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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CONE/REAR FUSELAGE - INSTALL SELF-ALIGNING NUTS AT FRAME 98 FEET BETWEEN STRINGER 15/17 (LH/RH)

MODIFICATION No.:

115286L83020

ATA SYSTEM: 53

TITLE: FUSELAGE - CONE/REAR FUSELAGE - INSTALL SELF-ALIGNING NUTS AT FRAME 98 FEET BETWEEN STRINGER 15/17 (LH/RH)

SUMMARY

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

A. MODIFICATIONS

CONF 001

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	115286L83020

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.

NOTE: This modification related to an Airworthiness issue has been classified by Airbus and confirmed by EASA as minor in accordance with EU Part 21.A.91. As such, this minor change is handled by Airbus under its Design Organisation Approval No. EASA.21J.031.

CONF 002

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	115286L83020

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.

NOTE: This modification related to an Airworthiness issue has been classified by Airbus and confirmed by EASA as minor in accordance with EU Part 21.A.91. As such, this minor change is handled by Airbus under its Design Organisation Approval No. EASA.21J.031.

CONF 003

MODIFICATION CLASSIFICATION	
MAJOR	None
MINOR	115286L83020

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.

NOTE: This modification related to an Airworthiness issue has been classified by Airbus and confirmed by EASA as minor in accordance with EU Part 21.A.91. As such, this minor change is handled by Airbus under its Design Organisation Approval No. EASA.21J.031.

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B. REASON

(1) History

During assembly of the section 19 skin to Frame (FR) 98 joint, it has been identified that the gaps at nut to FR flange seat are out of tolerance for 8 fasteners between stringer (STGR) 15 and 17, 4 Left Hand (LH) and 4 Right Hand (RH) sides. The investigation performed reveals that the areas to be riveted present higher inclination than the inclination that can be accepted by the fasteners defined on the engineering drawings. From the structural analysis performed it is found that the gaps out of tolerance at these positions are not acceptable from Fatigue & Damage perspective.

(2) Objective/Action

This Service Bulletin provides the necessary instructions to remove the affected fasteners, inspect the area and replace the fasteners with new self-aligning nuts.

Detailed visual inspection of adjacent areas is required to ensure that no effects have extended to those areas.

(3) Advantages

Accomplishment of this Service Bulletin will contribute to maintain the structural integrity at the affected section 19 skin to FR 98 joint.

(4) Operational/Maintenance Consequences

None

C. GENERAL EVALUATION

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

NOTE: Service Bulletin must be accomplished.

D. MAINTENANCE CONFIGURATION

CONF 001

No specific aircraft maintenance configuration required.

CONF 002

No specific aircraft maintenance configuration required.

CONF 003

No specific aircraft maintenance configuration required.

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E. MATERIAL PRICE INFORMATION

CONF 001

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 53P057C01R01	1	70.00 USD	BOLTS, NUTS
Aircraft standard tools	See SB	See Note	

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

CONF 002

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 53P057C01R01	1	70.00 USD	BOLTS, NUTS
Aircraft standard tools	See SB	See Note	

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

CONF 003

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C**	**MAIN PARTS**
Part kit 53P057C01R01	1	70.00 USD	BOLTS, NUTS
Aircraft standard tools	See SB	See Note	

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

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F. APPLICABILITY

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

AAR CAL CCA CES CHH CPA CRK CSC DAL DLH ETH EVE FBU FIN FJI FWI HVN IBE MAS MAU PAL QTR SAA SIA TAM THA

G. CONCURRENT REQUIREMENTS

None

H. NATURE OF THE WORK

CONF 001

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT	YES
EQUIPMENT	NO

CONF 002

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT	YES
EQUIPMENT	NO

CONF 003

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT	YES
EQUIPMENT	NO

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I. MANPOWER

CONF 001

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MANPOWER	
TOTAL MAN-HOURS	7.00 h
ELAPSED TIME (HOURS)	4.00 h

CONF 002

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MANPOWER	
TOTAL MAN-HOURS	7.00 h
ELAPSED TIME (HOURS)	4.00 h

CONF 003

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MANPOWER	
TOTAL MAN-HOURS	7.00 h
ELAPSED TIME (HOURS)	4.00 h

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J. GENERAL OVERVIEW

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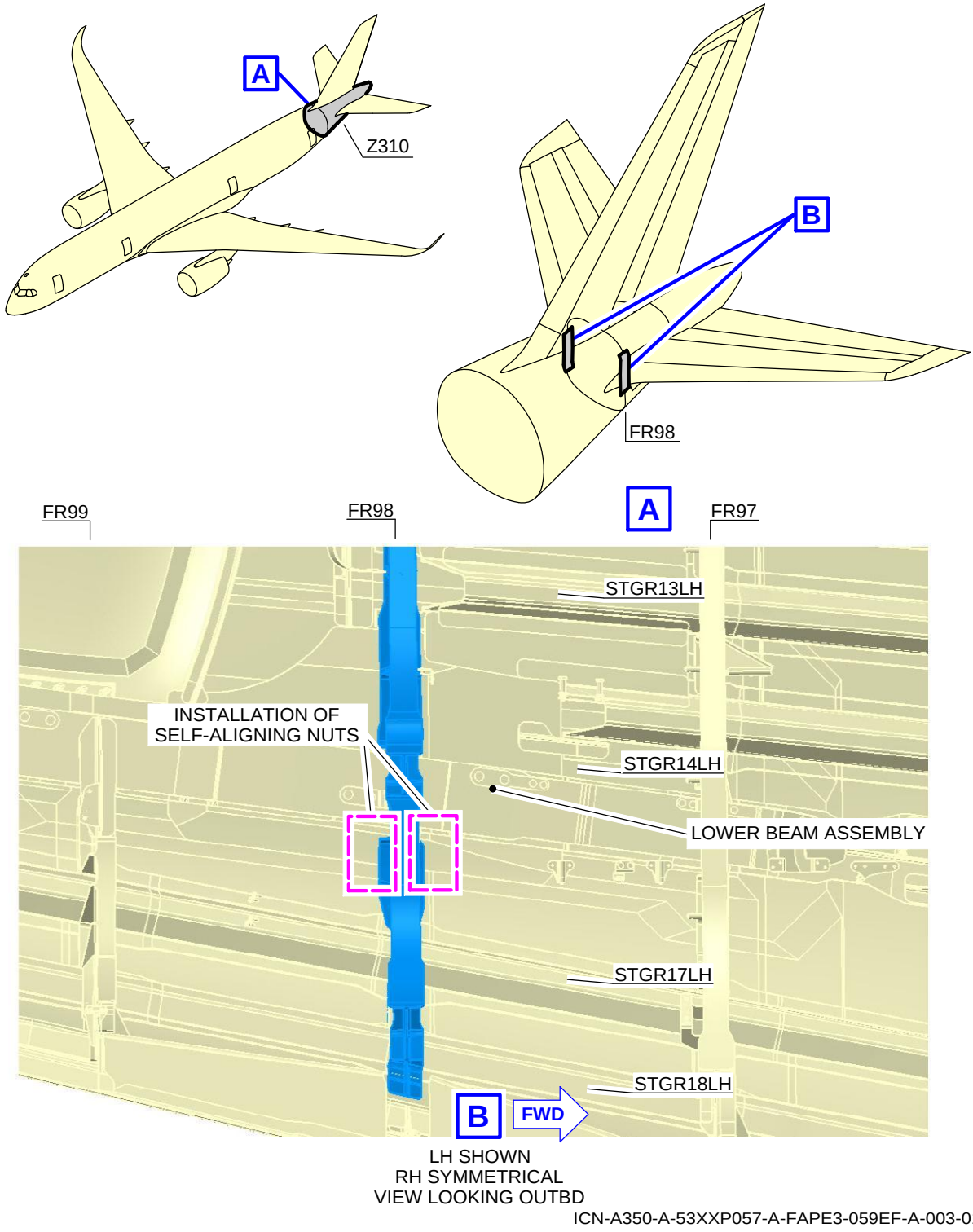


Figure ICN-A350-A-53XXP057-A-FAPE3-059EF-A-003-01 SHEET 1/1

ATA SYSTEM: 53

TITLE: FUSELAGE - CONE/REAR FUSELAGE - INSTALL SELF-ALIGNING NUTS AT FRAME 98 FEET BETWEEN STRINGER 15/17 (LH/RH)

1. PLANNING INFORMATION

A. APPLICABILITY

NOTE: This modification is applicable by Service Bulletin only.

NOTE: The intent of this modification is achieved in production on aircraft with Manufacturer Serial Number (MSN) (0307) and subsequent through modification No. (114295L83015).

(1) Models

ON A/C 0005-0058, 0060-0064, 0066-0070, 0072-0087, 0089-0101, 0103-0107, 0109, 0111-0117, 0119-0124, 0126-0130, 0132-0138, 0140, 0142-0151, 0153-0155, 0157-0160, 0162-0165, 0167, 0168, 0170, 0172-0187, 0189-0193, 0195-0205, 0207-0214, 0216-0221, 0223, 0224, 0226-0228, 0230-0232, 0234-0240, 0243-0251, 0254-0257, 0259-0261, 0263-0265, 0267-0273, 0276-0285, 0287, 0289, 0291-0295, 0297, 0299-0303, 0305

350-941

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(2) Applicability by MSN

0005-0058 0060-0064 0066-0070 0072-0087 0089-0101 0103-0107 0109 0111-0117 0119-0124 0126-0130 0132-0138 0140 0142-0151 0153-0155 0157-0160 0162-0165 0167 0168 0170 0172-0187 0189-0193 0195-0205 0207-0214 0216-0221 0223 0224 0226-0228 0230-0232 0234-0240 0243-0251 0254-0257 0259-0261 0263-0265 0267-0273 0276-0285 0287 0289 0291-0295 0297 0299-0303 0305

(3) MSN by configuration

CONF 001

MSN	CONFIGURATION
0005	001

CONF 002

MSN	CONFIGURATION
0006 0007 0008 0009 0010 0011 0012 0013 0014 0015 0016 0017 0018 0019 0020 0021 0022 0023 0024 0025 0026 0027 0028 0029 0030 0031 0032 0033 0034 0035 0036 0037 0038 0039 0040 0041 0042 0043 0044 0045 0046 0047 0048 0049 0050 0051 0052 0053 0054 0055 0056 0057 0058 0060 0061 0062 0063 0064 0066 0067 0068 0069 0070 0072 0073 0074 0075 0076 0077 0078 0079 0080 0081 0082 0083 0084 0085 0086 0087 0089 0090 0091 0092 0093 0094 0095 0096 0097 0098 0099 0100 0101 0103 0104 0105 0106 0107 0109 0111 0112 0113 0114 0115 0116 0117 0119 0120 0121 0122 0123 0124 0126 0127 0128 0129 0130 0132 0133 0134 0135 0136 0137 0138 0140 0142 0143 0144 0145 0146 0147 0148 0149 0150 0151 0153 0154 0155 0157 0158 0159 0160 0162 0163 0164 0165 0167 0168 0170 0172 0173 0174 0175 0176 0177 0178 0179 0180 0181 0182 0183 0184 0185 0186 0187 0189 0190 0191 0192 0193 0195 0196 0197 0198 0199 0200 0201	002

MSN	CONFIGURATION
0202 0203 0204 0205 0207 0208 0209 0210 0211 0212 0213 0214	

CONF 003

MSN	CONFIGURATION
0216 0217 0218 0219 0220 0221 0223 0224 0226 0227 0228 0230 0231 0232 0234 0235 0236 0237 0238 0239 0240 0243 0244 0245 0246 0247 0248 0249 0250 0251 0254 0255 0256 0257 0259 0260 0261 0263 0264 0265 0267 0268 0269 0270 0271 0272 0273 0276 0277 0278 0279 0280 0281 0282 0283 0284 0285 0287 0289 0291 0292 0293 0294 0295 0297 0299 0300 0301 0302 0303 0305	003

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(4) Configuration definition

CONF 001

Configuration 001

Config. 001 is valid for aircraft on which MOD No. 109496L80576 is embodied.

CONF 001 retrofits following modifications: 115286L83020.

CONF 002

Configuration 002

Config. 002 is valid for aircraft on which MOD No. 109496L80576 and MOD No. 110254L80604 are not embodied.

CONF 002 retrofits following modifications: 115286L83020.

CONF 003

Configuration 003

Config. 003 is valid for aircraft on which MOD No. 110254L80604 is embodied.

CONF 003 retrofits following modifications: 115286L83020.

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B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

During assembly of the section 19 skin to Frame (FR) 98 joint, it has been identified that the gaps at nut to FR flange seat are out of tolerance for 8 fasteners between stringer (STGR) 15 and 17, 4 Left Hand (LH) and 4 Right Hand (RH) sides. The investigation performed reveals that the areas to be riveted present higher inclination than the inclination that can be accepted by the fasteners defined on the engineering drawings. From the structural analysis performed it is found that the gaps out of tolerance at these positions are not acceptable from Fatigue & Damage perspective.

