SERVICE BULLETIN
SUMMARY

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
FRANCE
Tel : (33) 5 61 93 33 33
Telex : AIRBU 530526F
Fax : (33) 5 61 93 42 51

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

ATA SYSTEM: 52

TITLE: DOORS - AFT CARGO COMPARTMENT DOOR - IMPROVE FATIGUE LIFE BY COLD WORK OF AFT CARGO DOOR FRAME STRUCTURE

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	205671D52123				
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

Following structure analysis, it has been confirmed that FWD Cargo Compartment Door areas require reinforcements before reaching the Design Service Goal (DSG).

The accomplishment of the Service Bulletin will introduce a fatigue improvement of the fastener holes in the cargo door frame structure by cold working and changing fastener type and size.

The accomplishment of this Service Bulletin containing fatigue improvement by cold working of frame fork fastener and frame structure holes and changing fasteners give operators the option to optimize their maintenance planning for implementation of the mandatory structural reinforcement Service Bulletin 52-3106 / 52-3112 by postponing the Structural Modification Point (SMP).

Pre Service Bulletin 52-3115 Structural Modification Point: 18500 FC

Post Service Bulletin 52-3115 Structural Modification Point: POE Cold working +18500 FC (POE = Point Of Embodiment)

The related structure modification Service Bulletin is Service Bulletin 52-3106 / 52-3112.

NOTE: Service Bulletin 52-3115 (cold working) does not constitute terminating action for inspection Service Bulletin 52-3095 (repetitive inspection).

This Service Bulletin is based on the aircraft configuration as known by AIRBUS (first aircraft delivery configuration and modified by the reported incorporation of AIRBUS Service Bulletins).

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Prior to Service Bulletin embodiment, specific attention must be paid to structural damage which may exist and to repairs which were performed on the aircraft because they may be affected by the Service Bulletin. It must be verified that all allowable damage limits and repairs performed (both in accordance with the SRM and outside of the SRM) are still applicable and effective to the new Service Bulletin configuration. There may be additional or modified maintenance requirements, such as temporary limits or additional inspections that apply with respect to the Service Bulletin configuration.

AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before embodiment of the Service Bulletin. If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

GENERAL EVALUATION

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

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

MATERIAL PRICE INFORMATION

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 523115D01R01	1	1,100.00	Nut, Bolt, Washer, Rivet, Label
Component COMPD01	1	See SB	
Standard tool TOOLD01	1	See SB	Expendable Tool, Durable Tool, Capital Tool
Standard tool TOOLD02	1	See SB	Expendable Tool, Durable Tool, Capital Tool

EFFECTIVITY

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

BEL CPA F2I GIA HDA HFY KAL MAS OHY RSY SAI THA TSC XAX

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

TFU	52.32.00.003
OEB	None

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

AOT	None
SIL	None
ISI	51.48.00001
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None
OTHER	None

NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO
HARD	NO
SOFT	NO
OBRM	NO

MANPOWER

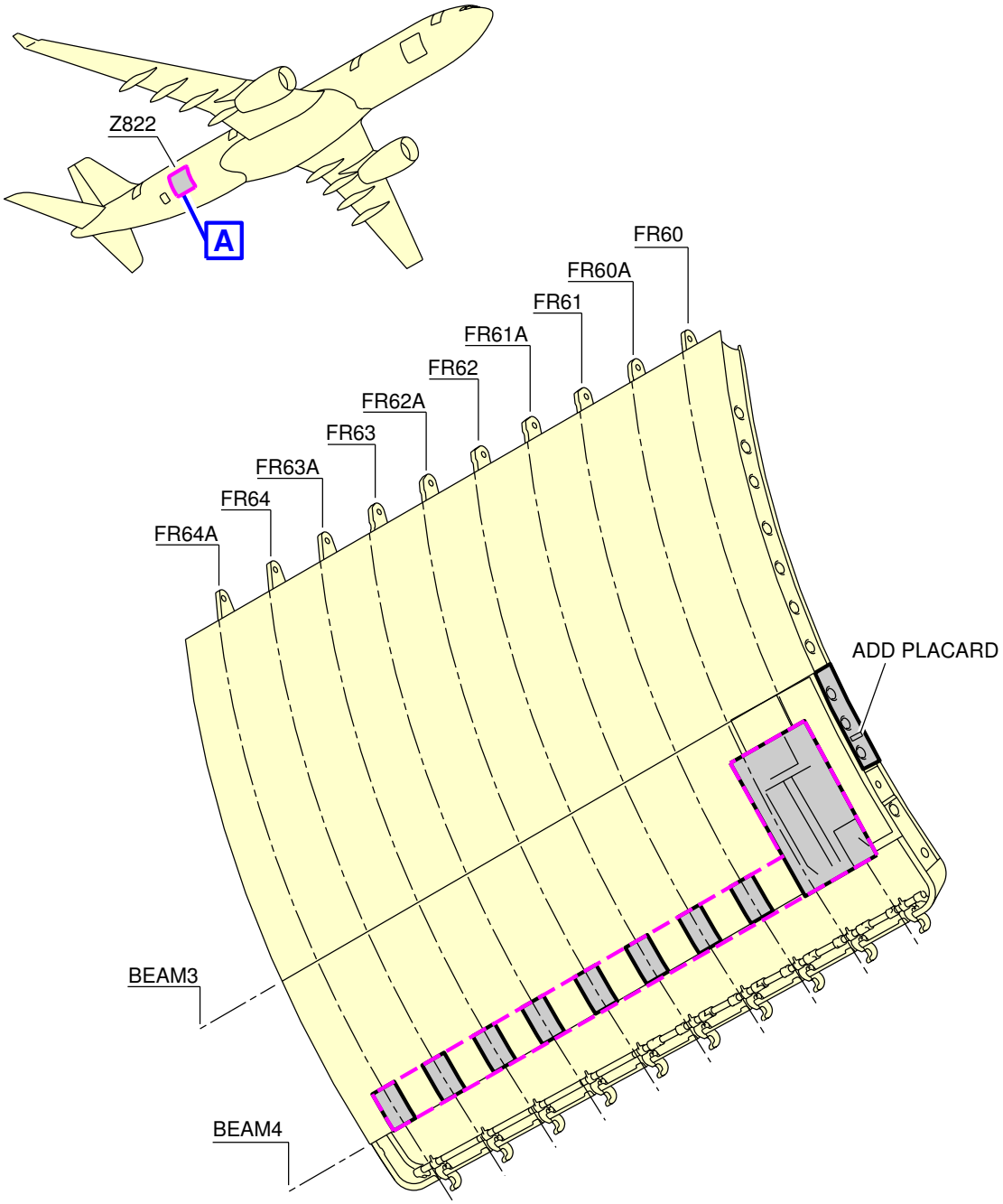
Task 523115-831-848-001: Modification	
TOTAL MANHOURS	168.00
ELAPSED TIME (HOURS)	168.0

APPENDICES

None

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

****CONF ALL**



NOTE:

AREA OF FASTENER REPLACEMENT

G_SB_523115_6_SAAA_01_01

Figure A-GSAAA - Sheet 01

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
FRANCE
Tel : (33) 5 61 93 33 33
Telex : AIRBU 530526F
Fax : (33) 5 61 93 42 51

ATA SYSTEM: 52

TITLE: DOORS - AFT CARGO COMPARTMENT DOOR - IMPROVE FATIGUE LIFE BY COLD WORK OF AFT CARGO DOOR FRAME STRUCTURE

MODIFICATION No.: 205671D52123

This document contains AIRBUS PROPRIETARY INFORMATION and shall at all times remain the property of AIRBUS; no intellectual property right or licence is granted by AIRBUS in connection with any information contained in it. It is delivered on the express condition that said document and the information contained in it shall be treated as confidential, shall not be used for any purpose other than that for which it is hereby delivered. It shall not be disclosed in whole or in part to third parties and shall not be duplicated in any manner (except for the purposes of performing the tasks described hereunder and provided that any recipient of such document shall comply with the conditions herein), without AIRBUS prior written consent.

1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This modification is applicable by Service Bulletin only.

(1) Models

330-301 330-321 330-322 330-341 330-342

(2) Effectivity by MSN

0012 0017 0030 0037 0045 0050 0054-0055 0060 0062 0064-0065 0070-0072 0082-0083 0086-0087 0095-0096 0098-0099 0102 0106 0109 0111-0113 0116 0118 0120-0122 0127 0132 0138 0140 0143-0144 0148 0153 0155 0162

(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.

OPERATOR	MSN
BEL	0030 0037 0045 0082 0095
CPA	0102 0113 0121
F2I	0087

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

OPERATOR	MSN
GIA	0138 0140 0144 0148 0153
HDA	0012 0017 0071 0083 0099 0106 0109 0118 0155
HFY	0096 0127
KAL	0162
MAS	0116
OHY	0072 0098 0143
RSY	0120
SAI	0055 0070 0086
THA	0050 0060 0062 0064 0065 0112 0122
TSC	0111 0132
XAX	0054

(4) Configuration by MSN

MSN	CONFIGURATION
0012 0017 0030 0037 0045 0050 0054 0055 0060 0062 0064 0065 0070 0071 0072 0082 0083 0086 0087 0095 0096 0098 0099 0102 0106 0109 0111 0112 0113 0116 0118 0120 0121 0122 0127 0132 0138 0140 0143 0144 0148 0153 0155 0162	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 523115D01R01	1	
Component COMPD01	1	
Consumable CMLD01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	

B. CONCURRENT REQUIREMENTS

None

C. REASON

(1) History

Following structure analysis, it has been confirmed that FWD Cargo Compartment Door areas require reinforcements before reaching the Design Service Goal (DSG).

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(2) Objective/Action

The accomplishment of the Service Bulletin will introduce a fatigue improvement of the fastener holes in the cargo door frame structure by cold working and changing fastener type and size.

(3) Advantages

The accomplishment of this Service Bulletin containing fatigue improvement by cold working of frame fork fastener and frame structure holes and changing fasteners give operators the option to optimize their maintenance planning for implementation of the mandatory structural reinforcement Service Bulletin 52-3106 / 52-3112 by postponing the Structural Modification Point (SMP).

Pre Service Bulletin 52-3115 Structural Modification Point: 18500 FC

Post Service Bulletin 52-3115 Structural Modification Point: POE Cold working +18500 FC (POE = Point Of Embodiment)

The related structure modification Service Bulletin is Service Bulletin 52-3106 / 52-3112.

NOTE: Service Bulletin 52-3115 (cold working) does not constitute terminating action for inspection Service Bulletin 52-3095 (repetitive inspection).

(4) Operational/Maintenance Consequences

This Service Bulletin is based on the aircraft configuration as known by AIRBUS (first aircraft delivery configuration and modified by the reported incorporation of AIRBUS Service Bulletins).

Prior to Service Bulletin embodiment, specific attention must be paid to structural damage which may exist and to repairs which were performed on the aircraft because they may be affected by the Service Bulletin. It must be verified that all allowable damage limits and repairs performed (both in accordance with the SRM and outside of the SRM) are still applicable and effective to the new Service Bulletin configuration. There may be additional or modified maintenance requirements, such as temporary limits or additional inspections that apply with respect to the Service Bulletin configuration.

AIRBUS disclaims any liability for the effect which the Service Bulletin may have on repairs performed on the aircraft before embodiment of the Service Bulletin. If the post Service Bulletin repair status is not covered by the SRM and for repairs outside of the SRM covered by an RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support department should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

D. DESCRIPTION

To accomplish this Service Bulletin it is necessary to :

Task 523115-831-848-001: Modification

(1) Remove Items for Access

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(2) Replace the Frame Fork Fasteners at Beam 4 FR64A

(3) Replace the Frame Fork Fasteners at Beam 4 FR64

(4) Replace the Frame Fork Fasteners at Beam 4 FR63A

(5) Replace the Frame Fork Fasteners at Beam 4 FR63

(6) Replace the Frame Fork Fasteners at Beam 4 FR62A

(7) Replace the Frame Fork Fasteners at Beam 4 FR62

(8) Replace the Frame Fork Fasteners at Beam 4 FR61A

(9) Replace the Frame Fork Fasteners at Beam 4 FR61

(10) Replace the Frame Fork Fasteners at Beam 4 FR60A

(11) Remove the Handle Brackets

(12) Replace the Joint Angle Fasteners at Mid Part FR60

(13) Install the Handle Brackets

(14) Replace the Fasteners Between Beam 3A and Beam 4 at FR60

(15) Install the Placard

(16) Install Items Removed for Access

E. COMPLIANCE

(1) Classification

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

(2) Accomplishment Timescale

Accomplishment of this Service Bulletin is recommended in the embodiment window of 14500 FC and 18500 FC.

