3 from Stringer 13 LH to Stringer 13 RH

Manpower Resources	
Manhours	4.00
Minimum number of person	2
Subtask elapsed time	2.00
Skills	NON SPECIFIC

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Sealant	09-016	As required	

(a) Around the butt straps, apply a bed of

Sealant 09-016 As required

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(5) Subtask 533127-831-008-001 - Paint the modified area

Work Zones and Access Panels			
	Zone	Access/Work location	
	250	Work location	Frame 53.3 from Stringer 13 LH to Stringer 13 RH

Manpower Resources	
Manhours	4.50
Minimum number of person	2
Subtask elapsed time	2.25
Skills	NON SPECIFIC

Material necessary to do the job

Consumable CMLA01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Anti-Corrosion Primer	16-001	As required	
	External Decoration Paint	16-016	As required	
	External Top Coat	16-018	As required	

(a) Apply

Anti-Corrosion Primer 16-001 As required

to the bolt heads then apply

External Top Coat 16-018 As required

or

External Decoration Paint 16-016 As required

to the bolt heads and the butt straps.

D. <u>TEST</u>

(1) Subtask 533127-700-009-001 - Testing

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	05-53-00, Page Block 501 21-20-00, Page Block 401 25-23-41, Page Block 401 25-24-51, Page Block 401 25-24-61, Page Block 401 25-80-00, Page Block 201

(a) Do a test for leakage in the repair area at a differential pressure of 280 mbar (4.06 psi), (Refer to AMM 05-53-00 Page Block 501).

(b) Install the removed equipment

1 Install the electrical wires and the insulation blankets that you disengaged to get access to the work area, (Refer to AMM 25-80-00 Page Block 201).

NOTE: If you disengaged the support plates of the decoder/encoder units 200RH17 and 200RH18, put them in position and attach with the fasteners retained at removal.

2 Install the air distribution ducts that you removed for an easier access to the work area, (Refer to AMM 21-20-00 Page Block 401).

3 Install the LH and RH lateral overhead stowage compartments at Frame 53.3, (Refer to AMM 25-24-51 Page Block 401).

4 Install the center stowage compartment at Frame 53.3, (Refer to AMM 25-24-61 Page Block 401).

5 Install the ceiling panels 251PC, 251QC, 252PC and 252QC, (Refer to AMM 25-23-41 Page Block 401).

(c) Do the test after the removal/installation of the ceiling panels, (Refer to AMM 25-23-41 Page Block 401).

(d) Do the test after the removal/installation of the center-overhead stowage compartments, (Refer to AMM 25-24-61 Page Block 401).

(e) Do the test after the removal/installation of the lateral-overhead stowage-compartments, (Refer to AMM 25-24-51 Page Block 401).

E. CLOSE-UP

(1) Subtask 533127-942-010-001 - Close-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	12-34-24, Page Block 201 52-10-00, Page Block 201

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(a) Put the aircraft on its wheels and remove the jacking equipment, (Refer to Appendix - 01).

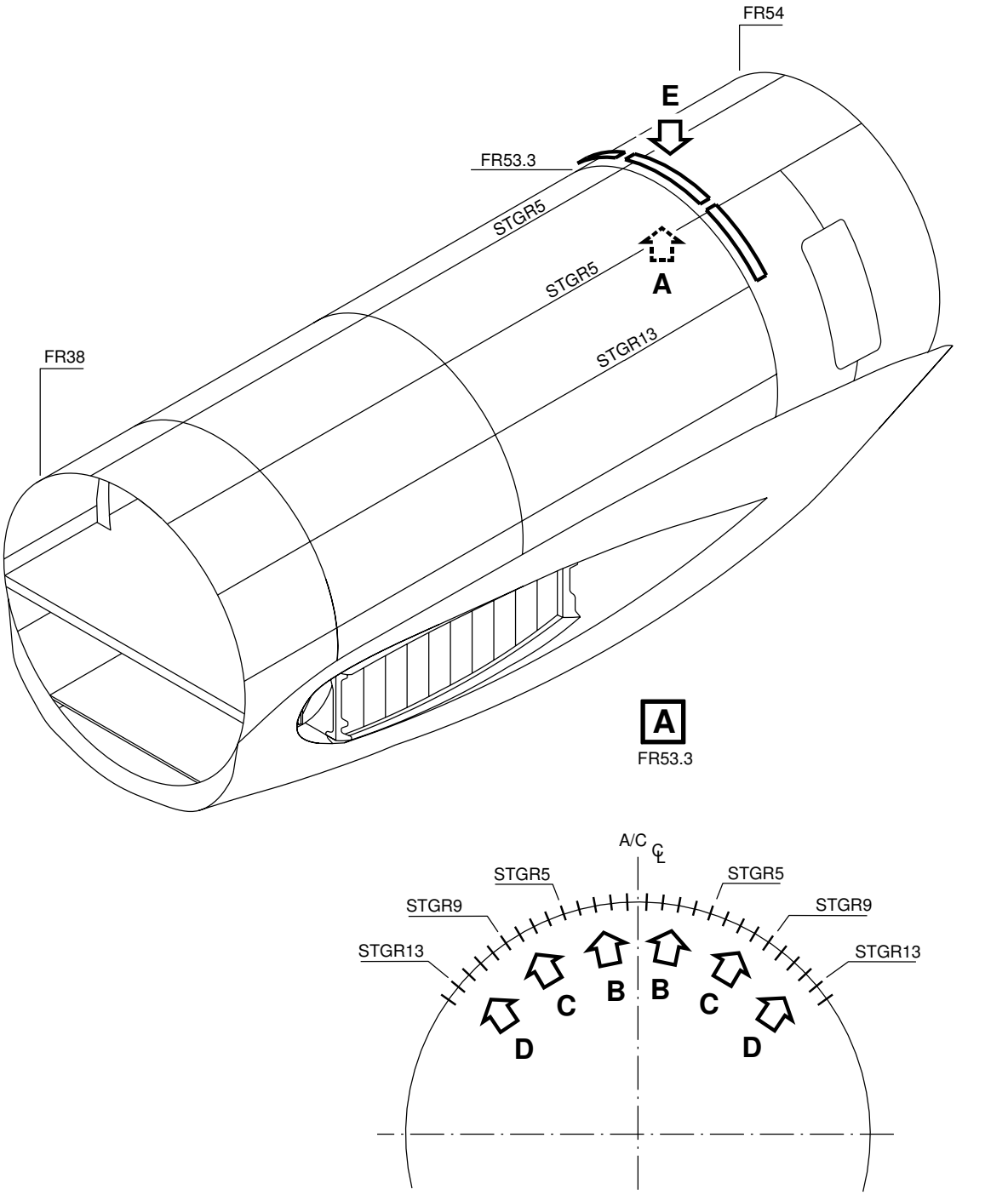
(b) Close the passenger/crew door 831, (Refer to AMM 52-10-00 Page Block 201).

