SERVICE BULLETIN
REVISION TRANSMITTAL SHEET

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - REINFORCE CIRCUMFERENTIAL JOINT BETWEEN FR53.6-FR53.7 FOR EMERGENCY DOOR TYPE 1 AREA

MODIFICATION No.: 204309D50888 204309D50892 204309D50893 204309D50904

This page transmits Revision No.03 of Service Bulletin No.A330-53-3226

ADDITIONAL WORK

****CONF ALL**

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

REASON

Revision No. 03 issued to incorporate changes found necessary and carried out during the accomplishment of this Service Bulletin on aircraft with Manufacturer Serial Number (MSN)s 0118 and 0083.

NOTE: This revision satisfies the requirements of the subsequent Technical Adaptation(s) (TA) issued for the related MSN(s):

TA	MSN(s)
80251266/023/2018	0118
80084877/104/2017	0083

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80226560/063/2018	0050, 0060, 0062, 0064-0065, 0071, 0083, 0099, 0102, 0109, 0112-0113, 0116, 0118, 0121-0122, 0138, 0140, 0143-0144, 0148, 0153, 0155, 0162, 0165, 0172, 0181, 0195, 0200, 0206, 0209, 0219, 0222-0224, 0226, 0229-0232, 0238, 0240-0241, 0244, 0247-0249, 0251, 0253, 0255-0256, 0258-0259, 0262, 0267, 0269, 0275-0277, 0279, 0281, 0283-0284, 0286-0288, 0290-0291, 0293-0296, 0299-0300, 0303, 0305-0306, 0308, 0311-0317, 0322-0324, 0326, 0328, 0330, 0333-0334, 0337-0338, 0340, 0342-0346, 0348, 0350-0351, 0358, 0361, 0364-0366, 0368, 0370, 0372, 0375, 0380, 0382, 0384, 0386, 0388-0389, 0392-0393, 0396-0398, 0400-0401, 0404, 0408-0409, 0412, 0418-0423, 0437, 0439, 0443, 0448, 0451-0452, 0455, 0458, 0462, 0465-0466, 0472-0473, 0477, 0481, 0486-0487, 0489, 0491, 0494, 0496-0498, 0500, 0502-0503, 0505-0511, 0513, 0515-0516, 0518-0519, 0521-0522, 0524-0527, 0529-0530, 0532-0533, 0535-0536, 0539, 0542, 0548-0549, 0552, 0555, 0565, 0567-0568, 0570-0571, 0573, 0576, 0578-0579, 0584, 0587-0588, 0591, 0600, 0605, 0609-0610, 0612, 0614, 0616, 0618, 0620-0621, 0623, 0625, 0629, 0631-0634, 0636-0638, 0640, 0642, 0644-0645, 0647-0650, 0652-0653, 0655-0657, 0659, 0661, 0663-0667, 0674, 0676, 0678-0679, 0682-0684, 0686-0687, 0690, 0693, 0696-0697, 0700-0701, 0703-0704, 0708-0709, 0713, 0717-0718, 0720, 0722, 0724, 0726, 0728-0730, 0732, 0735, 0737-0738, 0742-0743, 0746-0747, 0750-0751, 0754-0756, 0759-0760, 0770, 0772-0774, 0776-0778, 0780-0782, 0784-0785, 0788, 0791-0792, 0796-0797, 0799, 0801, 0803, 0806-0807, 0809-0811, 0815, 0817-0822, 0824-0825, 0827, 0830-0832, 0834, 0836, 0839-0843, 0845, 0849-0855, 0857-0860, 0862-0863, 0865-0869, 0871, 0873-0877, 0879, 0881-0885, 0887-0892, 0895-0896 and 0898-0901

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80226560/063/2018	0903-0906, 0908-0909, 0913-0916, 0919, 0922-0923, 0925-0928, 0930, 0932, 0934-0937, 0939-0949, 0951, 0954, 0956-0959, 0961-0964, 0967-0970, 0973, 0975-0980, 0982-0984, 0986, 0988-0991, 0994-0998, 1000, 1002-1003, 1006-1007, 1009-1016, 1018-1020, 1022-1023, 1026, 1028-1029, 1031, 1033-1039, 1041-1047, 1049, 1052-1054, 1057, 1059-1061, 1063, 1067, 1069, 1071, 1073-1074, 1076, 1078, 1080-1082, 1084-1086, 1088-1090, 1093-1096, 1098-1101, 1104-1105, 1107-1108, 1112, 1114, 1116, 1118, 1120, 1123-1124, 1127, 1129, 1132-1133, 1135, 1137-1138, 1141, 1143, 1145-1147, 1149-1150, 1153, 1155-1157, 1159-1161, 1163, 1167-1174, 1178, 1181, 1183-1184, 1186, 1188-1192, 1196, 1198, 1200, 1202-1205, 1208-1210, 1212-1214, 1217-1230, 1233-1241, 1243-1246, 1248-1252, 1255-1256, 1258-1264, 1266-1267, 1269, 1271, 1275-1277, 1279-1283, 1285-1295, 1297-1298, 1300, 1302-1314, 1316-1319, 1322, 1324-1325, 1327, 1330-1331, 1334-1338, 1342-1343, 1347-1349, 1354-1355, 1358, 1362-1366, 1369, 1372, 1374-1375, 1377, 1379, 1381-1382, 1384-1385, 1387-1390, 1392-1405, 1407-1410, 1412, 1415-1417, 1419, 1421-1422, 1424-1427, 1429-1432, 1434, 1436-1441, 1443-1444, 1446-1447, 1451-1455, 1457-1459, 1461-1462, 1465-1466, 1468-1474, 1476-1480, 1483-1492, 1494, 1496-1503, 1505, 1507-1508, 1511-1517, 1519-1521, 1523, 1526, 1528-1530, 1532, 1535-1537, 1540, 1542-1545, 1547-1548, 1551, 1554-1558, 1560-1562, 1565, 1567, 1569, 1571-1577, 1579-1580, 1582, 1585-1586, 1588, 1590-1593, 1595, 1597-1599, 1601, 1603, 1605-1611, 1613-1618, 1620-1645, 1647-1649, 1651, 1653-1657, 1660, 1662-1668, 1671-1672, 1676-1679, 1681, 1686, 1694, 1696-1701, 1703-1704, 1706, 1709-1710, 1713-1716, 1718-1721, 1723, 1725, 1728, 1730, 1732-1733, 1735-1737, 1740-1741, 1745-1748, 1751, 1753-1763, 1769, 1771, 1773, 1775-1777, 1779-1780, 1782-1785, 1787-1788, 1792-1793, 1796, 1798-1799, 1801, 1804-1805, 1808-1809, 1814-1816, 1818, 1821-1822, 1825-1826 and 1847

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- Add CONF 005
- Update item number for Part Number (PN) EN6114K3X11
- Update item number for PN NSA9117-23
- Update typo error in
  - . **CONF 001 SUBTASK 533226-831-214 001 Do the Modification of the RH Emergency Exit Door
  - . **CONF 002 SUBTASK 533226-831-214 002 Do the Modification of the RH Emergency Exit Door
  - . **CONF 003 SUBTASK 533226-831-214 003 Do the Modification of the RH Emergency Exit Door
  - . **CONF 004 SUBTASK 533226-831-214 004 Do the Modification of the RH Emergency Exit Door.
- Update item number in

  **CONF 001 thru 002, 005 Fig. A-GBAAA Sheet 04
- Update retrofitted modifications table to add CONF 005.

CHANGES

The main changes of this revision are:

- PLANNING INFORMATION paragraph updated:
  - . Effectivity updated
  - . Effectivity note updated
  - . Man-hours and elapsed time updated for CONF 003 and CONF 004
  - . Man-hours and elapsed time note updated
  - . Weight and balance note updated.
- MATERIAL INFORMATION paragraph updated:
  - . Procurement address updated for Kit 533226D01R04, Kit 533226D02R05, Kit 533226D03R03, Kit 533226D04R03, Kit 533226D05R03, Kit 533226D06R02, Kit 533226D07R04, Kit 533226D08R04, Kit 533226D09R01, Kit 533226D10R01 and Kit 533226D11R02.
  - . Description updated for Consumable
  - . Industry support information updated.
- ACCOMPLISHMENT INSTRUCTIONS paragraph updated:

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. CAUTION note updated

. Notes updated in Warning and caution section

. Standard practices section updated

. Note updated in Job Set-up section.

FRONT MATTER		
FUSELAGE - CENTER FUSELAGE - REINFORCE CIRCUMFERENTIAL JOINT BETWEEN FR53.6-FR53.7 FOR EMERGENCY DOOR TYPE 1 AREA	CONFIGURATION UPDATED	R
SUMMARY		
REASON/DESCRIPTION/OPERATIONAL CONSEQUENCES	REASON UPDATED	R
MATERIAL PRICE INFORMATION	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE UPDATED	R
	MATERIAL PRICE INFORMATION TABLE ADDED	N
EFFECTIVITY	OPERATOR LIST UPDATED	R
NATURE OF THE WORK	NATURE OF WORK TABLE UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER ADDED	N
APPENDICES	APPENDICES UPDATED	R
Fig. A-GSAAA	FIGURE SOLUTION UPDATED CONFIGURATION UPDATED	R
Fig. A-GSAAA Sheet 01	SHEET UPDATED	R
Fig. A-GSAAB		
Fig. A-GSAAB Sheet 01	SHEET UPDATED	R
PLANNING INFORMATION		
EFFECTIVITY	EFFECTIVITY RELATED INFORMATION UPDATED	R
Configuration definition	CONFIGURATION LIST UPDATED	R
CONF 001	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R
CONF 002	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R
CONF 003	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R
CONF 004	CONFIGURATION DEFINITION UPDATED CONFIGURATION DESCRIPTION UPDATED	R

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CONF 005	CONFIGURATION ADDED	N
Material Effectivity	MATERIAL EFFECTIVITY ADDED	N
REASON		
Objective/Action	OBJECTIVE/ACTION UPDATED	R
DESCRIPTION	DESCRIPTION UPDATED	R
MANPOWER	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER UPDATED	R
	MANPOWER ADDED	N
WEIGHT AND BALANCE	Minor editorial or document structure change	R
	CONFIGURATION UPDATED	R
	Minor editorial or document structure change	R
	Minor editorial or document structure change	R
REFERENCES	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION UPDATED	R
	REFERENCED DOCUMENTATION ADDED	N
MATERIAL INFORMATION		
MATERIAL - PRICE AND AVAILABILITY		
Procurement Addresses	PROCUREMENT ADDRESSES UPDATED MATERIAL SET UPDATED	R
Price and Availability	PRICE AND AVAILABILITY UPDATED MATERIAL PRICE UPDATED MATERIAL AVAILABILITY UPDATED MATERIAL SET UPDATED	R
INDUSTRY SUPPORT INFORMATION	INDUSTRY SUPPORT INFORMATION UPDATED	R
LIST OF COMPONENTS	LIST OF COMPONENTS UPDATED	R
Kit 533226D01R04	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D02R05	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D03R03	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R

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Kit 533226D04R03	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D05R03	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D06R02	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D07R04	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D08R04	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D09R01	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D10R01	PART MATERIAL SET UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED	R
Kit 533226D12R00	PART MATERIAL SET ADDED	N
Kit 533226D13R00	PART MATERIAL SET ADDED	N
LIST OF MATERIALS - OPERATOR SUPPLIED		
Consumable Materials		
Consumable CMLD01	CONSUMABLE MATERIAL SET UPDATED CONSUMABLE UPDATED QUANTITY UPDATED	R
PARTS TO BE RE-IDENTIFIED BY OPERATOR	PARTS TO BE RE-IDENTIFIED BY OPERATOR UPDATED	R
TOOLING		
Tooling - Price and Availability		
Procurement Addresses	PROCUREMENT ADDRESSES UPDATED	R
Tools	TOOLS UPDATED	R

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Standard tool TOOLD01	TOOL MATERIAL SET UPDATED	R
Standard tool TOOLD02	TOOL MATERIAL SET UPDATED	R
Standard tool TOOLD04	TOOL MATERIAL SET UPDATED QUANTITY UPDATED	R
Standard tool TOOLD05	TOOL MATERIAL SET UPDATED QUANTITY UPDATED	R
ACCOMPLISHMENT INSTRUCTIONS		
TASK 533226- 831-848-001-Modification	TASK SOLUTION UPDATED NOTE UPDATED CAUTION UPDATED	R
Task associated data - 003	ELAPSED TIME UPDATED	R
Task associated data - 004	ELAPSED TIME UPDATED	R
Task associated data - 005	TASK ASSOCIATED DATA ADDED	N
Subtask 533226-910-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 533226-910-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 533226-910-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 533226-910-201-001	SUBTASK SOLUTION UPDATED REFERENCED DOCUMENTATION UPDATED	R
Subtask 533226-910-201-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-839-201-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-941-201-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 533226-941-201-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 533226-941-201-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 533226-941-201-001	SUBTASK SOLUTION UPDATED NOTE UPDATED	R
Subtask 533226-941-201-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-010-201-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-215-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-216-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-218-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-220-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-222-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-224-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-226-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-228-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-230-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-232-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-236-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-237-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-240-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-243-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-244-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-247-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-250-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED NOTE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-251-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED CONFIGURATION UPDATED MATERIAL LIST UPDATED FIGURE REFERENCE UPDATED	R
Subtask 533226-831-213-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-206-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-212-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-214-001	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-215-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-216-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-218-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-220-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-222-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-224-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-227-002	SUBTASK SOLUTION UPDATED	R
Subtask 533226-831-226-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-228-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-230-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-232-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-236-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-237-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-240-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-243-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-244-002	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-247-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-250-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED NOTE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-251-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED CONFIGURATION UPDATED MATERIAL LIST UPDATED FIGURE REFERENCE UPDATED	R
Subtask 533226-831-213-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-212-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-214-002	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-215-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-216-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-218-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-220-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-226-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-228-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-236-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-237-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-240-003	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-243-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-244-003	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-247-003	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-250-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED NOTE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-251-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED CONFIGURATION UPDATED MATERIAL LIST UPDATED FIGURE REFERENCE UPDATED	R
Subtask 533226-831-212-003	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-214-003	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-215-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED QUANTITY UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-216-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-218-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-220-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-226-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-228-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED REFERENCED DOCUMENTATION UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-236-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-240-004	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-243-004	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-247-004	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-250-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED NOTE UPDATED MATERIAL LIST UPDATED	R

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Subtask 533226-831-251-001	SUBTASK SOLUTION UPDATED CONSUMABLE UPDATED CONFIGURATION UPDATED MATERIAL LIST UPDATED FIGURE REFERENCE UPDATED	R
Subtask 533226-831-212-004	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-214-004	SUBTASK SOLUTION UPDATED KEYWORD UPDATED ITEM NUMBER UPDATED PART NUMBER UPDATED QUANTITY UPDATED CONSUMABLE UPDATED MATERIAL LIST UPDATED	R
Subtask 533226-831-215-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-216-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-201-006	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-207-004	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-248-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-249-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-217-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-209-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-219-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-210-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-221-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-211-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-256-004	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-218-004	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-218-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-220-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-222-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-224-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-225-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-213-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-227-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-214-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-229-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-215-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-231-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-216-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-226-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-228-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-230-005	SUBTASK SOLUTION ADDED	N

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Subtask 533226-831-232-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-233-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-234-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-235-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-238-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-239-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-236-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-237-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-240-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-241-006	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-242-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-832-217-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-245-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-246-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-243-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-244-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-247-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-252-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-253-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-254-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-255-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-250-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-251-002	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-213-004	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-206-004	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-212-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-831-214-005	SUBTASK SOLUTION ADDED	N
Subtask 533226-710-201-001	SUBTASK SOLUTION ADDED	N
Subtask 533226-942-201-001	SUBTASK SOLUTION ADDED	N
Fig. A-GBAAA	FIGURE SOLUTION UPDATED CONFIGURATION UPDATED	R
Fig. A-GBAAA Sheet 01	SHEET UPDATED	R
Fig. A-GBAAA Sheet 02	SHEET UPDATED	R
Fig. A-GBAAA Sheet 03	SHEET UPDATED	R
Fig. A-GBAAA Sheet 04	SHEET UPDATED	R
Fig. A-GBBAA		
Fig. A-GBBAA Sheet 01	SHEET UPDATED	R
Fig. A-GBBAA Sheet 02	SHEET UPDATED	R
Fig. A-GBBAA Sheet 03	SHEET UPDATED	R
Fig. A-GBBAA Sheet 04	SHEET UPDATED	R
Fig. A-GBBAA Sheet 05	SHEET UPDATED	R
Fig. A-GBBAA Sheet 06	SHEET UPDATED	R
Fig. A-GBBAA Sheet 07	SHEET UPDATED	R
Fig. A-GBBAA Sheet 08	SHEET UPDATED	R
Fig. A-GBBAA Sheet 09	SHEET UPDATED	R

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Fig. A-GBBAA Sheet 10	SHEET UPDATED	R
Fig. A-GBBAB	FIGURE SOLUTION UPDATED CONFIGURATION UPDATED	R
Fig. A-GBBAB Sheet 01	SHEET UPDATED	R
Fig. A-GBBAB Sheet 02	SHEET UPDATED	R
Fig. A-GBBAB Sheet 03	SHEET UPDATED	R
Fig. A-GBBAB Sheet 04	SHEET UPDATED	R
Fig. A-GBBAB Sheet 05	SHEET UPDATED	R
Fig. A-GBBAB Sheet 06	SHEET UPDATED	R
Fig. A-GBBAB Sheet 07	SHEET UPDATED	R
Fig. A-GBBAB Sheet 08	SHEET UPDATED	R
Fig. A-GBBAB Sheet 09	SHEET UPDATED	R
Fig. A-GBBAB Sheet 10	SHEET UPDATED	R
Fig. A-GBBAC		
Fig. A-GBBAC Sheet 01	SHEET UPDATED	R
Fig. A-GBBAC Sheet 02	SHEET UPDATED	R
Fig. A-GBBAC Sheet 03	SHEET UPDATED	R
Fig. A-GBBAC Sheet 04	SHEET UPDATED	R
Fig. A-GBBAC Sheet 05	SHEET UPDATED	R
Fig. A-GBBAC Sheet 06	SHEET UPDATED	R
Fig. A-GBBAC Sheet 07	SHEET UPDATED	R
Fig. A-GBBAC Sheet 08	SHEET UPDATED	R
Fig. A-GBBAD		
Fig. A-GBBAD Sheet 01	SHEET UPDATED	R
Fig. A-GBBAD Sheet 02	SHEET UPDATED	R
Fig. A-GBBAD Sheet 03	SHEET UPDATED	R
Fig. A-GBBAD Sheet 04	SHEET UPDATED	R
Fig. A-GBBAD Sheet 05	SHEET UPDATED	R
Fig. A-GBBAD Sheet 06	SHEET UPDATED	R
Fig. A-GBBAD Sheet 07	SHEET UPDATED	R
Fig. A-GBCAA		
Fig. A-GBCAA Sheet 01	SHEET UPDATED	R
Fig. A-GBCAA Sheet 02	SHEET UPDATED	R
Fig. A-GBCAA Sheet 03	SHEET UPDATED	R
Fig. A-GBCAA Sheet 04	SHEET UPDATED	R
Fig. A-GBCAA Sheet 05	SHEET UPDATED	R
Fig. A-GBCAA Sheet 06	SHEET UPDATED	R
Fig. A-GBCAA Sheet 07	SHEET UPDATED	R
Fig. A-GBCAA Sheet 08	SHEET UPDATED	R
Fig. A-GBCAA Sheet 09	SHEET UPDATED	R
Fig. A-GBCAA Sheet 10	SHEET UPDATED	R

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Fig. A-GBCAA Sheet 11	SHEET UPDATED	R
Fig. A-GBCAB		
Fig. A-GBCAB Sheet 01	SHEET UPDATED	R
Fig. A-GBCAB Sheet 02	SHEET UPDATED	R
Fig. A-GBCAB Sheet 03	SHEET UPDATED	R
Fig. A-GBCAB Sheet 04	SHEET UPDATED	R
Fig. A-GBCAB Sheet 05	SHEET UPDATED	R
Fig. A-GBCAB Sheet 06	SHEET UPDATED	R
Fig. A-GBCAB Sheet 07	SHEET UPDATED	R
Fig. A-GBCAB Sheet 08	SHEET UPDATED	R
Fig. A-GBCAB Sheet 09	SHEET UPDATED	R
Fig. A-GBCAB Sheet 10	SHEET UPDATED	R
Fig. A-GBCAC		
Fig. A-GBCAC Sheet 01	SHEET UPDATED	R
Fig. A-GBCAC Sheet 02	SHEET UPDATED	R
Fig. A-GBCAC Sheet 03	SHEET UPDATED	R
Fig. A-GBCAC Sheet 04	SHEET UPDATED	R
Fig. A-GBCAC Sheet 05	SHEET UPDATED	R
Fig. A-GBCAC Sheet 06	SHEET UPDATED	R
Fig. A-GBCAC Sheet 07	SHEET UPDATED	R
Fig. A-GBCAC Sheet 08	SHEET UPDATED	R
Fig. A-GBCAD		
Fig. A-GBCAD Sheet 01	SHEET UPDATED	R
Fig. A-GBCAD Sheet 02	SHEET UPDATED	R
Fig. A-GBCAD Sheet 03	SHEET UPDATED	R
Fig. A-GBCAD Sheet 04	SHEET UPDATED	R
Fig. A-GBCAD Sheet 05	SHEET UPDATED	R
Fig. A-GBCAD Sheet 06	SHEET UPDATED	R
Fig. A-GBCAD Sheet 07	SHEET UPDATED	R
Fig. A-GBCAE	FIGURE SOLUTION ADDED	N
Fig. A-GBCAE Sheet 01	SHEET ADDED	N
Fig. A-GBCAE Sheet 02	SHEET ADDED	N
Fig. A-GBCAE Sheet 03	SHEET ADDED	N
Fig. A-GBCAE Sheet 04	SHEET ADDED	N
Fig. A-GBCAE Sheet 05	SHEET ADDED	N
Fig. A-GBCAE Sheet 06	SHEET ADDED	N
Fig. A-GBCAE Sheet 07	SHEET ADDED	N
Fig. A-GBCAE Sheet 08	SHEET ADDED	N
Fig. A-GBCAE Sheet 09	SHEET ADDED	N
Fig. A-GBCAE Sheet 10	SHEET ADDED	N
Fig. A-GBCAE Sheet 11	SHEET ADDED	N

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Fig. A-GBCAE Sheet 12	SHEET ADDED	N
Fig. A-GBDAA		
Fig. A-GBDAA Sheet 01	SHEET UPDATED	R
Fig. A-GBDAA Sheet 02	SHEET UPDATED	R
Fig. A-GBDAA Sheet 03	SHEET UPDATED	R
Fig. A-GBDAA Sheet 04	SHEET UPDATED	R
Fig. A-GBEAA		
Fig. A-GBEAA Sheet 01	SHEET UPDATED	R
Fig. A-GBEAA Sheet 02	SHEET UPDATED	R
Appendix 01 - Manpower Gantt Chart		
APPENDIX CONTENT	APPENDIX CONTENT ADDED	N
Fig. A-GAAAA	FIGURE SOLUTION UPDATED CONFIGURATION UPDATED	R
Fig. A-GAAAB	FIGURE SOLUTION UPDATED CONFIGURATION UPDATED	R
Fig. A-GAAAB Sheet 01	SHEET UPDATED	R
Fig. A-GAAAC	FIGURE SOLUTION ADDED	N
Fig. A-GAAAC Sheet 01	SHEET ADDED	N
Appendix 04 - Retrofitted Modifications		
APPENDIX CONTENT	APPENDIX CONTENT UPDATED	R

FILING INSTRUCTIONS

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

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

HISTORY OF PREVIOUS REVISIONS

Revision No. 01 issued to:

change compliance from Recommended to Mandatory,

add compliance time table in paragraph accomplishment timescale,

remove the FTI tool kits TOOLD06, TOOLD08, TOOLD09, TOOLD10, TOOLD11, TOOLD12, TOOLD13, TOOLD14, TOOLD15, TOOLD16 and TOOLD17.

Revision No. 02 issued to:

Reintroduce the jacking procedure

Add the procedure to rework the tooling holes at the existing inner doublers at the lower door frame area

Add the minimum allowable edge margins for the shims installation at the upper door area

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Update the kits to correct the grip length of some fasteners.

REVISION SEQUENCE

ORIGINAL: Jan 15/15

REVISION No. : 01 - Mar 03/16

REVISION No. : 02 - Oct 27/16

REVISION No. : 03 - Sep 10/18

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

MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - REINFORCE CIRCUMFERENTIAL JOINT BETWEEN FR53.6-FR53.7 FOR EMERGENCY DOOR TYPE 1 AREA

****CONF ALL**

MODIFICATIONS

MODIFICATION CLASSIFICATION					
MAJOR	204309D50888	204309D50892	204309D50893	204309D50904	
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 Widespread Fatigue Damage (WFD) analysis, it has been demonstrated that some structural areas require reinforcements before reaching the Design Service Goal (DSG). The circumferential joint between Frames (FR) Frame 53.6 and Frame 53.7 of emergency exit door type 1 has been identified as such area.