(2) Objective/Action

This Service Bulletin provides the necessary instructions to remove the affected fasteners, inspect the area and replace the fasteners with new self-aligning nuts.

Detailed visual inspection of adjacent areas is required to ensure that no effects have extended to those areas.

(3) Advantages

Accomplishment of this Service Bulletin will contribute to maintain the structural integrity at the affected section 19 skin to FR 98 joint.

(4) Operational/Maintenance Consequences

None

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to:

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

1 Remove the RH Fasteners

2 Perform NDT on RH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99

3 Install the RH Fasteners

4 Remove the LH Fasteners

5 Perform NDT on LH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99

6 Install the LH Fasteners

E. COMPLIANCE

CONF 001

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin must be done before 4817 flight cycles or 24085 flight hours from A/C first flight whichever occurs first.

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

CONF 002

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin must be done before 5431 flight cycles or 27155 flight hours from A/C first flight whichever occurs first.

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

CONF 003

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin must be done before 7303 flight cycles or 36515 flight hours from A/C first flight whichever occurs first.

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

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F. APPROVAL

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

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

G. MANPOWER

CONF 001

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

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

PREPARATION		
Get Access	0.50 h	
PROCEDURE		
Remove the RH Fasteners	1.00 h	
Perform NDT on RH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the RH Fasteners	1.00 h	
Remove the LH Fasteners	1.00 h	
Perform NDT on LH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the LH Fasteners	1.00 h	
PREPARATION FOR TEST		
None		
TEST		
None		
CLOSE-UP		

Close-up	0.50 h	
TOTAL MAN-HOURS	7.00 h	
ELAPSED TIME (HOURS)	4.00 h	

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

CONF 002

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

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

PREPARATION		
Get Access	0.50 h	
PROCEDURE		
Remove the RH Fasteners	1.00 h	
Perform NDT on RH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the RH Fasteners	1.00 h	
Remove the LH Fasteners	1.00 h	
Perform NDT on LH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the LH Fasteners	1.00 h	
PREPARATION FOR TEST		
None		
TEST		
None		
CLOSE-UP		
Close-up	0.50 h	
TOTAL MAN-HOURS	7.00 h	
ELAPSED TIME (HOURS)	4.00 h	

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

CONF 003

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

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

PREPARATION		
Get Access	0.50 h	
PROCEDURE		
Remove the RH Fasteners	1.00 h	
Perform NDT on RH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the RH Fasteners	1.00 h	
Remove the LH Fasteners	1.00 h	
Perform NDT on LH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99	1.00 h	
Install the LH Fasteners	1.00 h	
PREPARATION FOR TEST		
None		
TEST		
None		
CLOSE-UP		
Close-up	0.50 h	
TOTAL MAN-HOURS	7.00 h	
ELAPSED TIME (HOURS)	4.00 h	

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

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H. WEIGHT AND BALANCE

Not changed

I. ELECTRICAL LOAD DATA

Not changed

J. REFERENCES

CONF 001

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT STRUCTURAL REPAIR (ASR)	
A350-A-20-51-50-01ZZZ-25BZ-A	A350-A-51-24-XX-01ZZZ-667Z-A
A350-A-51-42-21-01ZZZ-667Z-A	A350-A-51-43-XX-01ZZZ-667Z-A
A350-A-51-75-12-00ZZZ-660Z-A	A350-A-51-77-11-00ZZZ-660Z-A

ELECTRICAL STANDARD PRACTICES (ESP)
A350-A-20-55-XX-01ZZZ-042Z-A

INTRODUCTION (INTRO)
A350-A-00-61-04-11ZZZ-018Z-D

MAINTENANCE PROCEDURE (MP)	
A350-A-24-41-XX-00ZZZ-170Z-A	A350-A-29-11-58-01ZZZ-520Z-A A350-A-29-11-58-01ZZZ-720Z-A
A350-A-29-13-58-01ZZZ-520Z-A A350-A-29-13-58-01ZZZ-720Z-A	A350-A-36-12-61-06ZZZ-520Z-A A350-A-36-12-61-06ZZZ-720Z-A

NON DESTRUCTIVE TEST (NDT)	
A350-A-51-96-50-00ZZZ-353Z-A	A350-A-51-99-10-00ZZZ-35AZ-A
A350-A-53-5X-XX-0HZZZ-35AZ-A	

TECHNICAL FOLLOW UP (TFU)
53.50.00007

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF 002

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT STRUCTURAL REPAIR (ASR)	
A350-A-20-51-50-01ZZZ-25BZ-A	A350-A-51-24-XX-01ZZZ-667Z-A
A350-A-51-42-21-01ZZZ-667Z-A	A350-A-51-43-XX-01ZZZ-667Z-A
A350-A-51-75-12-00ZZZ-660Z-A	A350-A-51-77-11-00ZZZ-660Z-A

ELECTRICAL STANDARD PRACTICES (ESP)
A350-A-20-55-XX-01ZZZ-042Z-A

INTRODUCTION (INTRO)
A350-A-00-61-04-11ZZZ-018Z-D

MAINTENANCE PROCEDURE (MP)	
A350-A-24-41-XX-00ZZZ-170Z-A	A350-A-29-11-58-01ZZZ-520Z-A A350-A-29-11-58-01ZZZ-720Z-A
A350-A-29-13-58-01ZZZ-520Z-A A350-A-29-13-58-01ZZZ-720Z-A	A350-A-36-12-61-06ZZZ-520Z-A A350-A-36-12-61-06ZZZ-720Z-A

NON DESTRUCTIVE TEST (NDT)	
A350-A-51-96-50-00ZZZ-353Z-A	A350-A-51-99-10-00ZZZ-35AZ-A
A350-A-53-5X-XX-0HZZZ-35AZ-A	

TECHNICAL FOLLOW UP (TFU)
53.50.00007

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

CONF 003

(1) Installation of Self-aligning Nuts Frame 98

(a) Task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

AIRCRAFT STRUCTURAL REPAIR (ASR)	
A350-A-20-51-50-01ZZZ-25BZ-A	A350-A-51-24-XX-01ZZZ-667Z-A
A350-A-51-42-21-01ZZZ-667Z-A	A350-A-51-43-XX-01ZZZ-667Z-A
A350-A-51-75-12-00ZZZ-660Z-A	A350-A-51-77-11-00ZZZ-660Z-A

ELECTRICAL STANDARD PRACTICES (ESP)
A350-A-20-55-XX-01ZZZ-042Z-A

INTRODUCTION (INTRO)
A350-A-00-61-04-11ZZZ-018Z-D

MAINTENANCE PROCEDURE (MP)	
A350-A-24-41-XX-00ZZZ-170Z-A	A350-A-29-11-58-01ZZZ-520Z-A A350-A-29-11-58-01ZZZ-720Z-A
A350-A-29-13-58-01ZZZ-520Z-A A350-A-29-13-58-01ZZZ-720Z-A	A350-A-36-12-61-06ZZZ-520Z-A A350-A-36-12-61-06ZZZ-720Z-A

NON DESTRUCTIVE TEST (NDT)	
A350-A-51-96-50-00ZZZ-353Z-A	A350-A-51-99-10-00ZZZ-35AZ-A
A350-A-53-5X-XX-0HZZZ-35AZ-A	

TECHNICAL FOLLOW UP (TFU)
53.50.00007

STANDARDS MANUAL (SM)

CONSUMABLE MATERIAL LIST (CML)

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K. PUBLICATION AFFECTED

None

L. INDUSTRY SUPPORT INFORMATION

AIRBUS will share the costs of accomplishment of this Service Bulletin by providing the kits at no charge for orders placed before Dec 31/22.

AIRBUS will credit the man hours indicated in this Service Bulletin at the agreed in-house warranty labor rate for claims received no later than 90 days after completion of the last affected aircraft of your fleet, for the accomplishment of this Service Bulletin before Dec 31/22.

This Service Bulletin is the subject of an AIRBUS monitored retrofit campaign.

For the organization of this retrofit, you are kindly requested to contact AIRBUS retrofit management department: monitored.retrofit@airbus.com.

2. MATERIAL INFORMATION

A. MATERIAL APPLICABILITY

CONF 001

Material for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Consumables	See SB	
Part kit 53P057C01R01	1	

CONF 002

Material for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Consumables	See SB	
Part kit 53P057C01R01	1	

CONF 003

Material for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

MATERIAL	QTY	SEE NOTES
Aircraft standard tools	See SB	
Consumables	See SB	
Part kit 53P057C01R01	1	

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B. TOOLING

CONF 001

Aircraft standard tools for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	98V53509002000	1	PLATFORM		

CONF 002

Aircraft standard tools for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	98V53509002000	1	PLATFORM		

CONF 003

Aircraft standard tools for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
	98V53509002000	1	PLATFORM		

CONF ALL

C. CONSUMABLES

CONF 001

Consumables for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04DAB2	Primer Epoxy Paint - - Corrosion Inhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAC1	Polysulfide Sealant - General Purpose Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

CONF 002

Consumables for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04DAB2	Primer Epoxy Paint - - Corrosion Inhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAC1	Polysulfide Sealant - General Purpose Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

CONF 003

Consumables for task set A350-A-53-XX-P057-01000-93AA-A Installation of Self-aligning Nuts Frame 98

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04DAB2	Primer Epoxy Paint - - Corrosion Inhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAC1	Polysulfide Sealant - General Purpose Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

CONF ALL

D. LIST OF NEW PARTS

Part kit 53P057C01R01

Cost	70.00 USD
Availability	230 d (calendar days from receipt of order)

Procurement address	
NOTE(S)	

AIRBUS
Material, Logistics and Suppliers ATP II B,
Hein-Sass-Weg 24
21129 HAMBURG
GERMANY
Phone: +49 40 743 51775
E-mail: airbus.kit@airbus.com
Internet: http://spares.airbus.com

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

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
3	EN6114K6-10	4	BOLT		
4	ASNA2537-6	4	NUT		
5	EN6114K5-8	4	BOLT		
6	ASNA2537-5	4	NUT		

NOTE(S)

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

E. LIST OF EXISTING PARTS

No parts

3. ACCOMPLISHMENT INSTRUCTIONS

Task set A350-A-53-XX-P057-01000-93AA-A
Installation of Self-aligning Nuts Frame 98

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 ESP Ref. ESP A350-A-20-55-XX-01ZZZ-042Z-A.

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

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

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

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

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

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

A. TASK SET ASSOCIATED INFORMATION

Task Manpower

CONF 001

TOTAL MAN-HOURS	7.00 h

CONF 002		
	TOTAL MAN-HOURS	7.00 h
CONF 003		
	TOTAL MAN-HOURS	7.00 h
CONF 001		
	ELAPSED TIME (HOURS)	4.00 h
CONF 002		
	ELAPSED TIME (HOURS)	4.00 h
CONF 003		
	ELAPSED TIME (HOURS)	4.00 h
CONF ALL		

B. PREPARATION

(1) Task A350-A-53-XX-P057-01001-540A-A - Get Access

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h

Material necessary to do the job

Aircraft standard tools					
ITEM	**PART No.**	**QTY (UM)**	**KEYWORD**	**DRAWING**	**SEE NOTES**
	98V53509002000	1	PLATFORM		

Referenced Information

Manuals/Drawings	References/Sheets
INTRO	A350-A-00-61-04-11ZZZ-018Z-D
MP	A350-A-24-41-XX-00ZZZ-170Z-A A350-A-29-11-58-01ZZZ-520Z-A A350-A-29-13-58-01ZZZ-520Z-A A350-A-36-12-61-06ZZZ-520Z-A

Procedure

NOTE: For the basic Aircraft configuration, refer to Ref. INTRO A350-A-00-61-04-11ZZZ-018Z-D “Introduction”.

(a) Make sure that the aircraft is electrically grounded, refer to Ref. MP A350-A-24-41-XX-00ZZZ-170Z-A.

(b) Put an access platform in position below access doors 311AB and 311BB.

(c) Gain access to the aft fuselage through access door 311AB.

NOTE: Be careful not to step on a closed access door.

(d) Install the tools to access gain access to the work area.

1	CENTRAL PLATFORM-S19	98V53509002000

(e) If required disconnect the Aft Green Temperature Control Valve, refer to Ref. MP A350-A-29-11-58-01ZZZ-520Z-A.

(f) If required disconnect the Aft Yellow Temperature Control Valve, refer to Ref. MP A350-A-29-13-58-01ZZZ-520Z-A.

(g) If required remove the Bleed Air Duct, refer to Ref. MP A350-A-36-12-61-06ZZZ-520Z-A.