(c) Remove the access platform(s).

(d) Disconnect the aircraft electrical ground-connection, (Refer to AMM 12-34-24 Page Block 201).

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**CONF ALL

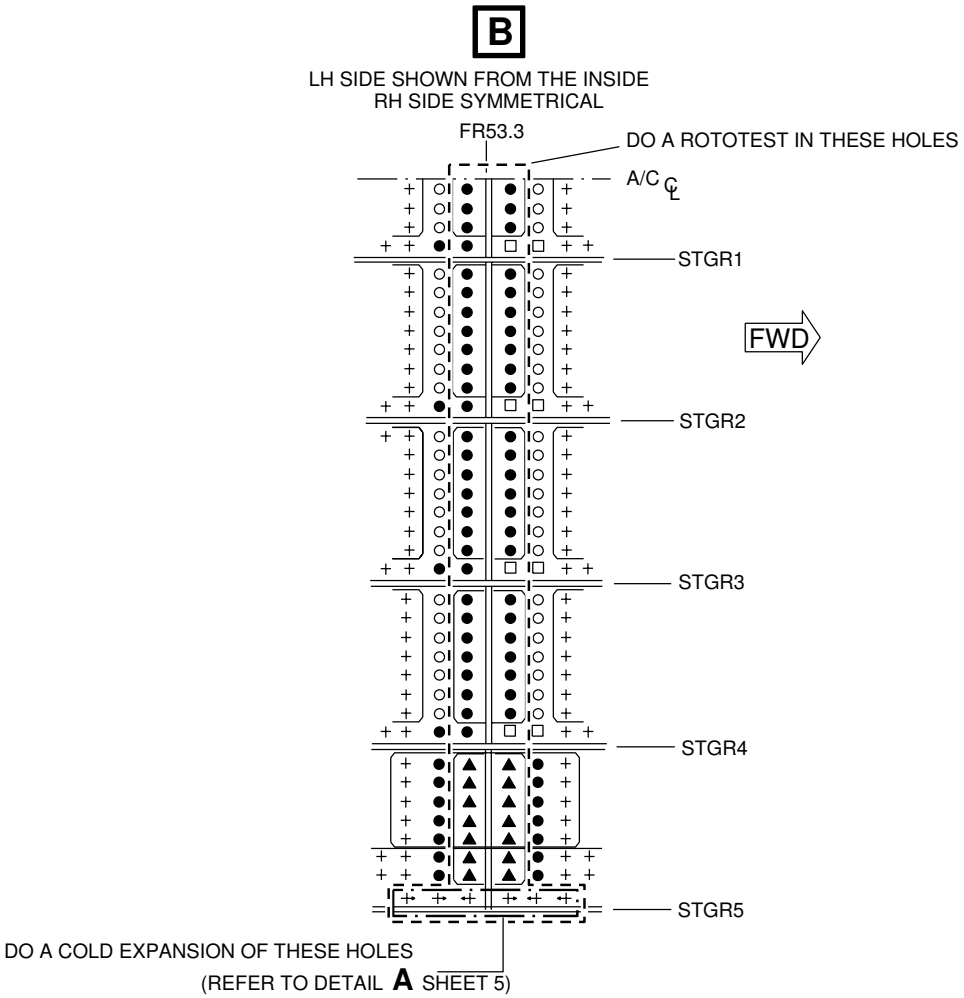


G_SB_533127_5_BAAA_01_01

Figure A-FBAAA - Sheet 01
Butt Strap Installation

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**CONF ALL



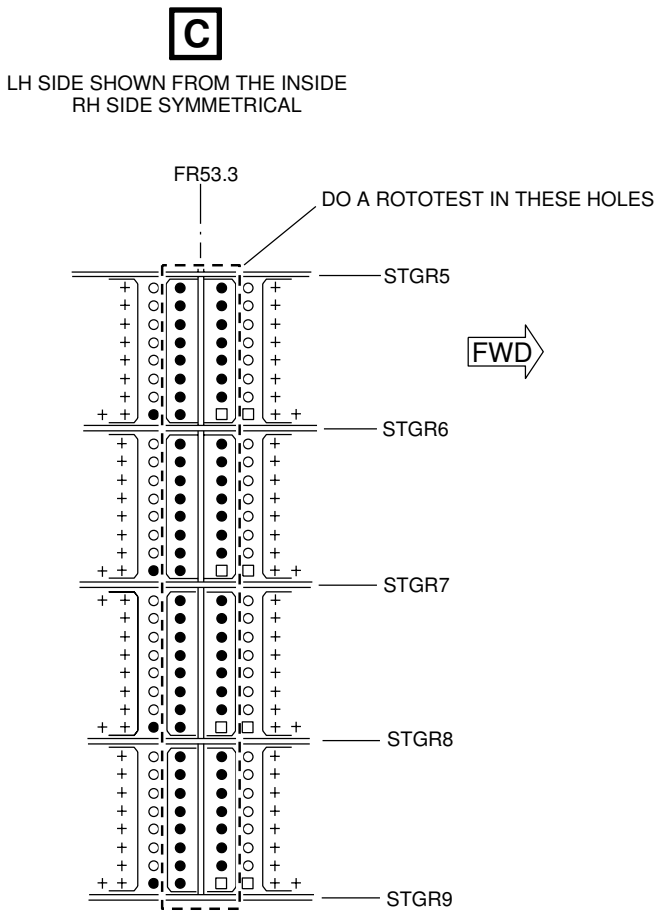
SYMBOL	REMOVED ITEMS		NEW HOLE DIAMETER		NEW BOLT		NEW NUT	
	NUT	BOLT	MIN. mm (in.)	MAX. mm (in.)	PN	ITEM	PN	ITEM
○	(1)	(2)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–8	2	ASNA2528–4	1
●	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2528–4	1
▲	(1)	(5)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–13	5	ASNA2528–4	1
□	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2531–4	11
+	FASTENERS NOT REMOVED							