This modification comprises the structural reinforcement as follows:

- For aircraft in Config. 001:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 0 deg aligned rain gutter
  - . install modified scuff plate due to external doubler
  - . install additional cold worked holes (rivet with interference fit) at upper and lower door frame shell.

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- For aircraft in Config. 002:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 5 deg aligned rain gutter
  - . install modified scuff plate due to external doubler
- For aircraft in Config. 003:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 5 deg aligned rain gutter
- For aircraft in Config. 004:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-29 LH/RH
  - . install additional shim for door cover plate
- For aircraft in Config. 005:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 5 deg aligned rain gutter
  - . install modified scuff plate due to external doubler

The accomplishment of this Service Bulletin will improve the fatigue life of the circumferential joint between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH.

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. There may be additional or modified maintenance requirements, such as temporary limits or additional inspections that apply with respect to the Service Bulletin configuration.

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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 a RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support (SEOE) should be contacted. Repair review will be done by AIRBUS at conditions of the Customer Services Catalogue.

GENERAL EVALUATION

EVALUATION TABLE			
COMPLIANCE	MANDATORY (1)	CANCELS INSPECTION SB	NO
POTENTIAL AD	YES	A/C OPERATION AFFECTED	NO
RELIABILITY AFFECTED	NO	PAX COMFORT AFFECTED	NO
COST SAVING	NO	ETOPS AFFECTED	NO
STRUCTURAL LIFE EXTN	YES	VENDOR SB INVOLVED	NO
SPECIAL JACKING	YES	DE-FUELLING/VENTILATION	YES

NOTE (1): Service Bulletin must be accomplished.

MATERIAL PRICE INFORMATION

****CONF 001**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D01R04	1	21,020.00	Doublers, Shims, Plates, Nuts, Bolts, Screws, Washers
Kit 533226D05R03	1	21,020.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D09R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D10R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D11R02	1	265.00	Bolts, Rivets
TOTAL		**43,469.00**	
Standard tool TOOLD01	1	See SB	FTI Capital Tooling
Standard tool TOOLD02	1	See SB	FTI Durable Tooling
Standard tool TOOLD03	1	See SB	FTI Expendable Tooling

****CONF 002**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D02R05	1	20,860.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D06R02	1	20,860.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D09R01	1	582.00	Shim, Screw, Nut, Rivets and Plate

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MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D10R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D11R02	1	265.00	Bolts, Rivets
TOTAL		**43,149.00**	
Standard tool TOOLD01	1	See SB	FTI Capital Tooling
Standard tool TOOLD04	1	See SB	FTI Durable Tooling
Standard tool TOOLD05	1	See SB	FTI Expendable Tooling

****CONF 003**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D03R03	1	17,210.00	Shims, Doublers, Nuts, Bolts, Rivets
Kit 533226D07R04	1	17,210.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D09R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D10R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D11R02	1	265.00	Bolts, Rivets
TOTAL		**35,849.00**	
Standard tool TOOLD01	1	See SB	FTI Capital Tooling
Standard tool TOOLD04	1	See SB	FTI Durable Tooling
Standard tool TOOLD07	1	See SB	FTI Expendable Tooling

****CONF 004**

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D04R03	1	17,210.00	Shims, Doublers, Nuts, Bolts
Kit 533226D08R04	1	17,210.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D09R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D10R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D11R02	1	265.00	Bolts, Rivets
TOTAL		**35,849.00**	
Standard tool TOOLD01	1	See SB	FTI Capital Tooling
Standard tool TOOLD04	1	See SB	FTI Durable Tooling
Standard tool TOOLD07	1	See SB	FTI Expendable Tooling

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**CONF 005

MATERIAL PRICE INFORMATION TABLE			
MATERIAL SET	**QTY PER A/C**	**PRICE PER A/C (USD)**	**MAIN PARTS**
Kit 533226D12R00	1	20,900.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D13R00	1	20,900.00	Shims, Doublers, Plates, Nuts, Bolts, Screws, Washers, Rivets
Kit 533226D09R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D10R01	1	582.00	Shim, Screw, Nut, Rivets and Plate
Kit 533226D11R02	1	265.00	Bolts, Rivets
TOTAL		**43,229.00**	
Standard tool TOOLD01	1	See SB	FTI Capital Tooling
Standard tool TOOLD04	1	See SB	FTI Durable Tooling
Standard tool TOOLD05	1	See SB	FTI Expendable Tooling

EFFECTIVITY

**CONF ALL

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

01Q	12P	18Q	36P	38W	39V	41N	46O	56O	57L	64N	83V	87Z
97X	AAL	AAR	AAW	ABR	ACA	ACI	AEA	AFL	AFR	AIB	ALD	ALK
ARG	ASL	ASY	AVA	AZA	AZU	BEC	BEL	BOS	CBJ	CCA	CES	CHH
CPA	CRK	CSC	CSN	D2F	DAH	DAL	DGA	DLH	EIN	ETD	EVA	F2I
FAF	FIN	FJI	FWI	G8E	GCR	GFA	GIA	GRL	HAL	HDA	HFY	HVN
IBE	IRA	ISS	JAI	JAV	KAC	KAL	KLM	LAA	LMU	MAS	MAU	MEA
MLM	MSR	NMB	NWS	OHY	OMA	ONE	P2C	QAF	QFA	QTR	RNA	RSF
RSY	RWD	RZO	SAA	SAF	SAI	SAS	SIA	SVA	SWR	SXD	TAE	TAM
TAP	TAR	TBA	TCX	THA	THY	TOW	TSC	U6A	UAE	UAF	VIR	VOZ
WOW	WRC	XAX										

CONCURRENT REQUIREMENTS

None

REFERENCES / REPERCUSSIONS

TFU	None
OEB	None
AOT	None
SIL	51-012
ISI	None
LINE MAINTENANCE AFFECTED	No
LIFE LIMIT	None
OTHER	None

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NATURE OF THE WORK

AIRCRAFT	YES
EQUIPMENT	NO

MANPOWER

****CONF 001**

Task 533226-831-848-001: Modification	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

****CONF 002**

Task 533226-831-848-001: Modification	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

****CONF 003**

Task 533226-831-848-001: Modification	
TOTAL MANHOURS	266.00
ELAPSED TIME (HOURS)	56.25

****CONF 004**

Task 533226-831-848-001: Modification	
TOTAL MANHOURS	256.00
ELAPSED TIME (HOURS)	53.75

****CONF 005**

Task 533226-831-848-001: Modification	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

APPENDICES

****CONF ALL**

Appendix 01 - Manpower Gantt Chart

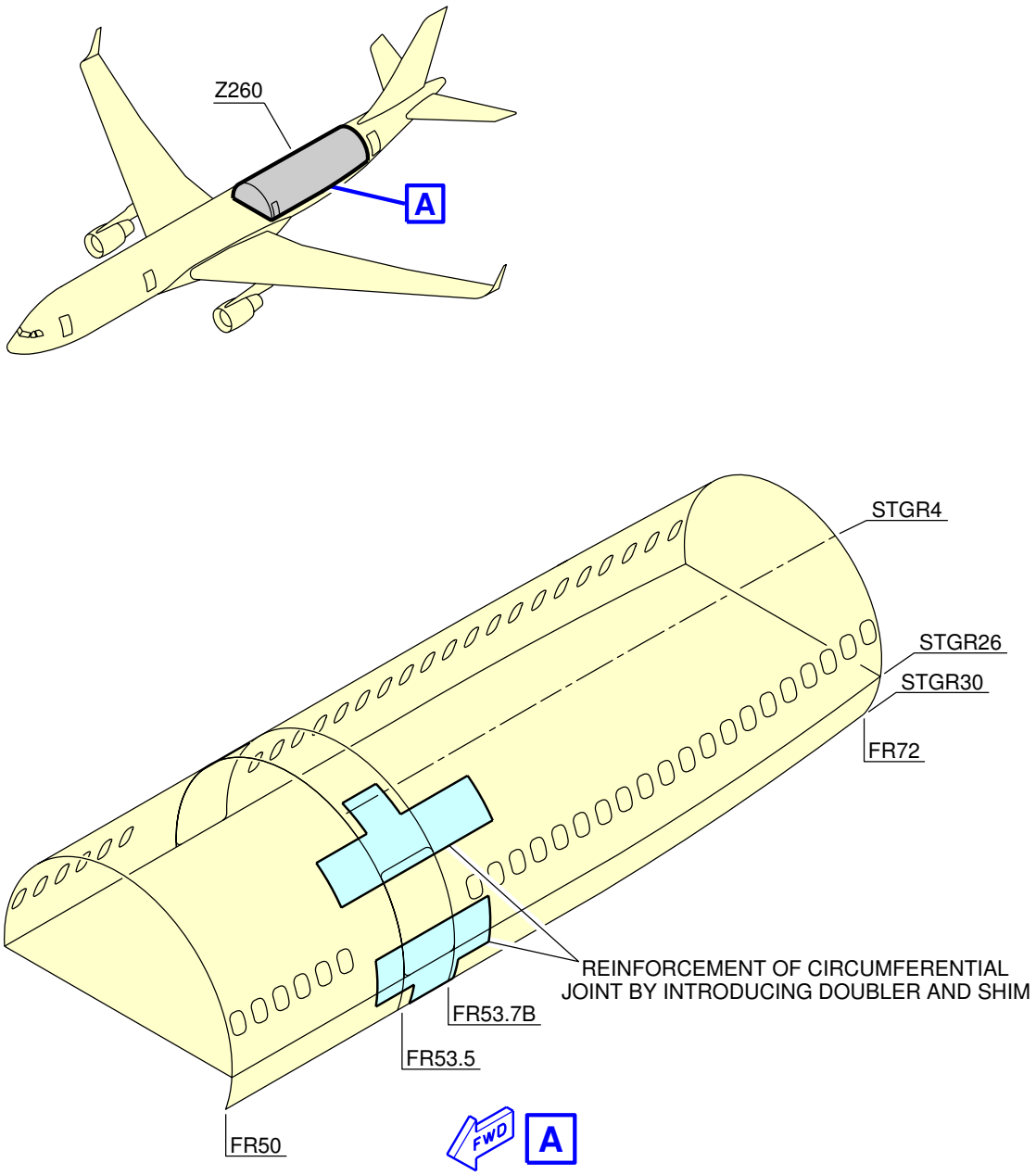
Appendix 02 - Zero Stress Jacking

Appendix 03 - Re-identification of the Emergency Exit Doors

Appendix 04 - Retrofitted Modifications

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**CONF 001 thru 002, 005

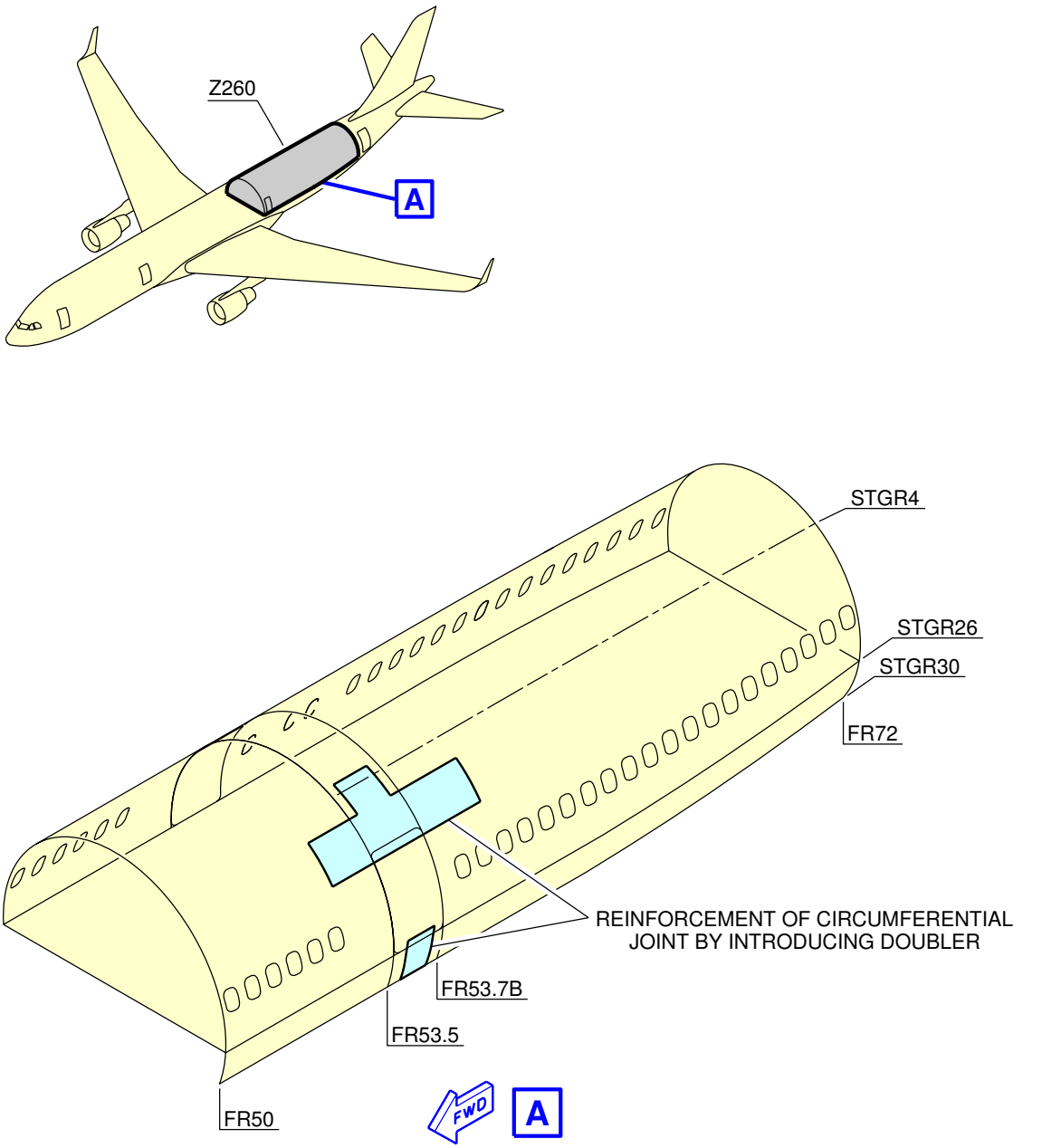


G_SB_533226_6_SAAA_01_02

Figure A-GSAAA - Sheet 01

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**CONF 003 thru 004



G_SB_533226_6_SAAB_01_02

Figure A-GSAAB - Sheet 01

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MANDATORY MANDATORY MANDATORY

ATA SYSTEM: 53

TITLE: FUSELAGE - CENTER FUSELAGE - REINFORCE CIRCUMFERENTIAL JOINT BETWEEN FR53.6-FR53.7 FOR EMERGENCY DOOR TYPE 1 AREA

MODIFICATION No.: 204309D50888 204309D50892 204309D50893 204309D50904

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1. PLANNING INFORMATION

****CONF ALL**

A. EFFECTIVITY

NOTE: This Service Bulletin is applicable on aircraft on which MOD No. 40161D17512 has not been embodied.

NOTE: This Service Bulletin is applicable to aircraft on which MOD No. 206136D52210, MOD No. 206136D52225, MOD No. 206136D52226 and MOD No. 206136D52227 (Service Bulletin No. A330-53-3273) are not embodied.

(1) Models

330-202 330-203 330-223 330-243 330-301 330-302 330-303 330-321
330-322 330-323 330-341 330-342 330-343

(2) Effectivity by MSN

0050 0060 0062 0065 0071 0083 0099 0102 0109 0112-0113 0116 0118 0121-0122
0138 0140 0143-0144 0148 0153 0155 0162 0165 0172 0181 0195 0200 0206 0209
0219 0222-0224 0226 0229-0232 0238 0240-0241 0244 0247-0249 0251 0253
0255-0256 0258-0259 0262 0267 0269 0275-0277 0279 0281 0283-0284 0286-0288

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0290-0291 0293 0295-0296 0300 0303 0305-0306 0308 0311-0317 0322-0324 0326
0328 0330 0333-0334 0337-0338 0340 0342-0346 0348 0350-0351 0358 0361
0364-0366 0368 0370 0372 0375 0380 0382 0384 0386 0388-0389 0392-0393
0396-0398 0400-0401 0404 0408-0409 0412 0418-0423 0437 0439 0443 0448
0451-0452 0455 0458 0462 0465-0466 0472-0473 0477 0481 0486-0487 0489 0491
0494 0496-0498 0500 0502-0503 0505-0511 0513 0515-0516 0518-0519 0521-0522
0524-0527 0529-0530 0532-0533 0535-0536 0539 0542 0548-0549 0552 0555 0565
0567-0568 0570-0571 0573 0576 0578-0579 0584 0587-0588 0591 0600 0605
0609-0610 0612 0614 0616 0618 0620-0621 0623 0625 0629 0631-0634 0636-0638
0640 0642 0644-0645 0647-0650 0652-0653 0655-0657 0659 0661 0663-0667 0674
0676 0678-0679 0682-0684 0686-0687 0690 0693 0696-0697 0700-0701 0703-0704
0708-0709 0713 0717-0718 0720 0722 0724 0726 0728-0730 0732 0735 0737-0738
0742-0743 0746-0747 0750-0751 0754-0756 0759-0760 0770 0772-0774 0776-0778
0780-0782 0784-0785 0788 0791-0792 0796-0797 0799 0801 0803 0806-0807
0809-0811 0815 0817-0822 0824-0825 0827 0830-0832 0834 0836 0839-0843 0845
0849-0855 0857-0860 0862-0863 0865-0869 0871 0873-0877 0879 0881-0885
0887-0892 0895-0896 0898-0901 0903-0906 0908-0909 0913-0916 0919 0922-0923
0925-0928 0930 0932 0934-0937 0939-0949 0951 0954 0956-0959 0961-0964
0967-0970 0973 0975-0980 0982-0984 0986 0988-0991 0994-0998 1000 1002-1003
1006-1007 1009-1016 1018-1020 1022-1023 1026 1028-1029 1031 1033-1039
1041-1047 1049 1052-1054 1057 1059-1061 1063 1067 1069 1071 1073-1074 1076
1078 1080-1082 1084-1086 1088-1090 1093-1096 1098-1101 1104-1105 1107-1108
1112 1114 1116 1118 1120 1123-1124 1127 1129 1132-1133 1135 1137-1138 1141
1143 1145-1147 1149-1150 1153 1155-1157 1159-1161 1163 1167-1174 1178 1181
1183-1184 1186 1188-1192 1196 1198 1200 1202-1205 1208-1210 1212-1214
1217-1230 1233-1241 1243-1246 1248-1252 1255-1256 1258-1264 1266-1267 1269
1271 1275-1277 1279-1283 1285-1295 1297-1298 1300 1302-1314 1316-1319 1322
1324-1325 1327 1330-1331 1334-1338 1342-1343 1347-1349 1354-1355 1358
1362-1366 1369 1372 1374-1375 1377 1379 1381-1382 1384-1385 1387-1390
1392-1405 1407-1410 1412 1415-1417 1419 1421-1422 1425-1427 1429-1432 1434
1436-1441 1443-1444 1446-1447 1451-1455 1457-1459 1461-1462 1465-1466
1468-1474 1476-1480 1483-1492 1494 1496-1503 1505 1507-1508 1511-1517
1519-1521 1523 1526 1528-1530 1532 1535-1537 1540 1542-1545 1547-1548 1551
1554-1558 1560-1562 1565 1567 1569 1571-1577 1579-1580 1582 1585-1586 1588
1590-1593 1595 1597-1599 1601 1603 1605-1611 1613-1618 1620-1645 1647-1649
1651 1653-1657 1660 1662-1668 1671-1672 1676-1679 1681 1686 1694 1696-1701
1703-1704 1706 1709-1710 1713-1716 1718-1721 1723 1725 1728 1730 1732-1733
1735-1737 1740-1741 1745-1748 1751 1753-1763 1769 1771 1773 1775-1777
1779-1780 1782-1785 1787-1788 1792-1793 1796 1798-1799 1801 1804-1805
1808-1809 1814-1816 1818 1821-1823 1825-1826 1830 1833 1835 1841-1842
1845-1848 1852 1854 1856-1859 1864 1868-1869 1872-1873 1877-1878 1881-1883
1885-1886 1891 1894 1905 1911-1912 1916 1919 1928 1932 1936

(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
01Q	1830
12P	1787 1848 1883 1891

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OPERATOR	MSN
18Q	1019
36P	1911 1919
38W	0401
39V	0255
41N	1676
46O	0655
56O	0231
57L	0735
64N	1751
83V	0366
87Z	0535
97X	1053
AAL	0315 0323 0333 0337 0342 0370 0375 0380 0388 1011 1022 1041 1069 1076 1095 1100 1415 1417 1441 1455 1480 1502 1512 1526
AAR	0640 0676 0708 0772 0803 0845
AAW	1043 1472 1535
ABR	0116
ACA	0277 0279 0284 0344 0400 0408 0412 0419
ACI	0507 0510
AEA	0505 0526 1574
AFL	0963 0973 1014 1045 1047 1264
AFR	0422 0443 0448 0458 0465 0481 0498 0500 0502 0503 0516 0519 0567 0584 0657
AIB	0871
ALD	0326 0328 0392
ALK	0303 0306 0311 0313
ARG	0290 0300 0358 0364 0587 0634 1605 1623 1737 1748
ASL	0885
ASY	0747 0892 0898 0951 0969 1036 1183
AVA	1009 1016 1073 1224 1279 1342 1400
AZA	0825 0831 1123 1135 1218 1225 1252 1283 1308 1313 1327 1354
AZU	0365 0372 0462 0494 0527 0529 0532
BEC	0863
BEL	0229 0249 0291 0324 0895 0915 0959 1010 1085
BOS	1864 1882
CBJ	0988 1020 1028 1052 1753 1763 1775 1782 1847
CCA	0750 0756 0759 0780 0785 0797 0810 0815 0839 0860 0867 0873 0884 0890 0903 0909 0930 0941 0944 0957 1237 1260 1282 1304 1330 1396 1434 1444 1459 1471
CES	0773 0777 0781 0782 0791 0821 0830 0836 0851 0862 0866 0916 0928 0936 0942 1262 1267 1280 1291 1303 1324 1331 1372 1375 1402 1421 1429 1440 1461 1468 1479 1484 1500 1520 1537 1547 1551 1569 1588 1595 1603 1617 1632 1639 1655 1664 1788 1796 1798 1801 1804 1809 1816 1833 1841 1842 1868 1869 1873 1881 1905
CHH	0875 0881 0906 0919 0982 1159 1168 1178 1190 1255 1325 1438 1532 1558 1573 1591 1614 1634 1656 1663 1677 1686 1703

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OPERATOR	MSN
CPA	0102 0113 0121 0386 0389 0393 0418 0420 0421 0423 0439 0539 0548 0565 0679 0776 0850 0855 1163 1196 1222 1239 1285 1317 1343 1349 1362 1366 1387 1409 1436 1443 1618 1621
CRK	0396 0452 1031 1034 1039 1042 1054 1059 1099 1105 1107 1124 1146 1157 1277 1286 1322 1358 1369 1384 1398 1668
CSC	1082 1138 1241 1397 1432 1528 1579 1662 1746 1780 1825 1856 1912
CSN	0649 0652 0656 0664 0818 0840 0879 0889 0908 0935 0937 0954 0958 0964 1096 1116 1129 1202 1220 1233 1244 1297 1309 1335 1392 1425 1430 1494 1519 1536 1575 1593 1625 1636 1645 1699 1714 1760 1776 1793 1814 1815 1818 1821 1826 1846 1852 1858 1885 1894
D2F	0209
DAH	0644 0647 0650 0653 0667 1613 1630 1649
DAL	0524 0533 0542 0549 0552 0578 0588 0591 0609 0614 0618 0620 0621 0631 0633 0663 0674 0690 0718 0722 0778 0784 0796 0799 0806 0817 0827 0843 0857 0858 0859 0865 1627 1628 1637 1679 1701 1716 1720 1721 1769 1783
DGA	0240
DLH	0570 0576 0579 0629 0636 0642 0645 0648 0687 0701 0896 0905 0913 0922 0989 1292 1305 1314 1497
EIN	0269 0330 0397 0841
ETD	0717 0724 0729 0730 0737 0788 0809 0824 0832 0852 0854 0868 0975 0991 1071 1081 1167 1205 1226 1245 1486 1521
EVA	0678 0693 0755
F2I	0200 0275
FAF	1735 1808 1916
FIN	0994 1007 1013 1023 1067 1078 1088 1173
FJI	0751 0807 1394 1416 1465
FWI	0253 0343
G8E	0288
GCR	1756 1758 1773 1805
GFA	0276 0281 0286 0287 0334 0340
GIA	0138 0140 0144 0148 0153 0165 1184 1214 1261 1288 1364 1410 1446 1474 1548 1560 1577 1585 1654 1671 1698 1709 1723 1733
GRL	0230
HAL	1104 1114 1171 1217 1259 1295 1302 1310 1316 1389 1399 1404 1422 1469 1488 1496 1511 1530 1565 1606 1615 1672 1732 1823
HDA	0071 0083 0099 0109 0118 0155 0244 1457 1503 1523 1545 1557 1567 1598
HFY	0262
HVN	0943 0962 1256 1266
IBE	1377 1385 1405 1426 1437 1490 1507 1515 1694 1700 1710 1719 1728 1736 1740 1747 1755 1761 1777 1784 1835 1854 1877 1932 1936
IRA	1540 1586
ISS	0521 0571
JAI	0888 0923 0947 0956