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.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

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 523115-831-848-001: Modification	
Get Access	0.50
On Aircraft	
Replace the Frame Fork Fasteners at Beam 4 FR64A	10.00
Replace the Frame Fork Fasteners at Beam 4 FR64	10.00
Replace the Frame Fork Fasteners at Beam 4 FR63A	10.00
Replace the Frame Fork Fasteners at Beam 4 FR63	10.00
Replace the Frame Fork Fasteners at Beam 4 FR62A	10.00
Replace the Frame Fork Fasteners at Beam 4 FR62	10.00
Replace the Frame Fork Fasteners at Beam 4 FR61A	10.00
Replace the Frame Fork Fasteners at Beam 4 FR61	10.00
Replace the Frame Fork Fasteners at Beam 4 FR60A	10.00
Remove the Handle Brackets	9.00
Replace the Joint Angle Fasteners at Mid Part FR60	4.50
Install the Handle Brackets	13.50
Replace the Fasteners Between Beam 3A and Beam 4 at FR60	27.50
Install the Placard	0.50
On Bench	
Remove Items for Access	8.00
Install Items Removed for Access	12.00
Tests	2.00
Close-Up	0.50
TOTAL MANHOURS	168.00
ELAPSED TIME (HOURS)	168.0

H. WEIGHT AND BALANCE

Not Changed

I. ELECTRICAL LOAD DATA

Not Changed

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

J. REFERENCES

Aircraft Maintenance Manual (AMM)	06-20-00 11-00-00 20-21-11 52-32-15 52-71-21	06-31-53 12-34-24 52-30-00 52-32-21	06-41-53 20-16-00 52-32-11 52-71-13
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-33-00 20-55-00	20-52-10	20-54-50
In Service Information (ISI)	ISI 51.48.00001		
Non Destructive Test Manual (NTM)	51-10-01	51-62-02	
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-23-12 51-42-11 51-44-11 51-48-00	51-24-00 51-43-00 51-46-11 51-49-00	51-42-00 51-44-00 51-47-00 51-75-12

K. PUBLICATION AFFECTED

None

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

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 523115D01R01	AIRBUS Material, Logistics and Suppliers ATP II B, Hein-Sass-Weg 24 21129 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by E-mail: airbus.kit@airbus.com Telephone Hotlines: A350/A380: +49 40 743 51775 A330/340, A300/310: +49 40 743 51616 A318/319/320/321: +49 40 743 51660

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:

Component COMPD01	AIRBUS Material, Logistics and Suppliers IFD - In Flight Desk Weg beim Jaeger 150 D-22335 HAMBURG GERMANY For ordering by internet: http://spares.airbus.com For ordering by fax: +49 40 50 76 4012 For ordering by E-mail: ifd.spares@airbus.com

(2) Price and Availability

Kit 523115D01R01	
Cost	1,100.00 USD
Availability	180 calendar days from receipt of order

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

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Component COMPD01

Operator supplied AIRBUS parts required to accomplish this Service Bulletin are to be purchased by a spares purchase order.

B. INDUSTRY SUPPORT INFORMATION

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

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

For the organisation of this retrofit, you are kindly requested to contact AIRBUS retrofit management department.

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX
France
Tel: (33) 5 67 19 06 22
E-mail: monitored.retrofit@airbus.com
Fax: (33) 5 61 93 27 45

C. LIST OF COMPONENTS

Kit 523115D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
700	NAS1149D0332K	70	WASHER				(1)
832	ASNA2657K3-4	40	BOLT				(2)
833	ASNA2657K3-5	31	BOLT				(2)
834	ASNA2657K3-6	43	BOLT				(2)
835	ASNA2657K3-7	10	BOLT				(2)
904	NAS1097KE5-9	2	RIVET				
920	LN9198-4017CF	49	RIVET				
973	EN6080KE5-08	2	RIVET				
980	LN9198-4814CF	10	RIVET				
991	ASNA2536-3	7	NUT				
993	ASNA2538-3	117	NUT				

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.

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

(2) Components

Component COMPD01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
660	F5237211205000	1	PLACARD				

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

None

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the FTI tool kits should contact:

Standard tool TOOLD01	Fatigue Technology Inc. 401 Andover Park East Seattle, Washington 98188-7605 USA Internet: www.fatiguetech.com Phone: (206) 2462010 Fax: (206) 2449886

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Operators interested in obtaining the WCI tool kits should contact:

Standard tool TOOLD02	West Coast Industries Inc. 14900 Whitman Ave. N Seattle, Washington 98133 Phone: (206) 365-7513 Fax: (206) 365-7483 Email: info@coldwork.com Europe, Middle-East, Africa, India and Russia: Tel.: +33 5 61 92 04 91 (France) Email: customer@capaero.com

(b) Price and Availability

Standard tool TOOLD01

Procurement to be negotiated directly with Fatigue Technology Inc. (FTI).

Standard tool TOOLD02

Procurement to be negotiated directly with West Coast Industries Inc. (WCI).

(2) Tools

NOTE: To accomplish this Service Bulletin it will be necessary to use the tools and equipment listed in the subsequent referenced tasks:

- refer to AMM Task 52-32-11-820-803
- refer to NTM Task 51-10-01-250-801

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

(3) Special Tools

None

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

This Page Intentionally Left Blank

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

3. ACCOMPLISHMENT INSTRUCTIONS

Task 523115-831-848-001 - Modification

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

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

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

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

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

NOTE: The accomplishment instructions of this Service Bulletin 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: Discarded parts must be managed at the operator's discretion.

Task Associated Data

Zone	
822	
Access	
Panel	822AR 822BR 822CR 822DR
Manpower	
TOTAL MANHOURS	168.00
ELAPSED TIME (HOURS)	168.0

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

A. GENERAL

(1) Subtask 523115-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53 11-00-00, Page Block 201 Task 20-16-00-912-801 Task 20-21-11-911-801
Consumable Material List (CML)	
Elec. Std. Practices Manual (ESPM)	20-33-00 20-52-10 20-54-50
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-42-11 51-43-00 51-44-11 51-46-11 51-47-00 51-48-00 51-49-00 51-75-12

(a) Tag all the parts you must remove and retain to make the subsequent installation easier.

(b) Put all the retained hardware in identified plastic bags and attach the bags to the related unit.

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

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

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

(f) For the identification of access panels, refer to AMM 06-41-53.

(g) For the protection of the connectors, contacts and terminals, refer to ESPM 20-54-50.

(h) For circuit breaker safety practices, refer to AMM Task 20-16-00-912-801.

(i) Remove and install fasteners in accordance with SRM 51-42-11.

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

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

(l) Torque and tighten Hi-Lite and Hi-lok fasteners in accordance with SRM 51-49-00

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

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

(o) If necessary, cut the solid rivets to the correct length in accordance with SRM 51-42-00.

(p) Check all edges distances before drilling in accordance with SRM 51-47-00.

(q) Obtain countersinking data in accordance with SRM 51-46-11.

(r) Do the cold expansion of fastener holes in accordance with SRM 51-48-00.

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

(t) Apply special coatings in accordance with SRM 51-23-12.

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

(v) In case of special paint build up, the removal and installation procedure of this special paint build up has to be taken into account.

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

(x) For the general installation of electrical wire harnesses, refer to ESPM 20-33-00.

(y) Do a check of the electrical connectors before you connect them, refer to ESPM 20-52-10.

(z) For the installation of placards, refer to AMM 11-00-00, Page Block 201.

(2) Subtask 523115-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

B. PREPARATION

(1) Subtask 523115-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 12-34-24-860-802

NOTE: The items given in this note shall be considered as the basic Aircraft configuration before you start a maintenance task:

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

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

(b) Put an access platform in position at Door 822

C. PROCEDURE

(1) Subtask 523115-010-201-001 - Remove Items for Access

Work Zones and Access Panels		
	Zone	Access/Work location
	822	

Manpower Resources	
Manhours	8.00
Minimum number of person	1
Subtask elapsed time	8.00
Skills	AIRFRAME

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Aircraft Maintenance Manual (AMM)	Task 52-30-00-010-805 Task 52-32-15-000-801 Task 52-32-21-000-801 Task 52-32-21-000-802 Task 52-32-21-000-803 Task 52-32-21-000-804 Task 52-32-21-000-805 Task 52-32-21-000-806 Task 52-32-21-000-807 Task 52-71-13-000-801 Task 52-71-21-000-802

(a) Remove the access panels 822AR, 822BR, 822CR, 822DR, from the Aft Cargo Compartment Door, refer to AMM Task 52-30-00-010-805.

(b) Remove the protection linings, refer to AMM Task 52-32-15-000-801.

(c) Remove the indicator light, refer to AMM Task 52-71-21-000-802.

(d) Remove the proximity sensor, refer to AMM Task 52-71-13-000-801.

(e) Remove the locking handle, refer to AMM Task 52-32-21-000-801.

(f) Remove the locking shaft, refer to AMM Task 52-32-21-000-802.

(g) Remove the latching handle, refer to AMM Task 52-32-21-000-803.

(h) Remove the latching shaft, refer to AMM Task 52-32-21-000-804.

(i) Remove the interlock mechanism, refer to AMM Task 52-32-21-000-805.

(j) Remove the target mechanism, refer to AMM Task 52-32-21-000-806.

(k) Remove the switch assembly, refer to AMM Task 52-32-21-000-807.

(2) Subtask 523115-831-222-001 - Replace the Frame Fork Fasteners at Beam 4 FR64A

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 64A

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K	70	WASHER	(1)
832	ASNA2657K3-4	2	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
834	ASNA2657K3-6	6	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-42-11 51-44-00 51-46-11 51-48-00 51-75-12

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 05, View K:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 05, View K.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 05, View L:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install in accordance with SRM 51-42-11, refer to Fig. A-GBAAA Sheet 05, View L:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
2	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
6	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(3) Subtask 523115-831-212-001 - Replace the Frame Fork Fasteners at Beam 4 FR64

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 64

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	2	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
834	ASNA2657K3-6	6	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 05, View K:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 05, View K.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 05, View L:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 05, View L:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
2	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
6	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(4) Subtask 523115-831-213-001 - Replace the Frame Fork Fasteners at Beam 4 FR63A

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 63A

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	4	BOLT	(2)
834	ASNA2657K3-6	6	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 04, View D:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 04, View D.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 04, View E:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 04, View E:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
6	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(5) Subtask 523115-831-214-001 - Replace the Frame Fork Fasteners at Beam 4 FR63

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 63

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	4	BOLT	(2)
833	ASNA2657K3-5	1	BOLT	(2)
834	ASNA2657K3-6	5	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 05, View H:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 05, View H.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

NOTE: In case the existing hole diameter is more than or equal to the

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

minimum starting hole diameter, please contact AIRBUS for further instructions before next flight.

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 05, View J:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 05, View J:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
1	Bolt	ASNA2657K3-5	Item 833
5	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

with:

Polysulfide Sealant- General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(6) Subtask 523115-831-215-001 - Replace the Frame Fork Fasteners at Beam 4 FR62A

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 62A

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	4	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
834	ASNA2657K3-6	4	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 04, View F:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 04, View F.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 04, View G:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 04, View G:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
4	Bolt	ASNA2657K3-6	Item 834

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

10	Nut	ASNA2538-3	Item 993
	with:		
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(7) Subtask 523115-831-216-001 - Replace the Frame Fork Fasteners at Beam 4 FR62

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 62

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	4	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
834	ASNA2657K3-6	4	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 04, View F:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 04, View F.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 04, View G:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 04, View G:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
4	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993
	with:		
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(8) Subtask 523115-831-217-001 - Replace the Frame Fork Fasteners at Beam 4 FR61A

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 61A

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
832	ASNA2657K3-4	4	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
834	ASNA2657K3-6	4	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 04, View F:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 04, View F.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 04, View G:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(j) Install, refer to Fig. A-GBAAA Sheet 04, View G:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
4	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(9) Subtask 523115-831-218-001 - Replace the Frame Fork Fasteners at Beam 4 FR61

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 61

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	4	BOLT	(2)
834	ASNA2657K3-6	6	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 04, View D:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 04, View D.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 04, View E:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 04, View E:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
4	Bolt	ASNA2657K3-4	Item 832
6	Bolt	ASNA2657K3-6	Item 834
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(10) Subtask 523115-831-219-001 - Replace the Frame Fork Fasteners at Beam 4 FR60A

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 60A

Manpower Resources	
Manhours	10.00
Minimum number of person	1
Subtask elapsed time	10.00
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	2	BOLT	(2)
833	ASNA2657K3-5	2	BOLT	(2)
835	ASNA2657K3-7	6	BOLT	(2)
993	ASNA2538-3	10	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 02, View B:

10	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 02, View B.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 03, View C:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(j) Install, refer to Fig. A-GBAAA Sheet 03, View C:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
2	Bolt	ASNA2657K3-4	Item 832
2	Bolt	ASNA2657K3-5	Item 833
6	Bolt	ASNA2657K3-7	Item 835
10	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(11) Subtask 523115-020-201-001 - Remove the Handle Brackets

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	from Frame 60 to Frame 60A

Manpower Resources	
Manhours	9.00
Minimum number of person	1
Subtask elapsed time	9.00
Skills	AIRFRAME

References	
Non Destructive Test Manual (NTM)	51-62-02
Fig. A-GBBAA Removal and Installation of Handle Brackets	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Remove from the inner skin, refer to Fig. A-GBBAA Sheet 04, View E:

34	Fastener	Item (1)	Discard

(b) Remove from the handle brackets, refer to Fig. A-GBBAA Sheet 02, View C, Fig. A-GBBAA Sheet 05, Section A-A, Fig. A-GBBAA Sheet 06, Section C-C and Fig. A-GBBAA Sheet 07, Section E-E:

20	Fastener	Item (1)	Discard

(c) Remove from the Cargo Door, refer to Fig. A-GBBAA Sheet 02, View C:

2	Retaining Ring	Item (2)	Retain
1	Tube	Item (3)	Retain
1	Bracket Assy	Item (4)	Retain
1	Bracket Assy	Item (5)	Retain

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(d) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener hole in accordance with NTM 51-62-02 and refer to Fig. A-GBBAA Sheet 05, Section A-A.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(12) Subtask 523115-831-221-001 - Replace the Joint Angle Fasteners at Mid Part FR60

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 60

Manpower Resources	
Manhours	4.50
Minimum number of person	1
Subtask elapsed time	4.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
980	LN9198-4814CF	9	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

References	
Structural Repair Manual (SRM)	51-44-00 51-48-00 51-75-12
Fig. A-GBCAA Replacement of Joint Angle Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) Remove, refer to Fig. A-GBCAA Sheet 03, Section A-A:

9	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBCAA Sheet 03, Section A-A.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 04.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBCAA Sheet 03, Section B-B:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBCAA Sheet 04.