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Figure A-FBAAA - Sheet 02
Butt Strap Installation

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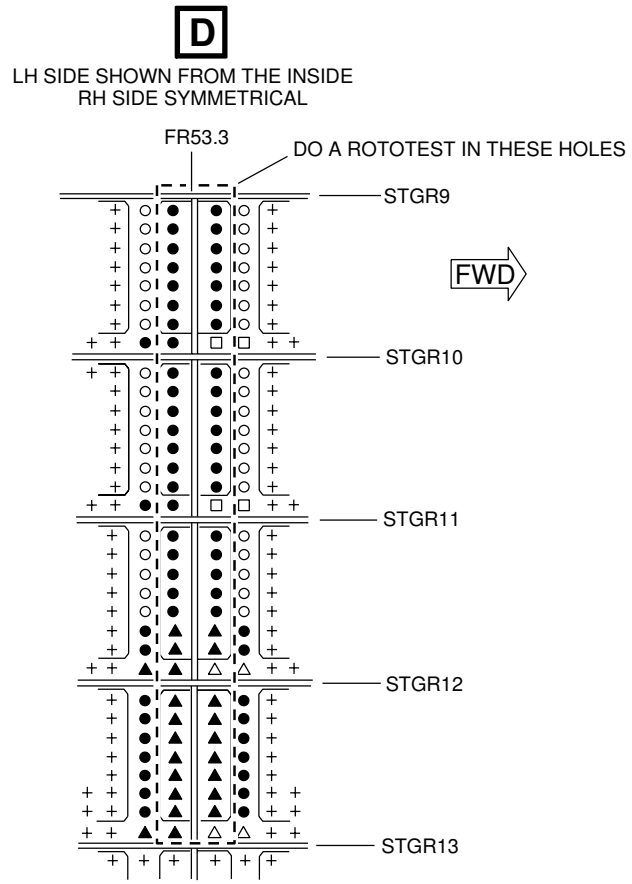
SYMBOL	REMOVED ITEMS		NEW HOLE DIAMETER		NEW BOLT		NEW NUT	
	NUT	BOLT	MIN. mm (in.)	MAX. mm (in.)	PN	ITEM	PN	ITEM
○	(1)	(2)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–8	2	ASNA2528–4	1
●	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2528–4	1
□	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2531–4	11
+	FASTENERS NOT REMOVED							

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Figure A-FBAAA - Sheet 03
Butt Strap Installation

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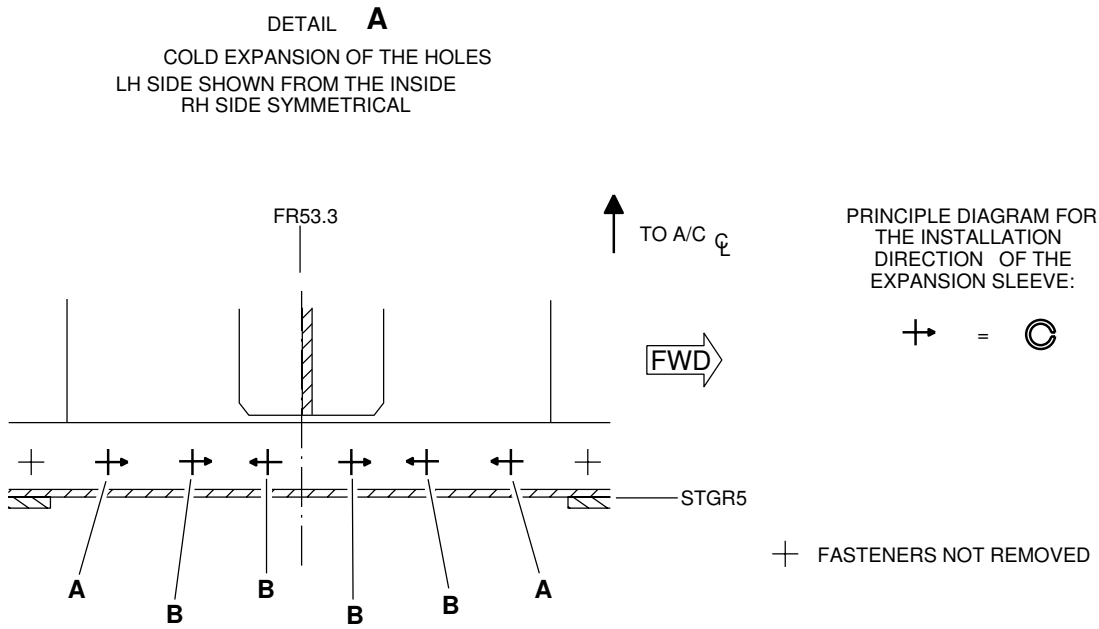
SYMBOL	REMOVED ITEMS		NEW HOLE DIAMETER		NEW BOLT		NEW NUT	
	NUT	BOLT	MIN. mm (in.)	MAX. mm (in.)	PN	ITEM	PN	ITEM
○	(1)	(2)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–8	2	ASNA2528–4	1
●	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2528–4	1
△	(1)	(5)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–13	5	ASNA2531–4	11
▲	(1)	(5)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–13	5	ASNA2528–4	1
□	(1)	(3)	6.310 (0.24842)	6.350 (0.25000)	ASNA2026V4–11	3	ASNA2531–4	11
+	FASTENERS NOT REMOVED							