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OPERATOR	MSN
JAV	0409
KAC	1626 1643 1653 1678 1681
KAL	0162 0172 0206 0219 0222 0226 0241 0256 0258 0267 0338 0350 0351 0368 1133 1155 1200 1203 1393 1556 1576 1590 1611 1638 1647
KLM	0682 0686 0703 0738 0770 0801 0925 1161 1287 1294 1300 1381 1580
LAA	1412 1505 1543
LMU	0661
MAS	0665 0822 0968 1112 1209 1219 1229 1234 1243 1281 1318 1336 1337 1347 1388 1395 1431 1470 1489
MAU	0883 1057
MEA	0926 0984 0995 0998 1725
MLM	0451
MSR	0600 0610 0666 0683 0696 0709 0726 1143 1230 1238 1246
NMB	1451 1466
NWS	0979 1002
OHY	0316 0345 0404 0437 0491 0509 0525 0625 0632
OMA	1038 1044 1049 1063 1093 1120 1227 1572 1582 1599
ONE	1208 1492 1508 1608 1657
P2C	0891 0927
QAF	0487 0605
QFA	0506 0508 0513 0522 0842 0853 0887 0940 0945 0976 1061 1094 1169 1174 1198 1251 1258 1365
QTR	0473 0489 0511 0623 0637 0638 0659 0743 0746 0760 0792 0820 0849
RNA	1872 1878
RSF	0980 0996 1235 1379 1478 1516
RSY	0283 0293 0295 0472 0700 0946
RWD	1741 1759
RZO	0970
SAA	1191 1210 1223 1236 1249 1271 1745 1754 1757 1779 1792
SAF	1667 1762 1799 1822 1857 1886
SAI	0811 0819 0834 0900
SAS	0496 0497 0515 0568 1660 1665 1697 1715 1928
SIA	0978 0983 0986 1132 1149 1156 1382 1401 1427 1447 1453 1477 1485 1517 1544 1562 1597 1609 1633 1648 1666
SVA	1108 1127 1137 1141 1147 1153 1189 1192 1454 1462 1473 1513
SWR	1000 1018 1026 1029 1084 1089 1101 1145 1181 1188 1276 1290 1355 1403
SXD	0530 0555 0573 0612 0616 0684
TAE	0348
TAM	0232 0238 0247 0259 0361 0466
TAP	0181 0195 0223 0305 0308 0312 0317 0477 0486 0877 0899 0904 0914 0934 0997 1006 1012 1015
TAR	1631 1641
TBA	1730 1771 1785 1845 1859

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OPERATOR	MSN
TCX	0398 0948 0967
THA	0050 0060 0062 0112 0122 0346 0990 1003 1035 1037 1060 1074 1086 1090 1263 1269 1289 1338 1348 1374 1408
THY	0697 0704 0742 0754 0774 0869 0874 0876 0882 0901 0932 0939 0949 0961 0977 1118 1150 1160 1170 1172 1204 1212 1213 1221 1228 1240 1298 1307 1311 1458 1476 1483 1487 1491 1499 1501 1514 1529 1542 1554 1571 1592 1616 1620 1622 1629 1635 1640 1642 1644 1651 1696 1704 1706 1713 1718
TOW	1033 1046 1248 1275 1312 1334 1363 1390 1419 1439 1498 1555 1601 1610
TSC	0248 0251 0314 0455 0518 0536 0728 0732
U6A	0065 0143 0224
UAE	0382 0384
UAF	1080 1186 1250
VIR	0322
VOZ	1293 1306 1319 1407 1452 1561
WOW	1098 1607 1624
WRC	0296
XAX	0713 0720

(4) Configuration by MSN

MSN	CONFIGURATION
0050 0060 0062 0065 0071 0083 0099 0102 0109 0112	001
0113 0116 0118 0121 0122	005
0138 0140 0143 0144 0148 0153 0155 0162 0165 0172 0181 0195 0200 0206 0209 0219 0222 0223 0224 0226 0229 0230 0231 0232 0238 0240 0241 0244 0247 0248 0249 0251 0253 0255 0256 0258 0259 0262 0267 0269 0275 0276 0277 0279 0281 0283 0284 0286 0287 0288 0290 0291 0293 0295 0296 0300 0303 0305 0306 0308 0311 0312 0313 0314 0315 0316 0317 0322 0323 0324 0326 0328 0330 0333 0334 0337 0338 0340 0342 0343 0344 0345 0346 0348 0350 0351 0358 0361 0364 0365 0366 0368 0370 0372 0375 0380 0382 0384 0386 0388 0389 0392 0393 0396 0397 0398 0400 0401 0404 0408 0409 0412 0418 0419 0420 0421 0422 0423 0437 0439 0443 0448 0451 0452 0455 0458 0462 0465 0466 0472 0473 0477 0481 0486 0487 0489 0491 0494 0496 0497 0498 0500 0502 0503 0505 0506 0507 0508 0509 0510 0511 0513 0515 0516 0518 0519 0521 0522 0524 0525 0526 0527 0529 0530 0532 0533 0535 0536 0539 0542 0548 0549 0552 0555 0565 0567 0568 0570 0571 0573 0576 0578 0579 0584 0587 0588 0591 0600 0605 0609 0610 0612 0614 0616 0618 0620 0621 0623 0625 0629	002

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MSN	CONFIGURATION
0631 0632 0633 0634 0636 0637 0638 0640 0642 0644 0645 0647 0648 0649 0650 0652 0653 0655 0656 0657 0659 0661 0663 0664 0665 0666 0667 0674 0676 0678 0679 0682 0683 0684 0686 0687 0690 0693 0696 0697 0700 0701 0703 0704 0708 0709 0713 0717 0718 0720 0722 0724 0726 0728 0729 0730 0732 0735 0737 0738 0742 0743 0746 0747 0750 0751 0754 0755 0756 0759 0760 0770 0772 0773 0774 0776 0777 0778 0780 0781 0782 0784 0785 0788 0791 0792 0796 0797 0799 0801 0803 0806 0807 0809 0810 0811 0815 0817 0818 0819 0820 0821 0822 0824 0825 0827 0830 0831 0832 0834 0836 0839 0840 0841 0842 0843 0845 0849 0850 0851 0852 0853 0854 0855 0857 0858 0859 0860 0862 0863 0865 0866 0867 0868 0869 0871 0873 0874 0875 0876 0877 0879 0881 0882 0883 0884 0885 0887 0888 0889 0890 0891 0892 0895 0896 0898 0899 0900 0901 0903 0904 0905 0906 0908 0909 0913 0914 0915 0916 0919 0922 0923 0925 0926 0927 0928 0930 0932 0934 0935 0936 0937 0939 0940 0941 0942 0943 0944 0945 0946 0947 0948 0949 0951 0954 0956 0957 0958 0959 0961 0962 0963 0964 0967 0968 0969 0970 0973 0975 0976 0977 0978 0979 0980 0982 0983 0984 0986 0988 0989 0990 0991 0994 0995 0996 0997 0998 1000 1002 1003 1006 1007 1009 1010 1011 1012 1013 1014 1015 1016 1018 1019 1020 1022 1023 1026 1028 1029 1031 1033 1034 1035 1036 1037 1038 1039 1041 1042 1043 1044 1045 1046 1047 1049 1052 1053 1054 1057 1059 1060 1061 1063 1067 1069 1071 1073 1074 1076 1078 1080 1081 1082 1084 1085 1086 1088 1089 1090 1093 1094 1095 1096 1098 1099 1100 1101 1104 1105 1107 1108 1112 1114 1116 1118 1120 1123 1124 1127 1129 1132 1133 1135 1137 1138 1141 1143 1145 1146 1147 1149 1150 1153 1155 1156 1157 1159 1160 1161 1163 1167 1168 1169 1170 1171 1172 1173 1174 1178 1181 1183 1184 1186 1188 1189 1190 1191 1192 1196 1198 1200 1202 1203 1204 1205 1208 1209 1210 1212 1213 1214 1217 1218 1219 1220 1221 1222 1223 1224 1225 1226 1227 1228 1229 1230 1233 1234 1235 1236 1237 1238 1239 1240 1241 1243 1244 1245 1246 1248 1249 1250 1251 1252 1255 1256 1258 1259 1260 1261 1262 1263 1264 1266 1267 1269 1271 1275 1276 1277 1279 1280 1281 1282 1283 1285 1286 1287 1288 1289 1290 1291 1292 1293 1294 1295 1297 1298 1300 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312 1313 1314 1316 1317 1318 1319 1322 1324 1325 1327 1330 1331 1334 1335 1336 1337 1338 1342 1343 1347 1348 1349 1354 1355 1358 1362 1363 1364 1365 1366 1369 1372 1374 1375 1377	003

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MSN	CONFIGURATION
1379 1381 1382 1384 1385 1387 1388 1389 1390 1392 1393 1394 1395 1396 1397 1398 1399 1400 1401 1402 1403 1404 1405 1407 1408 1409 1410 1412 1415 1416 1417 1419 1421 1422 1425 1426 1427 1429 1430 1431 1432 1434 1436 1437 1438 1439 1440 1441 1443 1444 1446 1447 1451 1452 1453 1454 1455 1457 1458 1459 1461 1462 1465 1466 1468 1469 1470 1471 1472 1473 1474 1476 1477 1478 1479 1480 1483 1484 1485 1486 1487 1488 1489 1490 1491 1492 1494 1496 1497 1498 1499 1500 1501 1502 1503 1505 1507 1508 1511 1512 1513 1514 1515 1516 1517 1519 1520 1521 1523 1526 1528 1529 1530 1532 1535 1536 1537 1540 1542 1543 1544 1545 1547 1548 1551 1554 1555 1556 1557 1558 1560 1561 1562 1565 1567 1569 1571 1572 1573 1574 1575 1576 1577 1579 1580 1582 1585 1586 1588 1590 1591 1592 1593 1595 1597 1598 1599 1601 1603 1605 1606 1607 1608 1609 1610 1611 1613 1614 1615 1616 1617 1618 1620 1621 1622 1623 1624 1625 1626 1627 1628 1629 1630 1631 1632 1633 1634 1635 1636 1637 1638 1639 1640 1641 1642 1643 1644 1645 1647 1648 1649 1651 1653 1654 1655 1656 1657 1660 1662 1663 1664 1665 1666 1667 1668 1671 1672 1676 1677 1678 1679 1681 1686 1694 1696 1697 1698 1699 1700 1701 1703 1704 1706 1709 1710 1713 1714 1715 1716 1718 1719 1720 1721 1723 1725 1728 1730 1732 1733 1735 1736 1737 1740 1741 1745 1746 1747 1748 1751 1753 1754 1755 1756 1757 1758 1759 1760 1761 1762 1763 1769 1771 1773 1775 1776 1777 1779 1780 1782 1783 1784 1785 1787 1788 1792 1793 1796 1798 1799 1801 1804 1805 1808 1809 1814 1815 1816 1818 1821 1822 1823 1825 1826 1830 1833 1835 1841 1842 1845 1846 1847 1848 1852 1854 1856 1857 1858 1859 1864 1868 1869 1872 1873 1877 1878 1881 1882 1883 1885 1886 1891 1894 1905 1911 1912 1916 1919 1928 1932 1936	004

(5) Configuration definition

**CONF 001
Config. 001 is valid for aircraft on which:
- MOD No. 202436D50514,
- MOD No. 41848D19279,
- MOD No. 43120D40069 and
- MOD No. 51331D44374 are not embodied.

**CONF 002
Config. 002 is valid for aircraft on which:
- MOD No. 41848D19279 and
- MOD No. 43120D40069 are embodied.
and on which:
- MOD No. 202436D50514 and
- MOD No. 51331D44374 are not embodied.

**CONF 003
Config. 003 is valid for aircraft on which:
- MOD No. 41848D19279,

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- MOD No. 43120D40069 and
- MOD No. 51331D44374 are embodied.

and on which:

- MOD No. 202436D50514 is not embodied.

**CONF 004

Config. 004 is valid for aircraft on which:

- MOD No. 202436D50514,
- MOD No. 41848D19279,
- MOD No. 43120D40069 and
- MOD No. 51331D44374 are embodied.

**CONF 005

Config. 005 is valid for aircraft on which:

- MOD No. 41848D19279 is embodied.

and on which:

- MOD No. 202436D50514,
- MOD No. 43120D40069 and
- MOD No. 51331D44374 are not embodied.

For the retrofitted modifications after accomplishment of this Service Bulletin, refer to Appendix 04 - Retrofitted Modifications .

(6) Material Effectivity

**CONF 001

MATERIAL	QTY PER A/C	SEE NOTES
Consumable CMLD01	1	
Kit 533226D01R04	1	
Kit 533226D05R03	1	
Kit 533226D09R01	1	
Kit 533226D10R01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD02	1	
Standard tool TOOLD03	1	
Kit 533226D11R02	1	

**CONF 002

MATERIAL	QTY PER A/C	SEE NOTES
Consumable CMLD01	1	
Kit 533226D02R05	1	
Kit 533226D06R02	1	
Kit 533226D09R01	1	
Kit 533226D10R01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD04	1	
Standard tool TOOLD05	1	
Kit 533226D11R02	1	

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**CONF 003

MATERIAL	QTY PER A/C	SEE NOTES
Consumable CMLD01	1	
Kit 533226D03R03	1	
Kit 533226D07R04	1	
Kit 533226D09R01	1	
Kit 533226D10R01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD04	1	
Standard tool TOOLD07	1	
Kit 533226D11R02	1	

**CONF 004

MATERIAL	QTY PER A/C	SEE NOTES
Consumable CMLD01	1	
Kit 533226D04R03	1	
Kit 533226D08R04	1	
Kit 533226D09R01	1	
Kit 533226D10R01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD04	1	
Standard tool TOOLD07	1	
Kit 533226D11R02	1	

**CONF 005

MATERIAL	QTY PER A/C	SEE NOTES
Consumable CMLD01	1	
Kit 533226D12R00	1	
Kit 533226D13R00	1	
Kit 533226D09R01	1	
Kit 533226D10R01	1	
Standard tool TOOLD01	1	
Standard tool TOOLD04	1	
Standard tool TOOLD05	1	
Kit 533226D11R02	1	

**CONF ALL

B. CONCURRENT REQUIREMENTS

None

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C. REASON

(1) History

Following Widespread Fatigue Damage (WFD) analysis, it has been demonstrated that some structural areas require reinforcements before reaching the Design Service Goal (DSG). The circumferential joint between Frames (FR) Frame 53.6 and Frame 53.7 of emergency exit door type 1 has been identified as such area.

(2) Objective/Action

This modification comprises the structural reinforcement as follows:

- For aircraft in Config. 001:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 0 deg aligned rain gutter
  - . install modified scuff plate due to external doubler
  - . install additional cold worked holes (rivet with interference fit) at upper and lower door frame shell.
- For aircraft in Config. 002:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 5 deg aligned rain gutter
  - . install modified scuff plate due to external doubler
- For aircraft in Config. 003:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH
  - . install additional shim for door cover plate
  - . install additional shim for 5 deg aligned rain gutter
- For aircraft in Config. 004:
  - . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-29 LH/RH
  - . install additional shim for door cover plate

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- For aircraft in Config. 005:

  . install external, circumferential doubler between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH

  . install additional shim for door cover plate

  . install additional shim for 5 deg aligned rain gutter

  . install modified scuff plate due to external doubler

(3) Advantages

The accomplishment of this Service Bulletin will improve the fatigue life of the circumferential joint between Frame 53.6 and Frame 53.7, STGR4-30 LH/RH.

(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. 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 a RAS issued by AIRBUS, AIRBUS Customer Services Repair Engineering Support (SEOE) 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 :

****CONF 001**

Task 533226-831-848-001: Modification

(1) Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

(2) Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

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(3) Remove the Scuff Plates from the LH Emergency Exit Door

(4) Remove the Scuff Plates from the RH Emergency Exit Door

(5) Remove Cross Plate from the Emergency Door Upper Area, LH

(6) Remove Cross Plate from the Emergency Door Upper Area, RH

(7) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(8) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(9) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(10) Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(11) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(12) Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(13) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(14) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(15) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(16) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(17) Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(18) Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(19) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(20) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(21) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(22) Do the Inpection of Fastener Holes at Upper Aft Corner of the Door Frame at

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Emergency Exit Door Type 1 RH

(23) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(24) Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(25) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(26) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(27) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(28) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(29) Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(30) Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(31) Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

(32) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(33) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(34) Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(35) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(36) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(37) Install Rain Gutter at Emergency Exit Door Type 1 Area LH

(38) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(39) Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

(40) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(41) Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and

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between STGR4 and STGR15A, RH

(42) Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(43) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(44) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(45) Install Rain Gutter at Emergency Exit Door Type 1 Area RH

(46) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(47) Apply Protections to the Upper Door Frame Area, LH

(48) Apply Protections to the Lower Door Frame Area, LH

(49) Apply Protections to the Upper Door Frame Area, RH

(50) Apply Protections to the Lower Door Frame Area, RH

(51) Install Cross Plate of the Emergency Door Upper Area, LH

(52) Install Cross Plate of the Emergency Door Upper Area, RH

(53) Install the Scuff Plates to the LH Emergency Exit Door

(54) Install the Scuff Plates to the RH Emergency Exit Door

(55) Do the Modification of the LH Emergency Exit Door

(56) Do the Modification of the RH Emergency Exit Door

****CONF 002**

Task 533226-831-848-001: Modification

(1) Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

(2) Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

(3) Remove the Scuff Plates from the LH Emergency Exit Door

(4) Remove the Scuff Plates from the RH Emergency Exit Door

(5) Remove Cross Plate from the Emergency Door Upper Area, LH

(6) Remove Cross Plate from the Emergency Door Upper Area, RH

(7) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

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(8) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(9) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(10) Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(11) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(12) Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(13) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(14) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(15) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(16) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(17) Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(18) Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(19) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(20) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(21) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(22) Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(23) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(24) Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(25) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

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(26) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(27) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(28) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(29) Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(30) Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(31) Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

(32) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(33) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(34) Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(35) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(36) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(37) Install Rain Gutter at Emergency Exit Door Type 1 Area LH

(38) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(39) Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

(40) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(41) Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(42) Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(43) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(44) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

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(45) Install Rain Gutter at Emergency Exit Door Type 1 Area RH

(46) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(47) Apply Protections to the Upper Door Frame Area, LH

(48) Apply Protections to the Lower Door Frame Area, LH

(49) Apply Protections to the Upper Door Frame Area, RH

(50) Apply Protections to the Lower Door Frame Area, RH

(51) Install Cross Plate of the Emergency Door Upper Area, LH

(52) Install Cross Plate of the Emergency Door Upper Area, RH

(53) Install the Scuff Plates to the LH Emergency Exit Door

(54) Install the Scuff Plates to the RH Emergency Exit Door

(55) Do the Modification of the LH Emergency Exit Door

(56) Do the Modification of the RH Emergency Exit Door

****CONF 003**

Task 533226-831-848-001: Modification

(1) Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

(2) Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

(3) Remove Cross Plate from the Emergency Door Upper Area, LH

(4) Remove Cross Plate from the Emergency Door Upper Area, RH

(5) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(6) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(7) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(8) Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(9) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(10) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

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(11) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(12) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(13) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(14) Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(15) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(16) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(17) Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

(18) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(19) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(20) Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(21) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(22) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(23) Install Rain Gutter at Emergency Exit Door Type 1 Area LH

(24) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(25) Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

(26) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(27) Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(28) Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(29) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

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(30) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(31) Install Rain Gutter at Emergency Exit Door Type 1 Area RH

(32) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(33) Apply Protections to the Upper Door Frame Area, LH

(34) Apply Protections to the Lower Door Frame Area, LH

(35) Apply Protections to the Upper Door Frame Area, RH

(36) Apply Protections to the Lower Door Frame Area, RH

(37) Install Cross Plate of the Emergency Door Upper Area, LH

(38) Install Cross Plate of the Emergency Door Upper Area, RH

(39) Do the Modification of the LH Emergency Exit Door

(40) Do the Modification of the RH Emergency Exit Door

****CONF 004**

Task 533226-831-848-001: Modification

(1) Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

(2) Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

(3) Remove Cross Plate from the Emergency Door Upper Area, LH

(4) Remove Cross Plate from the Emergency Door Upper Area, RH

(5) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(6) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(7) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(8) Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(9) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(10) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

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(11) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(12) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(13) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(14) Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(15) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(16) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(17) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(18) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(19) Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(20) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(21) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(22) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(23) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(24) Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(25) Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(26) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(27) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(28) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

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(29) Apply Protections to the Upper Door Frame Area, LH

(30) Apply Protections to the Lower Door Frame Area, LH

(31) Apply Protections to the Upper Door Frame Area, RH

(32) Apply Protections to the Lower Door Frame Area, RH

(33) Install Cross Plate of the Emergency Door Upper Area, LH

(34) Install Cross Plate of the Emergency Door Upper Area, RH

(35) Do the Modification of the LH Emergency Exit Door

(36) Do the Modification of the RH Emergency Exit Door

**CONF 005

Task 533226-831-848-001: Modification

(1) Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

(2) Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

(3) Remove the Scuff Plates from the LH Emergency Exit Door

(4) Remove the Scuff Plates from the RH Emergency Exit Door

(5) Remove Cross Plate from the Emergency Door Upper Area, LH

(6) Remove Cross Plate from the Emergency Door Upper Area, RH

(7) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(8) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(9) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(10) Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(11) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(12) Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(13) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(14) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at

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Emergency Exit Door Type 1 LH

(15) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(16) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(17) Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

(18) Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

(19) Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(20) Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(21) Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(22) Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(23) Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(24) Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(25) Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(26) Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(27) Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(28) Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(29) Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

(30) Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

(31) Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

(32) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

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(33) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(34) Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(35) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(36) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

(37) Install Rain Gutter at Emergency Exit Door Type 1 Area LH

(38) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

(39) Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

(40) Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(41) Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(42) Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(43) Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(44) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

(45) Install Rain Gutter at Emergency Exit Door Type 1 Area RH

(46) Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

(47) Apply Protections to the Upper Door Frame Area, LH

(48) Apply Protections to the Lower Door Frame Area, LH

(49) Apply Protections to the Upper Door Frame Area, RH

(50) Apply Protections to the Lower Door Frame Area, RH

(51) Install Cross Plate of the Emergency Door Upper Area, LH

(52) Install Cross Plate of the Emergency Door Upper Area, RH

(53) Install the Scuff Plates to the LH Emergency Exit Door

(54) Install the Scuff Plates to the RH Emergency Exit Door

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(55) Do the Modification of the LH Emergency Exit Door

(56) Do the Modification of the RH Emergency Exit Door

****CONF ALL**

E. COMPLIANCE

(1) Classification

MANDATORY: Service Bulletin must be accomplished.

(2) Accomplishment Timescale

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

Table 1, all Config. - Compliance Time

Weight Variant (WV) Group *		Threshold from first flight (whichever occurs first)		Grace period
		Flight Cycles (FC)	Flight Hours (FH)	Months (M)
Group 32A	Short Range (SR) **	26100	91600	12
	Long Range (LR) ***	21000	137200	12
Group 32E	SR **	19900	69900	12
	LR ***	16200	105100	12
Group 33A	SR **	34400	103300	12
	LR ***	27800	187300	12
Group 33B	SR **	19900	59800	12
	LR ***	16100	108400	12
Group 33C Group 33D Group 33E	SR **	15600	46800	12
	LR ***	12600	84800	12

NOTE: *

- For definitions of WV Groups, refer to Airworthiness Limitation Section (ALS) Part 2.

NOTE: **

- FC-optimized set, optimized for aircraft in SR operations.

NOTE: ***

- FH-optimized set, optimized for aircraft in LR operations.

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F. APPROVAL

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

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

G. MANPOWER

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

****CONF 001**

Task 533226-831-848-001: Modification	
Get Access	26.00
On Aircraft	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH	1.00
Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH	1.00
Remove the Scuff Plates from the LH Emergency Exit Door	2.00
Remove the Scuff Plates from the RH Emergency Exit Door	2.00
Remove Cross Plate from the Emergency Door Upper Area, LH	6.00
Remove Cross Plate from the Emergency Door Upper Area, RH	6.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00

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Task 533226-831-848-001: Modification	
Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inpection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area LH	1.00

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Task 533226-831-848-001: Modification	
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	10.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	1.50
Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area LH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	19.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area RH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	10.00
Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	1.50
Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area RH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	19.00
Apply Protections to the Upper Door Frame Area, LH	0.25
Apply Protections to the Lower Door Frame Area, LH	0.25
Apply Protections to the Upper Door Frame Area, RH	0.25
Apply Protections to the Lower Door Frame Area, RH	0.25
Install Cross Plate of the Emergency Door Upper Area, LH	6.00
Install Cross Plate of the Emergency Door Upper Area, RH	6.00
Install the Scuff Plates to the LH Emergency Exit Door	6.00
Install the Scuff Plates to the RH Emergency Exit Door	3.00
Do the Modification of the LH Emergency Exit Door	6.00
Do the Modification of the RH Emergency Exit Door	6.00

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Task 533226-831-848-001: Modification	
Tests	2.00
Close-Up	24.00
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAA given in Appendix 01 - Manpower Gantt Chart.