C. PROCEDURE

(1) Task A350-A-53-XX-P057-01001-520A-A - Remove the RH Fasteners

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	From Stringer 15 to Stringer 17 Frame 98

Manpower/Resources/Skills

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

Material necessary to do the job

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

Referenced Information

Manuals/Drawings	References/Sheets
ASR	A350-A-51-42-21-01ZZZ-667Z-A A350-A-51-77-11-00ZZZ-660Z-A

Procedure

(a) The Standard Practices given in this procedure are:

1 Remove and install fasteners in accordance with Ref. ASR A350-A-51-42-21-01ZZZ-667Z-A.

2 Get cleaning process in accordance with Ref. ASR A350-A-51-77-11-00ZZZ-660Z-A.

(b) Remove as shown on Ref. Fig. Fastener Removal View B and View C.

4	FASTENER	Discard

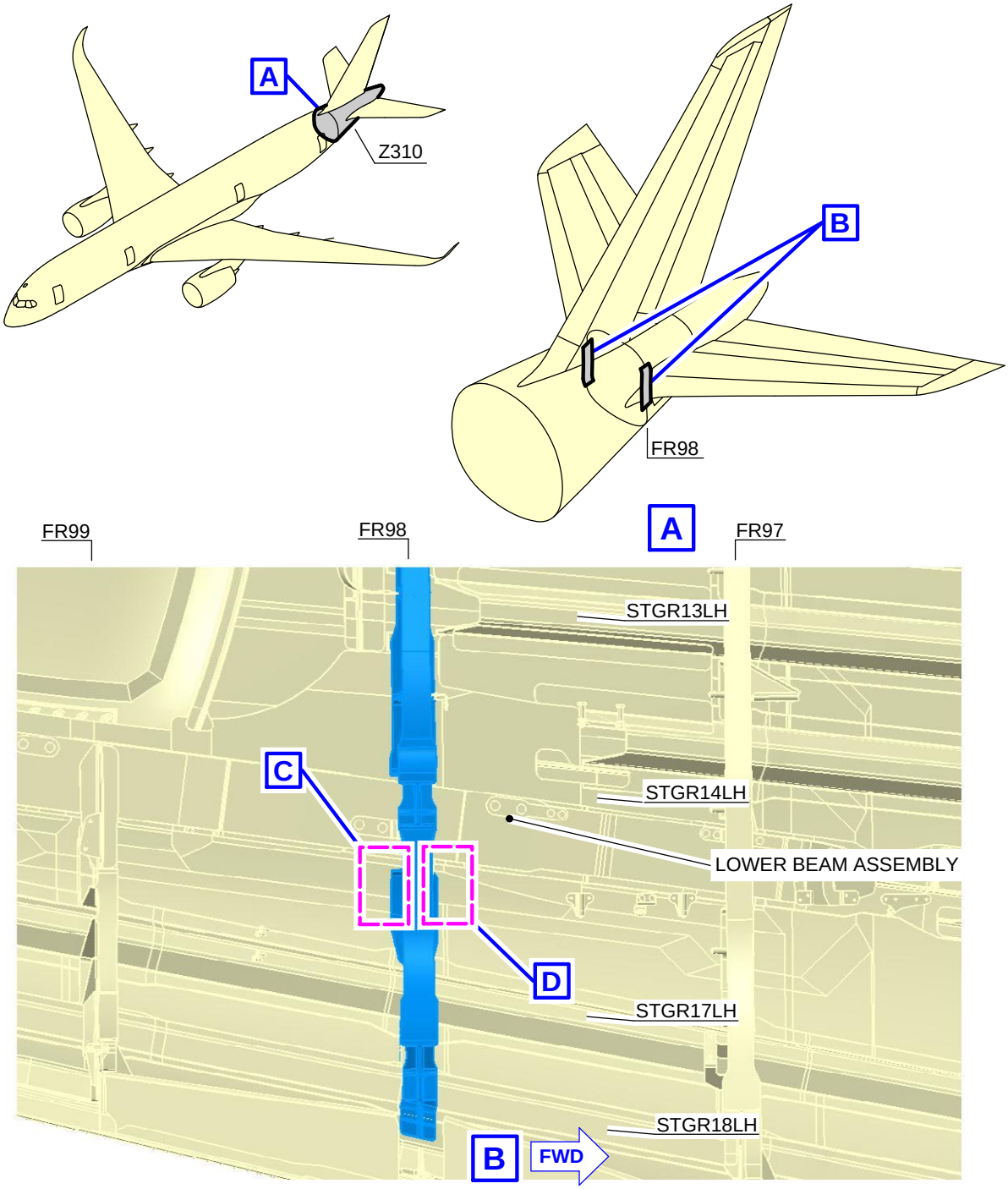
(c) Clean the work area with:

Textile - Lint free Cotton 14SBA1

and

Non Aqueous Cleaner - General 08BAA9

CONF ALL



LH SHOWN
RH SYMMETRICAL
VIEW LOOKING OUTBD

ICN-A350-A-53XXP057-A-FAPE3-059EJ-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EJ-A-003-01 SHEET 1/2

CONF ALL

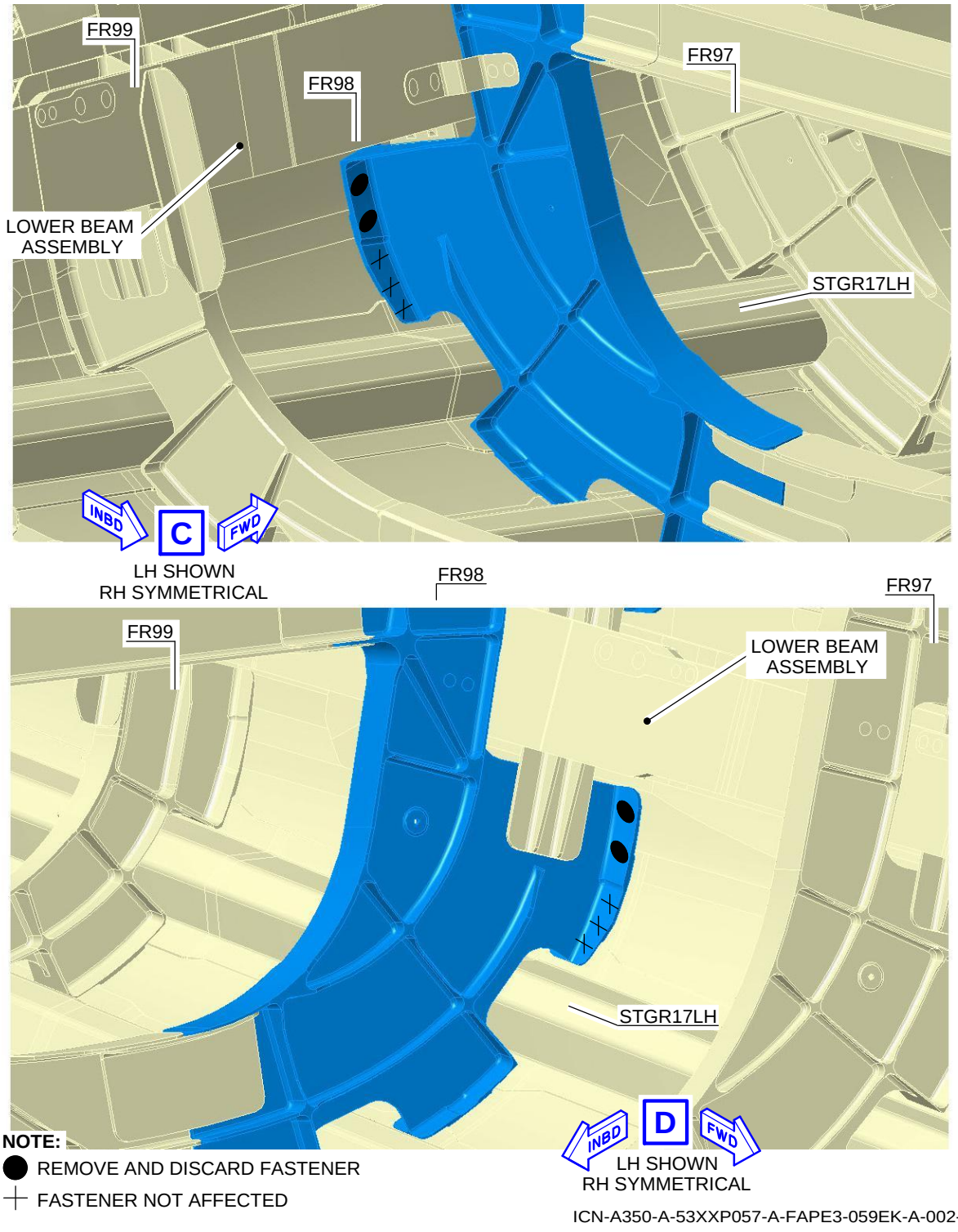


Figure ICN-A350-A-53XXP057-A-FAPE3-059EK-A-002-01 SHEET 2/2

(2) Task A350-A-53-XX-P057-01001-353A-A - Perform NDT on RH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	From Frame 97 to Frame 99 From Stringer 12 to Stringer 18

Manpower/Resources/Skills

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

Referenced Information

Manuals/Drawings	References/Sheets
NDT	A350-A-51-96-50-00ZZZ-353Z-A A350-A-51-99-10-00ZZZ-35AZ-A A350-A-53-5X-XX-0HZZZ-35AZ-A

Procedure

(a) Perform the NDT of the modification area, refer to Ref. Fig. Area Inspection.

1 Do a rotating probe test of the fastener holes, refer to Ref. NDT A350-A-51-96-50-00ZZZ-353Z-A and refer to Ref. Fig. Area Inspection Sheet 2, View C and View D.

2 Do an eddy current inspection of the surrounding flange in accordance with Ref. NDT A350-A-53-5X-XX-0HZZZ-35AZ-A and refer to Ref. Fig. Area Inspection Sheet 2, View C and View D.

3 Do a detailed inspection of the Frame 98, Frame 97, and Frame 99, refer to Ref. NDT A350-A-51-99-10-00ZZZ-35AZ-A and refer to Ref. Fig. Area Inspection Sheet 1, View B.

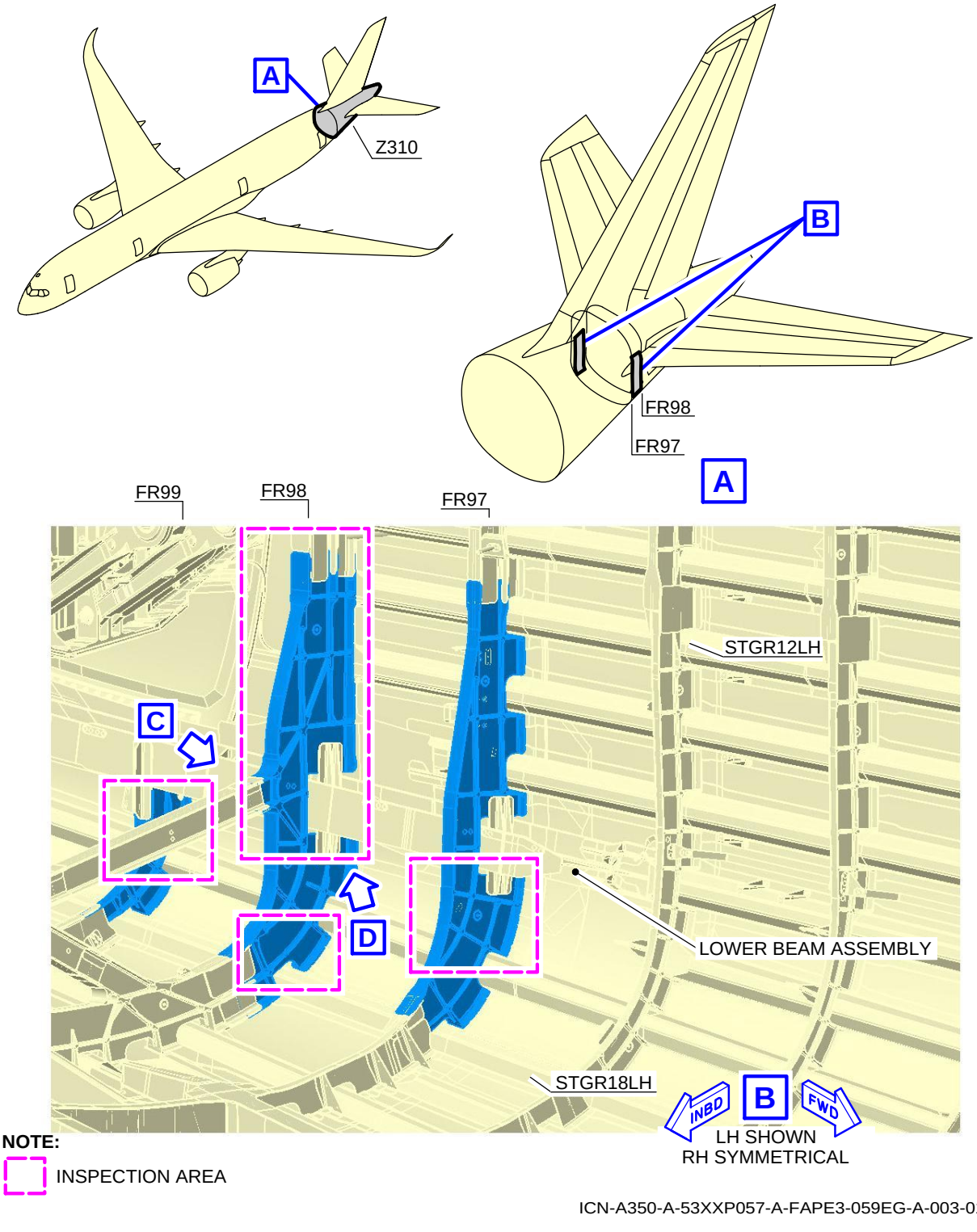
4 In case of findings:

a Contact AIRBUS for repair instructions.