G_SB_533127_5_BAAA_04_00

Figure A-FBAAA - Sheet 04
Butt Strap Installation

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COLD EXPANSION, HOLES AND FASTENERS DATA											
HOLES N°	REMOVED ITEMS		START * HOLE DIAMETER mm (in.)		STDN	FINISH * HOLE DIAMETER mm (in.)		NEW BOLT		NEW NUT	
	NUT	BOLT	MIN.	MAX.		MIN.	MAX.	PN/ITEM		PN/ITEM	
A	(1)	(3)	5.75 (0.22638)	5.79 (0.22795)	6.3N	6.227 (0.24516)	6.262 (0.24654)	ASNA 2026V4–11	3	ASNA 2531–4	11
B	(1)	(5)	5.75 (0.22638)	5.79 (0.22795)	6.3N	6.227 (0.24516)	6.262 (0.24654)	ASNA 2026V4–13	5	ASNA 2531–4	11

* – REAM THE START HOLE DIAMETERS WITH THE BUTT STRAP ITEM 6 AND THE SHIMS ITEM 12 AND 13 ATTACHED TO THE FUSELAGE

– REMOVE THE BUTT STRAP ITEM 6 AND THE SHIMS ITEM 12 AND 13 AND DO THE COLD EXPANSION OF HOLES IN THE FUSELAGE

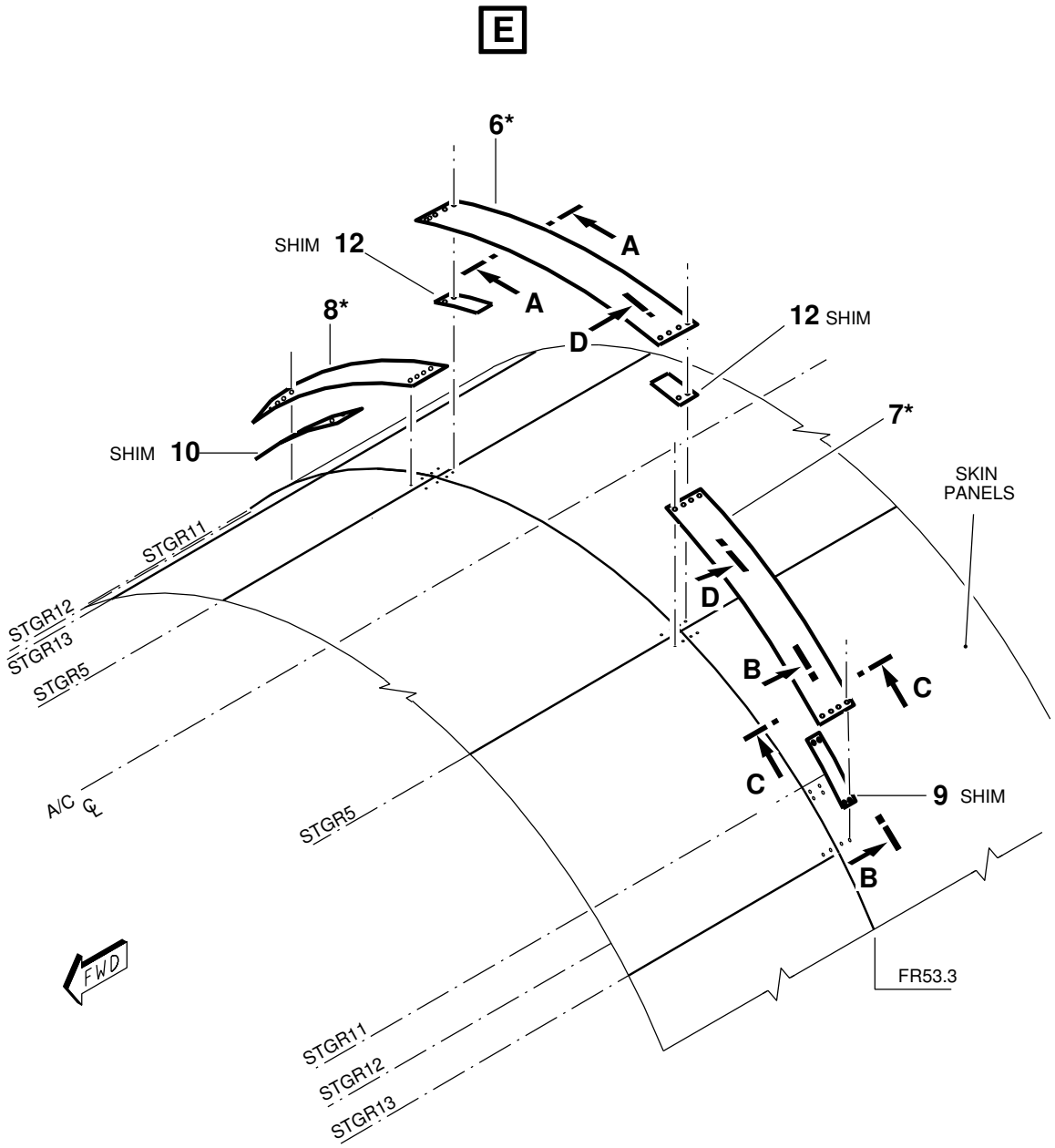
– ATTACH THE BUTT STRAP ITEM 6 AND THE SHIMS ITEM 12 AND 13 AGAIN TO THE FUSELAGE AND REAM THE FINISH HOLE DIAMETERS.