**CONF 002

Task 533226-831-848-001: Modification	
Get Access	26.00
On Aircraft	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH	1.00
Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH	1.00
Remove the Scuff Plates from the LH Emergency Exit Door	2.00
Remove the Scuff Plates from the RH Emergency Exit Door	2.00
Remove Cross Plate from the Emergency Door Upper Area, LH	6.00
Remove Cross Plate from the Emergency Door Upper Area, RH	6.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00

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Task 533226-831-848-001: Modification	
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area LH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	10.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	1.50
Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	1.00

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Task 533226-831-848-001: Modification	
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area LH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	19.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area RH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	10.00
Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	1.50
Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area RH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	19.00
Apply Protections to the Upper Door Frame Area, LH	0.25
Apply Protections to the Lower Door Frame Area, LH	0.25
Apply Protections to the Upper Door Frame Area, RH	0.25
Apply Protections to the Lower Door Frame Area, RH	0.25
Install Cross Plate of the Emergency Door Upper Area, LH	6.00
Install Cross Plate of the Emergency Door Upper Area, RH	6.00
Install the Scuff Plates to the LH Emergency Exit Door	6.00
Install the Scuff Plates to the RH Emergency Exit Door	3.00
Do the Modification of the LH Emergency Exit Door	6.00
Do the Modification of the RH Emergency Exit Door	6.00
Tests	2.00
Close-Up	24.00
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAA given in Appendix 01 - Manpower Gantt Chart.

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**CONF 003

Task 533226-831-848-001: Modification	
Get Access	26.00
On Aircraft	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH	1.00
Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH	1.00
Remove Cross Plate from the Emergency Door Upper Area, LH	6.00
Remove Cross Plate from the Emergency Door Upper Area, RH	6.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area LH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	10.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	1.50

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Task 533226-831-848-001: Modification	
Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area LH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	19.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area RH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	10.00
Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	1.50
Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area RH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	19.00
Apply Protections to the Upper Door Frame Area, LH	0.25
Apply Protections to the Lower Door Frame Area, LH	0.25
Apply Protections to the Upper Door Frame Area, RH	0.25
Apply Protections to the Lower Door Frame Area, RH	0.25
Install Cross Plate of the Emergency Door Upper Area, LH	6.00
Install Cross Plate of the Emergency Door Upper Area, RH	6.00
Do the Modification of the LH Emergency Exit Door	6.00
Do the Modification of the RH Emergency Exit Door	6.00
Tests	2.00
Close-Up	24.00
TOTAL MANHOURS	266.00
ELAPSED TIME (HOURS)	56.25

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAB given in Appendix 01 - Manpower Gantt Chart.

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**CONF 004

Task 533226-831-848-001: Modification	
Get Access	26.00
On Aircraft	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH	1.00
Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH	1.00
Remove Cross Plate from the Emergency Door Upper Area, LH	6.00
Remove Cross Plate from the Emergency Door Upper Area, RH	6.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	10.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	1.50
Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	4.00

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Task 533226-831-848-001: Modification	
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	28.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	19.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	10.00
Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	1.50
Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	28.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	19.00
Apply Protections to the Upper Door Frame Area, LH	0.25
Apply Protections to the Lower Door Frame Area, LH	0.25
Apply Protections to the Upper Door Frame Area, RH	0.25
Apply Protections to the Lower Door Frame Area, RH	0.25
Install Cross Plate of the Emergency Door Upper Area, LH	6.00
Install Cross Plate of the Emergency Door Upper Area, RH	6.00
Do the Modification of the LH Emergency Exit Door	6.00
Do the Modification of the RH Emergency Exit Door	6.00
Tests	2.00
Close-Up	24.00
TOTAL MANHOURS	256.00
ELAPSED TIME (HOURS)	53.75

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAC given in Appendix 01 - Manpower Gantt Chart.

****CONF 005**

Task 533226-831-848-001: Modification	
Get Access	26.00
On Aircraft	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH	1.00

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Task 533226-831-848-001: Modification	
Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH	1.00
Remove the Scuff Plates from the LH Emergency Exit Door	2.00
Remove the Scuff Plates from the RH Emergency Exit Door	2.00
Remove Cross Plate from the Emergency Door Upper Area, LH	6.00
Remove Cross Plate from the Emergency Door Upper Area, RH	6.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH	8.00
Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00

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Task 533226-831-848-001: Modification	
Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	1.00
Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	0.50
Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH	8.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area LH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	10.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	1.50
Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area LH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH	19.00
Remove Rain Gutter at Emergency Exit Door Type 1 Area RH	1.00
Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	10.00
Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	1.50

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Task 533226-831-848-001: Modification	
Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	4.00
Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	1.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH	28.00
Install Rain Gutter at Emergency Exit Door Type 1 Area RH	4.00
Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH	19.00
Apply Protections to the Upper Door Frame Area, LH	0.25
Apply Protections to the Lower Door Frame Area, LH	0.25
Apply Protections to the Upper Door Frame Area, RH	0.25
Apply Protections to the Lower Door Frame Area, RH	0.25
Install Cross Plate of the Emergency Door Upper Area, LH	6.00
Install Cross Plate of the Emergency Door Upper Area, RH	6.00
Install the Scuff Plates to the LH Emergency Exit Door	6.00
Install the Scuff Plates to the RH Emergency Exit Door	3.00
Do the Modification of the LH Emergency Exit Door	6.00
Do the Modification of the RH Emergency Exit Door	6.00
Tests	2.00
Close-Up	24.00
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

NOTE: For an explanation of the manhours and elapsed time, refer to the Gantt Chart, Fig. A-GAAAA given in Appendix 01 - Manpower Gantt Chart.

**CONF ALL

H. WEIGHT AND BALANCE

**CONF 001

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

Manufacturers Empty Weight	+16.400 KG	(+36.1554 LB)
Effect on Balance	+691.760 KGM	(+5003.500 LB.FT)

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**CONF 002, 005

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

Only for aircraft model A330-200		
Manufactures Empty Weight	+15.300 KG	(+33.798 LB)
Effect on Balance	+597.489 KGM	(+4321.575 LB FT)
Only for aircraft model A330-300		
Manufactures Empty Weight	+15.300 KG	(+33.798 LB)
Effect on Balance	+646.385 KGM	(+4675.239 LB FT)

**CONF 003

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

Only for aircraft model A330-200		
Manufactures Empty Weight	+14.300 KG	(+31.429 LB)
Effect on Balance	+555.607 KGM	(+4018.649 LB FT)
Only for aircraft model A330-300		
Manufactures Empty Weight	+14.300 KG	(+31.429 LB)
Effect on Balance	+601.076 KGM	(+4347.523 LB FT)

**CONF 004

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

Only for aircraft model A330-200		
Manufactures Empty Weight	+13.400 KG	(+29.447 LB)
Effect on Balance	+520.562 KGM	(+3765.175 LB FT)
Only for aircraft model A330-300		
Manufactures Empty Weight	+13.400 KG	(+29.447 LB)
Effect on Balance	+563.164 KGM	(+4073.305 LB FT)

**CONF ALL

I. ELECTRICAL LOAD DATA

Not Changed

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J. REFERENCES

**CONF 001

Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 07-11-00 12-34-24 21-20-00 25-23-43 25-42-41 33-51-00 36-22-17 52-71-00	06-31-53 11-00-00 20-16-00 25-21-41 25-23-48 25-53-00 33-51-38 52-10-00 53-35-15	06-41-53 12-11-28 20-21-11 25-23-41 25-24-51 25-80-00 36-12-41 52-22-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
In Service Information (ISI)	ISI 51.48.00001		
Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-10-00 51-40-00 51-44-00 51-47-00 51-71-15 51-75-12 51-76-11	51-23-12 51-42-00 51-44-11 51-48-00 51-72-11 51-75-15 53-21-12	51-24-00 51-43-00 51-46-11 51-51-00 51-75-11 51-76-00 53-31-39
Weight and Balance Manual (WBM)			

**CONF 002

Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 07-11-00 12-34-24 20-28-00 25-23-41 25-24-51 25-80-00 36-12-41 52-22-21	06-31-53 11-00-00 20-16-00 21-20-00 25-23-43 25-42-41 33-51-00 36-22-17 52-71-00	06-41-53 12-11-28 20-21-11 25-21-41 25-23-48 25-53-00 33-51-38 52-10-00 53-35-15
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
In Service Information (ISI)	ISI 51.48.00001		
Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			

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Structural Repair Manual (SRM)	51-10-00 51-40-00 51-44-00 51-47-00 51-71-15 51-75-12 51-76-11	51-23-12 51-42-00 51-44-11 51-48-00 51-72-11 51-75-15 53-21-12	51-24-00 51-43-00 51-46-11 51-51-00 51-75-11 51-76-00 53-31-39
Weight and Balance Manual (WBM)			

**CONF 003

Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 07-11-00 12-34-24 21-20-00 25-23-43 25-42-41 33-51-00 36-22-17 52-71-00	06-31-53 11-00-00 20-16-00 25-21-41 25-23-48 25-53-00 33-51-38 52-10-00	06-41-53 12-11-28 20-21-11 25-23-41 25-24-51 25-80-00 36-12-41 52-22-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
In Service Information (ISI)	ISI 51.48.00001		
Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-10-00 51-40-00 51-44-00 51-47-00 51-71-15 51-75-12 51-76-11	51-23-12 51-42-00 51-44-11 51-48-00 51-72-11 51-75-15 53-21-12	51-24-00 51-43-00 51-46-11 51-51-00 51-75-11 51-76-00 53-31-39
Weight and Balance Manual (WBM)			

**CONF 004

Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 07-11-00 12-34-24 21-20-00 25-23-43 25-42-41 33-51-00 36-22-17 52-71-00	06-31-53 11-00-00 20-16-00 25-21-41 25-23-48 25-53-00 33-51-38 52-10-00	06-41-53 12-11-28 20-21-11 25-23-41 25-24-51 25-80-00 36-12-41 52-22-21
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
In Service Information (ISI)	ISI 51.48.00001		

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Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-10-00 51-40-00 51-44-00 51-47-00 51-71-15 51-75-12 51-76-11	51-23-12 51-42-00 51-44-11 51-48-00 51-72-11 51-75-15 53-21-12	51-24-00 51-43-00 51-46-11 51-51-00 51-75-11 51-76-00 53-31-39
Weight and Balance Manual (WBM)			

**CONF 005

Airworthiness Limitation Section (ALS)	Airworthiness Limitation Section (ALS) Part 2		
Aircraft Maintenance Manual (AMM)	06-20-00 07-11-00 12-34-24 20-28-00 25-23-41 25-24-51 25-80-00 36-12-41 52-22-21	06-31-53 11-00-00 20-16-00 21-20-00 25-23-43 25-42-41 33-51-00 36-22-17 52-71-00	06-41-53 12-11-28 20-21-11 25-21-41 25-23-48 25-53-00 33-51-38 52-10-00 53-35-15
Consumable Material List (CML)			
Elec. Std. Practices Manual (ESPM)	20-55-00		
In Service Information (ISI)	ISI 51.48.00001		
Non Destructive Test Manual (NTM)	51-10-01		
Standards Manual (SM)			
Structural Repair Manual (SRM)	51-10-00 51-40-00 51-44-00 51-47-00 51-71-15 51-75-12 51-76-11	51-23-12 51-42-00 51-44-11 51-48-00 51-72-11 51-75-15 53-21-12	51-24-00 51-43-00 51-46-11 51-51-00 51-75-11 51-76-00 53-31-39
Weight and Balance Manual (WBM)			

**CONF ALL

K. PUBLICATION AFFECTED

Structural Repair Manual (SRM)	53-31-11

L. INTERCHANGEABILITY/MIXABILITY

Not Applicable

M. SPARES

None

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2. MATERIAL INFORMATION

****CONF ALL**

A. MATERIAL - PRICE AND AVAILABILITY

(1) Procurement Addresses

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

Kit 533226D01R04 Kit 533226D02R05 Kit 533226D03R03 Kit 533226D04R03 Kit 533226D05R03 Kit 533226D06R02 Kit 533226D07R04 Kit 533226D08R04 Kit 533226D09R01 Kit 533226D10R01 Kit 533226D11R02 Kit 533226D12R00 Kit 533226D13R00	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 Hotline: +49 40 743 51616

(2) Price and Availability

Kit 533226D01R04	
Cost	21,020.00 USD
Availability	220 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.

Kit 533226D02R05	
Cost	20,860.00 USD
Availability	220 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.

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Kit 533226D03R03	
Cost	17,210.00 USD
Availability	220 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.

Kit 533226D04R03	
Cost	17,210.00 USD
Availability	220 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.

Kit 533226D05R03	
Cost	21,020.00 USD
Availability	220 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.

Kit 533226D06R02	
Cost	20,860.00 USD
Availability	220 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.

Kit 533226D07R04	
Cost	17,210.00 USD
Availability	220 calendar days from receipt of order

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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.

Kit 533226D08R04	
Cost	17,210.00 USD
Availability	220 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.

Kit 533226D09R01	
Cost	582.00 USD
Availability	220 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.

Kit 533226D10R01	
Cost	582.00 USD
Availability	220 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.

Kit 533226D11R02	
Cost	265.00 USD
Availability	220 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.

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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.

Kit 533226D12R00	
Cost	20,900.00 USD
Availability	220 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.

Kit 533226D13R00	
Cost	20,900.00 USD
Availability	220 calendar days from receipt of order

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

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

B. INDUSTRY SUPPORT INFORMATION

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

C. LIST OF COMPONENTS

Kit 533226D01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5337175221800	1	SHIM				
5	F5337175222400	1	SHIM				
7	F5337175222200	1	SHIM				
9	F5337175320800	1	DOUBLER				
11	F5337175320600	1	DOUBLER				
13	F5337175221600	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1109	NUT				
24	ASNA2528-3A	72	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	66	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	28	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	70	BOLT				
37	EN6114K3X10	54	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	34	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K3A7	8	BOLT				
42	EN6114K3A9	4	BOLT				
43	EN6114K3A10	2	BOLT				
44	EN6114K3A11	10	BOLT				
45	EN6114K3A12	1	BOLT				
46	EN6114K3A13	20	BOLT				
47	EN6114K3A14	26	BOLT				
48	EN6114K3A15	1	BOLT				
49	ASNA2528-4	126	NUT				
50	EN6114K4X7	18	BOLT				
51	EN6114K4X9	26	BOLT				
52	EN6114K4X10	26	BOLT				
53	EN6114K4X11	10	BOLT				
54	EN6114K4X13	16	BOLT				
57	F5337175420400	1	PLATE				
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
90	EN6114K4X8	30	BOLT				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				

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.

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Kit 533226D02R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5337175221800	1	SHIM				
9	F5337175320800	1	DOUBLER				
11	F5337175320600	1	DOUBLER				
13	F5337175221600	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1104	NUT				
24	ASNA2528-3A	169	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	36	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				
43	EN6114K3A10	34	BOLT				
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	34	BOLT				
47	EN6114K3A14	24	BOLT				
48	EN6114K3A15	1	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
57	F5337175420400	1	PLATE				
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
93	EN6114K3A8	30	BOLT				

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.

Kit 533226D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5337175221800	1	SHIM				
9	F5337175320800	1	DOUBLER				
11	F5337175320600	1	DOUBLER				
13	F5337175221600	1	SHIM				
19	F5337175222600	1	SHIM				
23	ASNA2528-3	1088	NUT				
24	ASNA2528-3A	149	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	48	BOLT				
39	EN6114K3X13	32	BOLT				
40	EN6114K3X14	27	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				
43	EN6114K3A10	34	BOLT				
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	28	BOLT				
47	EN6114K3A14	11	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K3A8	30	BOLT				

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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.

Kit 533226D04R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5337175221800	1	SHIM				
9	F5337175320800	1	DOUBLER				
11	F5337175320600	1	DOUBLER				
13	F5337175221600	1	SHIM				
19	F5337175222600	1	SHIM				
23	ASNA2528-3	1091	NUT				
24	ASNA2528-3A	149	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	66	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	48	BOLT				
39	EN6114K3X13	32	BOLT				
40	EN6114K3X14	27	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				
43	EN6114K3A10	34	BOLT				
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	28	BOLT				
47	EN6114K3A14	11	BOLT				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K3A8	30	BOLT				

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.

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Kit 533226D05R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
2	F5337175221900	1	SHIM				
5	F5337175222400	1	SHIM				
7	F5337175222200	1	SHIM				
10	F5337175320900	1	DOUBLER				
12	F5337175320700	1	DOUBLER				
14	F5337175221700	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1109	NUT				
24	ASNA2528-3A	72	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	66	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	28	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	70	BOLT				
37	EN6114K3X10	54	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	34	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K3A7	8	BOLT				
42	EN6114K3A9	4	BOLT				
43	EN6114K3A10	2	BOLT				
44	EN6114K3A11	10	BOLT				
45	EN6114K3A12	1	BOLT				
46	EN6114K3A13	20	BOLT				
47	EN6114K3A14	26	BOLT				
48	EN6114K3A15	1	BOLT				
49	ASNA2528-4	126	NUT				
50	EN6114K4X7	18	BOLT				
51	EN6114K4X9	26	BOLT				
52	EN6114K4X10	26	BOLT				
53	EN6114K4X11	10	BOLT				
54	EN6114K4X13	16	BOLT				
57	F5337175420400	1	PLATE				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
90	EN6114K4X8	30	BOLT				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				

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.

Kit 533226D06R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
2	F5337175221900	1	SHIM				
10	F5337175320900	1	DOUBLER				
12	F5337175320700	1	DOUBLER				
14	F5337175221700	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1104	NUT				
24	ASNA2528-3A	169	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	36	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				
43	EN6114K3A10	34	BOLT				
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	34	BOLT				

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ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
47	EN6114K3A14	24	BOLT				
48	EN6114K3A15	1	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
57	F5337175420400	1	PLATE				
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K3A8	30	BOLT				

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.

Kit 533226D07R04

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
2	F5337175221900	1	SHIM				
10	F5337175320900	1	DOUBLER				
12	F5337175320700	1	DOUBLER				
14	F5337175221700	1	SHIM				
19	F5337175222600	1	SHIM				
23	ASNA2528-3	1088	NUT				
24	ASNA2528-3A	149	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	48	BOLT				
39	EN6114K3X13	32	BOLT				
40	EN6114K3X14	27	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
43	EN6114K3A10	34	BOLT				
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	28	BOLT				
47	EN6114K3A14	11	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K3A8	30	BOLT				

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.

Kit 533226D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
2	F5337175221900	1	SHIM				
10	F5337175320900	1	DOUBLER				
12	F5337175320700	1	DOUBLER				
14	F5337175221700	1	SHIM				
19	F5337175222600	1	SHIM				
23	ASNA2528-3	1091	NUT				
24	ASNA2528-3A	149	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	66	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	12	BOLT				
31	EN6114K3-10	17	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	48	BOLT				
39	EN6114K3X13	32	BOLT				
40	EN6114K3X14	27	BOLT				
41	EN6114K3A7	18	BOLT				
42	EN6114K3A9	18	BOLT				
43	EN6114K3A10	34	BOLT				

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ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
44	EN6114K3A11	10	BOLT				
46	EN6114K3A13	28	BOLT				
47	EN6114K3A14	11	BOLT				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K3A8	30	BOLT				

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.

Kit 533226D09R01

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
63	F5227016820000	1	SHIM				
64	NAS1102E3-17	14	SCREW				
65	NAS1726C3	14	NUT				
67	NSA9117-23	1	PLATE				
70	DIN65399-4014CF	72	RIVET				

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.

Kit 533226D10R01

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
63	F5227016820000	1	SHIM				
64	NAS1102E3-17	14	SCREW				
65	NAS1726C3	14	NUT				
67	NSA9117-23	1	PLATE				
70	DIN65399-4014CF	72	RIVET				

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.

Kit 533226D11R02

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
74	LN9198-4020CF	74	RIVET				
75	LN9198-4820CF	12	RIVET				
76	ASNA0082-204	11	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
77	ASNA0081A204	4	BOLT				
78	ASNA0082A306	5	BOLT				
79	ASNA0082-207	1	BOLT				
82	ASNA0082A206	18	BOLT				
83	ASNA0082-203	6	BOLT				
86	ASNA0082-205	2	RIVET				

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.

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
1	F5337175221800	1	SHIM				
9	F5337175320800	1	DOUBLER				
11	F5337175320600	1	DOUBLER				
13	F5337175221600	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1102	NUT				
24	ASNA2528-3A	45	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	14	BOLT				
31	EN6114K3-10	15	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	34	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K4X7	18	BOLT				
42	EN6114K4X9	18	BOLT				
43	EN6114K4X10	34	BOLT				
44	EN6114K4X11	10	BOLT				

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ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
46	EN6114K4X13	16	BOLT				
47	EN6114K3A14	24	BOLT				
48	EN6114K3A15	1	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
57	F5337175420400	1	PLATE				
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K4X8	30	BOLT				
94	ASNA2528-4	126	NUT				
95	EN6114K3A13	20	BOLT				

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.

Kit 533226D13R00

ITEM	NEW PART N˚	QTY (UM)	KEYWORD	ITEM	OLD PART N˚	INT	SEE NOTES
2	F5337175221900	1	SHIM				
10	F5337175320900	1	DOUBLER				
12	F5337175320700	1	DOUBLER				
14	F5337175221700	1	SHIM				
15	F5337175222100	1	SHIM				
17	F5337175222000	1	SHIM				
19	F5337175222600	1	SHIM				
21	NAS1102E3-9	12	SCREW				
22	NAS1169C10L	12	WASHER				
23	ASNA2528-3	1102	NUT				
24	ASNA2528-3A	45	NUT				
25	EN6114K3-4	220	BOLT				
26	EN6114K3-5	38	BOLT				
27	EN6114K3-6	63	BOLT				
28	EN6114K3-7	4	BOLT				
29	EN6114K3-8	4	BOLT				
30	EN6114K3-9	14	BOLT				
31	EN6114K3-10	15	BOLT				
32	EN6114K3-11	6	BOLT				
33	EN6114K3X6	212	BOLT				
34	EN6114K3X7	160	BOLT				

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	ITEM	OLD PART N°	INT	SEE NOTES
35	EN6114K3X8	66	BOLT				
36	EN6114K3X9	71	BOLT				
37	EN6114K3X10	60	BOLT				
38	EN6114K3X12	42	BOLT				
39	EN6114K3X13	34	BOLT				
40	EN6114K3X14	39	BOLT				
41	EN6114K4X7	18	BOLT				
42	EN6114K4X9	18	BOLT				
43	EN6114K4X10	34	BOLT				
44	EN6114K4X11	10	BOLT				
46	EN6114K4X13	16	BOLT				
47	EN6114K3A14	24	BOLT				
48	EN6114K3A15	1	BOLT				
55	F5337175223000	1	SHIM				
56	F5337175222800	1	SHIM				
57	F5337175420400	1	PLATE				
58	F5337175420300	1	PLATE				
59	F5337175420200	1	PLATE				
60	EN6081D5-09	8	RIVET				
61	EN6069D5-09	1	RIVET				
62	EN6081D5-12	4	RIVET				
91	EN6114K3X5	30	BOLT				
92	EN6114K3X11	24	BOLT				
93	EN6114K4X8	30	BOLT				
94	ASNA2528-4	126	NUT				
95	EN6114K3A13	20	BOLT				

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

D. LIST OF MATERIALS - OPERATOR SUPPLIED

(1) Consumable Materials

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Corrosion Preventive Compound-Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound-Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

(2) Components

To accomplish this Service Bulletin, use repair washers in accordance with SRM 51-71-15.

(3) Equipment

None

E. PARTS TO BE RE-IDENTIFIED BY OPERATOR

For detail of the PN evolution of the emergency exit doors, refer to Table 1 given in Appendix 03 - Re-identification of the Emergency Exit Doors

F. TOOLING

(1) Tooling - Price and Availability

(a) Procurement Addresses

Operators interested in obtaining the Fatigue Technology Incorporated (FTI) tool kit should contact:

Standard tool TOOLD01 Standard tool TOOLD02 Standard tool TOOLD03 Standard tool TOOLD04 Standard tool TOOLD05 Standard tool TOOLD07	Fatigue Technology Inc. 401 Andover Park East SEATTLE, WA 98188-7605 USA Interner: http://www.fatiguetech.com Phone: (206) 2462010 Fax: (206) 2449886

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(b) Price and Availability

The availability of the FTI durable tooling is 90 days from receipt of the order.

(2) Tools

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

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

Fatigue Technology Incorporated (FTI) has allocated the following tool kit numbers for cold expansion:

For the definition of capital, durable and expendable tools, refer to In-Service Information ISI 51.48.00001.

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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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.