5 In case of no findings:

a Continue to Ref. Task A350-A-53-XX-P057-01ZZZ-720Z-A.

CONF ALL



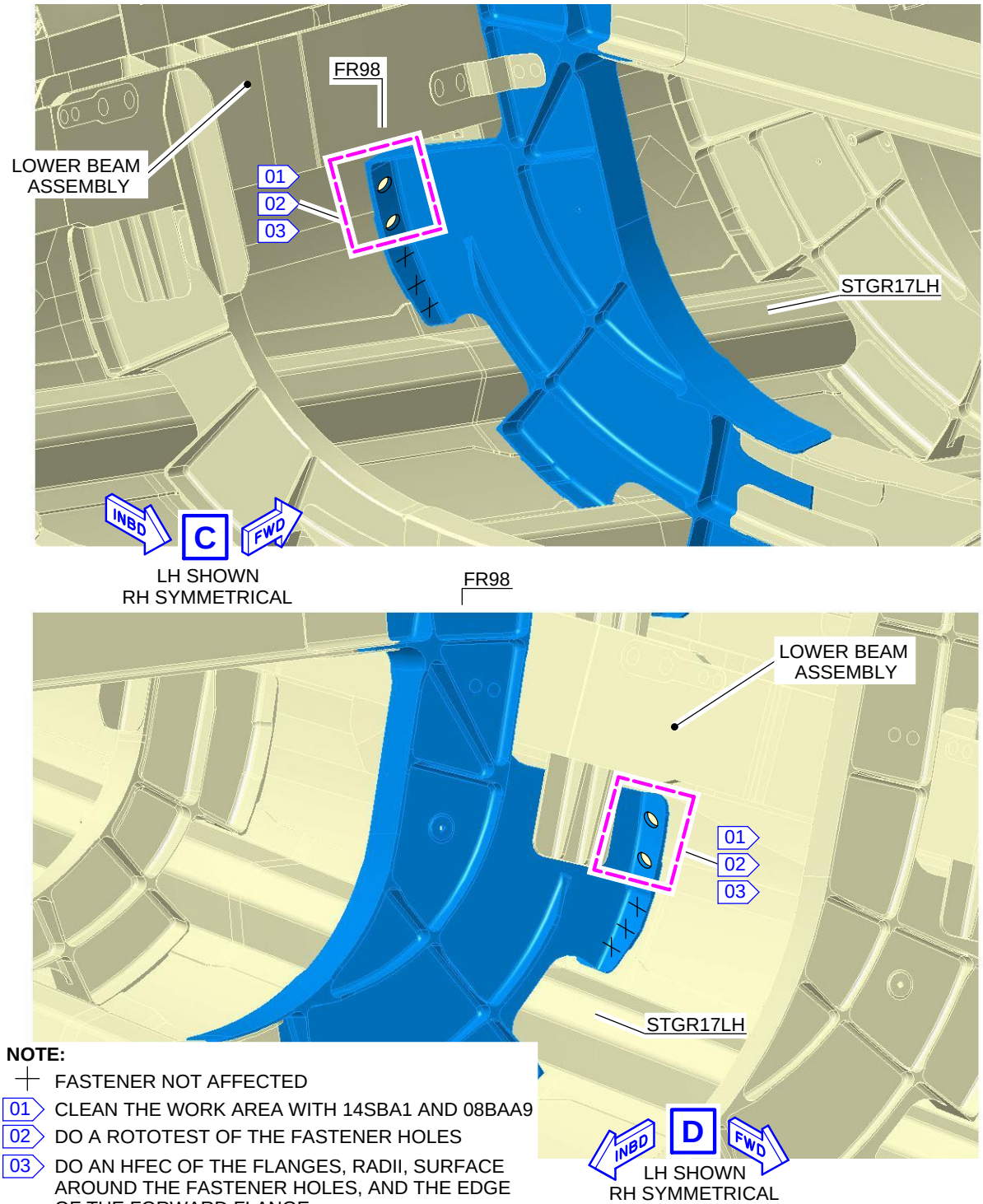
NOTE:

INSPECTION AREA

ICN-A350-A-53XXP057-A-FAPE3-059EG-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EG-A-003-01 SHEET 1/2

CONF ALL



NOTE:

- FASTENER NOT AFFECTED
- 01 CLEAN THE WORK AREA WITH 14SBA1 AND 08BAA9
- 02 DO A ROTOTEST OF THE FASTENER HOLES
- 03 DO AN HFEC OF THE FLANGES, RADII, SURFACE AROUND THE FASTENER HOLES, AND THE EDGE OF THE FORWARD FLANGE

ICN-A350-A-53XXP057-A-FAPE3-059EH-A-004-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EH-A-004-01 SHEET 2/2

(3) Task A350-A-53-XX-P057-01001-720A-A - Install the RH Fasteners

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	Frame 98 From Stringer 15 to Stringer 17

Manpower/Resources/Skills

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

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04DAB2	Primer Epoxy Paint - - Corrosion Inhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAC1	Polysulfide Sealant - General Purpose Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 53P057C01R01

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
3	EN6114K6-10	2	BOLT		
4	ASNA2537-6	2	NUT		
5	EN6114K5-8	2	BOLT		
6	ASNA2537-5	2	NUT		

Referenced Information

Manuals/Drawings	References/Sheets
ASR	A350-A-20-51-50-01ZZZ-25BZ-A A350-A-51-24-XX-01ZZZ-667Z-A A350-A-51-42-21-01ZZZ-667Z-A

Manuals/Drawings	References/Sheets
	A350-A-51-43-XX-01ZZZ-667Z-A A350-A-51-75-12-00ZZZ-660Z-A A350-A-51-77-11-00ZZZ-660Z-A
CML	CONSUMABLE MATERIAL LIST (CML)

Procedure

(a) The Standard Practices given in this procedure are:

1 Remove and install fasteners in accordance with Ref. ASR A350-A-51-42-21-01ZZZ-667Z-A.

2 Apply sealant in accordance with Ref. ASR A350-A-51-24-XX-01ZZZ-667Z-A.

3 To torque tighten the standard threaded fasteners, refer to Ref. ASR A350-A-20-51-50-01ZZZ-25BZ-A.

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

5 If the length of any fastener specified in this Service Bulletin does not meet installation standards given in ASR Data Module 51-4, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in (ASR Data Module 51-4 or SRM Chapter 51) may be used. In addition, washers may be installed for fastener grip length in accordance with (ASR Data Module 51-4 or SRM Chapter 51).

6 Get alternative and substitute fastener data in accordance with Ref. ASR A350-A-51-43-XX-01ZZZ-667Z-A.

7 Get cleaning process in accordance with Ref. ASR A350-A-51-77-11-00ZZZ-660Z-A.

8 Repair the paint coating in accordance with Ref. ASR A350-A-51-75-12-00ZZZ-660Z-A.

(b) Clean the installation area with:

Textile - Lint free Cotton 14SBA1
made moist with:

Non Aqueous Cleaner - General 08BAA9

(c) Wet install the new fasteners, refer to Ref. Fig. Fastener Installation.

2	BOLT	EN6114K6-10	Item 3
2	NUT-HEXAGONAL,SELF-LOCKING,BALL,BIHEX,FUSE	ASNA2537-6	Item 4

with

Polysulfide Sealant - General Purpose Interfay 06AAC1

(d) Torque the fasteners between 17.4 Nm (154.00 lbf.in) and 21 Nm (185.86 lbf.in).

(e) Wet install the new fasteners, refer to Ref. Fig. Fastener Installation.

2	BOLT	EN6114K5-8	Item 5

2	NUT-HEXAGONAL,SELF-LOCKING,BALL,BIHEX,FUSE	ASNA2537-5	Item 6
with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	

(f) Torque the fasteners between 10.0 Nm (88.50 lbf.in) and 13.1 Nm (115.94 lbf.in).

(g) Apply protection to the fasteners, use :

Primer Epoxy Paint - - Corrosion Inhibiting Structure	04DAB2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