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Figure A-FBAAA - Sheet 05
Butt Strap Installation

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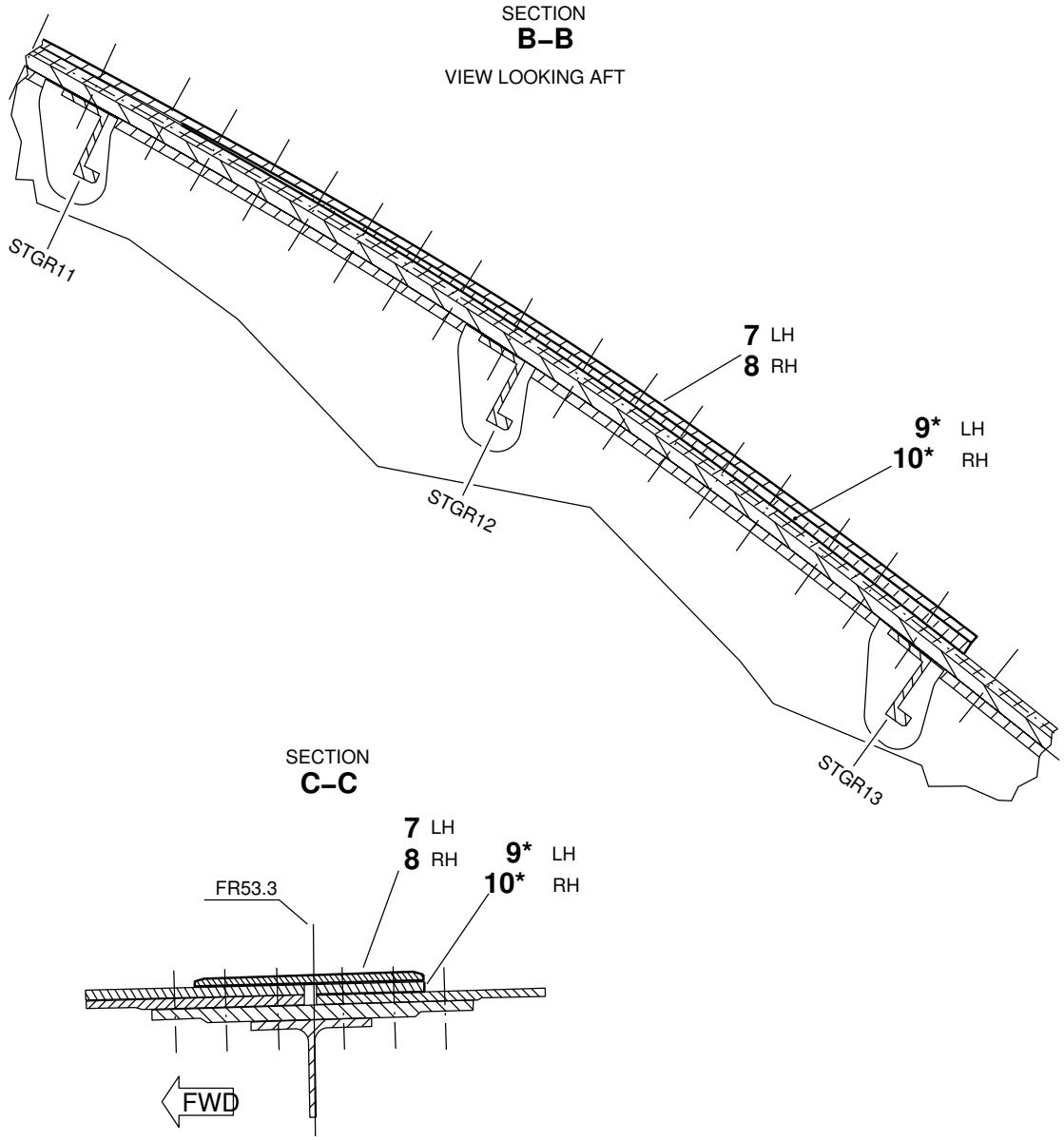
* : IF NECESSARY ADJUST THE LENGTH

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Figure A-FBAAA - Sheet 06
Butt Strap Installation

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* : ADJUST IF NECESSARY

NOTE: LH SIDE SECTIONS SHOWN
RH SIDE SYMMETRICAL

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Figure A-FBAAA - Sheet 07
Butt Strap Installation