Standard tool TOOLD04

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	2	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	2	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

Standard tool TOOLD07

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

(3) Special Tools

None

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3. ACCOMPLISHMENT INSTRUCTIONS

Task 533226-831-848-001 - Modification

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

WARNING: MAKE SURE THAT THE SAFETY DEVICES AND THE WARNING NOTICES ARE IN POSITION BEFORE YOU START A TASK ON OR NEAR:

- THE FLIGHT CONTROLS
- THE FLIGHT CONTROL SURFACES
- THE LANDING GEAR AND THE RELATED DOORS
- COMPONENTS THAT MOVE.

MOVEMENT OF COMPONENTS CAN KILL OR INJURE PERSONS.

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: This Service Bulletin contains the instructions for the on-aircraft maintenance

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necessary to ensure the continued airworthiness of the aircraft.

For any deviations to the instructions, including RC paragraph contained herein, contact AIRBUS for further instructions and approval.

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

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

Task Associated Data

****CONF 001**

Zone	
260	
Manpower	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

****CONF 002**

Zone	
260	
Manpower	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

****CONF 003**

Zone	
260	
Manpower	
TOTAL MANHOURS	266.00
ELAPSED TIME (HOURS)	56.25

****CONF 004**

Zone	
260	
Manpower	
TOTAL MANHOURS	256.00
ELAPSED TIME (HOURS)	53.75

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**CONF 005

Zone	
260	
Manpower	
TOTAL MANHOURS	317.00
ELAPSED TIME (HOURS)	69.00

**CONF ALL

A. GENERAL

**CONF 001

(1) Subtask 533226-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-16-00-912-801 Task 20-21-11-911-801 Task 25-80-00-000-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-71-15 51-75-12 51-76-11

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

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

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

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

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

(f) Cold work the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

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(h) Countersink the metallic structure in accordance with SRM 51-46-11.

(i) Protect the areas to prevent damage to the equipment and structure and all the parts.

(j) For the removal of the insulation blankets, refer to AMM Task 25-80-00-000-801.

(k) To accomplish this Service Bulletin it is necessary to use the repair washers in accordance with SRM 51-71-15.

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

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

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

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

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

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

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

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

(2) Subtask 533226-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF 002**

(1) Subtask 533226-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-16-00-912-801 Task 20-21-11-911-801 Task 25-80-00-000-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-71-15 51-75-12 51-76-11

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

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

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

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

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

(f) Cold work the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

(h) Countersink the metallic structure in accordance with SRM 51-46-11.

(i) Protect the areas to prevent damage to the equipment and structure and all the parts.

(j) For the removal of the insulation blankets, refer to AMM Task 25-80-00-000-801.

(k) To accomplish this Service Bulletin it is necessary to use the repair washers in accordance with SRM 51-71-15.

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

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

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

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

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

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

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

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

(2) Subtask 533226-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF 003**

(1) Subtask 533226-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-16-00-912-801 Task 20-21-11-911-801 Task 25-80-00-000-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-71-15 51-75-12 51-76-11

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

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

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

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

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

(f) Cold work the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

(h) Countersink the metallic structure in accordance with SRM 51-46-11.

(i) Protect the areas to prevent damage to the equipment and structure and all the parts.

(j) For the removal of the insulation blankets, refer to AMM Task 25-80-00-000-801.

(k) To accomplish this Service Bulletin it is necessary to use the repair washers in accordance with SRM 51-71-15.

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

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

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

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

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

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

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

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

(2) Subtask 533226-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

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**CONF 004

(1) Subtask 533226-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-16-00-912-801 Task 20-21-11-911-801 Task 25-80-00-000-801
Consumable Material List (CML)	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-71-15 51-75-12 51-76-11

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

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

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

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

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

(f) Cold work the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

(h) Countersink the metallic structure in accordance with SRM 51-46-11.

(i) Protect the areas to prevent damage to the equipment and structure and all the parts.

(j) For the removal of the insulation blankets, refer to AMM Task 25-80-00-000-801.

(k) To accomplish this Service Bulletin it is necessary to use the repair washers in accordance with SRM 51-71-15.

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

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

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

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

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

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

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

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

(2) Subtask 533226-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF 005**

(1) Subtask 533226-910-201-001 - Standard Practices

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	06-20-00, Page Block 001 06-31-53, Page Block 001 06-41-53, Page Block 001 Task 20-16-00-912-801 Task 20-21-11-911-801 Task 25-80-00-000-801
Consumable Material List (CML)	

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References	
Structural Repair Manual (SRM)	51-24-00 51-40-00 51-42-00 51-43-00 51-44-00 51-46-11 51-48-00 51-71-15 51-75-12 51-76-11

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

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

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

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

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

(f) Cold work the fastener holes in accordance with SRM 51-48-00.

(g) Get fastener hole diameters and drill data in accordance with SRM 51-44-00.

(h) Countersink the metallic structure in accordance with SRM 51-46-11.

(i) Protect the areas to prevent damage to the equipment and structure and all the parts.

(j) For the removal of the insulation blankets, refer to AMM Task 25-80-00-000-801.

(k) To accomplish this Service Bulletin it is necessary to use the repair washers in accordance with SRM 51-71-15.

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

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

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

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

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

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

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

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

(2) Subtask 533226-839-201-001 - Administrative

Manpower Resources	
Skills	NON SPECIFIC

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

****CONF ALL**

B. PREPARATION

****CONF 001**

(1) Subtask 533226-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 07-11-00-581-801 12-11-28, Page Block 301 Task 12-34-24-860-802
Structural Repair Manual (SRM)	51-51-00

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

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

(b) Do the jacking procedure for the installation of the external joint reinforcement straps in accordance with Appendix 02 - Zero Stress Jacking , SRM 51-51-00 and refer to AMM Task 07-11-00-581-801.

(c) Defuel the aircraft, refer to AMM 12-11-28, Page Block 301.

(d) Put an access platform in position between Frame 53.5 and Frame 53.8 at both the LH and RH sides of the aircraft.

(2) Subtask 533226-010-201-001 - Remove/Open for Access

Manpower Resources	
Skills	AIRFRAME

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References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-010-801 Task 25-21-41-000-801 Task 25-23-41-000-801 Task 25-23-43-000-802 Task 25-23-48-000-801 Task 25-24-51-000-801 Task 25-42-41-000-801 Task 25-53-00-000-801 Task 25-80-00-000-801 Task 33-51-38-000-801 Task 36-12-41-000-801 Task 36-22-17-000-801 Task 52-10-00-010-801 Task 52-22-21-000-801
Structural Repair Manual (SRM)	51-72-11

(a) Open the LH/RH Emergency Exit Doors, refer to AMM Task 52-10-00-010-801.

(b) Remove the passenger seats to gain access between Frame 53.6 and Frame 53.7 , refer to AMM Task 25-21-41-000-801.

(c) Remove the Overhead Storage Compartments to gain access between Frame 53.6 and Frame 53.7, refer to AMM Task 25-24-51-000-801.

(d) Remove the ceiling panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-41-000-801.

(e) Remove the sidewall panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-43-000-802.

(f) Remove the door linings as necessary, refer to AMM Task 25-23-48-000-801.

(g) Remove the air conditioning ducts for access between Frame 53.6 and Frame 53.7, refer to AMM Task 21-20-00-010-801.

(h) Remove the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-000-801.

(i) Remove the sensor actuation assembly and bracket, refer to AMM Task 52-22-21-000-801.

(j) Remove brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(k) Remove the lavatories as necessary, refer to AMM Task 25-42-41-000-801.

(l) Remove the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-000-801

(m) Remove sensing elements, refer to AMM Task 36-22-17-000-801.

(n) Remove the APU duct, refer to AMM Task 36-12-41-000-801.

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(o) Remove the insulation blankets between Frame 53.6 and Frame 53.7 to gain access and to disengage electrical wires (without connection), refer to AMM Task 25-80-00-000-801.

**CONF 002

(1) Subtask 533226-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 07-11-00-581-801 12-11-28, Page Block 301 Task 12-34-24-860-802
Structural Repair Manual (SRM)	51-51-00

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

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

(b) Do the jacking procedure for the installation of the external joint reinforcement straps in accordance with Appendix 02 - Zero Stress Jacking , SRM 51-51-00 and refer to AMM Task 07-11-00-581-801.

(c) Defuel the aircraft, refer to AMM 12-11-28, Page Block 301.

(d) Put an access platform in position between Frame 53.5 and Frame 53.8 at both the LH and RH sides of the aircraft.

(2) Subtask 533226-010-201-001 - Remove/Open for Access

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-010-801 Task 25-21-41-000-801 Task 25-23-41-000-801 Task 25-23-43-000-802 Task 25-23-48-000-801 Task 25-24-51-000-801 Task 25-42-41-000-801 Task 25-53-00-000-801 Task 25-80-00-000-801 Task 33-51-38-000-801 Task 36-12-41-000-801 Task 36-22-17-000-801 Task 52-10-00-010-801 Task 52-22-21-000-801

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References	
Structural Repair Manual (SRM)	51-72-11

(a) Open the LH/RH Emergency Exit Doors, refer to AMM Task 52-10-00-010-801.

(b) Remove the passenger seats to gain access between Frame 53.6 and Frame 53.7 , refer to AMM Task 25-21-41-000-801.

(c) Remove the Overhead Storage Compartments to gain access between Frame 53.6 and Frame 53.7, refer to AMM Task 25-24-51-000-801.

(d) Remove the ceiling panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-41-000-801.

(e) Remove the sidewall panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-43-000-802.

(f) Remove the door linings as necessary, refer to AMM Task 25-23-48-000-801.

(g) Remove the air conditioning ducts for access between Frame 53.6 and Frame 53.7, refer to AMM Task 21-20-00-010-801.

(h) Remove the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-000-801.

(i) Remove the sensor actuation assembly and bracket, refer to AMM Task 52-22-21-000-801.

(j) Remove brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(k) Remove the lavatories as necessary, refer to AMM Task 25-42-41-000-801.

(l) Remove the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-000-801

(m) Remove sensing elements, refer to AMM Task 36-22-17-000-801.

(n) Remove the APU duct, refer to AMM Task 36-12-41-000-801.

(o) Remove the insulation blankets between Frame 53.6 and Frame 53.7 to gain access and to disengage electrical wires (without connection), refer to AMM Task 25-80-00-000-801.

**CONF 003

(1) Subtask 533226-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

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References	
Aircraft Maintenance Manual (AMM)	Task 07-11-00-581-801 12-11-28, Page Block 301 Task 12-34-24-860-802
Structural Repair Manual (SRM)	51-51-00

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

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

(b) Do the jacking procedure for the installation of the external joint reinforcement straps in accordance with Appendix 02 - Zero Stress Jacking , SRM 51-51-00 and refer to AMM Task 07-11-00-581-801.

(c) Defuel the aircraft, refer to AMM 12-11-28, Page Block 301.

(d) Put an access platform in position between Frame 53.5 and Frame 53.8 at both the LH and RH sides of the aircraft.

(2) Subtask 533226-010-201-001 - Remove/Open for Access

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-010-801 Task 25-21-41-000-801 Task 25-23-41-000-801 Task 25-23-43-000-802 Task 25-23-48-000-801 Task 25-24-51-000-801 Task 25-42-41-000-801 Task 25-53-00-000-801 Task 25-80-00-000-801 Task 33-51-38-000-801 Task 36-12-41-000-801 Task 36-22-17-000-801 Task 52-10-00-010-801 Task 52-22-21-000-801
Structural Repair Manual (SRM)	51-72-11

(a) Open the LH/RH Emergency Exit Doors, refer to AMM Task 52-10-00-010-801.

(b) Remove the passenger seats to gain access between Frame 53.6 and Frame 53.7 , refer to AMM Task 25-21-41-000-801.

(c) Remove the Overhead Storage Compartments to gain access between Frame 53.6 and Frame 53.7, refer to AMM Task 25-24-51-000-801.

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(d) Remove the ceiling panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-41-000-801.

(e) Remove the sidewall panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-43-000-802.

(f) Remove the door linings as necessary, refer to AMM Task 25-23-48-000-801.

(g) Remove the air conditioning ducts for access between Frame 53.6 and Frame 53.7, refer to AMM Task 21-20-00-010-801.

(h) Remove the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-000-801.

(i) Remove the sensor actuation assembly and bracket, refer to AMM Task 52-22-21-000-801.

(j) Remove brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(k) Remove the lavatories as necessary, refer to AMM Task 25-42-41-000-801.

(l) Remove the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-000-801

(m) Remove sensing elements, refer to AMM Task 36-22-17-000-801.

(n) Remove the APU duct, refer to AMM Task 36-12-41-000-801.

(o) Remove the insulation blankets between Frame 53.6 and Frame 53.7 to gain access and to disengage electrical wires (without connection), refer to AMM Task 25-80-00-000-801.

**CONF 004

(1) Subtask 533226-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 07-11-00-581-801 12-11-28, Page Block 301 Task 12-34-24-860-802
Structural Repair Manual (SRM)	51-51-00

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

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

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(b) Do the jacking procedure for the installation of the external joint reinforcement straps in accordance with Appendix 02 - Zero Stress Jacking , SRM 51-51-00 and refer to AMM Task 07-11-00-581-801.

(c) Defuel the aircraft, refer to AMM 12-11-28, Page Block 301.

(d) Put an access platform in position between Frame 53.5 and Frame 53.8 at both the LH and RH sides of the aircraft.

(2) Subtask 533226-010-201-001 - Remove/Open for Access

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-010-801 Task 25-21-41-000-801 Task 25-23-41-000-801 Task 25-23-43-000-802 Task 25-23-48-000-801 Task 25-24-51-000-801 Task 25-42-41-000-801 Task 25-53-00-000-801 Task 25-80-00-000-801 Task 33-51-38-000-801 Task 36-12-41-000-801 Task 36-22-17-000-801 Task 52-10-00-010-801 Task 52-22-21-000-801
Structural Repair Manual (SRM)	51-72-11

(a) Open the LH/RH Emergency Exit Doors, refer to AMM Task 52-10-00-010-801.

(b) Remove the passenger seats to gain access between Frame 53.6 and Frame 53.7 , refer to AMM Task 25-21-41-000-801.

(c) Remove the Overhead Storage Compartments to gain access between Frame 53.6 and Frame 53.7, refer to AMM Task 25-24-51-000-801.

(d) Remove the ceiling panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-41-000-801.

(e) Remove the sidewall panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-43-000-802.

(f) Remove the door linings as necessary, refer to AMM Task 25-23-48-000-801.

(g) Remove the air conditioning ducts for access between Frame 53.6 and Frame 53.7, refer to AMM Task 21-20-00-010-801.

(h) Remove the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-000-801.

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(i) Remove the sensor actuation assembly and bracket, refer to AMM Task 52-22-21-000-801.

(j) Remove brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(k) Remove the lavatories as necessary, refer to AMM Task 25-42-41-000-801.

(l) Remove the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-000-801

(m) Remove sensing elements, refer to AMM Task 36-22-17-000-801.

(n) Remove the APU duct, refer to AMM Task 36-12-41-000-801.

(o) Remove the insulation blankets between Frame 53.6 and Frame 53.7 to gain access and to disengage electrical wires (without connection), refer to AMM Task 25-80-00-000-801.

**CONF 005

(1) Subtask 533226-941-201-001 - Job Set-up

Manpower Resources	
Skills	NON SPECIFIC

References	
Aircraft Maintenance Manual (AMM)	Task 07-11-00-581-801 12-11-28, Page Block 301 Task 12-34-24-860-802
Structural Repair Manual (SRM)	51-51-00

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

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

(b) Do the jacking procedure for the installation of the external joint reinforcement straps in accordance with Appendix 02 - Zero Stress Jacking , SRM 51-51-00 and refer to AMM Task 07-11-00-581-801.

(c) Defuel the aircraft, refer to AMM 12-11-28, Page Block 301.

(d) Put an access platform in position between Frame 53.5 and Frame 53.8 at both the LH and RH sides of the aircraft.

(2) Subtask 533226-010-201-001 - Remove/Open for Access

Manpower Resources	
Skills	AIRFRAME

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References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-010-801 Task 25-21-41-000-801 Task 25-23-41-000-801 Task 25-23-43-000-802 Task 25-23-48-000-801 Task 25-24-51-000-801 Task 25-42-41-000-801 Task 25-53-00-000-801 Task 25-80-00-000-801 Task 33-51-38-000-801 Task 36-12-41-000-801 Task 36-22-17-000-801 Task 52-10-00-010-801 Task 52-22-21-000-801
Structural Repair Manual (SRM)	51-72-11

(a) Open the LH/RH Emergency Exit Doors, refer to AMM Task 52-10-00-010-801.

(b) Remove the passenger seats to gain access between Frame 53.6 and Frame 53.7 , refer to AMM Task 25-21-41-000-801.

(c) Remove the Overhead Storage Compartments to gain access between Frame 53.6 and Frame 53.7, refer to AMM Task 25-24-51-000-801.

(d) Remove the ceiling panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-41-000-801.

(e) Remove the sidewall panels between Frame 53.6 and Frame 53.7 to gain access, refer to AMM Task 25-23-43-000-802.

(f) Remove the door linings as necessary, refer to AMM Task 25-23-48-000-801.

(g) Remove the air conditioning ducts for access between Frame 53.6 and Frame 53.7, refer to AMM Task 21-20-00-010-801.

(h) Remove the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-000-801.

(i) Remove the sensor actuation assembly and bracket, refer to AMM Task 52-22-21-000-801.

(j) Remove brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(k) Remove the lavatories as necessary, refer to AMM Task 25-42-41-000-801.

(l) Remove the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-000-801

(m) Remove sensing elements, refer to AMM Task 36-22-17-000-801.

(n) Remove the APU duct, refer to AMM Task 36-12-41-000-801.

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(o) Remove the insulation blankets between Frame 53.6 and Frame 53.7 to gain access and to disengage electrical wires (without connection), refer to AMM Task 25-80-00-000-801.

**CONF ALL

C. PROCEDURE

NOTE: THE FOLLOWING SUBTASKS MAY BE PERFORMED CONCURRENTLY AS THE AIRCRAFT IS IN ZERO-STRESS JACKING CONDITION. IT IS ALLOWED TO REMOVE ALL THE FASTENERS AT THE SAME TIME.

NOTE: It is allowed to perform each subtask for the LH and RH side of the aircraft at the same time.

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

NOTE: The roto test inspection of the fasteners holes in accordance with NTM 51-10-01 described in this Service Bulletin is only applicable to the aluminium and titanium layers. This procedure is not applicable to the steel layers that can be found at door frame.

**CONF 001

(1) Subtask 533226-831-215-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2		

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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	

References	
Structural Repair Manual (SRM)	51-75-11 51-75-12 51-76-00 53-21-12

(a) Prepare the fuselage outer skin for the modification on the LH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(2) Subtask 533226-831-216-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

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Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11

(a) Prepare the fuselage outer skin for the modification on the RH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

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(3) Subtask 533226-831-201-001 - Remove the Scuff Plates from the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5A to Frame 53.7A Stringer 26

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03, Views A and B, Sections A-A, C-C, D-D and E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff		Item (12)	Discard
1	Plate-Scuff		Item (13)	Discard
1	Plate-Scuff		Item (14)	Discard

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(4) Subtask 533226-831-207-001 - Remove the Scuff Plates from the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03, Views A and B, Sections A-A, C-C, D-D and E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff	F5337040020100	Item (12)	Discard
1	Plate-Scuff	F5337013820200	Item (13)	Discard
1	Plate-Scuff	F5337040020000	Item (14)	Discard

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(5) Subtask 533226-831-248-001 - Remove Cross Plate from the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520000	Item (88)	Retain

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(6) Subtask 533226-831-249-001 - Remove Cross Plate from the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520100	Item (89)	Retain

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(7) Subtask 533226-831-217-001 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

48	Fastener	Discard

NOTE: Be careful not to damage the holes.

(8) Subtask 533226-832-209-001 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

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References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 03, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12 and .

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(9) Subtask 533226-831-219-001 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

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References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

(10) Subtask 533226-832-210-001 - Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 11, Fig. A-GBCAA Sheet 12 and Fig. A-GBCAA Sheet 05

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the work steps that follow.

(11) Subtask 533226-831-221-001 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the lower AFT door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 10, Views A, G and K and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(12) Subtask 533226-832-211-001 - Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 10, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(13) Subtask 533226-831-256-001 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

33 Fastener Discard

NOTE: Be careful not to damage the holes.

(14) Subtask 533226-832-218-001 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 08, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(15) Subtask 533226-831-218-001 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	F5337175221600	1	SHIM	
23	ASNA2528-3	22	NUT	
24	ASNA2528-3A	26	NUT	
39	EN6114K3X13	22	BOLT	
41	EN6114K3A7	4	BOLT	
42	EN6114K3A9	2	BOLT	
43	EN6114K3A10	2	BOLT	
44	EN6114K3A11	4	BOLT	
46	EN6114K3A13	14	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

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Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15A - STGR16 cold work the 2 fasteners holes at the upper forward corner , refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03 and Fig. A-GBCAA Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

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6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-1 Durable Tooling 1

7 Do the countersinking in accordance with SRM 51-46-11

8 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(c) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR16, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 03, Views A, B and C, position:

1	Shim	F5337175221600	Item 13

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

(d) Transfer drill the holes from the aircraft structure through the Shim, item 13 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

(e) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR16 cold work the 24 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03 and Fig. A-GBCAA Sheet 12, Views A, B, C and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to the FTI tool list No.:

DKA330533226-1 Durable Tooling 1

NOTE: In case the existing hole diameter is more than or equal to the starting hole diameter, contact AIRBUS before next flight and follow their instructions.

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR18A,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 11.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 13, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(h) Check existing countersinks available under shim item 13 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 13 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR18A, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221600	Item 13
4	Bolt	EN6114K3A7	Item 41
2	Bolt	EN6114K3A9	Item 42
4	Bolt	EN6114K3A11	Item 44
14	Bolt	EN6114K3A13	Item 46
2	Bolt	EN6114K3A10	Item 43
26	Nut	ASNA2528-3A	Item 24
22	Bolt	EN6114K3X13	Item 39
22	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(16) Subtask 533226-831-220-001 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 15 to Frame 17 from Stringer 53.6 to Stringer 53.8

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5337175221800	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

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NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 05, Views A, B and E, position:

1	Shim	F5337175221800	Item 1

(c) Transfer drill the holes from the aircraft structure through the Shim, item 1 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 12, Views A, B, E and fasteners table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

NOTE: In case the existing hole diameter is more than or equal to the starting hole diameter, contact AIRBUS before next flight and follow their instructions.

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to the final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 11, Views A, B, E and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 1, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

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(h) Check existing countersinks available under shim item 1 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221800	Item 1
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(17) Subtask 533226-831-222-001 - Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 10, Views A, G and K, position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10 and Fig. A-GBCAA Sheet 12, Views A, G, K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27,

1 Ream to the final diamteter, the 11 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10 and Fig. A-GBCAA Sheet 11, Views A, G, K and fastener table.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

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(h) Check existing countersinks available under shim item 15 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, G, K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
3	Bolt	EN6114K3A13	Item 46
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(18) Subtask 533226-831-224-001 - Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	25	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
41	EN6114K3A7	4	BOLT	
42	EN6114K3A9	2	BOLT	
44	EN6114K3A11	6	BOLT	
45	EN6114K3A12	1	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	9	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, and Fig. A-GBCAA Sheet 08, Views A, G and H, position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the Shim item 17 and deburr and clean the fastener holes with:

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

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(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 15 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 12, Views A, G, H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(f) Put in position the shim item 17.

(g) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 10 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 12, Views A, G, H and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

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7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Between Frame 53.5 and Frame 53.7 and STGR25 - STGR27,

1 Ream to the final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 11, Views A, G, H and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(i) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(j) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(k) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(l) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, G, H and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
6	Bolt	EN6114K3A11	Item 44
1	Bolt	EN6114K3A12	Item 45
3	Bolt	EN6114K3A13	Item 46
9	Bolt	EN6114K3A14	Item 47

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25	Nut	ASNA2528-3A	Item 24
3	Bolt	EN6114K3-11	Item 32
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
11	Nut	ASNA2528-3	Item 23
4	Bolt	EN6114K3A7	Item 41
2	Bolt	EN6114K3A9	Item 42

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(m) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(19) Subtask 533226-831-225-001 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the upper FWD door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 03, Views A, B and F and in accordance with SRM 51-42-00, remove:

48	Fastener	Discard

NOTE: Be careful not to damage the holes.

(20) Subtask 533226-832-213-001 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 03, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(21) Subtask 533226-831-227-001 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

(22) Subtask 533226-832-214-001 - Do the Inpection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 05, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(23) Subtask 533226-831-229-001 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

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Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower AFT door frame, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 10, Views A, G and K and in accordance with SRM 51-42-00, remove:

18 Fastener Discard

NOTE: Be careful not to damage the holes.

(24) Subtask 533226-832-215-001 - Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 10, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(25) Subtask 533226-831-231-001 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

33	Fastener	Discard

NOTE: Be careful not to damage the holes.