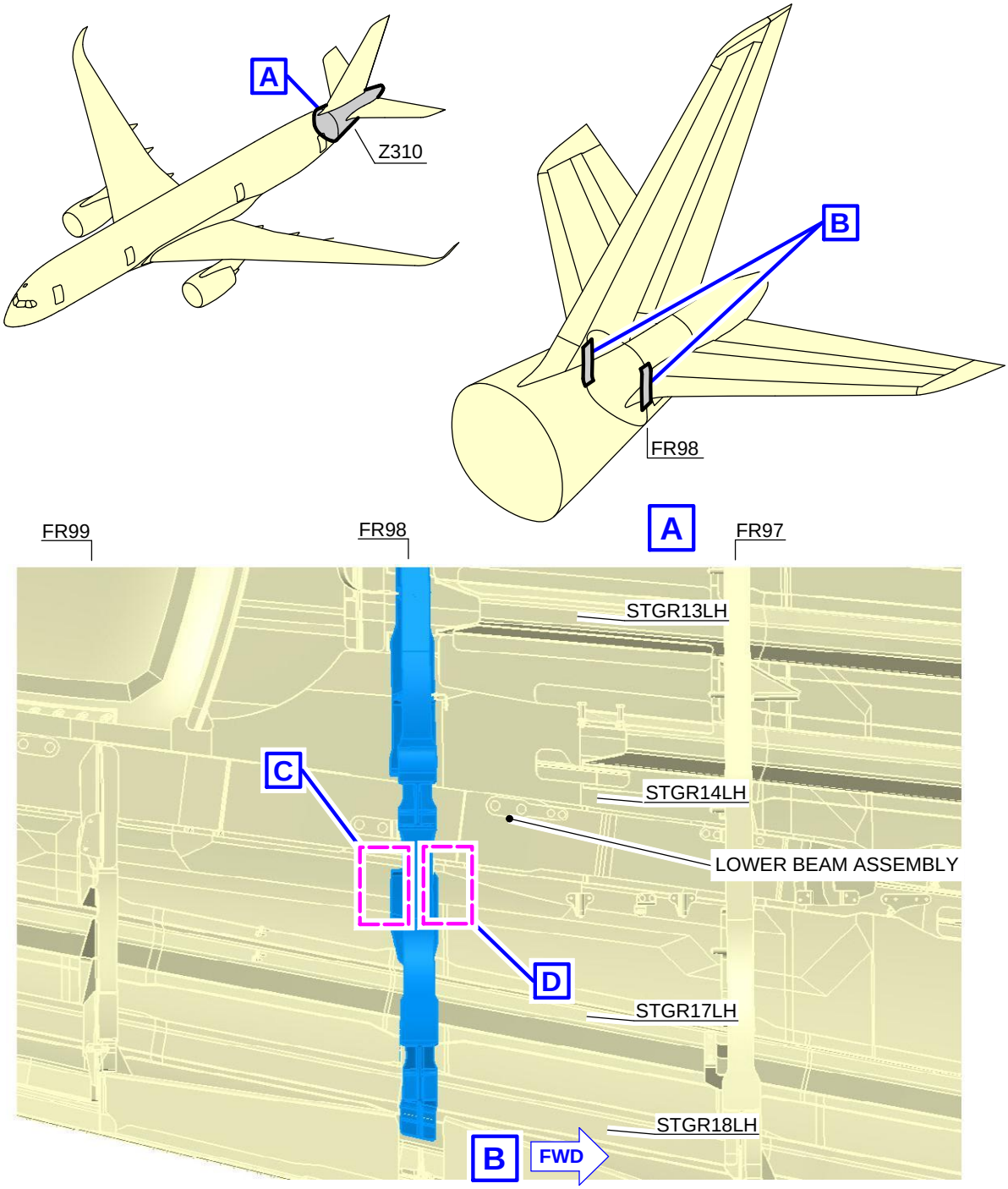
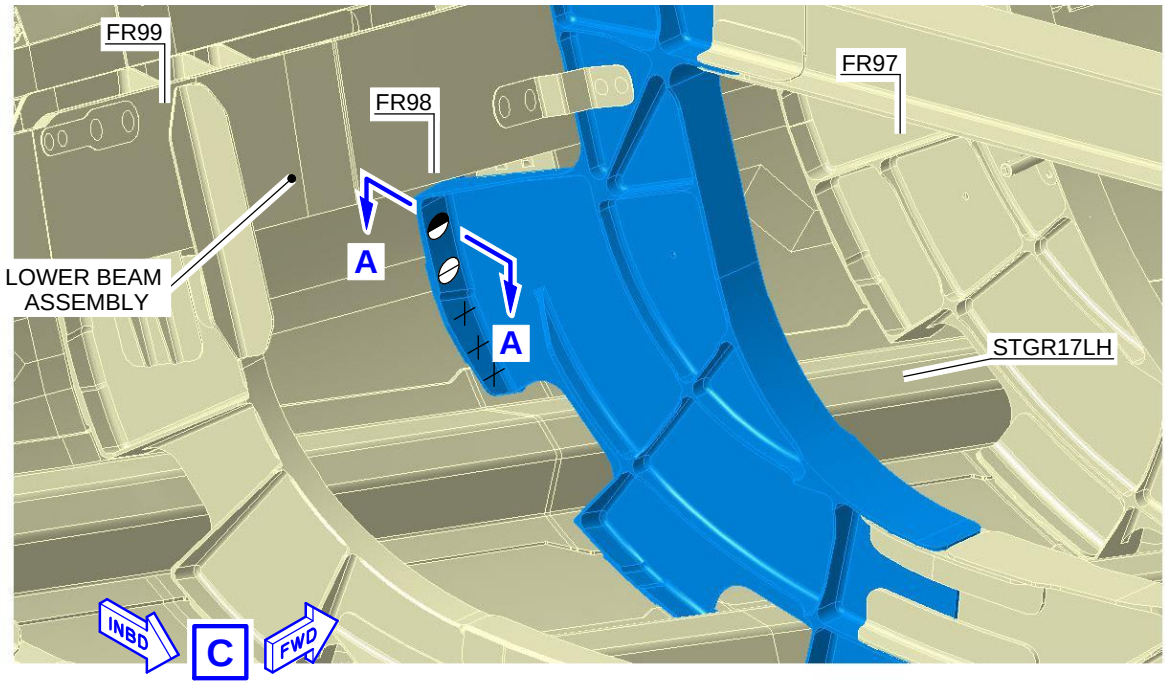
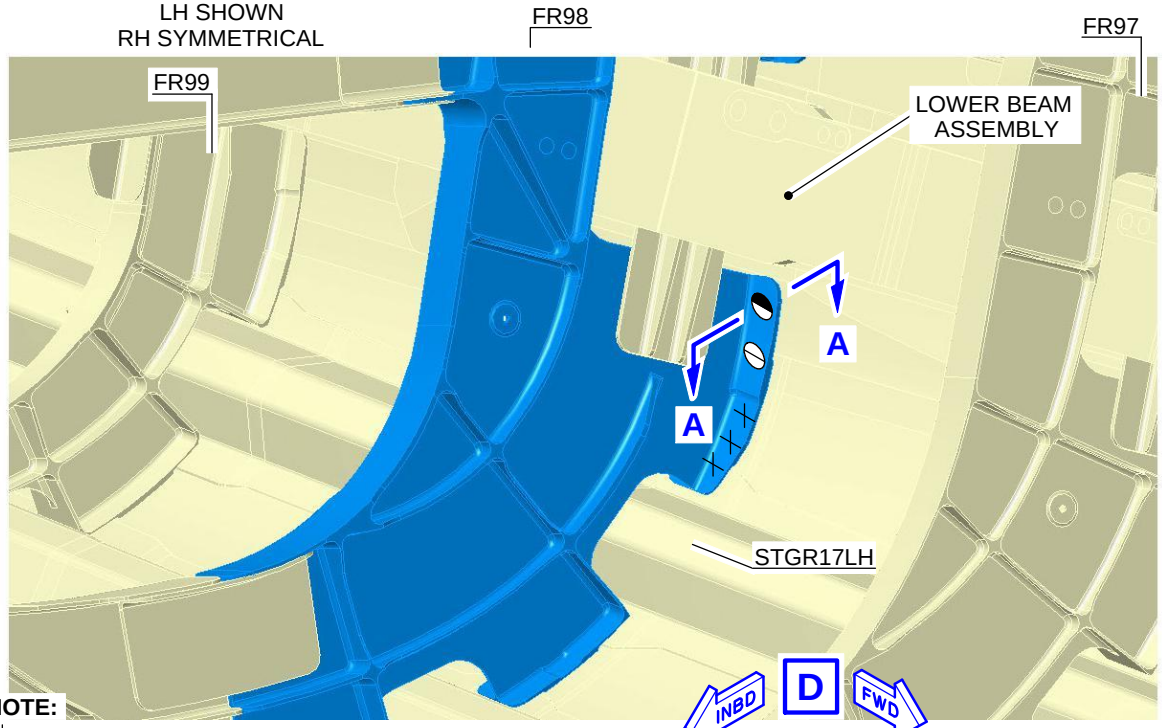


Figure ICN-A350-A-53XXP057-A-FAPE3-059EL-A-003-01 SHEET 1/3

CONF ALL



LH SHOWN
RH SYMMETRICAL



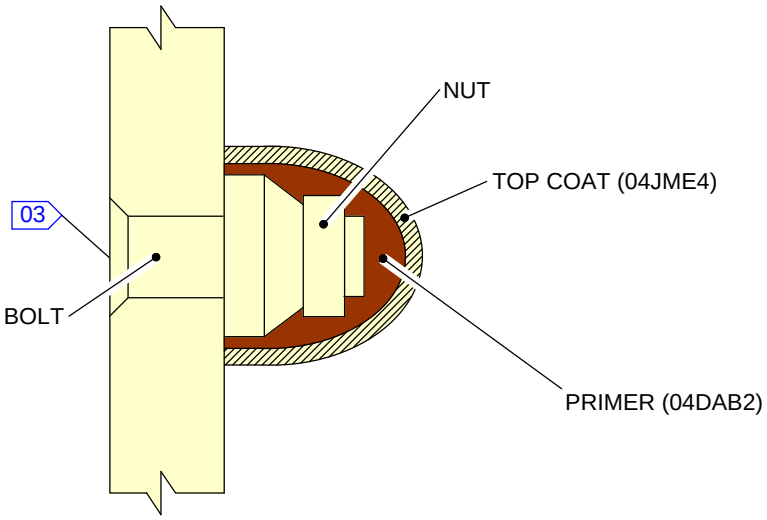
NOTE:
┼ FASTENER NOT AFFECTED
SEE SHEET 03 FOR FASTENER TABLE

LH SHOWN
RH SYMMETRICAL

ICN-A350-A-53XXP057-A-FAPE3-059EM-A-002-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EM-A-002-01 SHEET 2/3

CONF ALL



A-A
TYPICAL

HOLE SYMBOL	ITEM	PN	DESCRIPTION	FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTES
				MIN	MAX		
◓	3	EN6114K6-10	BOLT	9.514 mm (0.3746 in)	9.552 mm (0.3760 in)	LOW CLEARANCE	01 02
	4	ASNA2537-6	NUT				
⊖	5	EN6114K5-8	BOLT	7.927 mm (0.3121 in)	7.964 mm (0.3135 in)	LOW CLEARANCE	01 02
	6	ASNA2537-5	NUT				

NOTE:

01 WET INSTALL WITH MATERIAL No 06AAC1
02 SEE VIEW A-A FOR OVERCOATING SEALANT
03 TOUCH UP TOP COAT AS REQUIRED TO MATCH AIRCRAFT PAINT SCHEME

ICN-A350-A-53XXP057-A-FAPE3-059EN-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EN-A-003-01 SHEET 3/3

(4) Task A350-A-53-XX-P057-02001-520A-A - Remove the LH Fasteners

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	Frame 98 From Stringer 15 to Stringer 17

Manpower/Resources/Skills

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

Material necessary to do the job

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

Referenced Information

Manuals/Drawings	References/Sheets
ASR	A350-A-51-42-21-01ZZZ-667Z-A A350-A-51-77-11-00ZZZ-660Z-A

Procedure

(a) The Standard Practices given in this procedure are:

1 Remove and install fasteners in accordance with Ref. ASR A350-A-51-42-21-01ZZZ-667Z-A.

2 Get cleaning process in accordance with Ref. ASR A350-A-51-77-11-00ZZZ-660Z-A.

(b) Remove as shown on Ref. Fig. Fastener Removal View B and View C.

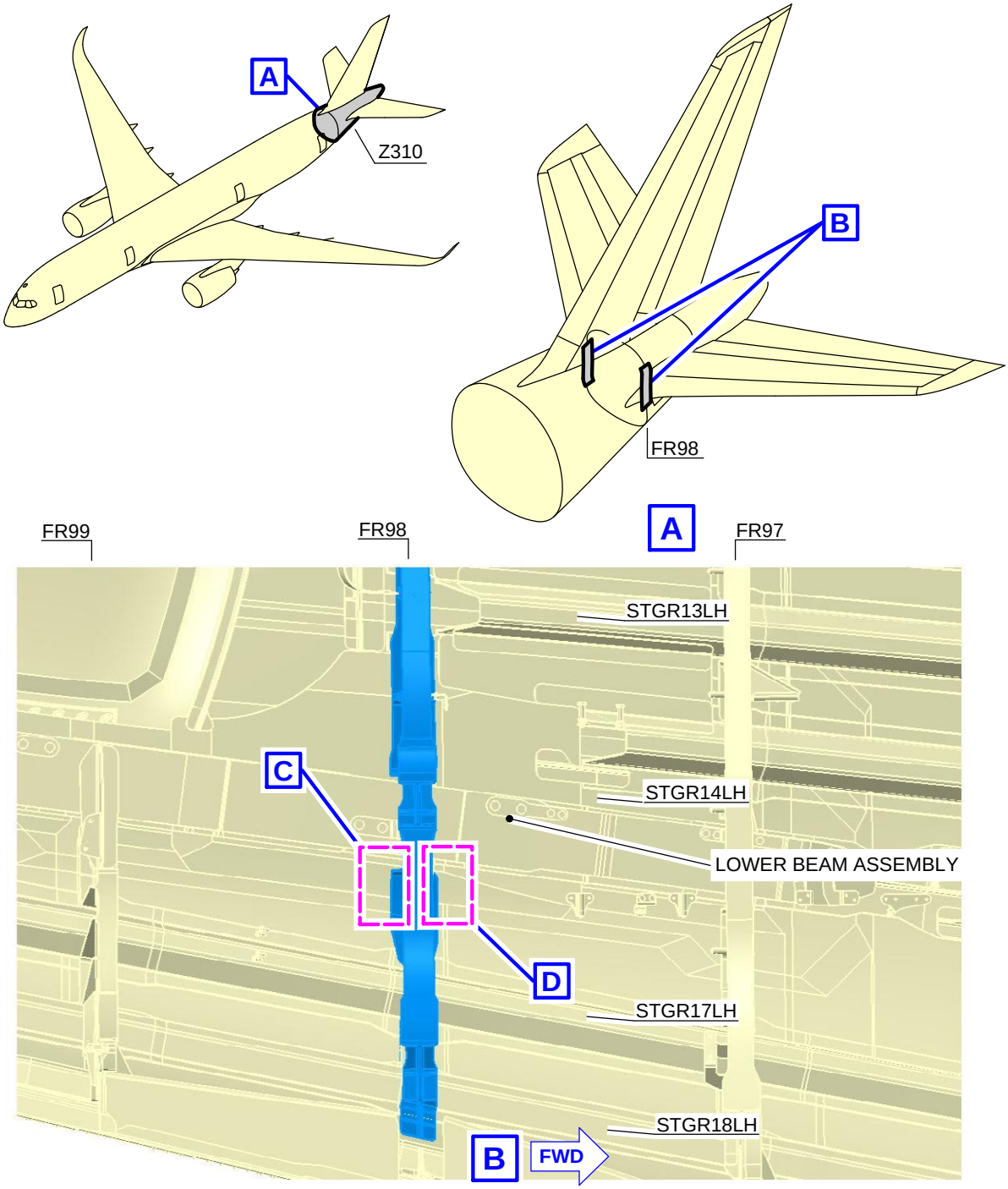
4 FASTENER Discard

(c) Clean the work area with:

Textile - Lint free Cotton 14SBA1
and

Non Aqueous Cleaner - General 08BAA9

CONF ALL



LH SHOWN
RH SYMMETRICAL
VIEW LOOKING OUTBD

ICN-A350-A-53XXP057-A-FAPE3-059EJ-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EJ-A-003-01 SHEET 1/2