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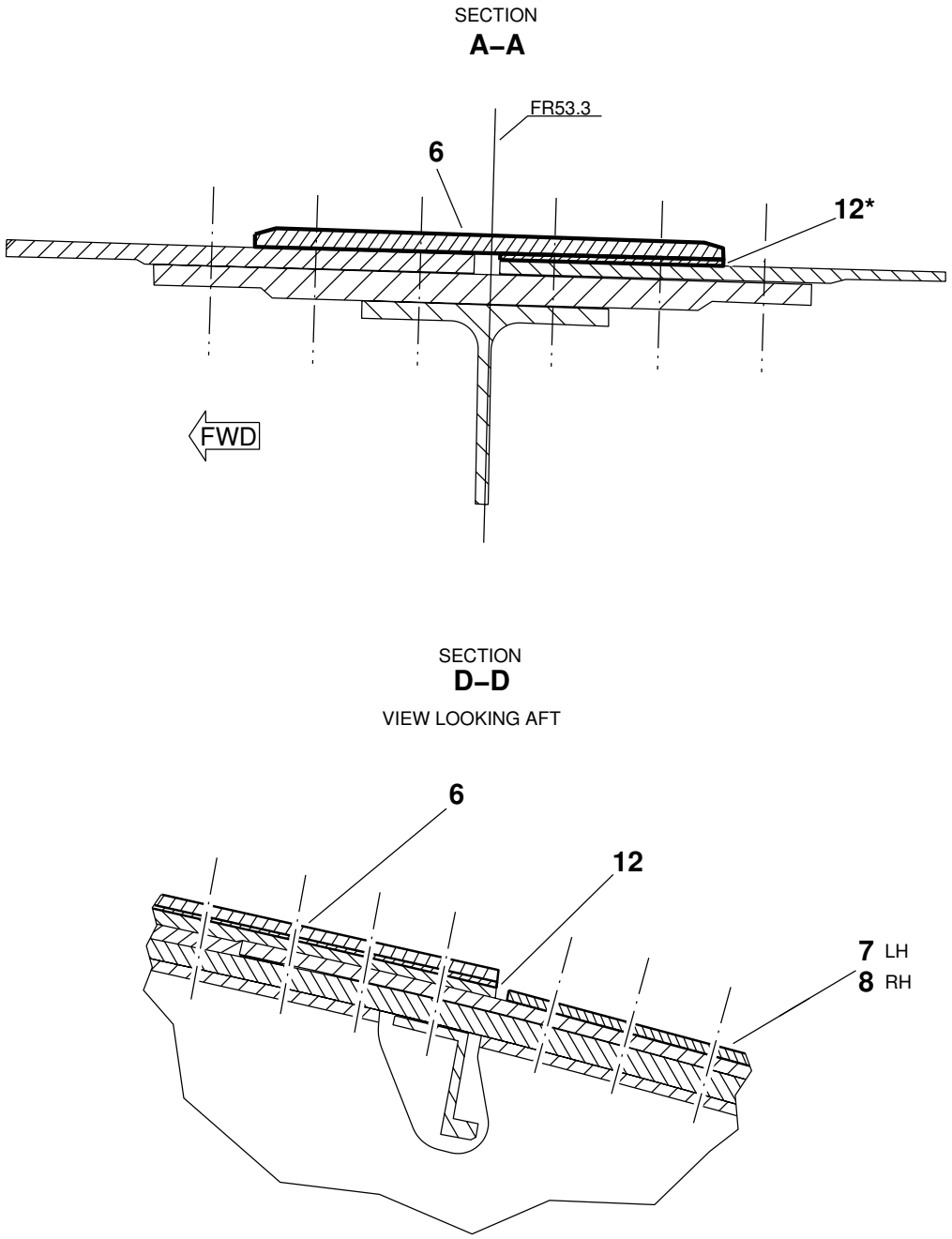


Figure A-FBAAA - Sheet 08
Butt Strap Installation

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(1) Jacking procedure for the installation of the butt straps on the fuselage skin at FR53.3, between STGR13 LH and STGR13 RH

(a) FIXTURE, TOOLS, TEST AND SUPPORT EQUIPMENT

ITEM	PART NUMBER		QTY	DESCRIPTION
	RECOMMEND	ALTERNATIVE		
2	98F07203002000	98F07203002001	6	HOIST TRIPOD
4	98F07203000150	98F07203000120	1	FR17 HOIST FITTING
5	98F07203000151	98F07203000121	1	FR17 HOIST FITTING
6	98F07203000140	98F07203000110	1	FR59 HOIST FITTING
7	98F07203000141	98F07203000111	1	FR59 HOIST FITTING
8	98F07203000142	98F07203000126	1	FR76 HOIST FITTING
9	98F07203000143	98F07203000127	1	FR76 HOIST FITTING
11	343A160KN2		1	LOAD CELL
12	343A1MN3		2	LOAD CELL
13	343A63KN2		3	LOAD CELL
14	343A100KN2		4	LOAD CELL
15	98A07003906200		8	LOAD CELL ADAPTOR
16	98A07003912200		2	LOAD CELL ADAPTOR
17	98A07003907200		7	LOAD CELL ADAPTOR
18	98A07003907201		2	LOAD CELL ADAPTOR
20	98A07003907202		1	LOAD CELL ADAPTOR

Refer to Fig. A-FABAA

NOTE: For Main Jack, Front Jack and Safety Jack, use your own standard tool or refer to SRM 51-51-00.

(b) AIRCRAFT CONFIGURATION

- This jacking procedure is only applicable to the configuration below: The aircraft without :

  . Fuel (except undrainable fuel)

  . Payload

  . Water (potable)

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. Baggage containers

. Pallets

. Emergency equipment

. Catering

. Documents and aircraft tool package.

- For the remaining aircraft configuration :

. Refer to Fig. A-FAAAA

NOTE (1): If the aircraft configuration is not the same as the configuration above, contact AIRBUS.

NOTE (2): If you do other tasks on the aircraft at the same time, contact AIRBUS.

(c) JACKING PROCEDURE

1 Obey the general jacking instructions, (Refer to SRM 51-51-00).

2 Lift the aircraft on the front, main and safety jacks shown in Fig. A-FACAA, (Refer to AMM 07-11-00, Page Block 201).

3 Install the additional jacking equipment at FR17, FR59 and FR76 (Refer to Fig. A-FACAA).

4 Apply the loads to the jacks at FR17, FR59 and FR76, one step after the other

Refer to Fig. A-FACAA

a Gradually apply the loads shown in step 1 to the jacks at FR17, FR59 and FR76. Wait until the loads on the jacks become stable and make sure that they are within a tolerance of +/- 10 percent. Make sure that the safety jack at FR87 is in contact without load.

b Continue the same procedure as above to apply the loads shown in step 2, then step 3 and step 4.

NOTE: When the loads given in step 4 are stable within a tolerance of +/- 10 percent on the jacks at FR17, FR59 and FR76, you can do the procedure given in ACCOMPLISHMENT INSTRUCTIONS, paragraph B.

(d) CLOSE-UP

1 Gradually decrease the loads one step after the other, from step 4 to zero on the jacks at FR17, FR59 and FR76 (Refer to Fig. A-FACAA).

2 Remove the jacks at FR17, FR59 and FR76.

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3 Lower the aircraft and remove the front, main and safety jacks, (Refer to AMM 07-11-00, Page Block 201).