(26) Subtask 533226-832-216-001 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 08, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(27) Subtask 533226-831-226-001 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	F5337175221700	1	SHIM	
23	ASNA2528-3	22	NUT	
24	ASNA2528-3A	26	NUT	
39	EN6114K3X13	22	BOLT	
41	EN6114K3A7	4	BOLT	
42	EN6114K3A9	2	BOLT	
43	EN6114K3A10	2	BOLT	
44	EN6114K3A11	4	BOLT	
46	EN6114K3A13	14	BOLT	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

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References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15A - STGR16 cold work the 2 holes consisting of fasteners covered by external doubler, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03 and Fig. A-GBCAA Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1 Durable Tooling 1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Do the countersinking in accordance with SRM 51-46-11

8 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(c) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR16, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 03, Views A, B and C, position:

1	Shim	F5337175221700	Item 14

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

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(d) Between Frame 53.5 and Frame 53.6 and STGR14 - STGR16 cold work the 24 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03 and Fig. A-GBCAA Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to the FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR18A,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) In shim item 14, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(g) Check existing countersinks available under shim item 14 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(h) Apply interfay sealant to the mating surface between the shim item 14 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(i) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR18A, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 03, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221700	Item 14
4	Bolt	EN6114K3A7	Item 41
2	Bolt	EN6114K3A9	Item 42
4	Bolt	EN6114K3A11	Item 44
14	Bolt	EN6114K3A13	Item 46
2	Bolt	EN6114K3A10	Item 43
26	Nut	ASNA2528-3A	Item 24
22	Bolt	EN6114K3X13	Item 39

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22	Nut	ASNA2528-3	Item 23
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(j) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(28) Subtask 533226-831-228-001 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	F5337175221900	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	

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

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 05, Views A, B and E, position:

1	Shim	F5337175221900	Item 2

(c) Transfer drill the holes from the aircraft structure through the Shim, item 2 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(e) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 12, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to the final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 11, Views A, B, E and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 2, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(h) Check existing countersinks available under shim item 2 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 05, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221900	Item 2
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(29) Subtask 533226-831-230-001 - Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 10, Views A, G and K, position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean and deburr the holes as necessary. Use:

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

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(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10 and Fig. A-GBCAA Sheet 12, Views A, G, K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-1	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10 and Fig. A-GBCAA Sheet 11, Views A, C, J and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(h) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 10, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, G, K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
3	Bolt	EN6114K3A13	Item 46
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32

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11	Nut	ASNA2528-3	Item 23
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(30) Subtask 533226-831-232-001 - Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	25	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
41	EN6114K3A7	4	BOLT	
42	EN6114K3A9	2	BOLT	
44	EN6114K3A11	6	BOLT	
45	EN6114K3A12	1	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	9	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD02				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-1	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-1

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.

Standard tool TOOLD03				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-1	Expandable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-1

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.

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References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 08, Views A, G and H, position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Remove the Shim item 15 and deburr and clean the fastener holes with:

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

(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 14 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 12, Views A, G, H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1	Durable Tooling	1

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

2 Clean the fastener holes with:

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

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1	Expandable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI Tool list No.:

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DKA330533226-1 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Put in position the shim item 15.

(g) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 13 holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 12, Views A, G, H and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAA Sheet 12.

Refer to FTI tool list No.:

DKA330533226-1 Durable Tooling 1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-1 Expandable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

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6 Ream the fastener holes to the final hole diameter, as shown in the fastener table.

Refer to FTI Tool list No.:

DKA330533226-1 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Between Frame 53.5 and Frame 53.7 and STGR25 - STGR27,

1 Ream to the final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08 and Fig. A-GBCAA Sheet 11, Views A, G, H and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(i) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(j) Check existing countersinks available under shim item 15 requires filling, fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAA Sheet 11.

(k) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(l) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 08, Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, G, H and fastener table and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
6	Bolt	EN6114K3A11	Item 44

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1	Bolt	EN6114K3A12	Item 45
3	Bolt	EN6114K3A13	Item 46
9	Bolt	EN6114K3A14	Item 47
25	Nut	ASNA2528-3A	Item 24
3	Bolt	EN6114K3-11	Item 32
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
11	Nut	ASNA2528-3	Item 23
4	Bolt	EN6114K3A7	Item 41
2	Bolt	EN6114K3A9	Item 42
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(m) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(31) Subtask 533226-831-233-001 - Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337007520000	Item (91)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(32) Subtask 533226-831-234-001 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 05, Views A, B, D and Section D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

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(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 04, Views A, B and D, remove:

562	Fastener	Discard

NOTE: Be careful not to damage the holes.

(33) Subtask 533226-831-235-001 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(34) Subtask 533226-831-238-001 - Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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References	
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 09, Views A, G, J and Section H-H, temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320800 Item 9

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 09, Views A, G and J and in accordance with SRM 51-42-00, remove:

218 Fastener

NOTE: Be careful not to damage the holes.

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(35) Subtask 533226-831-239-001 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

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(36) Subtask 533226-831-236-001 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	766	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	58	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	6	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	6	BOLT	
39	EN6114K3X13	8	BOLT	
49	ASNA2528-4	126	NUT	
50	EN6114K4X7	18	BOLT	
51	EN6114K4X9	26	BOLT	
52	EN6114K4X10	26	BOLT	
53	EN6114K4X11	10	BOLT	
54	EN6114K4X13	16	BOLT	
90	EN6114K4X8	30	BOLT	
91	EN6114K3X5	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 05:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

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(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 04, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 11, Views A, B, D and Section D-D and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Check if existing countersinks available under shim item 19 and doubler item 11, if necessary fill them in accordance with SRM 51-71-15.

(f) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(g) Put the doubler item 11 in position and shim item 19.

(h) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAA Sheet 11.

NOTE: Do not ream the 2 fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation as shown in Fig. A-GBCAA Sheet 06.

(i) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(j) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 11 except the 2 holes for rain gutter (91) installation.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 04, Fig. A-GBCAA Sheet 05 and Fig. A-GBCAA Sheet 11, Views A, B, D and Section D-D and fastener table, wet install:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
58	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-9	Item 30
6	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
6	Bolt	EN6114K3X10	Item 37
4	Bolt	EN6114K3-8	Item 29
30	Bolt	EN6114K3X5	Item 91
8	Bolt	EN6114K3X13	Item 39
766	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K4X7	Item 50
26	Bolt	EN6114K4X9	Item 51
26	Bolt	EN6114K4X10	Item 52
10	Bolt	EN6114K4X11	Item 53
30	Bolt	EN6114K4X8	Item 90
16	Bolt	EN6114K4X13	Item 54

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126	Nut	ASNA2528-4	Item 49
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(37) Subtask 533226-831-237-001 - Install Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	F5337175222400	1	SHIM	
7	F5337175222200	1	SHIM	
23	ASNA2528-3	12	NUT	
31	EN6114K3-10	10	BOLT	
37	EN6114K3X10	2	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Temporarily position the rain gutter item 91, shim items 5 and 7, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 06, View F

1	Gutter-Rain	F5337007520000	Item (91)	Retained at removal
1	Shim	F5337175222200	Item 7	
1	Shim	F5337175222400	Item 5	

(b) Transfer drill holes from rain gutter item 91 to shim items 5 and 7.

(c) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(d) Between all the parts, apply a thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(e) Put in position rain gutter item 91 and shim items 5 and 7.

(f) Ream the fasteners holes to final hole diameter, refer to Fig. A-GBCAA Sheet 11.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(h) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, install:

1	Gutter-Rain	F5337007520000	Item (91)	Retained at removal
1	Shim	F5337175222200	Item 7	
1	Shim	F5337175222400	Item 5	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
10	Bolt	EN6114K3-10	Item 31	
2	Bolt	EN6114K3X10	Item 37	
12	Nut	ASNA2528-3	Item 23	

(i) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(38) Subtask 533226-831-240-001 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	
23	ASNA2528-3	260	NUT	
25	EN6114K3-4	10	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	52	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 09:

1	Doubler	F5337175320800	Item 9

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11, Views A, G, J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 9, de-burr and clean, use

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

(e) Put the doubler, item 9, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAA Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 9.

(h) Clean and deburr the holes as necessary. Use:

Textile-Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(i) Check if existing countersinks available under doubler item 9, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surface between the shim item 19 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11, A, G, J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320800	Item 9
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
52	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
260	Nut	ASNA2528-3	Item 23

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(l) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(39) Subtask 533226-831-241-001 - Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337007520100	Item (92)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(40) Subtask 533226-831-242-001 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

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Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02. Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 05, Views A, B and D and Sections B-B, C-C and D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

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Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 04, Views A, B and D, remove:

562	Fastener	Discard

NOTE: Be careful not to damage the holes.

(41) Subtask 533226-832-217-001 - Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(42) Subtask 533226-831-245-001 - Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

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Material necessary to do the job

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 09, Views A, G and H and Section H-H, temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320900 Item 10

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

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NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 07 and Fig. A-GBBAA Sheet 09, Views A, G and J and in accordance with SRM 51-42-00, remove:

218 Fastener

NOTE: Be careful not to damage the holes.

(43) Subtask 533226-831-246-001 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(44) Subtask 533226-831-243-001 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	766	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	58	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	6	BOLT	
33	EN6114K3X6	206	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	6	BOLT	
39	EN6114K3X13	8	BOLT	
49	ASNA2528-4	126	NUT	
50	EN6114K4X7	18	BOLT	
51	EN6114K4X9	26	BOLT	
52	EN6114K4X10	26	BOLT	
53	EN6114K4X11	10	BOLT	
54	EN6114K4X13	16	BOLT	
90	EN6114K4X8	30	BOLT	
91	EN6114K3X5	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00

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References	
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAA Sheet 04 and Fig. A-GBCAA Sheet 05:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 04, Views A, B and D.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler item 12 in position and the shim item 19,.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAA Sheet 11.

NOTE: Do not ream the 2 fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation as shown in Fig. A-GBCAA Sheet 06.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 12 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under doubler item 12, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02, Fig. A-GBCAA Sheet 04, Fig. A-GBCAA Sheet 05 ,Fig. A-GBCAA Sheet 11 and Fig. A-GBCAA Sheet 12, Views A, B and D and Sections B-B, C-C and D-D, wet install:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
58	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30

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6	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
6	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
766	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K4X7	Item 50
26	Bolt	EN6114K4X9	Item 51
26	Bolt	EN6114K4X10	Item 52
10	Bolt	EN6114K4X11	Item 53
30	Bolt	EN6114K4X8	Item 90
16	Bolt	EN6114K4X13	Item 54
126	Nut	ASNA2528-4	Item 49
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(45) Subtask 533226-831-244-001 - Install Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

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Material necessary to do the job

Kit 533226D01R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	F5337175222400	1	SHIM	
7	F5337175222200	1	SHIM	

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
5	F5337175222400	1	SHIM	
7	F5337175222200	1	SHIM	
23	ASNA2528-3	12	NUT	
31	EN6114K3-10	10	BOLT	
37	EN6114K3X10	2	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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References	
Fig. A-GBBAA Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Temporarily position the rain gutter item 92, shim items 5 and 7, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 02 and Fig. A-GBCAA Sheet 06, View F

1	Gutter-Rain	F5337007520100	Item (92)	Retained at removal
1	Shim	F5337175222200	Item 7	
1	Shim	F5337175222400	Item 5	

(b) Transfer drill holes from rain gutter item 92 to shim items 5 and 7.

(c) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(d) Between all the parts, apply a thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(e) Put in position rain gutter item 92 and shim items 5 and 7.

(f) Ream the fasteners holes to final hole diameter, refer to Fig. A-GBCAA Sheet 11.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(h) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAA Sheet 01, Fig. A-GBBAA Sheet 02 and Fig. A-GBBAA Sheet 06, Views A, B and F and Sections F-F and G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337007520100	Item (92)	Retained at removal
1	Shim	F5337175222200	Item 7	
1	Shim	F5337175222400	Item 5	
10	Bolt	EN6114K3-10	Item 31	
2	Bolt	EN6114K3X10	Item 37	
12	Nut	ASNA2528-3	Item 23	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(i) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(46) Subtask 533226-831-247-001 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	
23	ASNA2528-3	260	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	52	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAA Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to refer to Fig. A-GBCAA Sheet 07 and Fig. A-GBCAA Sheet 09:

1	Doubler	F5337175320900	Item 10

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11, Views A, G, J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 10, deburr and clean, use:

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

(e) Put the doubler, item 10, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAA Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 10.

(h) Clean and deburr the holes as necessary. Use:

Textile-Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(i) Check if existing countersinks available under doubler item 10, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAA Sheet 01, Fig. A-GBCAA Sheet 07, Fig. A-GBCAA Sheet 09 and Fig. A-GBCAA Sheet 11, Views A, G, J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320900	Item 10
	with		
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
52	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
260	Nut	ASNA2528-3	Item 23
	with		

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(l) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(47) Subtask 533226-831-252-001 - Apply Protections to the Upper Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

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(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(48) Subtask 533226-831-253-001 - Apply Protections to the Lower Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

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(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(49) Subtask 533226-831-254-001 - Apply Protections to the Upper Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

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(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(50) Subtask 533226-831-255-001 - Apply Protections to the Lower Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

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(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(51) Subtask 533226-831-250-001 - Install Cross Plate of the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520000	Item (88)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	
11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal

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6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(52) Subtask 533226-831-251-001 - Install Cross Plate of the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39

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References	
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520100	Item (89)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
	NOTE:	Applicable up to MSN 0122. From MSN 0123 on the rivet quantity is 62.		
12	Rivet	LN9198-4820CF	Item 75	
	NOTE:	Applicable from MSN 0123 on.		
11	Bolt	ASNA0082-204	Item 76	
	NOTE:	11 Rivets ASNA0081A206 applicable to MSN 0600 on.		
4	Bolt	ASNA0081A204	Item 77	
	NOTE:	Applicable quantity from MSN 0128 to 0507 is 0.		
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
	NOTE:	Applicable for MSN 0128 to 0507. From MSN up to 0122 and from MSN 0508 to 0599, the quantity is 14. The quantity from MSN 0600 on is 4.		
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(53) Subtask 533226-831-213-001 - Install the Scuff Plates to the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D01R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	
59	F5337175420200	1	PLATE	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04, Views A and B and AMM Task 53-35-15-400-801 install:

1	Plate	F5337175420300	Item 58
1	Plate	F5337175420400	Item 57

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1	Plate	F5337175420200	Item 59	
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal
2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal

(54) Subtask 533226-831-206-001 - Install the Scuff Plates to the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D05R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
59	F5337175420200	1	PLATE	

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

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04, Views A and B, Sections A-A, B-B, C-C, D-D and E-E and AMM Task 53-35-15-400-801 wet install:

1	Plate	F5337175420300	Item 58	
1	Plate	F5337175420400	Item 57	
1	Plate	F5337175420200	Item 59	
	with			
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal
2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal
	use			

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(55) Subtask 533226-831-212-001 - Do the Modification of the LH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D09R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Seal Retainer	Item (81)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

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(d) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(f) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(g) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

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(h) Re-identify the LH Emergency Exit Door 834, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(i) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(j) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(56) Subtask 533226-831-214-001 - Do the Modification of the RH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D10R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12

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References	
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Seal Retainer	Item (81)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63

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1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the RH Emergency Exit Door 844, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required

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Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

**CONF 002

(1) Subtask 533226-831-215-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2		
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11 51-75-12 51-76-00 53-21-12

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(a) Prepare the fuselage outer skin for the modification on the LH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

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

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(2) Subtask 533226-831-216-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	

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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	

References	
Structural Repair Manual (SRM)	51-75-11

(a) Prepare the fuselage outer skin for the modification on the RH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(3) Subtask 533226-831-201-005 - Remove the Scuff Plates from the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5A to Frame 53.7 Stringer 26

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

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References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03, Views A and B, Sections A-A, C-C, D-D and E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff		Item (12)	Discard
1	Plate-Scuff		Item (13)	Discard
1	Plate-Scuff		Item (14)	Discard

(4) Subtask 533226-831-207-003 - Remove the Scuff Plates from the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5A to Frame 53.7A Stringer 26

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801

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References	
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03, Views A and B, Sections A-A, C-C, D-D and E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff	F5337040020100	Item (12)	Discard
1	Plate-Scuff	F5337013820200	Item (13)	Discard
1	Plate-Scuff	F5337040020000	Item (14)	Discard

(5) Subtask 533226-831-248-001 - Remove Cross Plate from the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

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(a) Remove the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520000	Item (88)	Retain

(6) Subtask 533226-831-249-001 - Remove Cross Plate from the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

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(a) Remove the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520100	Item (89)	Retain

(7) Subtask 533226-831-217-002 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36	Fastener	Discard

NOTE: Be careful not to damage the holes.

(8) Subtask 533226-832-209-002 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(9) Subtask 533226-831-219-002 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the upper AFT door frame corner, refer to Fig. A-GBBAB Sheet 05, Fig. A-GBBAB Sheet 01 and Fig. A-GBBAB Sheet 02, Views A, B and E and in accordance with SRM 51-42-00, remove:

38	Fastener	Discard

NOTE: Be careful not to damage the holes.

(10) Subtask 533226-832-210-002 - Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 05, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the work steps that follow.

(11) Subtask 533226-831-221-002 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower AFT door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 10, Views A, G and K and in accordance with SRM 51-42-00, remove:

18 Fastener Discard

NOTE: Be careful not to damage the holes.

(12) Subtask 533226-832-211-002 - Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 10, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(13) Subtask 533226-831-256-002 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 25A to Stringer 27

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Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to , Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

18 Fastener Discard

NOTE: Be careful not to damage the holes.

(14) Subtask 533226-832-218-002 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 08, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(15) Subtask 533226-831-218-002 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	F5337175221600	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 03, Views A, B and C, position:

1	Shim	F5337175221600	Item 13

(c) Transfer drill the holes from the aircraft structure through the Shim, item 13 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 13, deburr and clean with

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03 and Fig. A-GBCAB Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 03 and Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table. refer to Fig. A-GBCAB Sheet 03 and Fig. A-GBCAB Sheet 12

Refer to Tool No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the 24 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03, Views A, B, C and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 13, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 12.

(h) Check existing countersinks available under shim item 13 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 12.

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(i) Apply interfay sealant to the mating surface between the shim item 13 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221600	Item 13
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(16) Subtask 533226-831-220-002 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5337175221800	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 05, Views A, B and E, position:

1	Shim	F5337175221800	Item 1

(c) Transfer drill the holes from the aircraft structure through the Shim, item 1 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 05 and Fig. A-GBCAB Sheet 11, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to the final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 05 and Fig. A-GBCAB Sheet 11, Views A, B, E and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 1, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(h) Check existing countersinks available under shim item 1 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 05, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221800	Item 1
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(17) Subtask 533226-831-222-002 - Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 10, Views A, G and K, position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer toFig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 10 and Fig. A-GBCAB Sheet 12, Views A, G, K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 11.

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer toFig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 10, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12 and , Views A, G, K and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(h) Check existing countersinks available under shim item 15 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 10, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, G, K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
3	Bolt	EN6114K3A13	Item 46
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(18) Subtask 533226-831-224-002 - Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	7	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 08, Views A, G and H, position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 17, deburr and clean the fastener holes with :

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 10 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08 and Fig. A-GBCAB Sheet 12, Views A, G, H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General 08BAA9 As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton 14SBA1 As required

made moist with

Non Aqueous Cleaner - General 08BAA9 As required

(f) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08 and Fig. A-GBCAB Sheet 11, Views A, G, H and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton 14SBA1 As required

made moist with

Non Aqueous Cleaner - General 08BAA9 As required

(g) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(h) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, G, H and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
3	Bolt	EN6114K3A13	Item 46
7	Bolt	EN6114K3A14	Item 47
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(19) Subtask 533226-831-225-002 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

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Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36 Fastener Discard

NOTE: Be careful not to damage the holes.

(20) Subtask 533226-832-213-002 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(21) Subtask 533226-831-227-002 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38	Fastener	Discard

NOTE: Be careful not to damage the holes.

(22) Subtask 533226-832-214-002 - Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 05, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(23) Subtask 533226-831-229-002 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the lower AFT door frame, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 10, Views A, G and K and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(24) Subtask 533226-832-215-002 - Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 10, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(25) Subtask 533226-831-231-002 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(26) Subtask 533226-832-216-002 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 08, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(27) Subtask 533226-831-226-002 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 17

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	F5337175221700	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

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NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 03, Views A, B and C, position:

1	Shim	F5337175221700	Item 14

(c) Transfer drill the holes from the aircraft structure through the Shim, item 14 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 14, deburr and clean with

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.6 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03 and Fig. A-GBCAB Sheet 12, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.6 and STGR15 - STGR17,

1 Ream to final diameter the 24 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03 and Fig. A-GBCAB Sheet 11, Views A, B, C and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 14, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 12.

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(h) Check existing countersinks available under shim item 14 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 12.

(i) Apply interfay sealant to the mating surface between the shim item 14 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 03, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221700	Item 14
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(28) Subtask 533226-831-228-002 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
2	F5337175221900	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 05, Views A, B and E, position:

1	Shim	F5337175221900	Item 2

(c) Transfer drill the holes from the aircraft structure through the Shim, item 2 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 05 and Fig. A-GBCAB Sheet 12, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17,

1 Ream to final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 05 and Fig. A-GBCAB Sheet 11, Views A, B, E and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 2, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(h) Check existing countersinks available under shim item 2 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 2 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 05, Fig. A-GBCAB Sheet 11 andFig. A-GBCAB Sheet 12, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221900	Item 2
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(29) Subtask 533226-831-230-002 - Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 10, Views A, G and K, position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean and deburr the holes as necessary with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, and Fig. A-GBCAB Sheet 10, Views A, G, K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

1 Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 10 and Fig. A-GBCAB Sheet 11, Views A, G, K and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(g) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(h) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(i) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 10, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, G, K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
3	Bolt	EN6114K3A13	Item 46
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(j) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(30) Subtask 533226-831-232-002 - Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
46	EN6114K3A13	3	BOLT	
47	EN6114K3A14	7	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 08, Views A, G and H, position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 10 holes, refer to Fig. A-GBCAB Sheet 01 Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08 and Fig. A-GBCAB Sheet 12, Views A, G, H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAB Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08 and Fig. A-GBCAB Sheet 11, Views A, G, H and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

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(h) Check existing countersinks available under shim item 15 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAB Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 08, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12, Views A, G, H and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
3	Bolt	EN6114K3A13	Item 46
7	Bolt	EN6114K3A14	Item 47
10	Nut	ASNA2528-3A	Item 24
3	Bolt	EN6114K3-11	Item 32
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(31) Subtask 533226-831-233-002 - Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

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Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620200	Item (71)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(32) Subtask 533226-831-234-002 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600		DOUBLER	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 05, Views A, B, D and Section D-D temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

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NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 04, Views A, B and D, remove:

566	Fastener	Discard

NOTE: Be careful not to damage the holes.

(33) Subtask 533226-831-235-002 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 04, Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(34) Subtask 533226-831-238-002 - Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D02R05				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00

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References	
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 09, Views A, G, J and Section H-H temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320800 Item 9

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

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(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 09, Views A, G and J and in accordance with SRM 51-42-00, remove:

219 Fastener

NOTE: Be careful not to damage the holes.

(35) Subtask 533226-831-239-002 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

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2 If no cracks are detected, do the next step.

(36) Subtask 533226-831-236-002 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 05:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11, Views A, B, D and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler, item 11 and the Shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 11 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 11, if necessary fill them in accordance with SRM 51-71-15.

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(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11, Views A, B, D and Section D-D and fastener table, wet install:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43

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10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(37) Subtask 533226-831-237-002 - Install Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D02R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Aircraft Maintenance Manual (AMM)	20-28-00 Task 20-28-00-912-801
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Temporarily position the rain gutter item (71), shim items 55 and 56, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 06, View F

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item (71) to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAB Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) Between all the parts, apply thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position shim item 56, wet install

1	Rivet	EN6069D5-09	Item 61

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(i) Put in position rain gutter item (71) and shim item 55, refer to Fig. A-GBCAB Sheet 06.

(j) Ream the remaining holes at the doubler item 11 and rain gutter item (71) to the final hole diameter, refer to Fig. A-GBCAB Sheet 06.

(k) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(l) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 06, Views A, B, F and Sections F-F and G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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8	Rivet	EN6081D5-09	Item 60
4	Rivet	EN6081D5-12	Item 62

except at bonding points.

(m) Install bonding points in accordance with AMM Task 20-28-00-912-801.

(n) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(38) Subtask 533226-831-240-002 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	
23	ASNA2528-3	261	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 09:

1	Doubler	F5337175320800	Item 9

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11, Views A, G, J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

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NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 9, de-burr and clean, use:

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

(e) Put the doubler, item 9, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 9.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 9, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11, Views A, G, J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320800	Item 9
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27

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4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
261	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(39) Subtask 533226-831-241-005 - Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620300	Item (72)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(40) Subtask 533226-831-242-002 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00

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References	
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 05, Views A, B and D and Section B-B, C-C and D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

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(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 04, Views A, B and D, remove:

566	Fastener	Discard

NOTE: Be careful not to damage the holes.

(41) Subtask 533226-832-217-002 - Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11 and Fig. A-GBCAB Sheet 12:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(42) Subtask 533226-831-245-002 - Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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References	
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 09, Views A, G and J, temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320900 Item 10

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 09, Views A, G and J and in accordance with SRM 51-42-00, remove:

219 Fastener

NOTE: Be careful not to damage the holes.