(g) Deburr all holes in accordance with SRM 51-44-00.

(h) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(i) Install, refer to Fig. A-GBCAA Sheet 03, Section B-B:

9	Rivet	LN9198-4814CF	Item 980

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(j) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(13) Subtask 523115-420-201-001 - Install the Handle Brackets

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	from Frame 60 to Frame 60A

Manpower Resources	
Manhours	13.50
Minimum number of person	1
Subtask elapsed time	13.50
Skills	AIRFRAME

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Material necessary to do the job

Kit 523115D01R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
904	NAS1097KE5-9	2	RIVET	
920	LN9198-4017CF	49	RIVET	
973	EN6080KE5-08	2	RIVET	
980	LN9198-4814CF	1	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Structural Repair Manual (SRM)	51-44-00 51-48-00 51-75-12
Fig. A-GBBAA Removal and Installation of Handle Brackets	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(b) Drill the hole to the starting hole diameter, refer to Fig. A-GBBAA Sheet 07.

NOTE: In case the existing hole diameter is more than or equal to the minimum starting hole diameter, please contact AIRBUS for further

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

instructions before next flight.

(c) Do the cold expansion of the fastener hole in accordance with the SRM 51-48-00 and refer to Fig. A-GBBAA Sheet 05, Section B-B:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(d) Drill the hole to the final hole diameter, refer to Fig. A-GBBAA Sheet 07.

(e) Deburr the hole in accordance with SRM 51-44-00.

(f) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

(g) Install in the Cargo Door, refer to Fig. A-GBBAA Sheet 03, View D:

2	Retaining Ring		Item (2)	Retained at removal
1	Tube		Item (3)	Retained at removal
1	Bracket Assy		Item (4)	Retained at removal
1	Bracket Assy		Item (5)	Retained at removal
1	Rivet	LN9198-4814CF	Item 980	
15	Rivet	LN9198-4017CF	Item 920	

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

2	Rivet	NAS1097KE5-9	Item 904
2	Rivet	EN6080KE5-08	Item 973
	with:		
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(h) Install on the inner skin, refer to Fig. A-GBBAA Sheet 04, View F:

34	Rivet	LN9198-4017CF	Item 920

(i) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(14) Subtask 523115-831-220-001 - Replace the Fasteners Between Beam 3A and Beam 4 at FR60

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Access	Panel 822AR, Panel 822BR, Panel 822CR, Panel 822DR
		Work location	Frame 60

Manpower Resources	
Manhours	27.50
Minimum number of person	1
Subtask elapsed time	27.50
Skills	AIRFRAME NON DESTRUCTIVE TESTING

Material necessary to do the job

Kit 523115D01R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
700	NAS1149D0332K		WASHER	(1)
832	ASNA2657K3-4	10	BOLT	(2)
833	ASNA2657K3-5	18	BOLT	(2)

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
834	ASNA2657K3-6	2	BOLT	(2)
835	ASNA2657K3-7	4	BOLT	(2)
991	ASNA2536-3	7	NUT	
993	ASNA2538-3	27	NUT	

NOTE (1): A quantity of 70 of this washer is contained in the kit. Use only as necessary to compensate the grip length of the bolt ASNA2657K.

NOTE (2): Refer to the table below for alternate fasteners without any restrictions.

Part Number	Alternative Fasteners			
ASNA2657K*-*	HST11AG*-*	HST11KM*-*	HST11AP*-*	HST11AZ*-*

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - Decorative External Struc	04JMD3	As required	
	Polysulfide Sealant-General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner-General	08BAA9	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	FTIA330523115-1	Capital Tooling	1	(3)

NOTE: FTI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from FTI.

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330523115-1	Durable Tooling	1	(1)
	EKA330523115-1	Expendable Tooling	1	(2)
	WCIA330523115-1	Capital Tooling	1	(3)

NOTE: WCI has allocated the above tool kit numbers for cold expansion. For the definition of capital, durable and expendable tools, refer to ISI 51.48.00001.

NOTE (1): The durable tool kit contains the minimum quantity of durable tools necessary to accomplish the Service Bulletin on one aircraft. If the Service Bulletin is to be accomplished on more than one aircraft, the number of durable kits required can be established by reference to ISI 51.48.00001.

NOTE (2): The expendable tool kit contains the quantity of expendable tools required to accomplish the Service Bulletin on one aircraft. Order one expendable tool kit for every aircraft on which this Service Bulletin is to be accomplished.

NOTE (3): The capital tools provided in this kit are not specific to this Service Bulletin and are normally already available in operators' stock as a long-term investment or can be loaned from WCI.

References	
Non Destructive Test Manual (NTM)	51-62-02
Structural Repair Manual (SRM)	51-44-00 51-46-11 51-48-00 51-75-12
Fig. A-GBAAA Replacement of Frame Fork Fasteners	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06

(a) Remove, refer to Fig. A-GBAAA Sheet 02, View B:

34	Fastener	Item (1)	Discard

(b) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Textile-Lint Free Cotton	14SBA1	As required

and, if necessary, a non metallic scraper.

(c) Do a Special Detailed Inspection (SDI), High Frequency Eddy Current Roto Test method, of the fastener holes in accordance with NTM 51-62-02 and refer to Fig. A-GBAAA Sheet 02, View B.

1 If cracks are detected, contact AIRBUS.

2 If no cracks are detected, continue with the next work-step.

(d) Drill the holes to the starting hole diameter, refer to Fig. A-GBAAA Sheet 06.

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

(e) Do the cold expansion of the fastener holes in accordance with the SRM 51-48-00 and refer to Fig. A-GBAAA Sheet 03, View C:

Refer to FTI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
FTIA330523115-1	Capital Tooling	1

or

Refer to WCI tools No.:

EKA330523115-1	Expendable Tooling	1
DKA330523115-1	Durable Tooling	1
WCIA330523115-1	Capital Tooling	1

(f) Drill the holes to the final hole diameter, refer to Fig. A-GBAAA Sheet 06.

(g) Countersink holes in accordance with SRM 51-46-11.

(h) Deburr all holes in accordance with SRM 51-44-00.

(i) Clean the contact surfaces with:

Non Aqueous Cleaner-General	08BAA9	As required
Textile-Lint Free Cotton	14SBA1	As required

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(j) Install, refer to Fig. A-GBAAA Sheet 03, View C:

NOTE: If necessary install the washer, Item 700, with bolt ASNA2657K, in order to achieve the correct grip length.

70	Washer	NAS1149D0332K	Item 700
10	Bolt	ASNA2657K3-4	Item 832
18	Bolt	ASNA2657K3-5	Item 833
2	Bolt	ASNA2657K3-6	Item 834
4	Bolt	ASNA2657K3-7	Item 835
7	Nut	ASNA2536-3	Item 991
27	Nut	ASNA2538-3	Item 993

with:

Polysulfide Sealant-General Purpose Interfay	06AAC1	As required

(k) Renew the protective finish in accordance with SRM 51-75-12 with:

Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required
Top Coat Polyurethane - Decorative External Struc	04JMD3	As required

(15) Subtask 523115-400-206-001 - Install the Placard

Work Zones and Access Panels			
	Zone	Access/Work location	
	822	Work location	Frame 59A

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

Material necessary to do the job

Component COMPD01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
660	F5237211205000	1	PLACARD	

References	
Fig. A-GBDAA Installation of Placard	Sheet 01 Sheet 02

(a) Install, refer to Fig. A-GBDAA Sheet 02:

1 Placard F5237211205000 Item 660

(16) Subtask 523115-410-201-001 - Install Items Removed for Access

Work Zones and Access Panels		
	Zone	Access/Work location
	822	

Manpower Resources	
Manhours	12.00
Minimum number of person	1
Subtask elapsed time	12.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 52-30-00-410-805 Task 52-32-15-400-801 Task 52-32-21-400-801 Task 52-32-21-400-802 Task 52-32-21-400-803 Task 52-32-21-400-804 Task 52-32-21-400-805 Task 52-32-21-400-806 Task 52-32-21-400-807 Task 52-71-13-400-801 Task 52-71-21-400-802

(a) Install the indicator light, refer to AMM Task 52-71-21-400-802.

(b) Install the proximity sensor, refer to AMM Task 52-71-13-400-801.

(c) Install the locking handle, refer to AMM Task 52-32-21-400-801.

(d) Install the locking shaft, refer to AMM Task 52-32-21-400-802.

(e) Install the latching handle, refer to AMM Task 52-32-21-400-803.

(f) Install the latching shaft, refer to AMM Task 52-32-21-400-804.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

(g) Install the interlock mechanism, refer to AMM Task 52-32-21-400-805.

(h) Install the target mechanism, refer to AMM Task 52-32-21-400-806.

(i) Install the switch assembly, refer to AMM Task 52-32-21-400-807.

(j) Remove the protection linings, refer to AMM Task 52-32-15-400-801.

(k) Install access panels 822AR, 822BR, 822CR, 822DR, to the Aft Cargo Compartment Door, refer to AMM Task 52-30-00-410-805.

D. TEST

(1) Subtask 523115-710-201-001 - Operational Test

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 52-32-11-400-801

(a) Do the test procedure as specified in the installation of the Aft Cargo Compartment Door, refer to AMM Task 52-32-11-400-801.

E. CLOSE-UP

(1) Subtask 523115-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

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

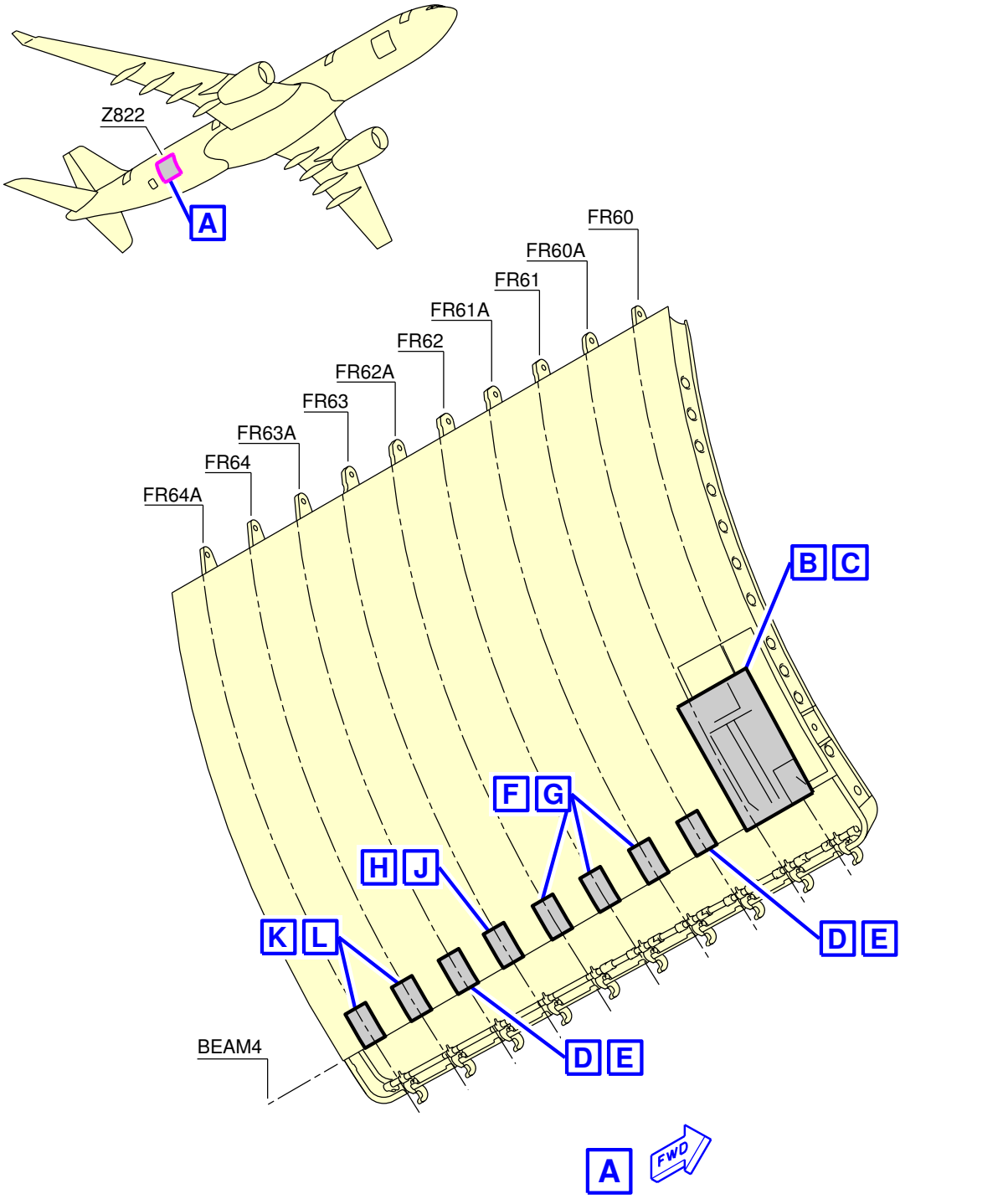
(b) Close the access door 822.