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AIRCRAFT CONFIGURATION FOR JACKING:

FUSELAGE

EQUIPEMENT/FURNISHING	INSTALLED	REMOVED
FUSELAGE SECTION 11	X	
FUSELAGE SECTION 12	X	
FUSELAGE SECTION 13	X	
FUSELAGE SECTION 14	X	
FUSELAGE SECTION 14A	X	
FUSELAGE SECTION 15		X
FUSELAGE SECTION 16		X
FUSELAGE SECTION 17		X
FUSELAGE SECTION 18		X
FUSELAGE SECTION 19	X	
FUSELAGE SECTION 19.1	X	

MOVABLE ELEMENTS	INSTALLED	REMOVED
HORIZONTAL STABILIZER	X	
VERTICAL STABILIZER	X	
L/H PAX DOOR 1	X	
R/H PAX DOOR 1	X	
L/H PAX DOOR 2	X	
R/H PAX DOOR 2	X	
L/H PAX DOOR 3	X	
R/H PAX DOOR 3	X	
L/H PAX DOOR 4	X	
R/H PAX DOOR 4	X	
FWD CARGO DOOR	X	
AFT CARGO DOOR	X	
BULK CARGO DOOR	X	
APU	X	
CREW REST		X

LANDING GEARS	INSTALLED	REMOVED
NOSE LANDING GEAR	X	
L/H MAIN LANDING GEAR	X	
R/H MAIN LANDING GEAR	X	

L/H WING	INSTALLED	REMOVED
L/H WINGLET	X	
L/H SLATS	X	
L/H FLAPS	X	
L/H SPOILERS	X	
L/H AILERONS	X	

R/H WING	INSTALLED	REMOVED
R/H WINGLET	X	
R/H SLATS	X	
R/H FLAPS	X	
R/H SPOILERS	X	
R/H AILERONS	X	

ENGINES	INSTALLED	REMOVED
L/H ENGINE	X	
R/H ENGINE	X	

THRUST REVERSERS	INSTALLED	REMOVED
L/H ENGINE	X	
R/H ENGINE	X	

PYLONS	INSTALLED	REMOVED
L/H PYLON	X	
R/H PYLON	X	

FUEL

L/H WING TANKS	O
R/H WING TANKS	O
TRIM TANKS	O

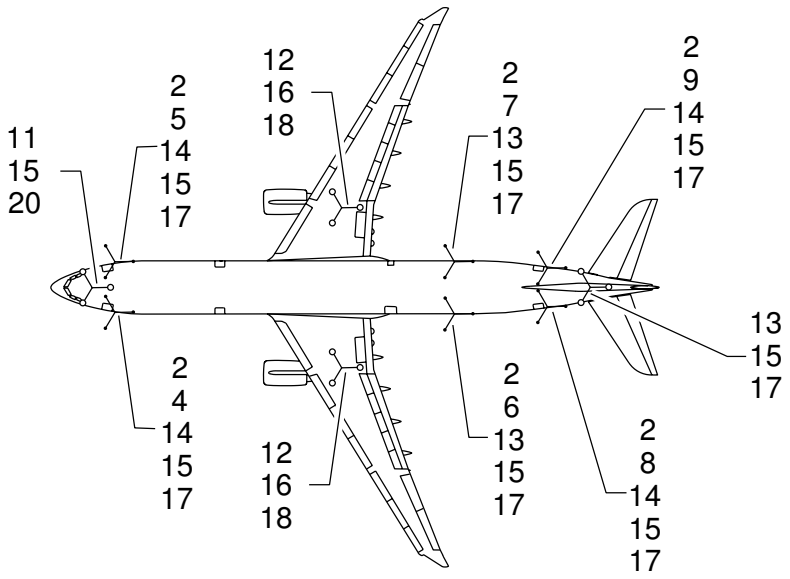
EXCEPT UNDRAINABLE FUEL

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Figure A-FAAAA - Sheet 01
Aircraft Configuration for Jacking

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ITEM	QUANTITY	DESIGNATION	PART NUMBER
2	6	HOIST TRIPOD	98F07203002000
4	1	FR17 HOIST FITTING	98F07203000120
5	1	FR17 HOIST FITTING	98F07203000121
6	1	FR59 HOIST FITTING	98F07203000110
7	1	FR59 HOIST FITTING	98F07203000111
8	1	FR76 HOIST FITTING	98F07203000126
9	1	FR76 HOIST FITTING	98F07203000127
11	1	LOAD CELL	343A160KN2
12	2	LOAD CELL	343A1MN3
13	3	LOAD CELL	343A63KN2
14	4	LOAD CELL	343A100KN2
15	8	LOAD CELL ADAPTOR	98A07003906200
16	2	LOAD CELL ADAPTOR	98A07003912200
17	7	LOAD CELL ADAPTOR	98A07003907200
18	2	LOAD CELL ADAPTOR	98A07003907201
20	1	LOAD CELL ADAPTOR	98A07003907202

G_SB_533127_5_ABAA_01_01

Figure A-FABAA - Sheet 01
Jacking Equipment

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JACKING POINTS	MAX. PERMIS. LOADS	APPLIED LOADS (Kg) +/– 10%				% OF TOTAL LOADS	ACTUAL LOADS (SEE NOTE 1)
		STEP 1	STEP 2	STEP 3	STEP 4		
FR87 (SAFETY JACK) (CONTACT ONLY)	4590	0	0	0	0	0	
FR17 (2 JACKS) (SEE NOTE 2)	16820	2800	5610	8410	11210	10	
FR59 (2 JACKS) (SEE NOTE 2)	8050	530	1060	1580	2110	2	
FR76 (2 JACKS) (SEE NOTE 2)	15190	3450	6900	10350	13800	12	

NOTE 1: TO INSTALL KIT A01 (REFER TO ACCOMPLISHEMENT INSTRUCTION, PARAGRAPH B.), MAKE SURE THAT THE ACTUAL LOADS ARE IN A TOLERANCE OF +/– 10% OF THE VALUES GIVEN IN STEP 4.

NOTE 2: APPLIED LOADS ARE TOTAL LOADS PER STATION (FOR A STATION WITH TWO JACKS, THE LOAD FOR EACH JACK IS THE APPLIED LOAD DIVIDED BY TWO).