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(43) Subtask 533226-831-246-002 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

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(44) Subtask 533226-831-243-002 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 05:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

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(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11, Views A, B and D and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with:

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

(e) Put the doubler, item 12 and the shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAB Sheet 04 and Fig. A-GBCAB Sheet 11.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use

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

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 12 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 12, if necessary fill them in accordance with SRM 51-71-15.

(j) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02, Fig. A-GBCAB Sheet 04, Fig. A-GBCAB Sheet 05 and Fig. A-GBCAB Sheet 11, Views A, B and D and Sections B-B, C-C and D-D, wet install:

1	Doubler	F5337175320700	Item 12

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1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43
10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(45) Subtask 533226-831-244-002 - Install Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D06R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-912-801
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12

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References	
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Temporarily position the rain gutter item (72), shim items 55 and 56, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 06, View F

1	Gutter-Rain	F5337023620300	Item (72)	Retain
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item (72) to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use

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

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAB Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

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

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(g) Between all the parts, apply thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position shim item 56, wet install

1	Rivet	EN6069D5-09	Item 61	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(i) Put in position rain gutter item (72) and shim item 55, refer to Fig. A-GBCAB Sheet 06.

(j) Ream the remaining holes at the doubler item 12 and rain gutter item (72) to the final hole diameter, refer to Fig. A-GBCAB Sheet 06.

(k) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 02 and Fig. A-GBCAB Sheet 06, Views A, B and F and Sections F-F and G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620300	Item (72)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	
8	Rivet	EN6081D5-09	Item 60	
4	Rivet	EN6081D5-12	Item 62	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

except at bonding points.

(l) Install bonding points in accordance with AMM Task 20-28-00-912-801.

(m) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

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(46) Subtask 533226-831-247-002 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	
23	ASNA2528-3	261	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAB Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to refer to Fig. A-GBCAB Sheet 07 and Fig. A-GBCAB Sheet 09:

1	Doubler	F5337175320900	Item 10

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11, Views A, G, J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Remove the doubler, item 10, deburr and clean, use:

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

(e) Put the doubler, item 10, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAB Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 10.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 10, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAB Sheet 01, Fig. A-GBCAB Sheet 07, Fig. A-GBCAB Sheet 09 and Fig. A-GBCAB Sheet 11, Views A, G, J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320900	Item 10
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31

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24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
261	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(47) Subtask 533226-831-252-001 - Apply Protections to the Upper Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

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(48) Subtask 533226-831-253-001 - Apply Protections to the Lower Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

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(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(49) Subtask 533226-831-254-001 - Apply Protections to the Upper Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

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(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(50) Subtask 533226-831-255-001 - Apply Protections to the Lower Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

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(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(51) Subtask 533226-831-250-001 - Install Cross Plate of the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520000	Item (88)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	

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11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(52) Subtask 533226-831-251-001 - Install Cross Plate of the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520100	Item (89)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
	NOTE:	Applicable up to MSN 0122. From MSN 0123 on the rivet quantity is 62.		
12	Rivet	LN9198-4820CF	Item 75	
	NOTE:	Applicable from MSN 0123 on.		
11	Bolt	ASNA0082-204	Item 76	
	NOTE:	11 Rivets ASNA0081A206 applicable to MSN 0600 on.		
4	Bolt	ASNA0081A204	Item 77	
	NOTE:	Applicable quantity from MSN 0128 to 0507 is 0.		
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	

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18	Bolt	ASNA0082A206	Item 82	
	NOTE:	Applicable for MSN 0128 to 0507. From MSN up to 0122 and from MSN 0508 to 0599, the quantity is 14. The quantity from MSN 0600 on is 4.		
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(53) Subtask 533226-831-213-003 - Install the Scuff Plates to the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D02R05

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	
59	F5337175420200	1	PLATE	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02,Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04, Views A and B and Sections A-A, B-B, C-C, D-D and E-E and AMM Task 53-35-15-400-801 wet install:

1	Plate	F5337175420300	Item 58	
1	Plate	F5337175420400	Item 57	
1	Plate	F5337175420200	Item 59	
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal
2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal

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(54) Subtask 533226-831-206-003 - Install the Scuff Plates to the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D06R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	
59	F5337175420200	1	PLATE	

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04, Views A and B, Sections A-A, B-B, C-C, D-D and E-E and AMM Task 53-35-15-400-801 wet install:

1	Plate	F5337175420300	Item 58	
1	Plate	F5337175420400	Item 57	
1	Plate	F5337175420200	Item 59	
	with			
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal

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2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal

(55) Subtask 533226-831-212-002 - Do the Modification of the LH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D09R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Seal Retainer	Item (81)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

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(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

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(g) Re-identify the LH Emergency Exit Door 834, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(56) Subtask 533226-831-214-002 - Do the Modification of the RH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D10R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12

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References	
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63

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1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the RH Emergency Exit Door 844, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required

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Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

**CONF 003

(1) Subtask 533226-831-215-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2		
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11 51-75-12 51-76-00 53-21-12

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(a) Prepare the fuselage outer skin for the modification on the LH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

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

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(2) Subtask 533226-831-216-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	

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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	

References	
Structural Repair Manual (SRM)	51-75-11

(a) Prepare the fuselage outer skin for the modification on the RH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(3) Subtask 533226-831-248-001 - Remove Cross Plate from the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

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References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520000	Item (88)	Retain

(4) Subtask 533226-831-249-001 - Remove Cross Plate from the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39

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References	
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520100	Item (89)	Retain

(5) Subtask 533226-831-217-003 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36	Fastener	Discard

NOTE: Be careful not to damage the holes.

(6) Subtask 533226-832-209-003 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(7) Subtask 533226-831-219-003 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

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(8) Subtask 533226-832-210-003 - Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 05, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the work steps that follow.

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(9) Subtask 533226-831-218-003 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	F5337175221600	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 03, Views A, B and C, position:

1	Shim	F5337175221600	Item 13

(c) Transfer drill the holes from the aircraft structure through the Shim, item 13 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 03 and Fig. A-GBCAC Sheet 09, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAC Sheet 10.

Refer to the FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table Fig. A-GBCAC Sheet 10.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 03 and Fig. A-GBCAC Sheet 09.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 13, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(h) Check existing countersinks available under shim item 13 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(i) Apply interfay sealant to the mating surface between the shim item 13 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 03, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221600	Item 13
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(10) Subtask 533226-831-220-003 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D03R03				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
1	F5337175221800	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 05, Views A, B and E, position:

1	Shim	F5337175221800	Item 1

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(c) Transfer drill the holes from the aircraft structure through the Shim, item 1 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 05 and Fig. A-GBCAC Sheet 10, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAC Sheet 10.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

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4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 10.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 05 and Fig. A-GBCAC Sheet 09.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 1, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(h) Check existing countersinks available under shim item 1 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin.

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

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(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 05, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221800	Item 1
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(11) Subtask 533226-831-225-003 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

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(a) At the upper FWD door frame corner, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36	Fastener	Discard

NOTE: Be careful not to damage the holes.

(12) Subtask 533226-832-213-003 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(13) Subtask 533226-831-227-003 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

(14) Subtask 533226-832-214-003 - Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 05, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(15) Subtask 533226-831-226-003 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D07R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	F5337175221700	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

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NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 03, Views A, B and C, position:

1	Shim	F5337175221700	Item 14

(c) Transfer drill the holes from the aircraft structure through the Shim, item 14 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 03 and Fig. A-GBCAC Sheet 10, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAC Sheet 10.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 10

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 03 and Fig. A-GBCAC Sheet 09.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 14, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(h) Check existing countersinks available under shim item 14 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

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(i) Apply interfay sealant to the mating surface between the shim item 14 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) BetweenFrame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 03, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221700	Item 14
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(16) Subtask 533226-831-228-003 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D07R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	F5337175221900	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 05, Views A, B and E, position:

1	Shim	F5337175221900	Item 2

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(c) Transfer drill the holes from the aircraft structure through the Shim, item 2 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 05 and Fig. A-GBCAC Sheet 10, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAC Sheet 10.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

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4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 10.

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAC Sheet 05 and Fig. A-GBCAC Sheet 09.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 2, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(h) Check existing countersinks available under shim item 2 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAC Sheet 09.

(i) Apply interfay sealant to the mating surface between the shim item 2 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

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(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 05,Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B, E and fastener table and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221900	Item 2
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(17) Subtask 533226-831-233-003 - Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

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(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620200	Item (71)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(18) Subtask 533226-831-234-003 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

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References	
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05, Views A, B, D and Section D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02and Fig. A-GBBAC Sheet 04, Views A, B and D, remove:

568	Fastener	Discard

NOTE: Be careful not to damage the holes.

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(19) Subtask 533226-831-235-003 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

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(20) Subtask 533226-831-238-003 - Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07 and Fig. A-GBCAC Sheet 08, Views A, G and H, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320800	Item 9

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NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 07 and Fig. A-GBBAC Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

214 Fastener

NOTE: Be careful not to damage the holes.

(21) Subtask 533226-831-239-003 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(22) Subtask 533226-831-236-003 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D03R03				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05, Views A, B , D , Sections B-B, C-C and D-D.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Deburr and clean the fasteners holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler, item 11 and the Shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 11 except holes for rain gutter (71) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 11, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 04, Fig. A-GBCAC Sheet 05, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B and D, wet install:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25

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38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43
10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(23) Subtask 533226-831-237-003 - Install Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12

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References	
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Temporarily position the rain gutter item 71, shim items 55 and 56, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 , Fig. A-GBCAC Sheet 06 and Fig. A-GBCAC Sheet 09, View F

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item (71) to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use

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

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAC Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

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

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(g) Between all the parts, apply a thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position shim item 56, wet install:

1	Rivet	EN6069D5-09	Item 61	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(i) Put in position rain gutter item (71) and shim items 55, refer to Fig. A-GBCAC Sheet 06.

(j) Ream the remaining holes at the doubler item 11 and rain gutter item (71) to final hole diameter, refer to Fig. A-GBCAC Sheet 09.

(k) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(l) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 , Fig. A-GBCAC Sheet 06 and Fig. A-GBCAC Sheet 09, Views A, B and F and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	
8	Rivet	EN6081D5-09	Item 60	
4	Rivet	EN6081D5-12	Item 62	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(m) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(24) Subtask 533226-831-240-003 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D03R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	
23	ASNA2528-3	267	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	48	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAC Sheet 07 and Fig. A-GBCAC Sheet 08:

1	Doubler	F5337175320800	Item 9

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07, Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09, Views A, G, H and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

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NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 9, de-burr and clean, use:

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

(e) Put the doubler, item 9, in position.

(f) Ream the remaining fastener holes to the final hole diameter, refer to Fig. A-GBCAC Sheet 09.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 9.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 9, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07, Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09, Views A, G, H and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320800	Item 9
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28

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8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
48	Bolt	EN6114K3X12	Item 38
267	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(25) Subtask 533226-831-241-003 - Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

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(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 06, Views A, B and F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620200	Item (71)	Retain
13	Fastener			Discard

NOTE: Be careful not to damage the holes.

(26) Subtask 533226-831-242-003 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D07R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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References	
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05, Views A, B and D and Sections B-B, C-C and D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 02 and Fig. A-GBBAC Sheet 04, Views A, B and D, remove:

568	Fastener	Discard

NOTE: Be careful not to damage the holes.

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(27) Subtask 533226-832-217-003 - Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

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(28) Subtask 533226-831-245-003 - Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D07R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10
Fig. A-GBBAC Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07 and Fig. A-GBCAC Sheet 08, Views A, G and H, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320900	Item 10

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NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBBAC Sheet 01, Fig. A-GBBAC Sheet 07 and Fig. A-GBBAC Sheet 08, Views A, G and H and in accordance with SRM 51-42-00, remove:

196 Fastener

NOTE: Be careful not to damage the holes.

(29) Subtask 533226-831-246-003 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(30) Subtask 533226-831-243-003 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D07R04				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 04 and Fig. A-GBCAC Sheet 05, Views A, B , D , Sections B-B, C-C and D-D.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler, item 12 and the Shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 12 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 12, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02, Fig. A-GBCAC Sheet 04, Fig. A-GBCAC Sheet 05, Fig. A-GBCAC Sheet 09 and Fig. A-GBCAC Sheet 10, Views A, B and D, wet install:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25

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38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43
10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(31) Subtask 533226-831-244-003 - Install Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D07R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12

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References	
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Temporarily position the rain gutter item 72, shim items 55 and 56, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 , Fig. A-GBCAC Sheet 06 and Fig. A-GBCAC Sheet 09, View F

1	Gutter-Rain	F5337023620300	Item (72)	Retain
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item 72 to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use

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

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAC Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

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

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(g) Between all the parts, apply a thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position rain gutter item 72 and shim items 55 and 56.

(i) Ream the fasteners holes to final hole diameter, refer to Fig. A-GBCAC Sheet 09.

(j) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(k) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 02 and Fig. A-GBCAC Sheet 06 and Fig. A-GBCAC Sheet 09, Views A, B and F and Sections F-F and G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620300	Item (72)	Retain
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	
1	Rivet	EN6069D5-09	Item 61	
8	Rivet	EN6081D5-09	Item 60	
4	Rivet	EN6081D5-12	Item 62	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) For application of protections refer to SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(32) Subtask 533226-831-247-003 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D07R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	
23	ASNA2528-3	267	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	48	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAC Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAC Sheet 07 and Fig. A-GBCAC Sheet 08:

1	Doubler	F5337175320900	Item 10

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07, Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09, Views A, G, H and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Remove the doubler, item 10, deburr and clean, use:

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

(e) Put the doubler, item 10, in position.

(f) Ream the remaining fastener holes to the final hole diameter, refer to Fig. A-GBCAC Sheet 09.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 10.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 10, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAC Sheet 01, Fig. A-GBCAC Sheet 07, Fig. A-GBCAC Sheet 08 and Fig. A-GBCAC Sheet 09, Views A, G, H and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320900	Item 10
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31

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24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
48	Bolt	EN6114K3X12	Item 38
267	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(33) Subtask 533226-831-252-001 - Apply Protections to the Upper Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

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(34) Subtask 533226-831-253-001 - Apply Protections to the Lower Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

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(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(35) Subtask 533226-831-254-001 - Apply Protections to the Upper Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

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(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(36) Subtask 533226-831-255-001 - Apply Protections to the Lower Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

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(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(37) Subtask 533226-831-250-001 - Install Cross Plate of the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520000	Item (88)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	

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11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(38) Subtask 533226-831-251-001 - Install Cross Plate of the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520100	Item (89)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
	NOTE:	Applicable up to MSN 0122. From MSN 0123 on the rivet quantity is 62.		
12	Rivet	LN9198-4820CF	Item 75	
	NOTE:	Applicable from MSN 0123 on.		
11	Bolt	ASNA0082-204	Item 76	
	NOTE:	11 Rivets ASNA0081A206 applicable to MSN 0600 on.		
4	Bolt	ASNA0081A204	Item 77	
	NOTE:	Applicable quantity from MSN 0128 to 0507 is 0.		
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	

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18	Bolt	ASNA0082A206	Item 82	
	NOTE:	Applicable for MSN 0128 to 0507. From MSN up to 0122 and from MSN 0508 to 0599, the quantity is 14. The quantity from MSN 0600 on is 4.		
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(39) Subtask 533226-831-212-003 - Do the Modification of the LH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D09R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Seal Retainer	Item (81)	Retain
1	Door Seal Segment	Item (80)	Retain

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(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

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(f) Apply:

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(g) Re-identify the LH Emergency Exit Door 834, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(40) Subtask 533226-831-214-003 - Do the Modification of the RH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D10R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12

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References	
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63

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1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the RH Emergency Exit Door 844, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required

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Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

**CONF 004

(1) Subtask 533226-831-215-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2		
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11 51-75-12 51-76-00 53-21-12

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(a) Prepare the fuselage outer skin for the modification on the LH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

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

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(2) Subtask 533226-831-216-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	

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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	

References	
Structural Repair Manual (SRM)	51-75-11

(a) Prepare the fuselage outer skin for the modification on the RH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

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

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(3) Subtask 533226-831-248-001 - Remove Cross Plate from the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

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References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520000	Item (88)	Retain

(4) Subtask 533226-831-249-001 - Remove Cross Plate from the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39

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References	
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520100	Item (89)	Retain

(5) Subtask 533226-831-217-004 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36 Fastener Discard

NOTE: Be careful not to damage the holes.

(6) Subtask 533226-832-209-004 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(7) Subtask 533226-831-219-004 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

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(a) At the upper AFT door frame, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBCAD Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38	Fastener	Discard

NOTE: Be careful not to damage the holes.

(8) Subtask 533226-832-210-004 - Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 05, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the work steps that follow.

(9) Subtask 533226-831-218-004 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D04R03

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	F5337175221600	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD07				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15

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References	
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02 and Fig. A-GBCAD Sheet 03, Views A, B and C, position:

1	Shim	F5337175221600	Item 13

(c) Transfer drill the holes from the aircraft structure through the Shim, item 13 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 03 and Fig. A-GBCAD Sheet 09, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAD Sheet 09.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAD Sheet 08.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 13, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 08.

(h) Check existing countersinks available under shim item 13 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 08.

(i) Apply interfay sealant to the mating surface between the shim item 13 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01,Fig. A-GBCAD Sheet 02,Fig. A-GBCAD Sheet 03, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221600	Item 13
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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(k) In accordance with SUBTASK 533226-831-252 002 Apply Protections to the Upper Door Frame Area, LH .

(10) Subtask 533226-831-220-004 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 18

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D04R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5337175221800	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02 and Fig. A-GBCAD Sheet 05, Views A, B and E, position:

1	Shim	F5337175221800	Item 1

(c) Transfer drill the holes from the aircraft structure through the Shim, item 1 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 05 and Fig. A-GBCAD Sheet 09, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAD Sheet 09.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAD Sheet 09.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to the final diameter, the 27 non-cold worked holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 05 and Fig. A-GBCAD Sheet 08, Views A, B, E and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 1, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 09.

(h) Check existing countersinks available under shim item 1 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 09.

(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01,Fig. A-GBCAD Sheet 02,Fig. A-GBCAD Sheet 05, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221800	Item 1
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 002 Apply Protections to the Upper Door Frame Area, LH .

(11) Subtask 533226-831-225-004 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

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References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 03, Views A, B and C and in accordance with SRM 51-42-00, remove:

36 Fastener Discard

NOTE: Be careful not to damage the holes.

(12) Subtask 533226-832-213-004 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(13) Subtask 533226-831-227-004 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 05, Views A, B and E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

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(14) Subtask 533226-832-214-004 - Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 05, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

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(15) Subtask 533226-831-226-004 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	F5337175221700	1	SHIM	
23	ASNA2528-3	24	NUT	
24	ASNA2528-3A	12	NUT	
39	EN6114K3X13	24	BOLT	
46	EN6114K3A13	12	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01

ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02 and Fig. A-GBCAD Sheet 03, Views A, B and C, position:

1	Shim	F5337175221700	Item 14

(c) Transfer drill the holes from the aircraft structure through the Shim, item 14 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

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

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 03 and Fig. A-GBCAD Sheet 09, Views A, B, C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAD Sheet 09.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAD Sheet 09.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the remaining fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAD Sheet 08.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 14, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 08.

(h) Check existing countersinks available under shim item 14 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 08.

(i) Apply interfay sealant to the mating surface between the shim item 14 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01,Fig. A-GBCAD Sheet 02,Fig. A-GBCAD Sheet 03, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, B, C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221700	Item 14
12	Bolt	EN6114K3A13	Item 46
12	Nut	ASNA2528-3A	Item 24
24	Bolt	EN6114K3X13	Item 39
24	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 002 Apply Protections to the Upper Door Frame Area, RH .

(16) Subtask 533226-831-228-004 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D08R04				
ITEM	NEW PART N˚	QTY (UM)	KEYWORD	SEE NOTES
2	F5337175221900	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N˚	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD07				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-3	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-3

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02 and Fig. A-GBCAD Sheet 05, Views A, B and E, position:

1	Shim	F5337175221900	Item 2

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(c) Transfer drill the holes from the aircraft structure through the Shim, item 2 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 05 and Fig. A-GBCAD Sheet 09, Views A, B, E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAD Sheet 09.

Refer to the FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-3	Expendable Tooling	1

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4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table. refer to Fig. A-GBCAD Sheet 09.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 05 and Fig. A-GBCAD Sheet 08, Views A, B, E and fastener table.

2 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 2, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 09.

(h) Check existing countersinks available under shim item 2 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAD Sheet 09.

(i) Apply interfay sealant to the mating surface between the shim item 2 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

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(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAD Sheet 01,Fig. A-GBCAD Sheet 02,Fig. A-GBCAD Sheet 05, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221900	Item 2
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 002 Apply Protections to the Upper Door Frame Area, RH .

(17) Subtask 533226-831-234-004 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D04R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00

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References	
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 04 and Fig. A-GBCAD Sheet 05, Views A, B, D and Section D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

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(d) Refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 04, Views A, B and D, remove:

568	Fastener	Discard

NOTE: Be careful not to damage the holes.

(18) Subtask 533226-831-235-004 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 08:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

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2 If no cracks are detected, do the next step.

(19) Subtask 533226-831-238-004 - Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D03R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) SSS Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06 and Fig. A-GBCAD Sheet 07, Views A, G and H, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320800	Item 9

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NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06 and Fig. A-GBCAD Sheet 07, Views A, G and H and in accordance with SRM 51-42-00, remove:

214 Fastener

NOTE: Be careful not to damage the holes.

(20) Subtask 533226-831-239-004 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 07 and Fig. A-GBCAD Sheet 08:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(21) Subtask 533226-831-236-004 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D04R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	773	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	58	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAD Sheet 04 and Fig. A-GBCAD Sheet 05:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02 and Fig. A-GBCAD Sheet 04 and Fig. A-GBCAD Sheet 05, Views A, B, D, Sections B-B, C-C and D-D.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Deburr and clean the fasteners holes with:

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

(e) Put the doubler item 11 in position and shim item 19.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

(g) Deburr and clean the holes as necessary, use

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

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 11.

(i) Check if existing countersinks available under shim item 19 and doubler item 11, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required
to all the mating surfaces.		

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 04, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, B and D, wet install:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
58	Bolt	EN6114K3-6	Item 27

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4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
773	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43
10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(22) Subtask 533226-831-240-004 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D04R03				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	
23	ASNA2528-3	267	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	48	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00

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References	
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAD Sheet 06 and Fig. A-GBCAD Sheet 07:

1	Doubler	F5337175320800	Item 9

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06, Fig. A-GBCAD Sheet 07 and Fig. A-GBCAD Sheet 08, Views A, F, G and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 9, de-burr and clean, use:

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

(e) Put the doubler, item 9, in position.

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(f) Ream the remaining fastener holes to the final hole diameter, refer to Fig. A-GBCAD Sheet 08.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 9.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 9, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06, Fig. A-GBCAD Sheet 07, Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09, Views A, F, G and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320800	Item 9
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37

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48	Bolt	EN6114K3X12	Item 38
267	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(23) Subtask 533226-831-242-004 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700		DOUBLER	
19	F5337175222600		SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

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References	
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 04, Views A, B and D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 02 and Fig. A-GBBAD Sheet 04, Views A, B and D, remove:

568	Fastener	Discard

NOTE: Be careful not to damage the holes.

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(24) Subtask 533226-832-217-004 - Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 08:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

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(25) Subtask 533226-831-245-004 - Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900		DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09
Fig. A-GBBAD Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06 and Fig. A-GBCAD Sheet 07, Views A, G and Section F-F, temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320900 Item 10

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

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Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAD Sheet 01, Fig. A-GBBAD Sheet 06 and Fig. A-GBBAD Sheet 07, Views A, F and G and in accordance with SRM 51-42-00, remove:

214 Fastener

NOTE: Be careful not to damage the holes.

(26) Subtask 533226-831-246-004 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAD Sheet 07 and Fig. A-GBCAD Sheet 08:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(27) Subtask 533226-831-243-004 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D08R04				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	773	NUT	
24	ASNA2528-3A	126	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	58	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K3A7	18	BOLT	
42	EN6114K3A9	18	BOLT	
43	EN6114K3A10	34	BOLT	
44	EN6114K3A11	10	BOLT	
46	EN6114K3A13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K3A8	30	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAD Sheet 04 and Fig. A-GBCAD Sheet 05:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 04 and Fig. A-GBCAD Sheet 05, Views A, B, D, Sections B-B, C-C and D-D.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler, item 12 in position and the shim, item 19.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAD Sheet 08 and Fig. A-GBCAD Sheet 09.

(g) Deburr and clean the holes as necessary, use

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 12.