CONF ALL

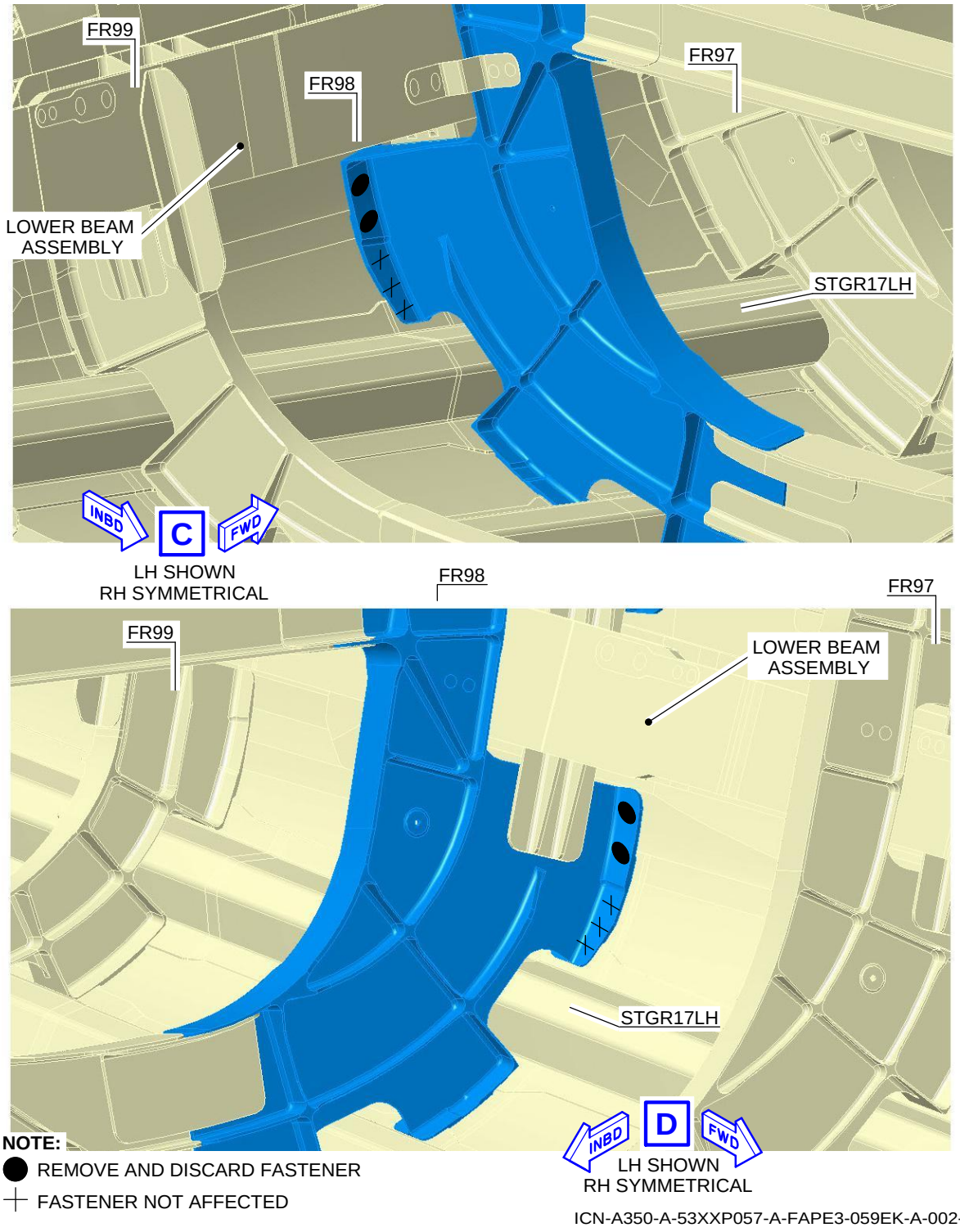


Figure ICN-A350-A-53XXP057-A-FAPE3-059EK-A-002-01 SHEET 2/2

(5) Task A350-A-53-XX-P057-02001-353A-A - Perform NDT on LH Fastener Holes and DET Inspection on Frame 97, Frame 98, and Frame 99

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	From Frame 97 to Frame 99 From Stringer 12 to Stringer 18

Manpower/Resources/Skills

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

Referenced Information

Manuals/Drawings	References/Sheets
NDT	A350-A-51-96-50-00ZZZ-353Z-A A350-A-51-99-10-00ZZZ-35AZ-A A350-A-53-5X-XX-0HZZZ-35AZ-A

Procedure

(a) Perform the NDT of the modification area, refer to Ref. Fig. Area Inspection.

1 Do a rotating probe test of the fastener holes, refer to Ref. NDT A350-A-51-96-50-00ZZZ-353Z-A and refer to Ref. Fig. Area Inspection Sheet 2, View C and View D.

2 Do an eddy current inspection of the surrounding flange in accordance with Ref. NDT A350-A-53-5X-XX-0HZZZ-35AZ-A and refer to Ref. Fig. Area Inspection Sheet 2, View C and View D.

3 Do a detailed inspection of the Frame 98, Frame 97, and Frame 99, refer to Ref. NDT A350-A-51-99-10-00ZZZ-35AZ-A and refer to Ref. Fig. Area Inspection Sheet 1, View B.

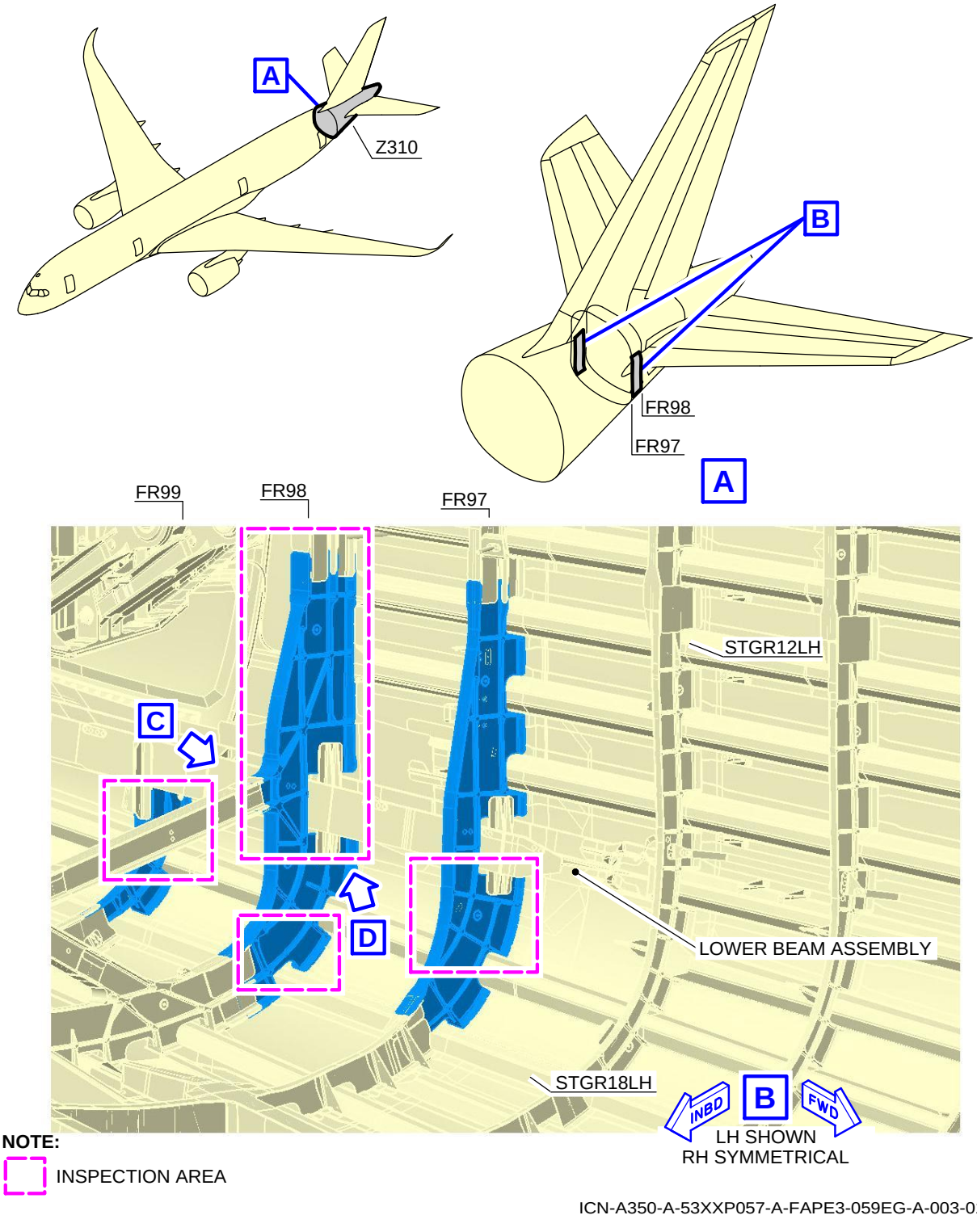
4 In case of findings:

a Contact AIRBUS for repair instructions.

5 In case of no findings:

a Continue to Ref. Task A350-A-53-XX-P057-02ZZZ-720Z-A.

CONF ALL



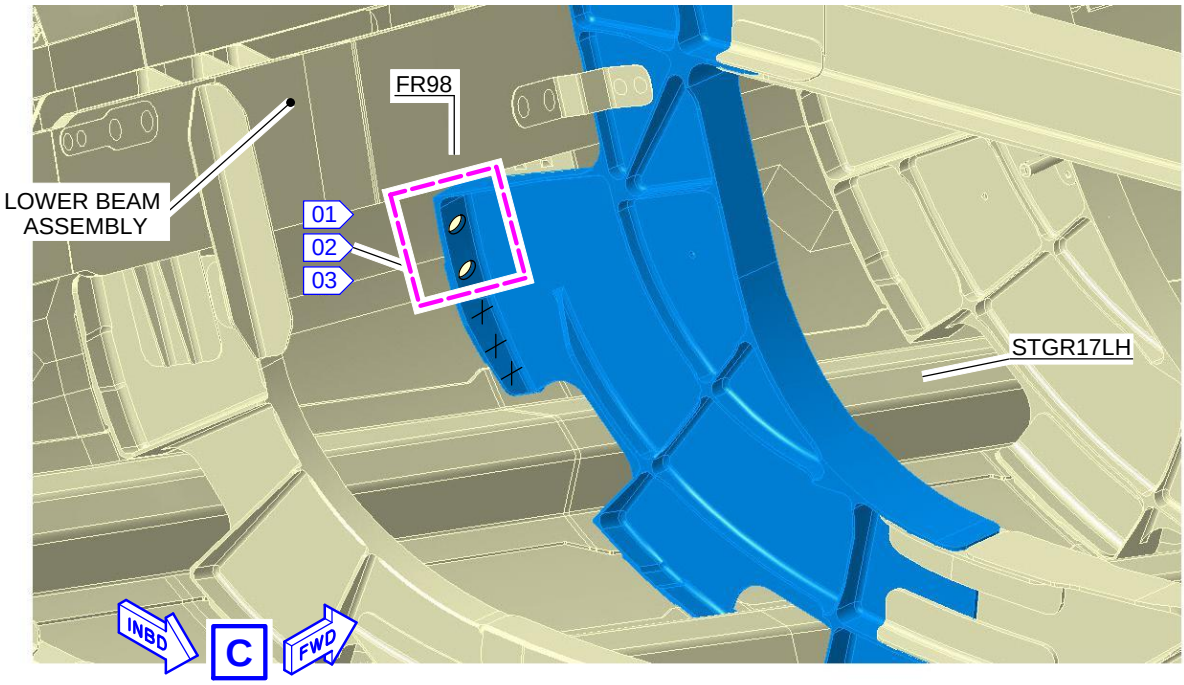
NOTE:

INSPECTION AREA

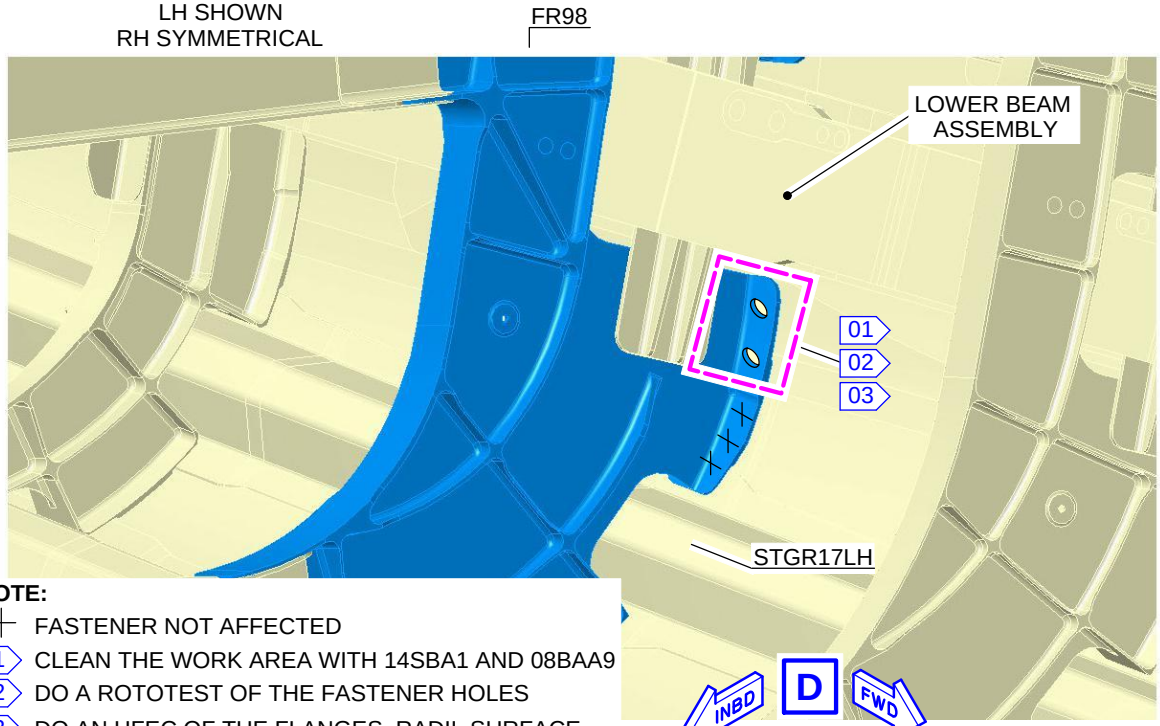
ICN-A350-A-53XXP057-A-FAPE3-059EG-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EG-A-003-01 SHEET 1/2

CONF ALL



LH SHOWN
RH SYMMETRICAL



LH SHOWN
RH SYMMETRICAL

NOTE:

- FASTENER NOT AFFECTED
- 01 CLEAN THE WORK AREA WITH 14SBA1 AND 08BAA9
- 02 DO A ROTOTEST OF THE FASTENER HOLES
- 03 DO AN HFEC OF THE FLANGES, RADII, SURFACE AROUND THE FASTENER HOLES, AND THE EDGE OF THE FORWARD FLANGE

ICN-A350-A-53XXP057-A-FAPE3-059EH-A-004-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EH-A-004-01 SHEET 2/2

(6) Task A350-A-53-XX-P057-02001-720A-A - Install the LH Fasteners

WARNING: YOU MUST PUT ON AND ATTACH A SAFETY HARNESS BEFORE YOU START WORK:
- IN THE NLG OR MLG BAYS
- ON THE THS OR IN THE REAR FUSELAGE
- ON TOP OF THE WINGS OR PYLONS.
WITHOUT A SAFETY HARNESS, YOU CAN FALL. THIS CAN KILL YOU OR CAUSE YOU INJURY.

Job Set-Up Information

Working Area

Impacted Zone	Access / Work Location	
300	Access	Door 311AB
	Work location	Frame 98 From Stringer 15 to Stringer 17

Manpower/Resources/Skills

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

Material necessary to do the job

Consumables

ITEM	REFERENCE CML	DESCRIPTION	DRAWING	SEE NOTES
	04DAB2	Primer Epoxy Paint - - Corrosion Inhibiting Structure		
	04JME4	Top Coat Polyurethane - - Grey InternalStructure		
	06AAC1	Polysulfide Sealant - General Purpose Interfay		
	08BAA9	Non Aqueous Cleaner - General		
	14SBA1	Textile - Lint free Cotton		

Part kit 53P057C01R01

ITEM	PART No.	QTY (UM)	KEYWORD	DRAWING	SEE NOTES
3	EN6114K6-10	2	BOLT		
4	ASNA2537-6	2	NUT		
5	EN6114K5-8	2	BOLT		
6	ASNA2537-5	2	NUT		

Referenced Information

Manuals/Drawings	References/Sheets
ASR	A350-A-20-51-50-01ZZZ-25BZ-A A350-A-51-24-XX-01ZZZ-667Z-A A350-A-51-42-21-01ZZZ-667Z-A

Manuals/Drawings	References/Sheets
	A350-A-51-43-XX-01ZZZ-667Z-A A350-A-51-75-12-00ZZZ-660Z-A A350-A-51-77-11-00ZZZ-660Z-A
CML	CONSUMABLE MATERIAL LIST (CML)

Procedure

(a) The Standard Practices given in this procedure are:

1 Remove and install fasteners in accordance with Ref. ASR A350-A-51-42-21-01ZZZ-667Z-A.

2 Apply sealant in accordance with Ref. ASR A350-A-51-24-XX-01ZZZ-667Z-A.

3 To torque tighten the standard threaded fasteners, refer to Ref. ASR A350-A-20-51-50-01ZZZ-25BZ-A.

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

5 If the length of any fastener specified in this Service Bulletin does not meet installation standards given in ASR Data Module 51-4, then a fastener of the same specification, or an approved substitute, with a length which meets the installation standards given in (ASR Data Module 51-4 or SRM Chapter 51) may be used. In addition, washers may be installed for fastener grip length in accordance with (ASR Data Module 51-4 or SRM Chapter 51).

6 Get alternative and substitute fastener data in accordance with Ref. ASR A350-A-51-43-XX-01ZZZ-667Z-A.

7 Get cleaning process in accordance with Ref. ASR A350-A-51-77-11-00ZZZ-660Z-A.

8 Repair the paint coating in accordance with Ref. ASR A350-A-51-75-12-00ZZZ-660Z-A.

(b) Clean the installation area with:

Textile - Lint free Cotton 14SBA1
made moist with:

Non Aqueous Cleaner - General 08BAA9

(c) Wet install the new fasteners, refer to Ref. Fig. Fastener Installation.

2	BOLT	EN6114K6-10	Item 3
2	NUT-HEXAGONAL,SELF-LOCKING,BALL,BIHEX,FUSE	ASNA2537-6	Item 4

with

Polysulfide Sealant - General Purpose Interfay 06AAC1

(d) Torque the fasteners between 17.4 Nm (154.00 lbf.in) and 21 Nm (185.86 lbf.in).

(e)

2	BOLT	EN6114K5-8	Item 5

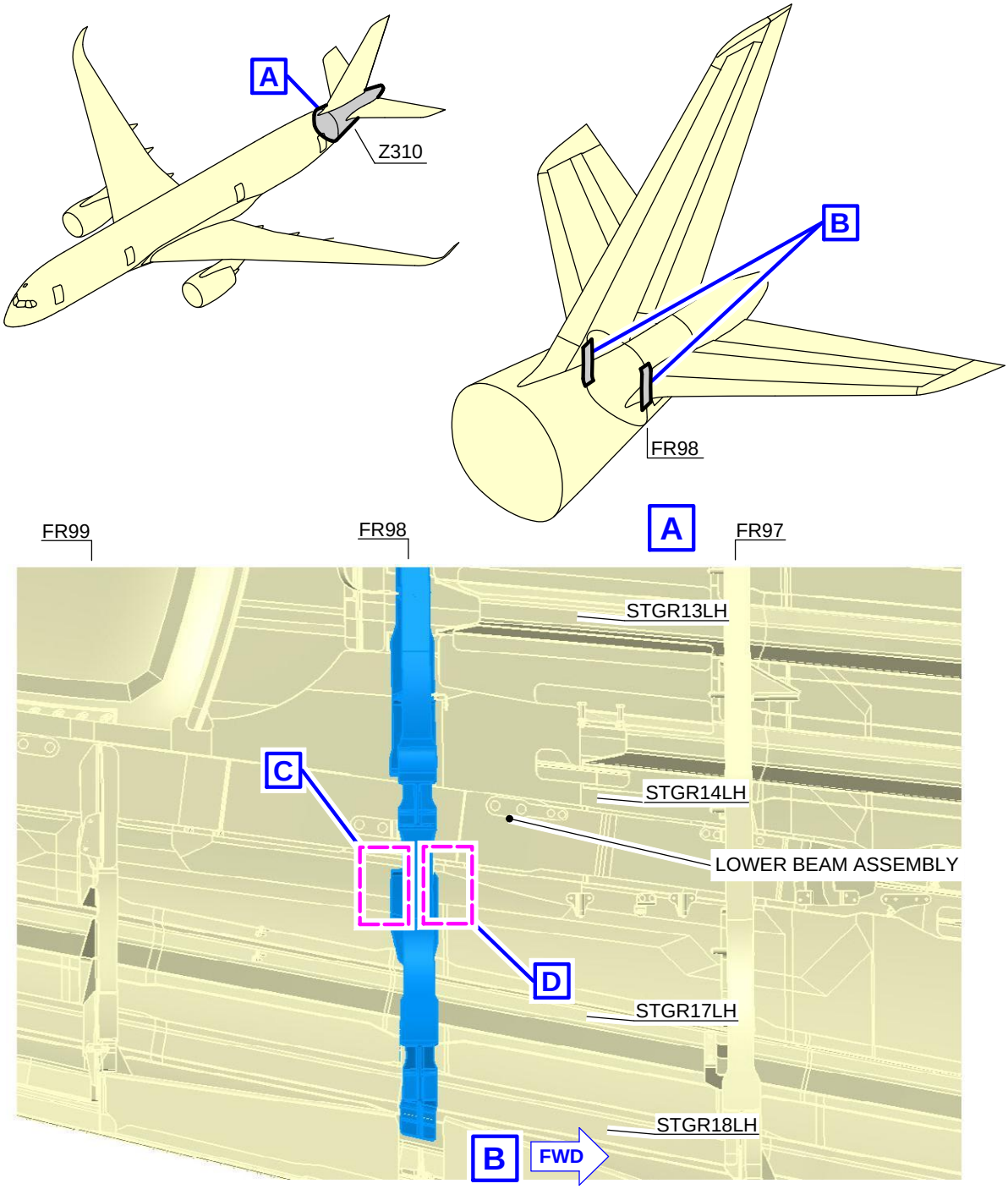
2	NUT-HEXAGONAL,SELF-LOCKING,BALL,BIHEX,FUSE	ASNA2537-5	Item 6
with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	

(f) Torque the fasteners between 10.0 Nm (88.50 lbf.in) and 13.1 Nm (115.94 lbf.in).

(g) Apply protection to the fasteners, use :

Primer Epoxy Paint - - Corrosion Inhibiting Structure	04DAB2
Top Coat Polyurethane - - Grey InternalStructure	04JME4

CONF ALL

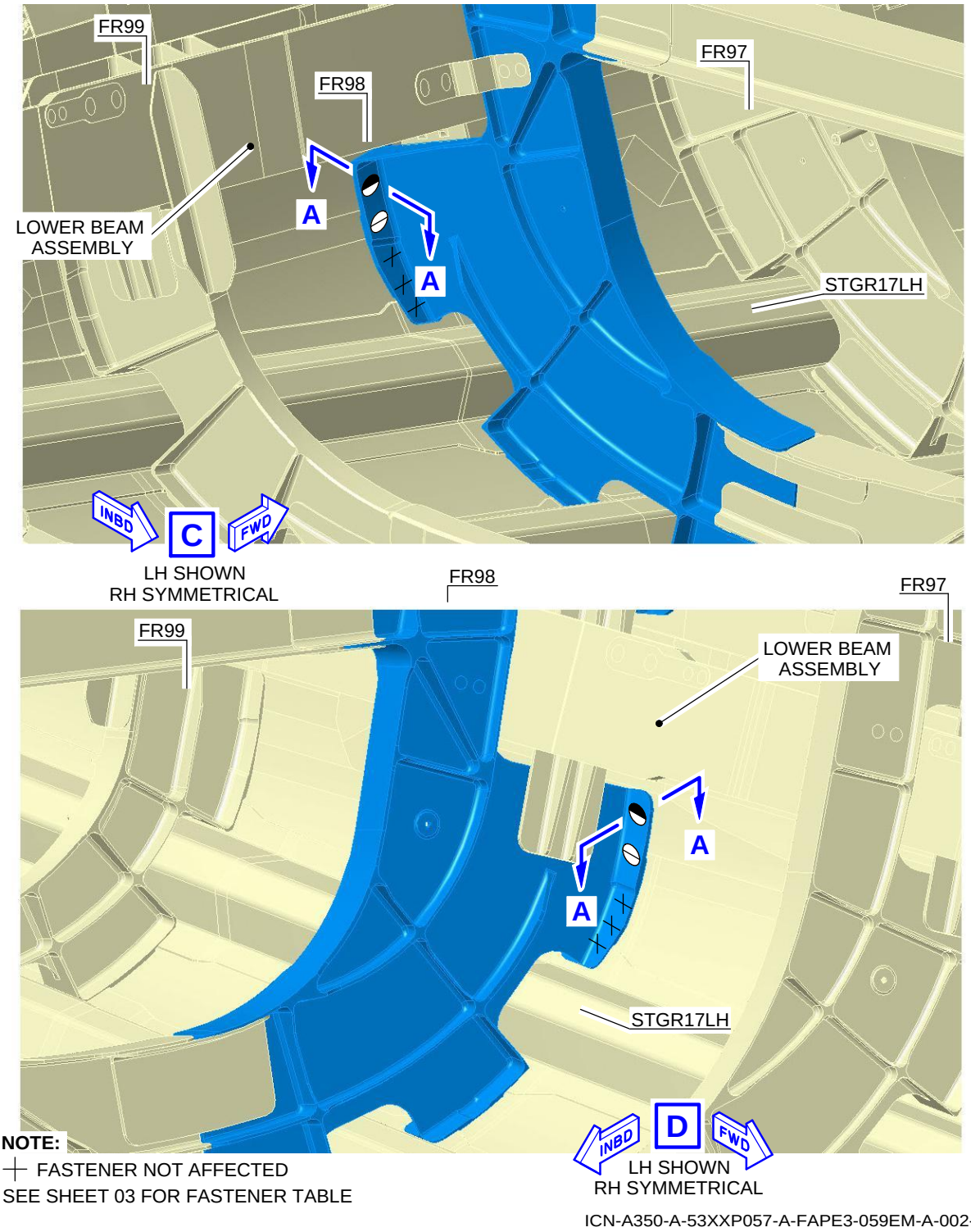


LH SHOWN
RH SYMMETRICAL
VIEW LOOKING OUTBD

ICN-A350-A-53XXP057-A-FAPE3-059EL-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EL-A-003-01 SHEET 1/3