(c) Remove the access platform(s).

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

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

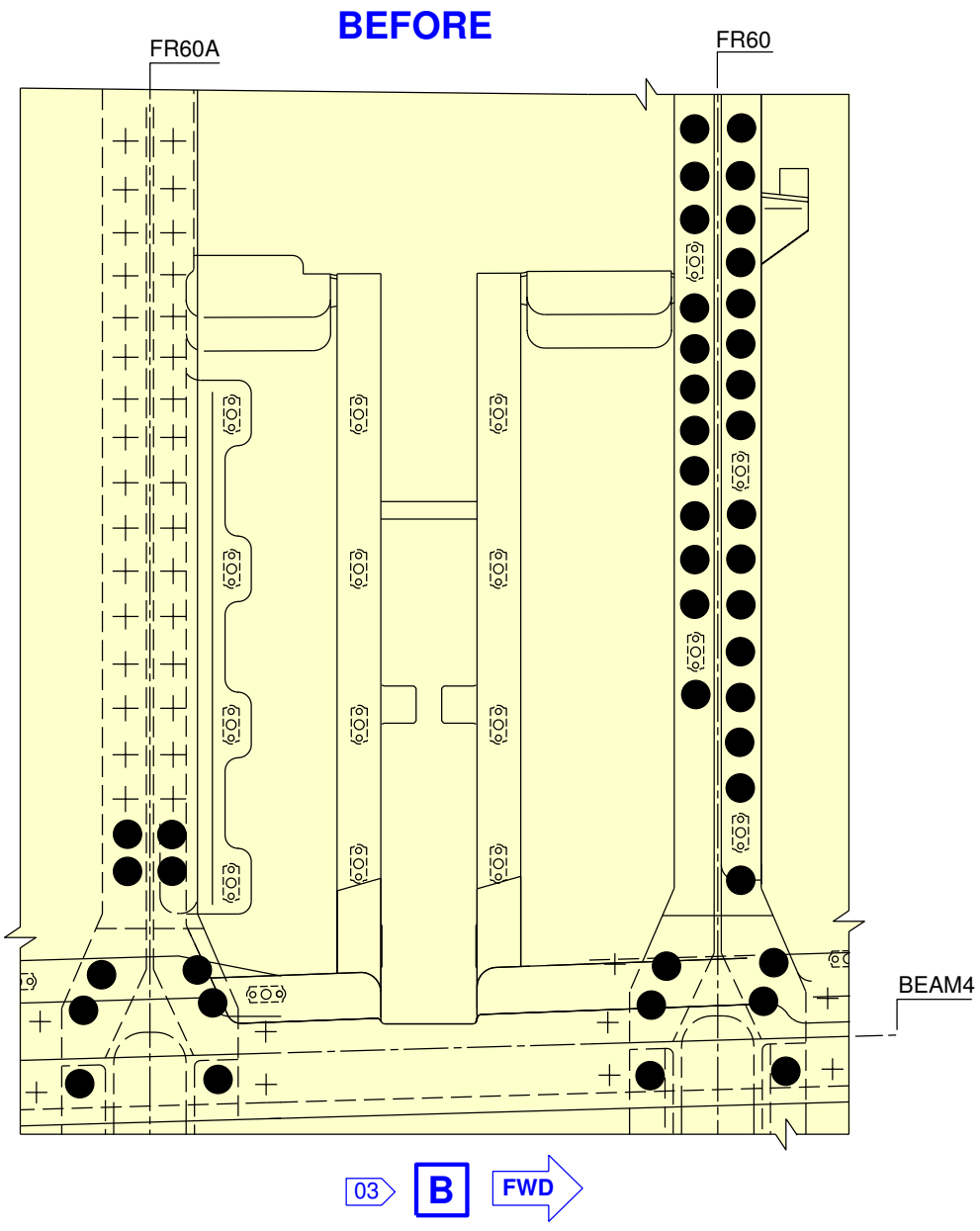


G_SB_523115_6_BAAA_01_00

Figure A-GBAAA - Sheet 01
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL



VIEW LOOKING INBOARD

NOTE:

SEE SHEET 6 FOR FASTENER TABLE AND FLAGNOTES

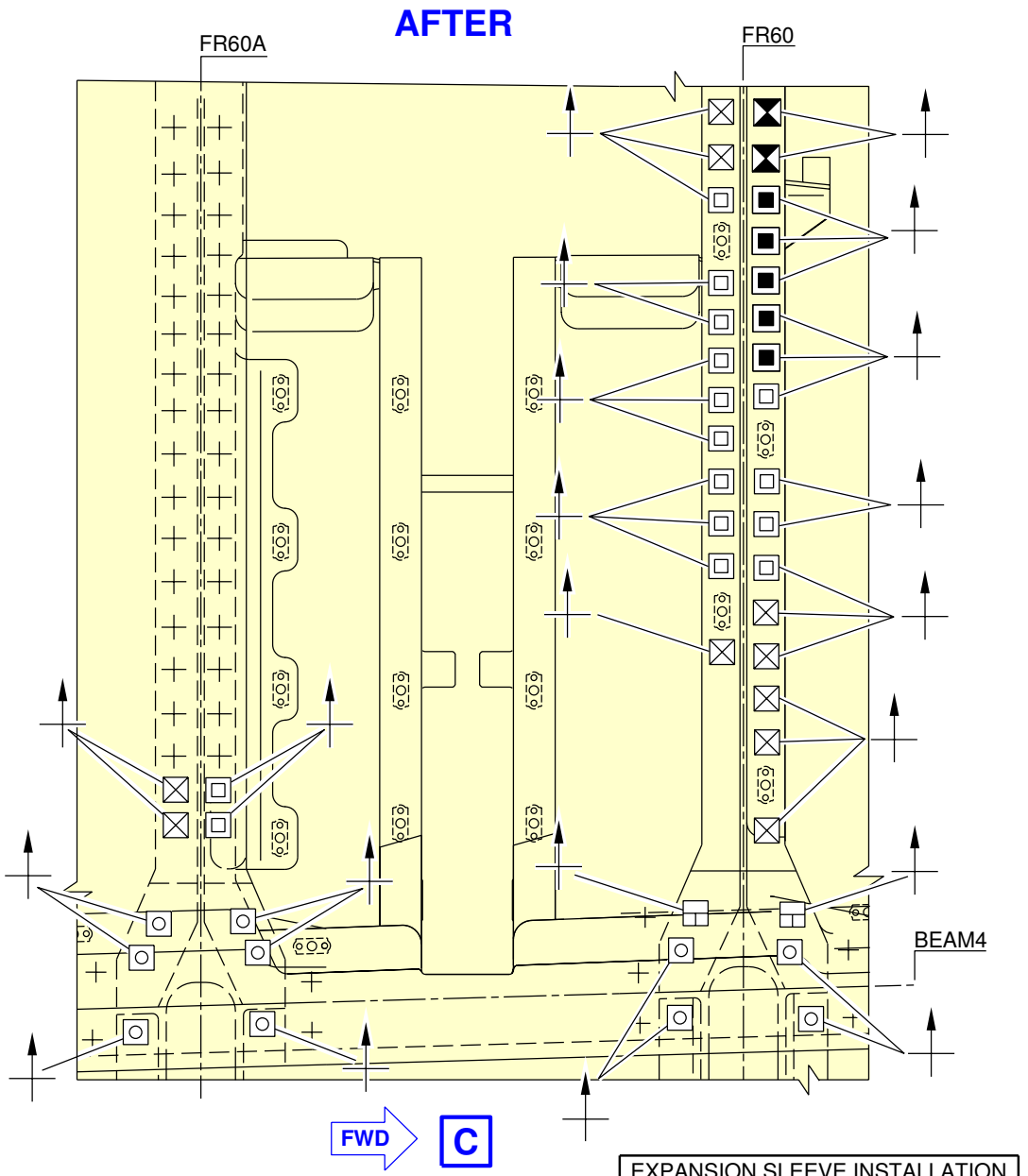
03 DO A HFEC ROTO TEST AS PER NTM 51–62–02
TO THE HOLES OF THE REMOVED FASTENERS

G_SB_523115_6_BAAA_02_00

Figure A-GBAAA - Sheet 02
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL



NOTE:

SEE SHEET 6 FOR FASTENER TABLE AND FLAGNOTES

UNLESS OTHERWISE SPECIFIED, ALL FASTENERS ARE INSTALLED FROM THIS SIDE

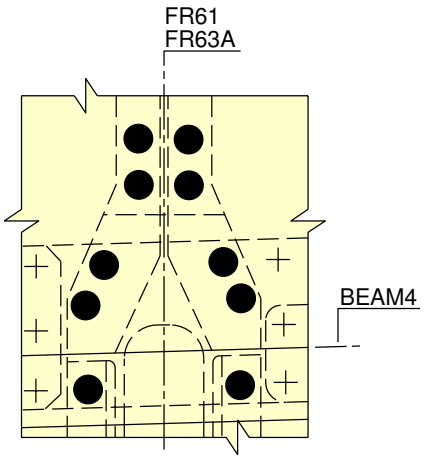
G_SB_523115_6_BAAA_03_00

Figure A-GBAAA - Sheet 03
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

****CONF ALL**

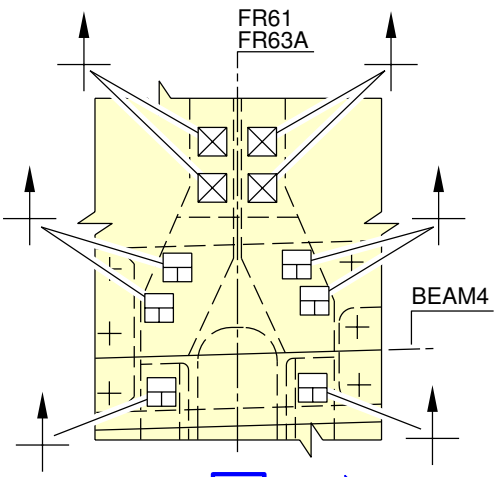
BEFORE



03 D FWD

TYPICAL
VIEW LOOKING INBOARD

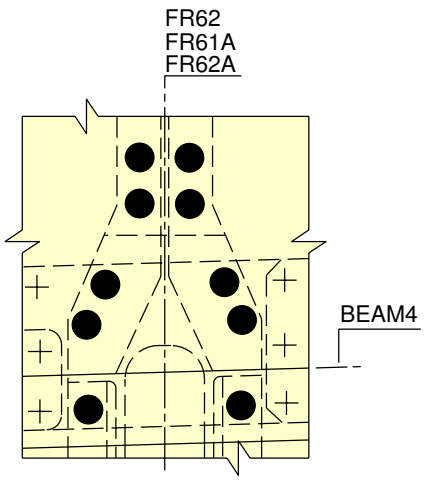
AFTER



E FWD

TYPICAL
VIEW LOOKING INBOARD

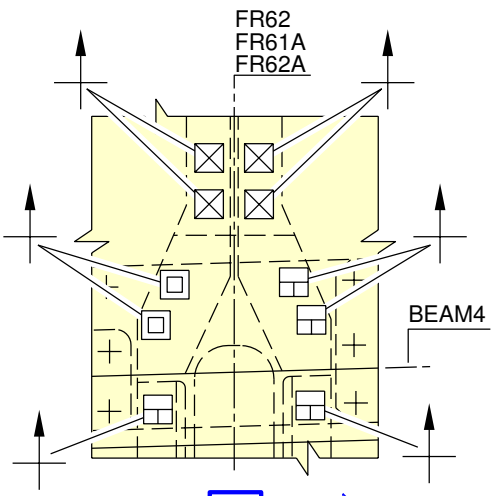
BEFORE



03 F FWD

TYPICAL
VIEW LOOKING INBOARD

AFTER



G FWD

TYPICAL
VIEW LOOKING INBOARD

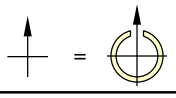
NOTE:

SEE SHEET 6 FOR FASTENER TABLE AND FLAGNOTES

UNLESS OTHERWISE SPECIFIED, ALL FASTENERS ARE INSTALLED FROM THIS SIDE

03 DO A HFEC ROTO TEST AS PER NTM 51–62–02 TO THE HOLES OF THE REMOVED FASTENERS

EXPANSION SLEEVE INSTALLATION ORIENTATION SCHEMATIC DIAGRAM

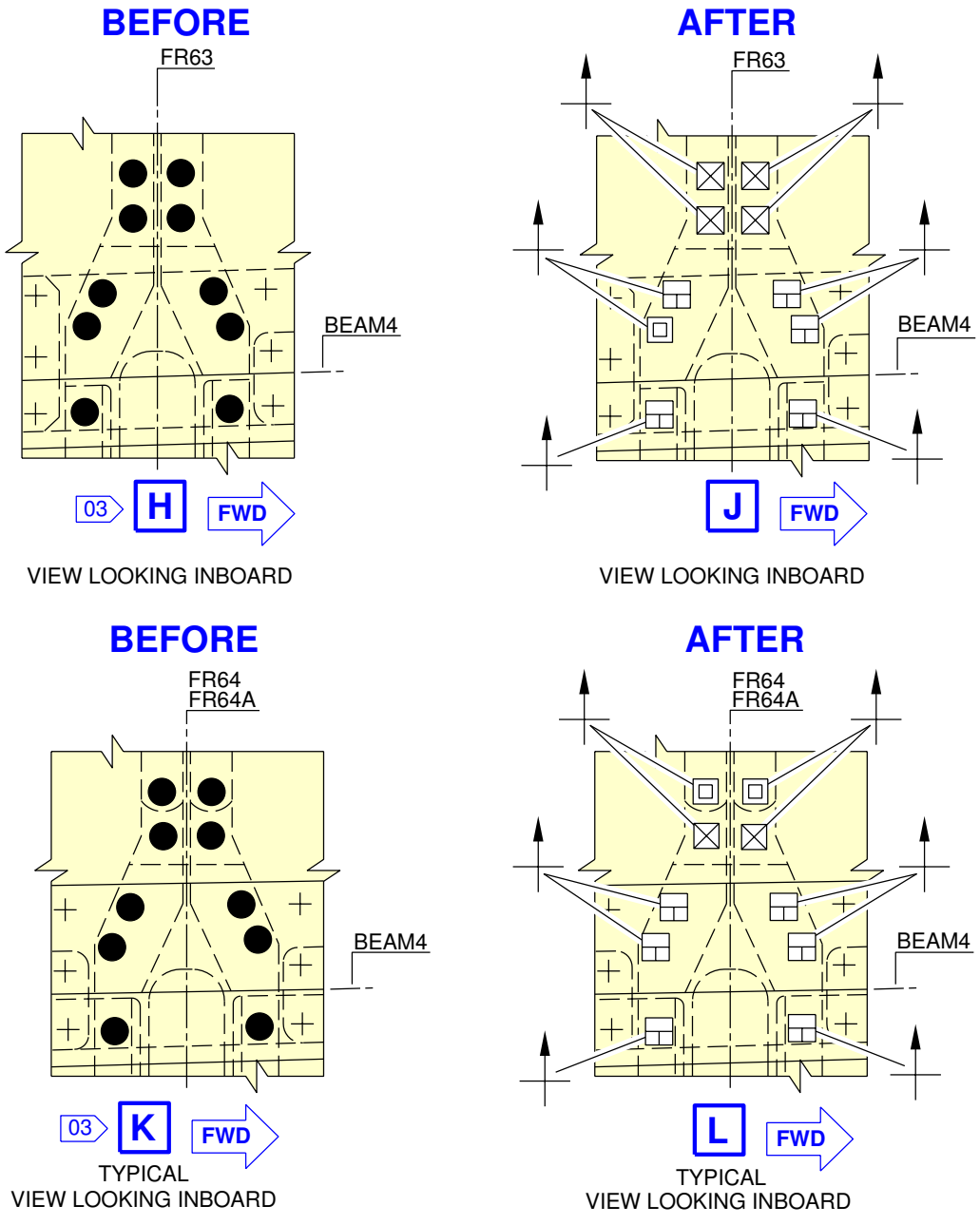


G_SB_523115_6_BAAA_04_00

Figure A-GBAAA - Sheet 04
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

****CONF ALL**

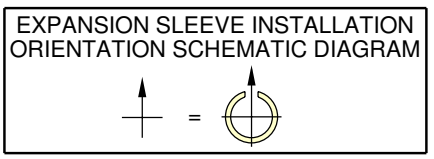


NOTE:

SEE SHEET 6 FOR FASTENER TABLE AND FLAGNOTES

UNLESS OTHERWISE SPECIFIED, ALL FASTENERS ARE INSTALLED FROM THIS SIDE

03 DO A HFEC ROTO TEST AS PER NTM 51–62–02 TO THE HOLES OF THE REMOVED FASTENERS



G_SB_523115_6_BAAA_05_00

Figure A-GBAAA - Sheet 05
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/FIT TYPE	NOTES
					MIN	MAX	MIN	MAX		
⧓	832	ASNA2657K3–4	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	991	ASNA2536–3	NUT							
⊠	832	ASNA2657K3–4	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	993	ASNA2538–3	NUT							
■	833	ASNA2657K3–5	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	991	ASNA2536–3	NUT							
⧈	833	ASNA2657K3–5	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	993	ASNA2538–3	NUT							
⊞	834	ASNA2657K3–6	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	993	ASNA2538–3	NUT							
⊙	835	ASNA2657K3–7	BOLT	4–4–N	4.290 mm (0.1689 in)	4.340 mm (0.1709 in)	4.733 mm (0.1863 in)	4.758 mm (0.1873 in)	NOMINAL SIZE INTERFERENCE FIT	01 02
	993	ASNA2538–3	NUT							
●	(1)	REMOVE FASTENER								
+	—	FASTENER NOT AFFECTED								

NOTE:

01 4% COLD WORKING

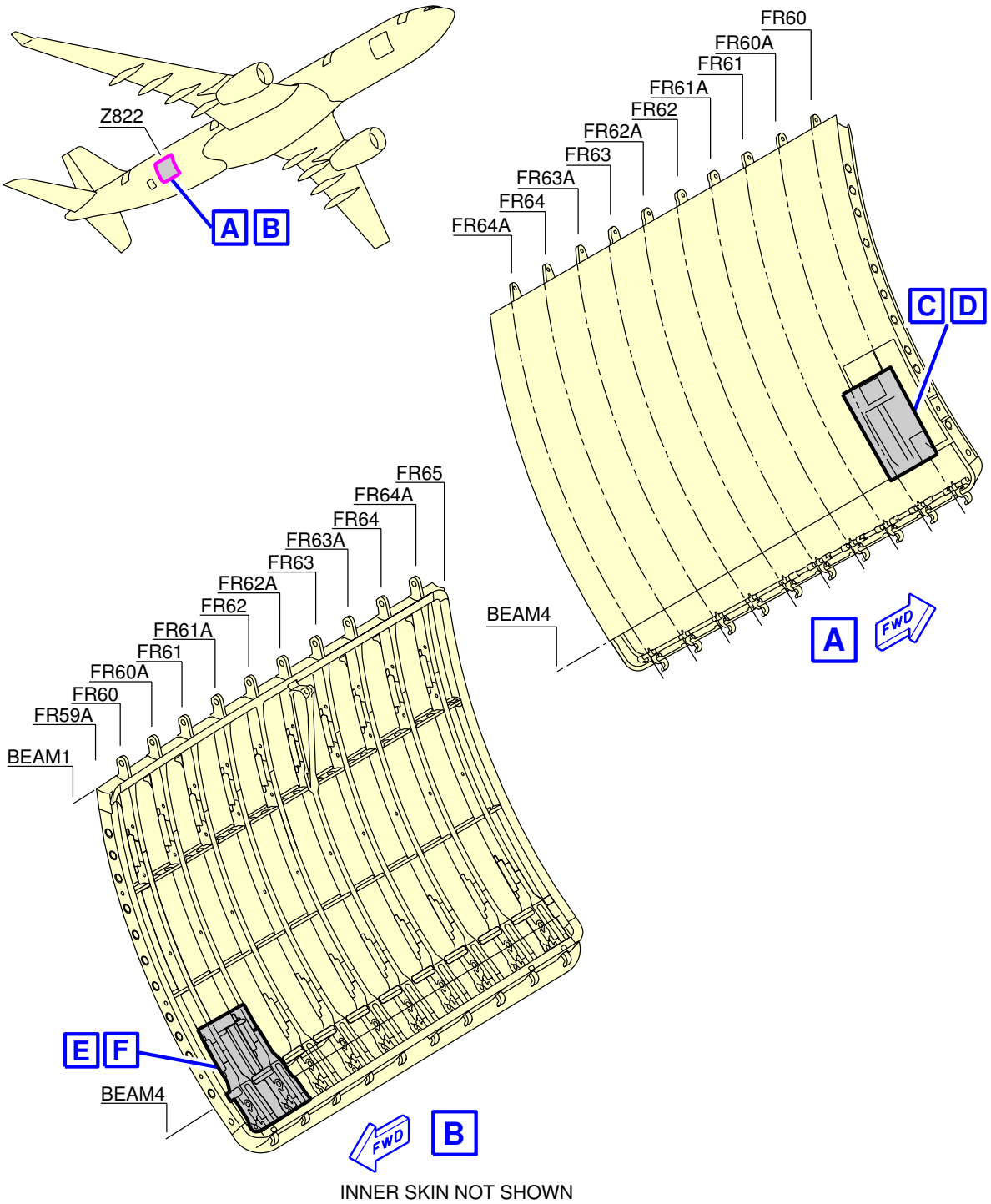
02 WET INSTALL FASTENERS WITH MATERIAL No 06AAC1

G_SB_523115_6_BAAA_06_01

Figure A-GBAAA - Sheet 06
Replacement of Frame Fork Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL



INNER SKIN NOT SHOWN

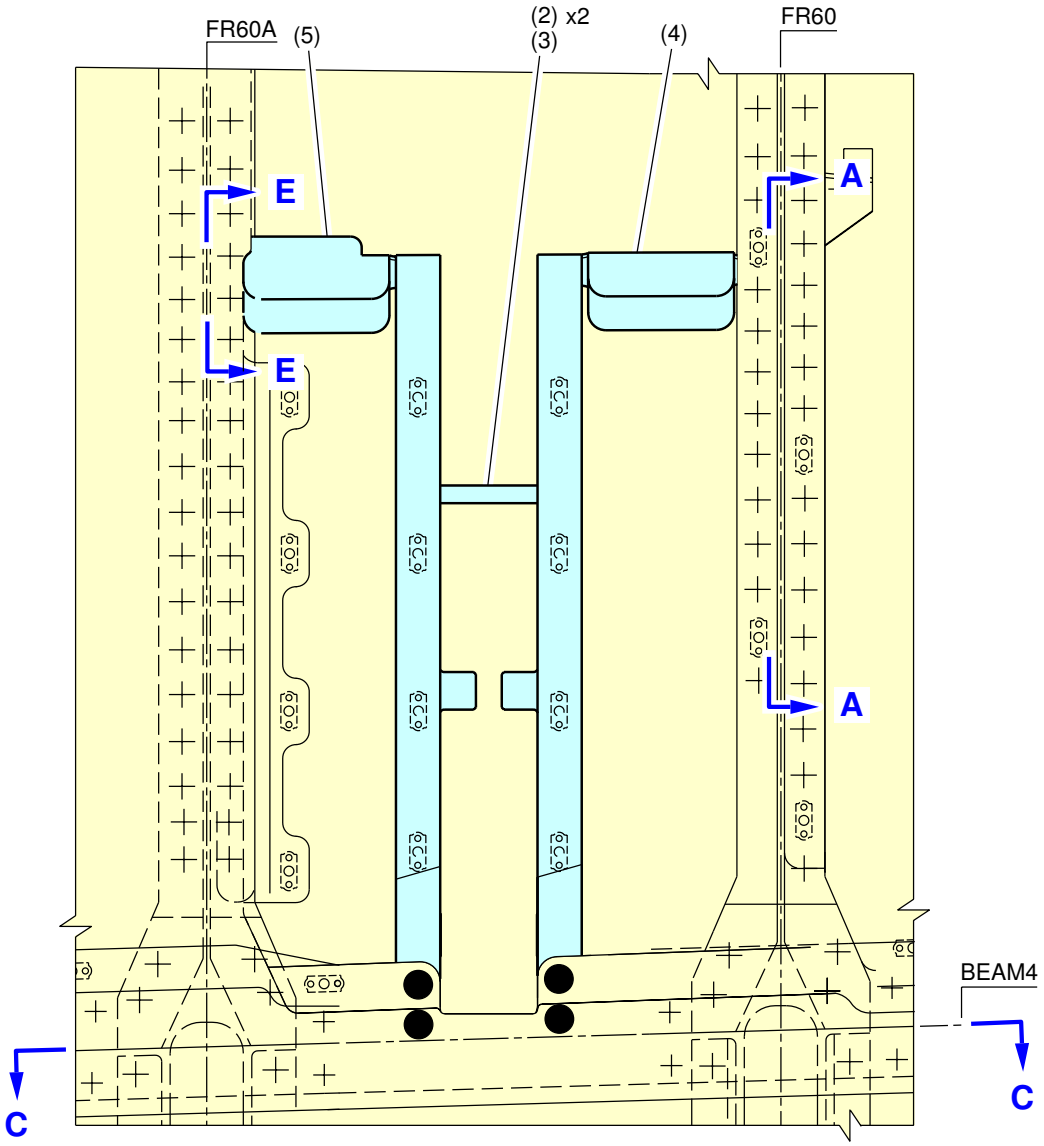
G_SB_523115_6_BBAA_01_01

Figure A-GBBAA - Sheet 01
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

BEFORE



VIEW LOOKING INBOARD

NOTE:
SEE SHEET 7 FOR FASTENER TABLE AND FLAGNOTES

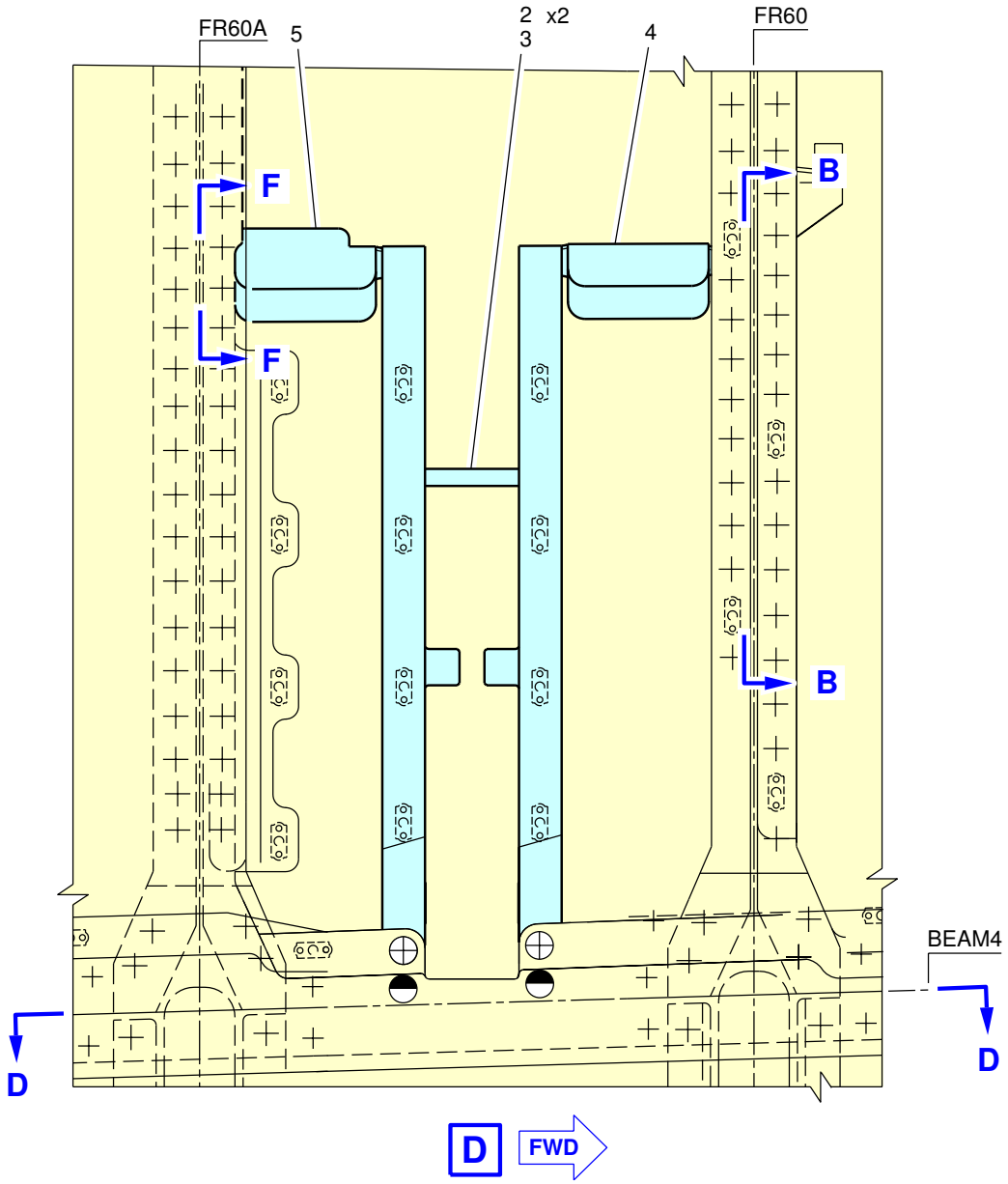
G_SB_523115_6_BBAA_02_02

Figure A-GBBAA - Sheet 02
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

AFTER



VIEW LOOKING INBOARD

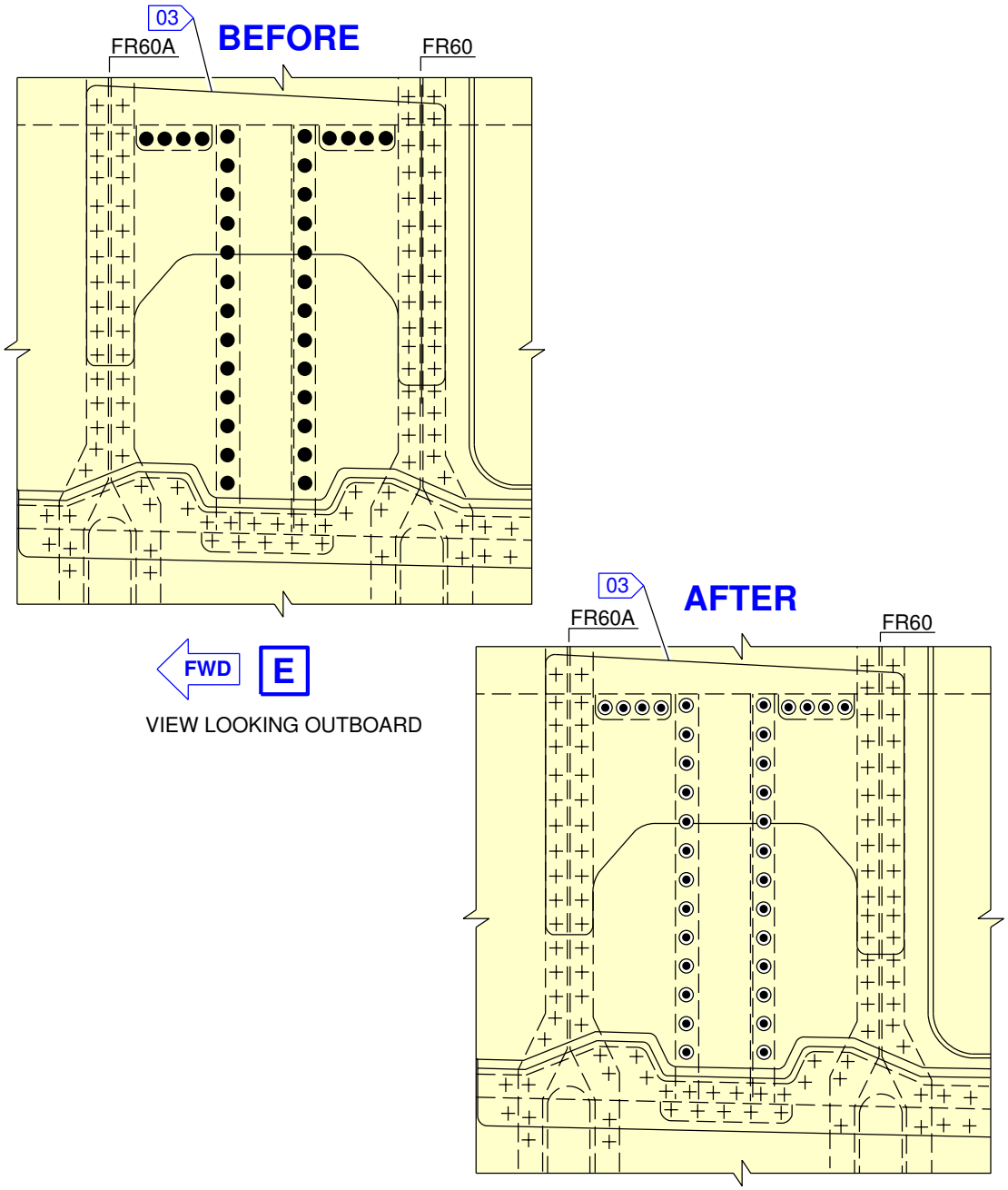
NOTE:
SEE SHEET 7 FOR FASTENER TABLE AND FLAGNOTES
UNLESS OTHERWISE SPECIFIED, ALL FASTENERS ARE INSTALLED FROM THIS SIDE

G_SB_523115_6_BBAA_03_02

Figure A-GBBAA - Sheet 03
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

****CONF ALL**



NOTE:

SEE SHEET 7 FOR FASTENER TABLE AND FLAGNOTES

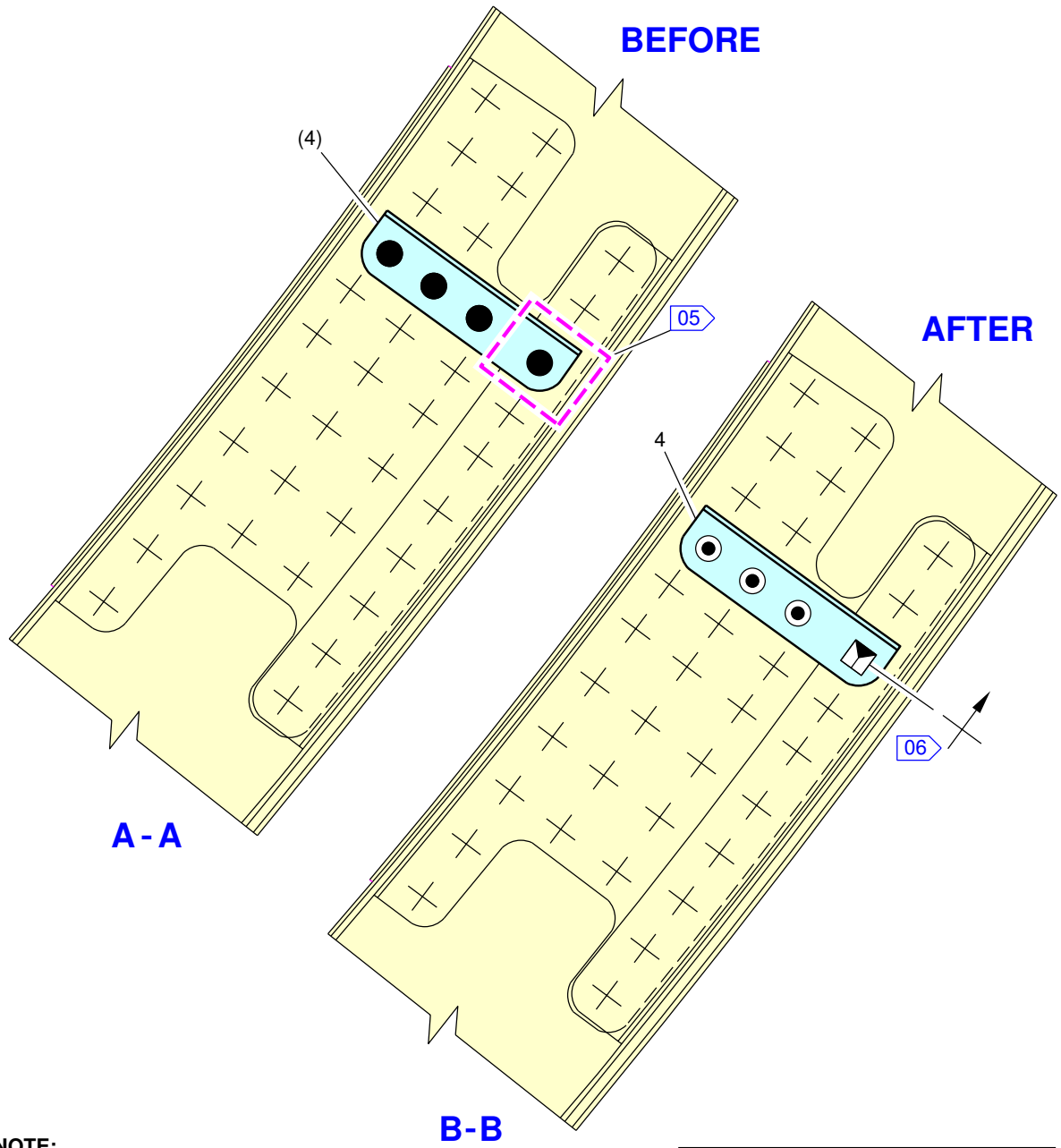
03 PLATE SHOWN FOR REFERENCE
PLATE IS PRESENT ONLY IF SB 52–3044 IS EMBODIED

G_SB_523115_6_BBAA_04_01

Figure A-GBBAA - Sheet 04
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

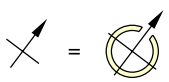


NOTE:
SEE SHEET 7 FOR FASTENER TABLE AND FLAGNOTES

05 DO A HFEC ROTO TEST AS PER NTM 51–62–02 TO THE HOLES OF THE REMOVED FASTENERS WITHOUT ITEM 4 INSTALLED

06 PERFORM COLD WORKING WITHOUT ITEM 4 INSTALLED

EXPANSION SLEEVE INSTALLATION ORIENTATION SCHEMATIC DIAGRAM

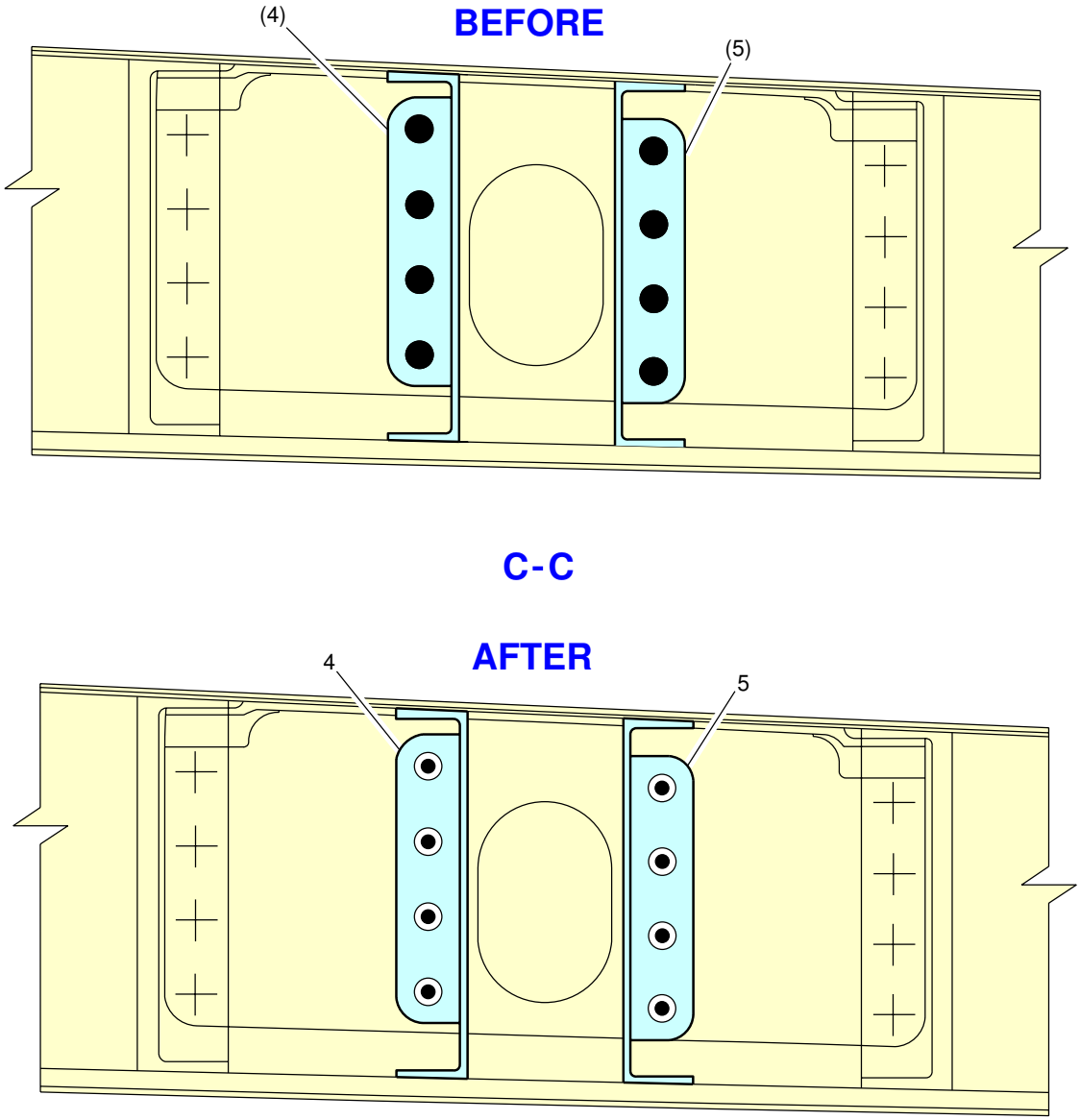


G_SB_523115_6_BBAA_05_02

Figure A-GBBAA - Sheet 05
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL



NOTE:
SEE SHEET 7 FOR FASTENER TABLE AND FLAGNOTES

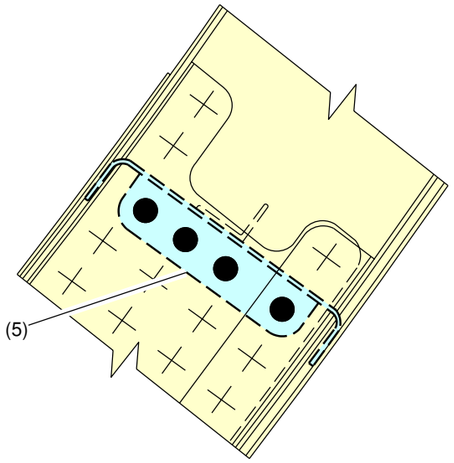
G_SB_523115_6_BBAA_06_01

Figure A-GBBAA - Sheet 06
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

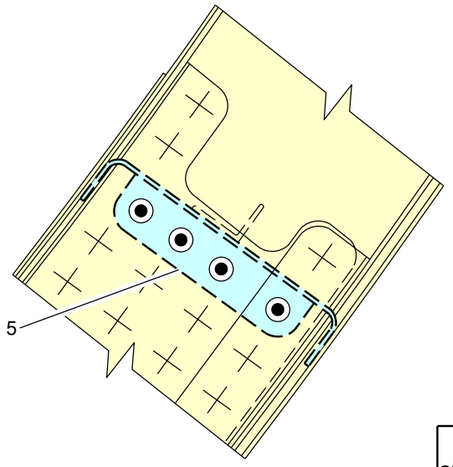
**CONF ALL

BEFORE



E-E

AFTER



F-F

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/ FIT TYPE	NOTES
					MIN	MAX	MIN	MAX		
◪	980	LN9198–4814CF	RIVET	4–4–N	4.29 mm (0.1689 in)	4.34 mm (0.1709 in)	4.850 mm (0.1909 in)	4.920 mm (0.1937 in)	NOMINAL SIZE/ TRANSITION FIT	01 02
◉	920	LN9198–4017CF	RIVET							02 04
⊕	973	EN6080KE5–08	RIVET							02 04
◓	904	NAS1097KE5–9	RIVET							02 04
●	(1)	REMOVE FASTENER								
+	—	FASTENER NOT AFFECTED								

NOTE:

01 4% COLD WORKING

02 WET INSTALL FASTENERS WITH MATERIAL No 06AAC1

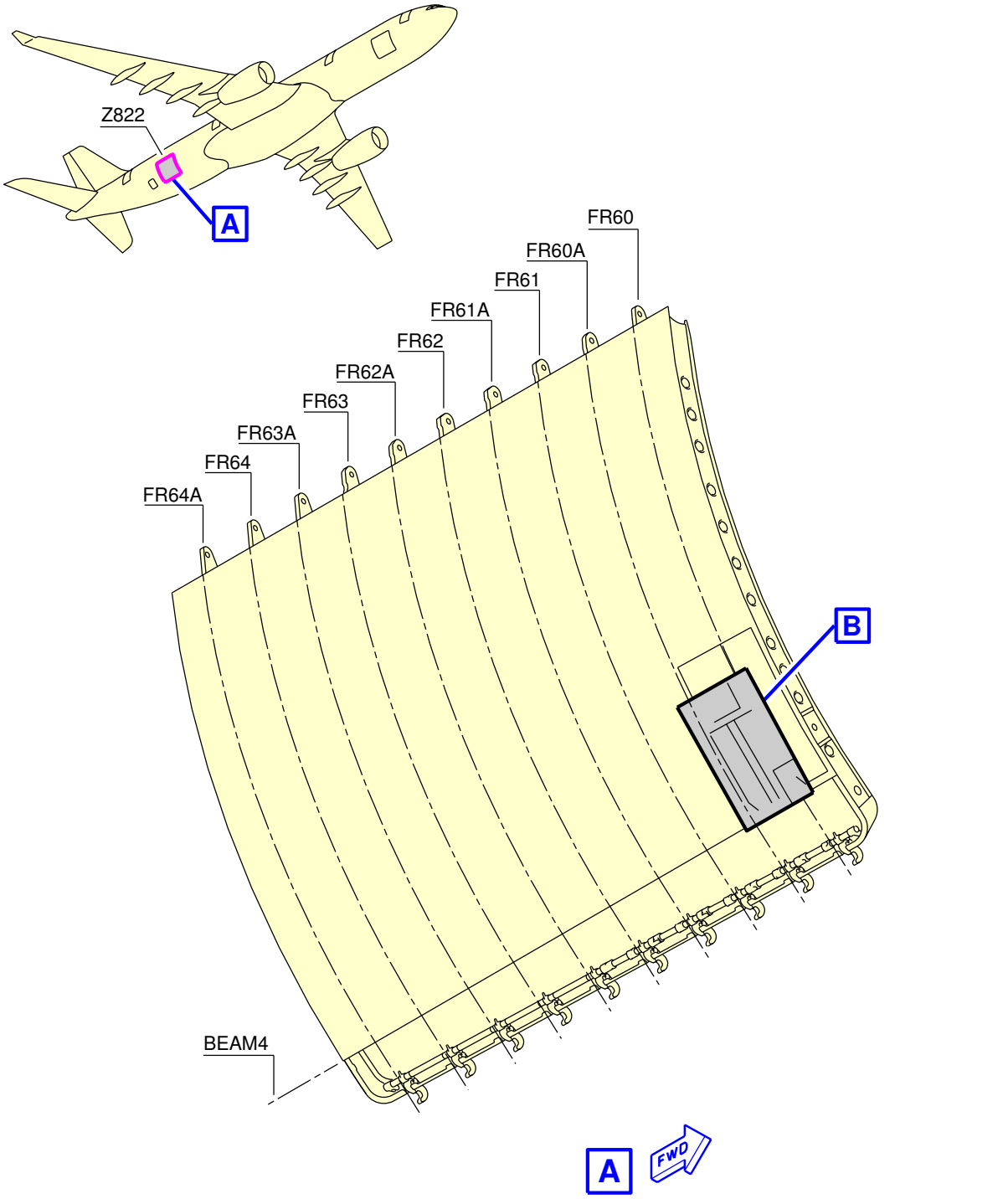
04 REFER TO SRM 51–42–00

G_SB_523115_6_BBAA_07_00

Figure A-GBBAA - Sheet 07
Removal and Installation of Handle Brackets

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

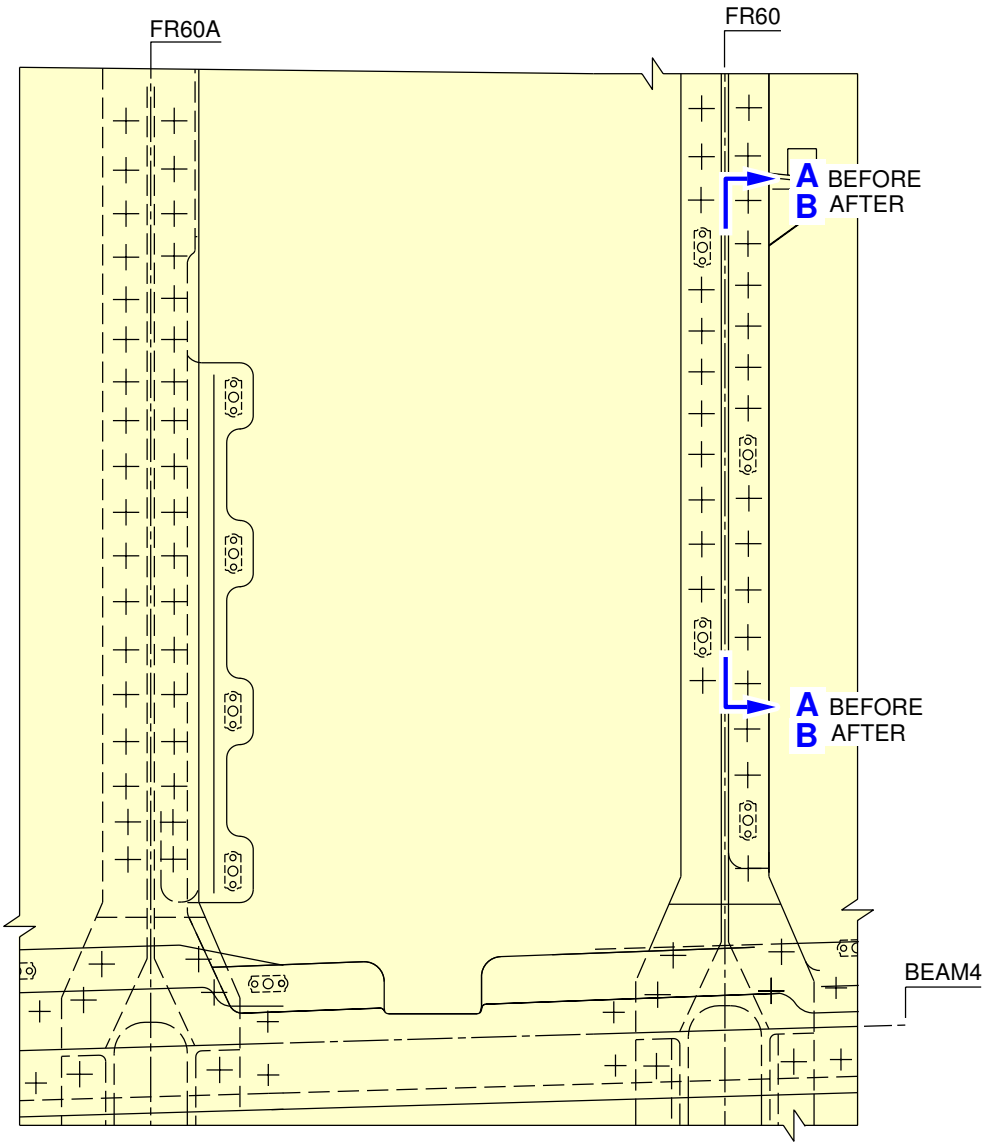


G_SB_523115_6_BCAA_01_01

Figure A-GBCAA - Sheet 01
Replacement of Joint Angle Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