SUPPORT POINTS	MAX. PERMIS. LOADS	REMAINING LOADS (Kg)			
FRONT JACK	12540	FOR INFORMATION	11200	10	
LH MAIN JACK	75130	FOR INFORMATION	38100	33	
RH MAIN JACK	75130	FOR INFORMATION	38100	33	

CORRESPONDING WEIGHT OF THE AIRCRAFT: 114400 (INCLUDING BALLASTS IF ANY)

G_SB_533127_5_ACAA_01_01

Figure A-FACAA - Sheet 01
Jacking Procedure

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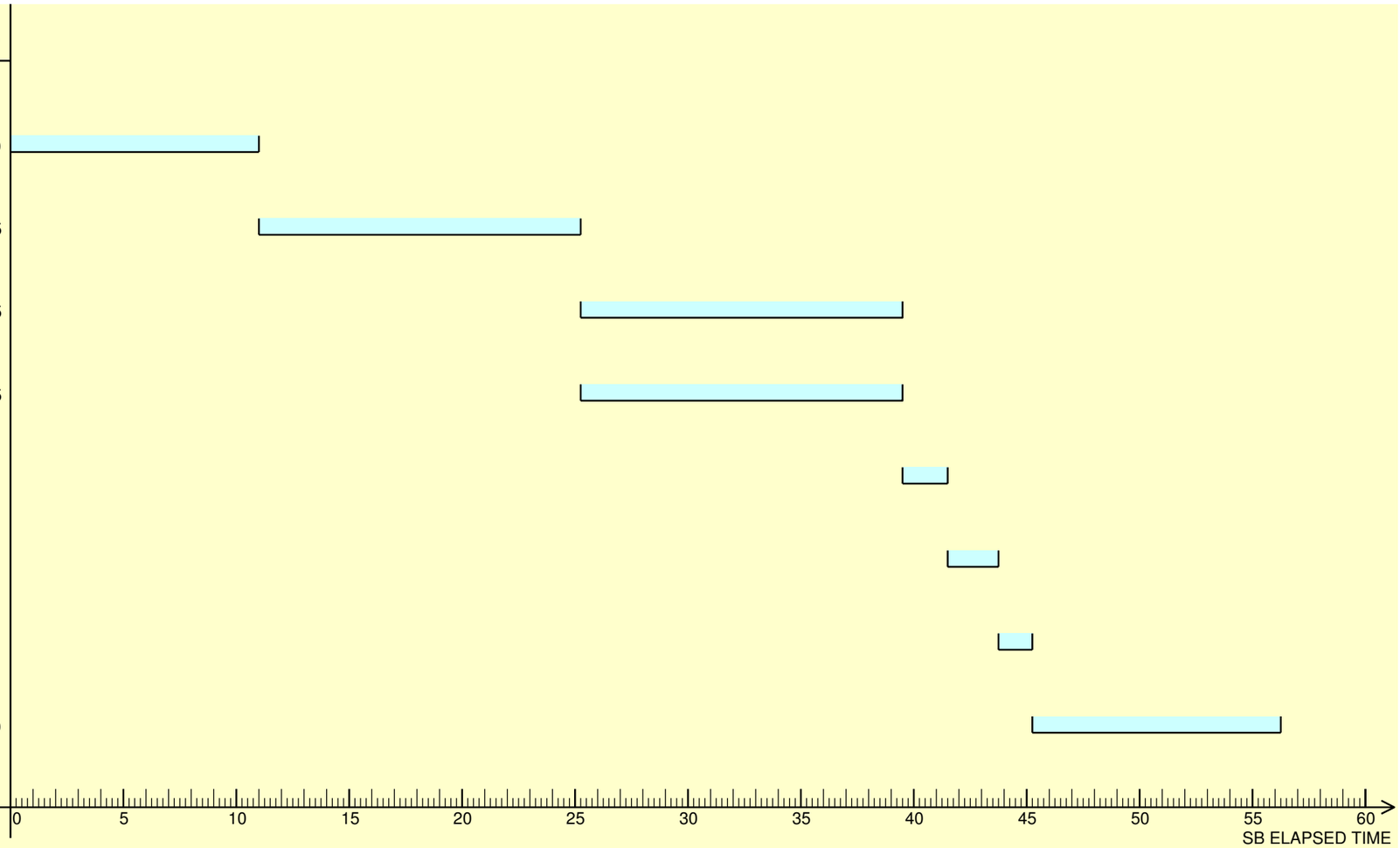
Refer to the subsequent Gantt Chart for the detail concerning the elapsed time assumptions.

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ELAPSED TIME ASSUMPTIONS SERVICE BULLETIN No. A330–53–3127 01 02

STEPS	MH	PER	ET/S
GET ACCESS	66.00	6	11.00
INSTALL THE BUTT STRAP AT FR53.3 BETWEEN LH AND RH STRG5	57.00	4	14.25
INSTALL THE BUTT STRAP AT FR53.3 BETWEEN LH STGR5 AND LH STRG13	57.00	4	14.25
INSTALL THE BUTT STRAP AT FR53.3 BETWEEN RH STGR5 AND RH STRG13	57.00	4	14.25
APPLY SEALANT	4.00	2	2.00
PAINT THE AREA MODIFIED	4.50	2	2.25
TEST	3.00	2	1.50
CLOSE–UP	66.00	6	11.00



TOTAL MANHOURS 314.50
SB ELAPSED TIME 56.25

NOTES:

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

02 MANHOURS GIVEN IN VENDOR SERVICE BULLETINS ARE NOT REFLECTED IN THIS GANTT CHART.

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

G_SB_533127_5_ADAA_01_01

Figure A-FADAA - Sheet 01
Gantt Chart

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SERVICE BULLETIN
REPORTING SHEET

TITLE: FUSELAGE - CENTER FUSELAGE - CIRCUMFERENTIAL JOINT FRAME 53.3, STGR 13 LH TO STGR 13 RH - FATIGUE LIFE IMPROVEMENT

MODIFICATION No.: 49403S16334

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
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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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