CONF ALL



NOTE:

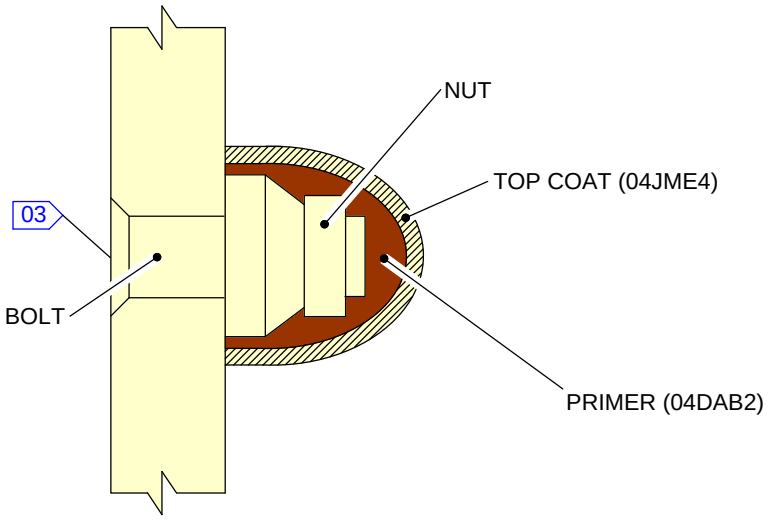
┼ FASTENER NOT AFFECTED

SEE SHEET 03 FOR FASTENER TABLE

ICN-A350-A-53XXP057-A-FAPE3-059EM-A-002-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EM-A-002-01 SHEET 2/3

CONF ALL



A-A
TYPICAL

HOLE SYMBOL	ITEM	PN	DESCRIPTION	FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTES
				MIN	MAX		
◓	3	EN6114K6-10	BOLT	9.514 mm (0.3746 in)	9.552 mm (0.3760 in)	LOW CLEARANCE	01 02
	4	ASNA2537-6	NUT				
⊖	5	EN6114K5-8	BOLT	7.927 mm (0.3121 in)	7.964 mm (0.3135 in)	LOW CLEARANCE	01 02
	6	ASNA2537-5	NUT				

NOTE:

01 WET INSTALL WITH MATERIAL No 06AAC1
02 SEE VIEW A-A FOR OVERCOATING SEALANT
03 TOUCH UP TOP COAT AS REQUIRED TO MATCH AIRCRAFT PAINT SCHEME

ICN-A350-A-53XXP057-A-FAPE3-059EN-A-003-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EN-A-003-01 SHEET 3/3

D. PREPARATION FOR TEST

None

E. TEST

None

F. CLOSE-UP

(1) Task A350-A-53-XX-P057-01001-740A-A - Close-up

Job Set-Up Information

Manpower/Resources/Skills

Man-hours	0.50 h
Minimum Number of person	1
Elapsed Time	0.50 h

Referenced Information

Manuals/Drawings	References/Sheets
MP	A350-A-29-11-58-01ZZZ-720Z-A A350-A-29-13-58-01ZZZ-720Z-A A350-A-36-12-61-06ZZZ-720Z-A

Procedure

(a) Put an access platform in position below access doors 311AB and 311BB.

(b) If required reconnect the Aft Green Temperature Control Valve, refer to Ref. MP A350-A-29-11-58-01ZZZ-720Z-A.

(c) If required reconnect the Aft Yellow Temperature Control Valve, refer to Ref. MP A350-A-29-13-58-01ZZZ-720Z-A.

(d) If removed reinstall the Bleed Air Duct, refer to Ref. MP A350-A-36-12-61-06ZZZ-720Z-A.

(e) Close the aft fuselage through access door 311AB.

NOTE: Be careful not to step on a closed access door.

(f) Remove the access platform(s).

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

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

G. ADMINISTRATIVE

(1) Task A350-A-53-XX-P057-01001-90AA-A - Admisitrative

Procedure

Confirm in the applicable aircraft records that you have completed all the work defined in this Service Bulletin task set as required.

APPENDIX

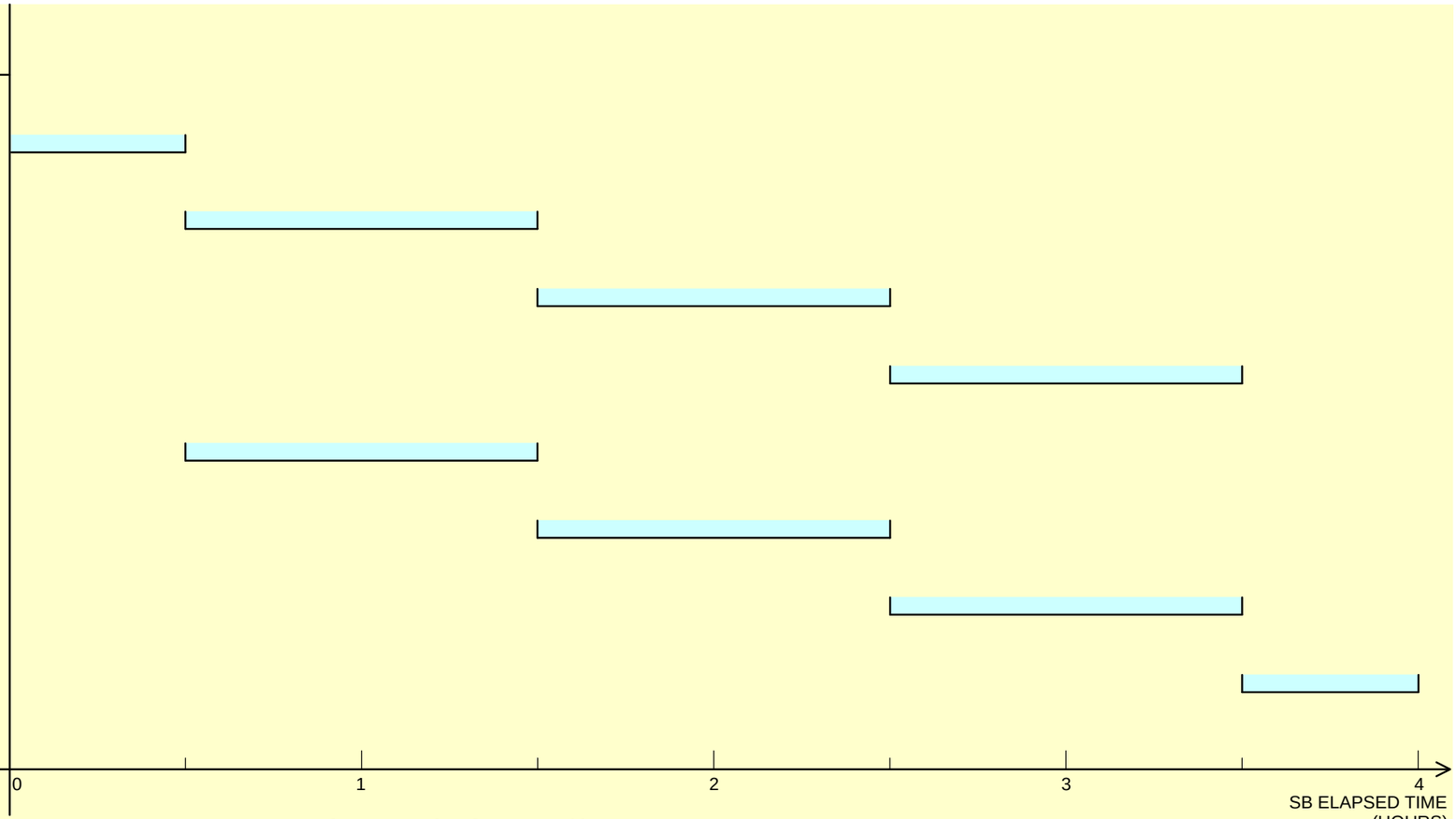
A. Manpower Gantt Chart

Manpower Gantt Chart

For an explanation of the man-hours and elapsed time, refer to the next page(s).

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A350-53-P057 01 02

STEPS	MH	PER	ET/S
GET ACCESS	0.50	1	0.50
REMOVE THE RH FASTENERS	1.00	1	1.00
PERFORM NDT ON RH FASTENER HOLES AND SURROUNDING AREA	1.00	1	1.00
INSTALL RH FASTENERS	1.00	1	1.00
REMOVE THE LH FASTENERS	1.00	1	1.00
PERFORM NDT ON LH FASTENER HOLES AND SURROUNDING AREA	1.00	1	1.00
INSTALL LH FASTENERS	1.00	1	1.00
CLOSE-UP	0.50	1	0.50



TOTAL MANHOURS 7.00
SB ELAPSED TIME 4.00

NOTE:

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

02 IF A VSB IS INVOLVED, THE ASSOCIATED MANHOURS ARE NOT REFLECTED IN THIS GANTT CHART.

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

ICN-A350-A-53XXP057-A-FAPE3-059EI-A-001-01

Figure ICN-A350-A-53XXP057-A-FAPE3-059EI-A-001-01 SHEET 1/1

Gantt Chart

B. REPORTING SHEET

TITLE:	FUSELAGE - CONE/REAR FUSELAGE - INSTALL SELF-ALIGNING NUTS AT FRAME 98 FEET BETWEEN STRINGER 15/17 (LH/RH)

MODIFICATION No.:	115286L83020

(1) SB Reporting status

This Service Bulletin will only be incorporated into affected customized Maintenance and Flight Operations Products if it is duly reported to Airbus.

(2) GENERAL information

The SB Reporting policy is published in ISI 00.00.00135. This document provides information regarding: the SB Reporting means and benefits, the update of customized Maintenance Products and customized Flight Operations Products.

If this Service Bulletin has an operational impact, refer to paragraph "Flight Operations Products" for further information on the update of affected Flight Operations Products.

(3) SB Reporting procedure

Standard practice to report SB is to use the online reporting application on AirbusWorld.

Refer to ISI 00.00.00179:

- For complete information on reporting means to Airbus, Question 2 "What are the standard practices for SB Reporting?"
- If this SB requires previous or simultaneous accomplishment of other SBs, Question 3 "What about the reporting of prerequisite Service Bulletins?"

NOTE: ISI 00.00.00179 covers all the frequently asked questions about SB Reporting. It is revised on a regular basis.

C. QUALITY PERCEPTION FORM

Use this form to tell us what is your perception of the quality of this Service Bulletin.

The reported data that you provide us will be used to analyse areas of difficulties and to take corrective action to further improve the quality of our Service Bulletin.

We thank you for the time you have taken in completing this form.

Quality rating of this SB	4	3	2	1
Quality rating of the Accomplishment Instructions	4	3	2	1
Quality rating of the Illustrations	4	3	2	1
Is this SB easy to understand ?	Y / N			

NOTE: Please rate on a scale of 1 to 4, with 4 being the highest score

If you have difficulties in the accomplishment of this SB please quote below the area(s) and give a short description of the issue.

	Planning		Material		Instructions
X	Applicability	X	Tooling	X	Preparation
X	Reason	X	List of Materials Operator Supplied	X	Mod/Inspection
X	Manpower	X	Kit content	X	Test
X	References	X	Re-identification	X	Close-up
X	Publication			X	Illustrations
X	Industry Support				

Comments :

Operator : Date :

Name/Title

Please return this form to :

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Or via your Resident Customer Support Office.