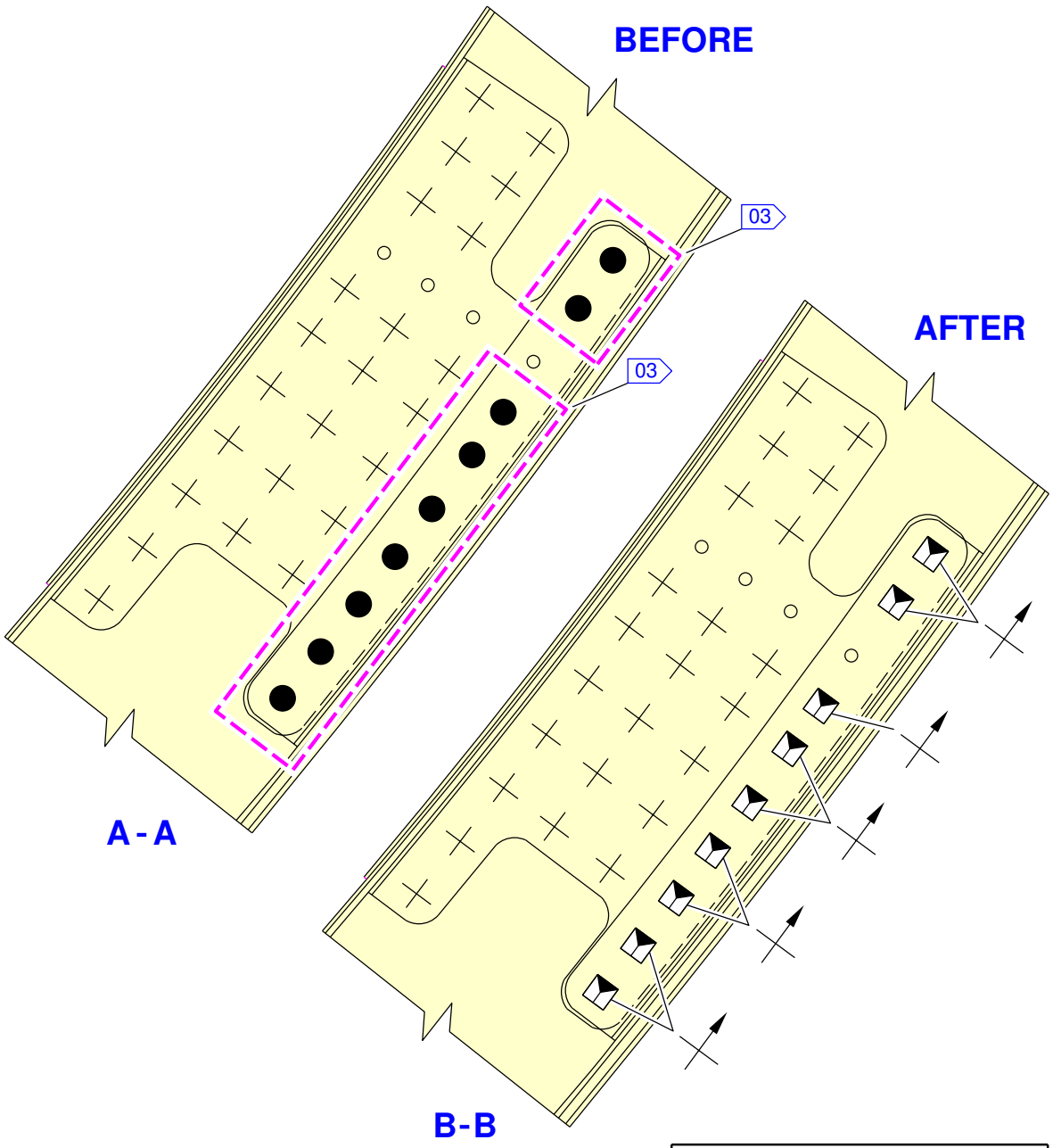


G_SB_523115_6_BCAA_02_02

Figure A-GBCAA - Sheet 02
Replacement of Joint Angle Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL



NOTE:
SEE SHEET 4 FOR FASTENER TABLE AND FLAGNOTES

03 DO A HFEC ROTO TEST AS PER NTM 51–62–02 TO THE HOLES OF THE REMOVED FASTENERS

G_SB_523115_6_BCAA_03_01

Figure A-GBCAA - Sheet 03
Replacement of Joint Angle Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE/ FIT TYPE	NOTES
					MIN	MAX	MIN	MAX		
	980	LN9198–4814CF	RIVET	4–4–N	4.29 mm (0.1689 in)	4.34 mm (0.1709 in)	4.850 mm (0.1909 in)	4.920 mm (0.1937 in)	NOMINAL SIZE/ TRANSITION FIT	01 02
	(1)	REMOVE FASTENER								
	—	FASTENER NOT AFFECTED								

NOTE:

01 4% COLD WORKING

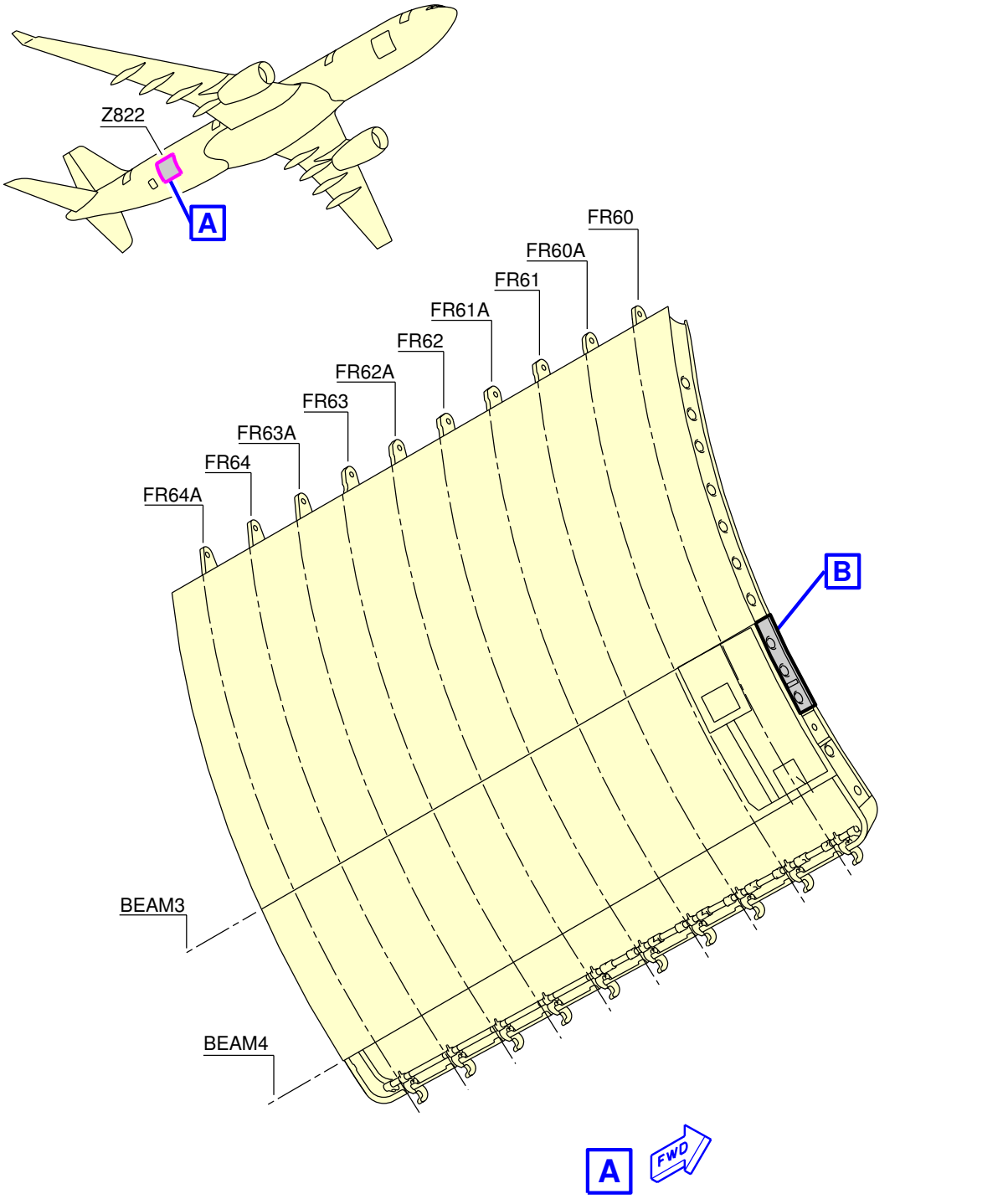
02 WET INSTALL FASTENERS WITH MATERIAL No 06AAC1

G_SB_523115_6_BCAA_04_00

Figure A-GBCAA - Sheet 04
Replacement of Joint Angle Fasteners

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

**CONF ALL

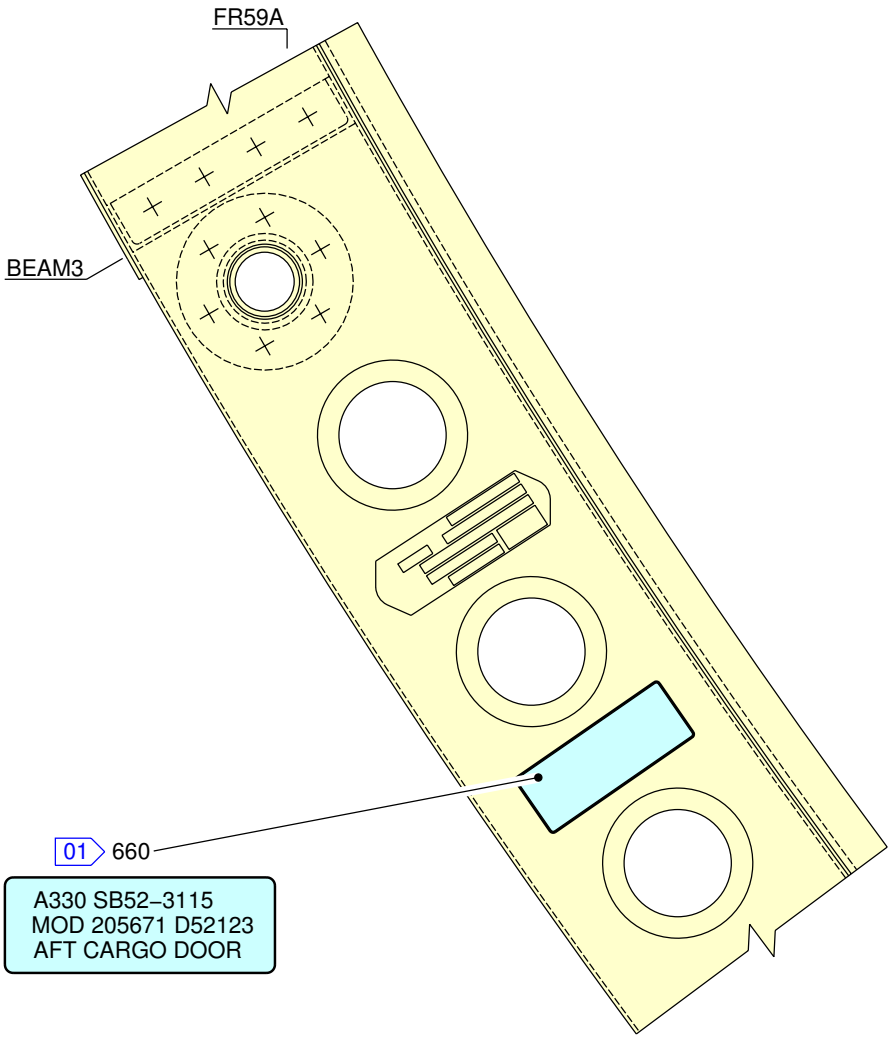


G_SB_523115_6_BDAA_01_00

Figure A-GBDAA - Sheet 01
Installation of Placard

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

****CONF ALL**



NOTE:

01 BOND THE PLACARD NEAR THE EXISTING DOOR IDENTIFICATION PLATE

G_SB_523115_6_BDAA_02_01

Figure A-GBDAA - Sheet 02
Installation of Placard

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

SERVICE BULLETIN
REPORTING SHEET

TITLE: DOORS - AFT CARGO COMPARTMENT DOOR - IMPROVE FATIGUE LIFE BY COLD WORK OF AFT CARGO DOOR FRAME STRUCTURE

MODIFICATION No.: 205671D52123

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.

Please return this completed sheet to:

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE

Attn: SDC32 Technical Data and Documentation Services
FAX: (+33) 5 61 93 28 06
e-mail: sb.reporting@airbus.com
or via your Resident Customer Support Office.

Alternatively, SB lists via letters or fax are also accepted.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.

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

(Please rate on a scale of 1 to 4, with 4 being the highest score)

- 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			

If you have had 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	Effectivity	X	Kit content	X	Preparation
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:

Operator: Date:

Name/Title:

Please return this form to:

AIRBUS
CUSTOMER SERVICES DIRECTORATE
1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE

Attn : SEM4 Service Bulletins Management
FAX : (33) 5 61 93 42 51

Or via your Resident Customer Support Office.

Printed in FRANCE © AIRBUS S.A.S. 2007. All rights reserved.