(i) Check if existing countersinks available under shim item 19 and doubler item 12, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 02, Fig. A-GBCAD Sheet 04, Fig. A-GBCAD Sheet 05 and Fig. A-GBCAD Sheet 09, Views A, B and D, wet install:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
58	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-9	Item 30

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4	Bolt	EN6114K3-8	Item 29
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
773	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K3A7	Item 41
30	Bolt	EN6114K3A8	Item 93
18	Bolt	EN6114K3A9	Item 42
34	Bolt	EN6114K3A10	Item 43
10	Bolt	EN6114K3A11	Item 44
16	Bolt	EN6114K3A13	Item 46
126	Nut	ASNA2528-3A	Item 24
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(28) Subtask 533226-831-247-004 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D08R04

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	
23	ASNA2528-3	267	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	8	BOLT	
31	EN6114K3-10	12	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	48	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAD Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAD Sheet 06 and Fig. A-GBCAD Sheet 07:

1	Doubler	F5337175320900	Item 10

(c) Transfer drill the existing fastener holes and drill the new fastener holes, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06, Fig. A-GBCAD Sheet 07 and Fig. A-GBCAD Sheet 08, Views A, F and G and fastener table and Section F-F and in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 10, deburr and clean, use:

Textile-Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Put the doubler, item 10, in position.

(f) Ream the remaining fastener holes to the final hole diameter, refer to Fig. A-GBCAD Sheet 08.

NOTE: Install fasteners as necessary to prevent movement.

(g) Clean and deburr the holes as necessary. Use:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(h) Countersink fastener holes at doubler 10.

(i) Clean and deburr the holes as necessary. Use:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(j) Check if existing countersinks available under doubler item 10, if necessary fill them in accordance with SRM 51-71-15.

(k) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(l) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAD Sheet 01, Fig. A-GBCAD Sheet 06, Fig. A-GBCAD Sheet 07 and Fig. A-GBCAD Sheet 08, Views A, F and G and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320900	Item 10
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27

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4	Bolt	EN6114K3-7	Item 28
8	Bolt	EN6114K3-9	Item 30
12	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
48	Bolt	EN6114K3X12	Item 38
267	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(m) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(29) Subtask 533226-831-252-002 - Apply Protections to the Upper Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

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(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(30) Subtask 533226-831-253-001 - Apply Protections to the Lower Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

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(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(31) Subtask 533226-831-254-002 - Apply Protections to the Upper Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

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(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(32) Subtask 533226-831-255-001 - Apply Protections to the Lower Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

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(33) Subtask 533226-831-250-001 - Install Cross Plate of the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520000	Item (88)	Retained at removal

with

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	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	
11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(34) Subtask 533226-831-251-001 - Install Cross Plate of the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D11R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520100	Item (89)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
	NOTE:	Applicable up to MSN 0122. From MSN 0123 on the rivet quantity is 62.		
12	Rivet	LN9198-4820CF	Item 75	
	NOTE:	Applicable from MSN 0123 on.		
11	Bolt	ASNA0082-204	Item 76	

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	NOTE:	11 Rivets ASNA0081A206 applicable to MSN 0600 on.		
4	Bolt	ASNA0081A204	Item 77	
	NOTE:	Applicable quantity from MSN 0128 to 0507 is 0.		
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
	NOTE:	Applicable for MSN 0128 to 0507. From MSN up to 0122 and from MSN 0508 to 0599, the quantity is 14. The quantity from MSN 0600 on is 4.		
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(35) Subtask 533226-831-212-004 - Do the Modification of the LH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D09R01				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws	Discard
72	Rivets	Discard

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1	Strip		Item (66)	Retain
1	Seal Retainer		Item (81)	Retain
1	Door Seal Segment		Item (80)	Retain

(b) Clean the work area with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	

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14	Nut	NAS1726C3	Item 65
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the LH Emergency Exit Door 834, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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Top Coat Polyurethane - External Structure	04JAA3	As required

(36) Subtask 533226-831-214-004 - Do the Modification of the RH Emergency Exit Door

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D10R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, D and F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

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Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04, Views A, B, E and G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the RH Emergency Exit Door 844, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

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4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

**CONF 005

(1) Subtask 533226-831-215-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

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Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2		
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2		
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11 51-75-12 51-76-00 53-21-12

(a) Prepare the fuselage outer skin for the modification on the LH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

4 If necessary, apply the surface protection:

Wash Primer - Structure	04CMA2	As required
Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

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(2) Subtask 533226-831-216-001 - Perform Paint-Stripping of the Aircraft Skin at the Modification Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Wash Primer - Structure	04CMA2	As required	
	Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-75-11

(a) Prepare the fuselage outer skin for the modification on the RH side:

1 Mark the area on the fuselage outer skin where modification will be performed.

2 Carefully remove the paint by stripping the marked fuselage outer skin, refer to SRM 51-75-11.

3 Clean the area with:

Textile - Lint Free Cotton 14SBA1 As required

made moist with

Non Aqueous Cleaner - General 08BAA9 As required

4 If necessary, apply the surface protection:

Wash Primer - Structure 04CMA2 As required

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Primer Polyurethane Paint - Corrosion Inhibiting	04EAC2	As required

(3) Subtask 533226-831-201-006 - Remove the Scuff Plates from the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5A to Frame 53.7 Stringer 26

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03 view A, view B, section A-A, section C-C, section D-D, section E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff		Item (12)	Discard
1	Plate-Scuff		Item (13)	Discard
1	Plate-Scuff		Item (14)	Discard

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(4) Subtask 533226-831-207-004 - Remove the Scuff Plates from the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5A to Frame 53.7A Stringer 26

Manpower Resources	
Manhours	2.00
Minimum number of person	1
Subtask elapsed time	2.00
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-000-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02 and Fig. A-GBAAA Sheet 03 view A, view B, section A-A, section C-C, section D-D, section E-E and AMM Task 53-35-15-000-801 remove:

8	Screw	NAS1102E3-7	Item (105)	Retain
2	Washer	NAS1169C10L	Item (6)	Retain
2	Screw	NAS1102E3-10	Item (8)	Retain
2	Nut	MS21042-3	Item (9)	Retain
2	Washer	AN960KD10L	Item (10)	Retain
12	Screw		Item (21)	Discard
12	Washer		Item (22)	Discard
1	Plate-Scuff	F5337040020100	Item (12)	Discard
1	Plate-Scuff	F5337013820200	Item (13)	Discard
1	Plate-Scuff	F5337040020000	Item (14)	Discard

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(5) Subtask 533226-831-248-001 - Remove Cross Plate from the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520000	Item (88)	Retain

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(6) Subtask 533226-831-249-001 - Remove Cross Plate from the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Remove the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

74	Rivet	LN9198-4020CF	Item (74)	Discard
12	Rivet	LN9198-4820CF	Item (75)	Discard
11	Bolt	ASNA082-204	Item (76)	Discard
4	Bolt	ASNA0081A204	Item (77)	Discard
5	Bolt	ASNA0082A306	Item (78)	Discard
1	Bolt	ASNA0082-207	Item (79)	Discard
18	Bolt	ASNA0082A206	Item (82)	Discard
6	Bolt	ASNA0082-203	Item (83)	Discard
2	Bolt	ASNA0082-205	Item (86)	Discard
6	Bolt	NAS6703U4	Item (84)	Retain
6	Washer	AN960XC10LL	Item (85)	Retain
1	Cross Plate	F5337015520100	Item (89)	Retain

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(7) Subtask 533226-831-217-005 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 03 view A, view B, view C and in accordance with SRM 51-42-00, remove:

36	Fastener	Discard

NOTE: Be careful not to damage the holes.

(8) Subtask 533226-832-209-005 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

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References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(9) Subtask 533226-831-219-005 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

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References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 05 view A, view B, view E and in accordance with SRM 51-42-00, remove:

38 Fastener Discard

NOTE: Be careful not to damage the holes.

(10) Subtask 533226-832-210-005 - Do the Inspection of the Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 05, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the work steps that follow.

(11) Subtask 533226-831-221-005 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 15 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the lower AFT door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 10 view A, view G, view K and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(12) Subtask 533226-832-211-005 - Do the Inspection of the Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 10, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(13) Subtask 533226-831-256-004 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 08 view A, view G, view H and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(14) Subtask 533226-832-218-004 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 08, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(15) Subtask 533226-831-218-005 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
13	F5337175221600	1	SHIM	
23	ASNA2528-3	22	NUT	
24	ASNA2528-3A	14	NUT	
39	EN6114K3X13	22	BOLT	
95	EN6114K3A13	14	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

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NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 03 view A, view B and view C position:

1	Shim	F5337175221600	Item 13

(c) Transfer drill the holes from the aircraft structure through the Shim, item 13 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 13, deburr and clean with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 03 and Fig. A-GBCAE Sheet 12 view A, view B, view C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 03 and Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

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Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table. refer to Fig. A-GBCAE Sheet 03 and Fig. A-GBCAE Sheet 12

Refer to Tool No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17,

1 Ream the 24 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 03 view A, view B, view C and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 13, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 12.

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(h) Check existing countersinks available under shim item 13 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 12.

(i) Apply interfay sealant to the mating surface between the shim item 13 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 03, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view B, view C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221600	Item 13
14	Bolt	EN6114K3A13	Item 95
14	Nut	ASNA2528-3A	Item 24
22	Bolt	EN6114K3X13	Item 39
22	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(16) Subtask 533226-831-220-005 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D12R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
1	F5337175221800	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 05 view A, view B and view E, position:

1	Shim	F5337175221800	Item 1

(c) Transfer drill the holes from the aircraft structure through the Shim, item 1 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05 and Fig. A-GBCAE Sheet 11 view A, view B, view E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17,

1 Ream to the final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05 and Fig. A-GBCAE Sheet 11, Views A, B, E and fastener table.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 1, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(h) Check existing countersinks available under shim item 1 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 1 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR15 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12, Views A, B, E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221800	Item 1
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(17) Subtask 533226-831-222-005 - Do the Modification of Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	
95	EN6114K3A13	3	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 10 view A, view G and view K position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and Clean the fastener holes with:

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

(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer toFig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 10 and Fig. A-GBCAE Sheet 12 view A, view G, view K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

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

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 11.

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer toFig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 10, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view G, view K and fastener table.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(h) Check existing countersinks available under shim item 15 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 10, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view G, view K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
3	Bolt	EN6114K3A13	Item 95
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(18) Subtask 533226-831-224-005 - Do the Modification of the Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
47	EN6114K3A14	7	BOLT	
95	EN6114K3A13	3	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

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Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 08 view A, view G and view H position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 17, deburr and clean the fastener holes with :

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

(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 10 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08 and Fig. A-GBCAE Sheet 12 view A, view G, view H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08 and Fig. A-GBCAE Sheet 11 view A, view G, view H and fastener table.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(h) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view G, view H and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
3	Bolt	EN6114K3A13	Item 95
7	Bolt	EN6114K3A14	Item 47
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(19) Subtask 533226-831-225-005 - Remove Fasteners at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

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Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 03 view A, view B, view C and in accordance with SRM 51-42-00, remove:

36 Fastener Discard

NOTE: Be careful not to damage the holes.

(20) Subtask 533226-832-213-005 - Do the Inspection of Fastener Holes at Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 18A

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801

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References	
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(21) Subtask 533226-831-227-005 - Remove Fasteners at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00

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References	
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the upper AFT door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 05 view A, view B, view E and in accordance with SRM 51-42-00, remove:

38	Fastener	Discard

NOTE: Be careful not to damage the holes.

(22) Subtask 533226-832-214-005 - Do the Inspection of Fastener Holes at Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 05, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(23) Subtask 533226-831-229-005 - Remove Fasteners at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

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(a) At the lower AFT door frame, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 10 view A, view G, view K and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(24) Subtask 533226-832-215-005 - Do the Inspection of Fastener Holes at Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 10, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(25) Subtask 533226-831-231-005 - Remove Fasteners at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 27

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) At the lower FWD door frame corner, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 08 view A, view G, view H and in accordance with SRM 51-42-00, remove:

18	Fastener	Discard

NOTE: Be careful not to damage the holes.

(26) Subtask 533226-832-216-005 - Do the Inspection of Fastener Holes at Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	0.50
Minimum number of person	1
Subtask elapsed time	0.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 08, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12.

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a High Frequency Eddy Current (HFEC) (rotating probe) inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

1 If there are crack findings, contact AIRBUS before next flight and follow their instructions.

2 If there are no crack findings, continue with the worksteps that follow.

(27) Subtask 533226-831-226-005 - Do the Modification of Upper Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 14 to Stringer 17

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
14	F5337175221700	1	SHIM	
23	ASNA2528-3	22	NUT	
24	ASNA2528-3A	14	NUT	
39	EN6114K3X13	22	BOLT	
95	EN6114K3A13	14	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

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NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required

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Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR15 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 03 view A, view B and view C position:

1	Shim	F5337175221700	Item 14

(c) Transfer drill the holes from the aircraft structure through the Shim, item 14 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove shim item 14, deburr and clean with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.5 and Frame 53.6 and STGR15 - STGR17 cold work the 12 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 03 and Fig. A-GBCAE Sheet 12 view A, view B, view C and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.6 and STGR15 - STGR17,

1 Ream to final diameter the 24 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 03 and Fig. A-GBCAE Sheet 11 view A, view B, view C and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 14, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 12.

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(h) Check existing countersinks available under shim item 14 requires filling, fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 12.

(i) Apply interfay sealant to the mating surface between the shim item 14 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR14 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 03, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view B, view C and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221700	Item 14
14	Bolt	EN6114K3A13	Item 95
14	Nut	ASNA2528-3A	Item 24
22	Bolt	EN6114K3X13	Item 39
22	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(28) Subtask 533226-831-228-005 - Do the Modification of Upper Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 15 to Stringer 17

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
2	F5337175221900	1	SHIM	
23	ASNA2528-3	27	NUT	
24	ASNA2528-3A	11	NUT	
40	EN6114K3X14	27	BOLT	
47	EN6114K3A14	11	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 05 view A, view B and view E position:

1	Shim	F5337175221900	Item 2

(c) Transfer drill the holes from the aircraft structure through the Shim, item 2 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17 cold work the 11 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05 and Fig. A-GBCAE Sheet 12 view A, view B, view E and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2 Expendable Tooling 1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1 Capital Tooling 1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2 Durable Tooling 1

7 Deburr and clean the fastener holes with

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17,

1 Ream to final diameter the 27 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05 and Fig. A-GBCAE Sheet 11 view A, view B, view E and fastener table.

2 Deburr and clean the fastener holes with:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) In shim item 2, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(h) Check existing countersinks available under shim item 2 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

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(i) Apply interfay sealant to the mating surface between the shim item 2 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.6 and Frame 53.8 and STGR14 - STGR17, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 05, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view B, view E and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175221900	Item 2
11	Bolt	EN6114K3A14	Item 47
11	Nut	ASNA2528-3A	Item 24
27	Bolt	EN6114K3X14	Item 40
27	Nut	ASNA2528-3	Item 23

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

(29) Subtask 533226-831-230-005 - Do the Modification of the Lower Aft Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
17	F5337175222000	1	SHIM	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
47	EN6114K3A14	6	BOLT	
48	EN6114K3A15	1	BOLT	
95	EN6114K3A13	3	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

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Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 10 view A, view G and view K, position:

1	Shim	F5337175222000	Item 17

(c) Transfer drill the holes from the aircraft structure through the Shim item 17 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Clean and deburr the holes as necessary with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(e) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 cold work the 10 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 10 view A, view G, view K and fastener table and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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3 Install the split sleeves.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

1 Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27 ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 10 and Fig. A-GBCAE Sheet 11 view A, view G, view K and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) In shim item 17, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(g) Check existing countersinks available under shim item 17 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

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(h) Apply interfay sealant to the mating surface between the shim item 17 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(i) Between Frame 53.6 and Frame 53.8 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 10, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view G, view K and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222000	Item 17
3	Bolt	EN6114K3A13	Item 95
6	Bolt	EN6114K3A14	Item 47
1	Bolt	EN6114K3A15	Item 48
10	Nut	ASNA2528-3A	Item 24
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
3	Bolt	EN6114K3-11	Item 32
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(j) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(30) Subtask 533226-831-232-005 - Do the Modification of Lower Forward Corner of the Door Frame at Emergency Exit Door Type 1 RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.7 from Stringer 24 to Stringer 27

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Manpower Resources	
Manhours	8.00
Minimum number of person	2
Subtask elapsed time	4.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
15	F5337175222100	1	SHIM	
23	ASNA2528-3	11	NUT	
24	ASNA2528-3A	10	NUT	
32	EN6114K3-11	3	BOLT	
39	EN6114K3X13	2	BOLT	
40	EN6114K3X14	6	BOLT	
47	EN6114K3A14	7	BOLT	
95	EN6114K3A13	3	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

Standard tool TOOLD01				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	FTIA330533226-1	Capital Tooling	1	(1)

NOTE (1): Capital Tooling.Ref: FTI-A330-53-3226-1

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 Fatigue Technology Incorporated (FTI).

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Standard tool TOOLD04				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	DKA330533226-2	Durable Tooling	1	(1)

NOTE (1): Durable Tooling.Ref: DK-A330-53-3226-2

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.

Standard tool TOOLD05				
ITEM	TOOL N°	TOOL NAME	QTY	SEE NOTES
	EKA330533226-2	Expendable Tooling	1	(1)

NOTE (1): Expendable Tooling.Ref: EK-A330-53-3226-2

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.

References	
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-11 51-46-11 51-47-00 51-48-00 51-71-15 51-75-12 51-75-15
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

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(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 08 view A, view G and view H position:

1	Shim	F5337175222100	Item 15

(c) Transfer drill the holes from the aircraft structure through the Shim item 15 in accordance with SRM 51-44-11.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and Clean the fastener holes with:

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

(e) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27 cold work the 10 holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08 and Fig. A-GBCAE Sheet 12 view A, view G, view H and in accordance with SRM 51-48-00:

1 Oversize the fastener holes to the starting hole diameter, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI tool list No.:

DKA330533226-2	Durable Tooling	1

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

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2 Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

3 Install the split sleeves.

Refer to FTI Tool list No.:

EKA330533226-2	Expendable Tooling	1

4 Cold work the fastener holes.

Refer to FTI Tool list No.:

FTIA330533226-1	Capital Tooling	1

5 Remove the split sleeves.

6 Ream the fastener holes to the final hole diameter, as shown in the fastener table, refer to Fig. A-GBCAE Sheet 12.

Refer to FTI Tool list No.:

DKA330533226-2	Durable Tooling	1

7 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(f) Between Frame 53.5 and Frame 53.7 and STGR24 - STGR27,

1 Ream to final diameter the 11 non-cold worked holes, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08 and Fig. A-GBCAE Sheet 11 view A, view G, view H and fastener table.

2 Deburr and Clean the fastener holes with:

Textile-Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

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(g) In shim item 15, do the countersinking in accordance with SRM 51-46-11 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(h) Check existing countersinks available under shim item 15 requires filling , fill them as necessary in accordance with SRM 51-71-15 for the new fastener head depth, refer to Fig. A-GBCAE Sheet 11.

(i) Apply interfay sealant to the mating surface between the shim item 15 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(j) Between Frame 53.5 and Frame 53.7 and STGR25A - STGR27, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 08, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12 view A, view G, view H and fastener tables and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5337175222100	Item 15
3	Bolt	EN6114K3A13	Item 95
7	Bolt	EN6114K3A14	Item 47
10	Nut	ASNA2528-3A	Item 24
3	Bolt	EN6114K3-11	Item 32
2	Bolt	EN6114K3X13	Item 39
6	Bolt	EN6114K3X14	Item 40
11	Nut	ASNA2528-3	Item 23

with:

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(k) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(31) Subtask 533226-831-233-005 - Remove Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

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Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 06 view A, view B, view F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620200	Item (71)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(32) Subtask 533226-831-234-005 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
19	F5337175222600	1	SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 05 view A, view B, view D and Section D-D temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

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NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 04 view A, view B and view D, remove:

566	Fastener	Discard

NOTE: Be careful not to damage the holes.

(33) Subtask 533226-831-235-005 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 04, Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(34) Subtask 533226-831-238-005 - Remove Fasteners between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D12R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00

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References	
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 09 view A, view G, view J and section H-H temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320800 Item 9

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

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(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 09 view A, view G and view J and in accordance with SRM 51-42-00, remove:

219	Fastener	Discard

NOTE: Be careful not to damage the holes.

(35) Subtask 533226-831-239-005 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

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2 If no cracks are detected, do the next step.

(36) Subtask 533226-831-236-005 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
11	F5337175320600	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K4X7	18	BOLT	
42	EN6114K4X9	18	BOLT	
43	EN6114K4X10	34	BOLT	
44	EN6114K4X11	10	BOLT	
46	EN6114K4X13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K4X8	30	BOLT	
94	ASNA2528-4	126	NUT	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 05:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11 view A, view B, view D and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with:

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

(e) Put the doubler, item 11 and the Shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use:

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

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 11 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 11, if necessary fill them in accordance with SRM 51-71-15.

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(j) Apply a thin layer of

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

to all the mating surfaces.

(k) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11 view A, view B, view D, Section D-D and fastener table, wet install:

1	Doubler	F5337175320600	Item 11
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K4X7	Item 41
30	Bolt	EN6114K4X8	Item 93
18	Bolt	EN6114K4X9	Item 42
34	Bolt	EN6114K4X10	Item 43

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10	Bolt	EN6114K4X11	Item 44
16	Bolt	EN6114K4X13	Item 46
126	Nut	ASNA2528-4	Item 94
	with:		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(37) Subtask 533226-831-237-005 - Install Rain Gutter at Emergency Exit Door Type 1 Area LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1		
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

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References	
Aircraft Maintenance Manual (AMM)	20-28-00 Task 20-28-00-912-801
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Temporarily position the rain gutter item (71), shim items 55 and 56, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 06 view F

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item (71) to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAE Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

Textile - Lint Free Cotton	14SBA1	As required

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made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(g) Between all the parts, apply thin layer of interfay sealant

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position shim item 56, wet install

1	Rivet	EN6069D5-09	Item 61	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(i) Put in position rain gutter item (71) and shim item 55, refer to Fig. A-GBCAE Sheet 06.

(j) Ream the remaining holes at the doubler item 11 and rain gutter item (71) to the final hole diameter, refer to Fig. A-GBCAE Sheet 06.

(k) Deburr and clean the holes as necessary, use:

Textile - Lint Free Cotton	14SBA1	As required

made moist with

Non Aqueous Cleaner - General	08BAA9	As required

(l) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 06 view A, view B, view F, section F-F, section G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620200	Item (71)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

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8	Rivet	EN6081D5-09	Item 60
4	Rivet	EN6081D5-12	Item 62

except at bonding points.

(m) Install bonding points in accordance with AMM Task 20-28-00-912-801.

(n) In accordance with SUBTASK 533226-831-252 001 Apply Protections to the Upper Door Frame Area, LH .

(38) Subtask 533226-831-240-005 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
9	F5337175320800	1	DOUBLER	
23	ASNA2528-3	261	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	10	BOLT	
31	EN6114K3-10	10	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 09:

1	Doubler	F5337175320800	Item 9

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(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11 view A, view G, view J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Remove the doubler, item 9, de-burr and clean, use:

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

(e) Put the doubler, item 9, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 9.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 9, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

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(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11 view A, view G, view J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320800	Item 9
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
10	Bolt	EN6114K3-9	Item 30
10	Bolt	EN6114K3-10	Item 31
24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
261	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-253 001 Apply Protections to the Lower Door Frame Area, LH .

(39) Subtask 533226-831-241-006 - Remove Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 14

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Manpower Resources	
Manhours	1.00
Minimum number of person	2
Subtask elapsed time	0.50
Skills	AIRFRAME

References	
Structural Repair Manual (SRM)	51-42-00
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 06 view A, view B, view F and in accordance with SRM 51-42-00, remove:

1	Gutter-Rain	F5337023620300	Item (72)	Retain
12	Fastener			Discard

NOTE: Be careful not to damage the holes.

(40) Subtask 533226-831-242-005 - Remove Fasteners between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	10.00
Minimum number of person	2
Subtask elapsed time	5.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
19	F5337175222600	1	SHIM	

References	
Structural Repair Manual (SRM)	51-10-00 51-47-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR4 and STGR15A, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 05 view A, view B, view D, section B-B, section C-C and section D-D, temporarily put these items in position and mark their shape on the fuselage skin:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

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NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

(d) Refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 02 and Fig. A-GBBAB Sheet 04 view A, view B and view D, remove:

566	Fastener	Discard

NOTE: Be careful not to damage the holes.

(41) Subtask 533226-832-217-005 - Do the Inspection of the Fasteners Holes between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	1.50
Minimum number of person	1
Subtask elapsed time	1.50
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11 and Fig. A-GBCAE Sheet 12:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

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2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(42) Subtask 533226-831-245-005 - Remove Fasteners from between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

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

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	

References	
Structural Repair Manual (SRM)	51-10-00 51-42-00 51-47-00

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References	
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12
Fig. A-GBBAB Removal of the Fasteners between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10

(a) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 09 view A, view G, and view J, temporarily put these items in position and mark their shape on the fuselage skin:

1 Doubler F5337175320900 Item 10

NOTE: Make sure that there is no sealant at the overlap area of the two panels.

Make sure that the two panels are aligned. If they are not aligned, the lower panel can be reworked, in accordance with SRM 51-10-00. The edge distances as given in the SRM 51-47-00 have to be respected.

NOTE: Make sure that the edge distance of the fasteners is in accordance with the SRM 51-47-00.

NOTE: Make sure that the fastener spacing is the same as the existing pitch or in accordance with the SRM 51-47-00.

NOTE: If necessary cut straps to the correct length (only cut in the circumferential direction), if a strap is cut, make sure aerodynamic chamfer is maintained.

(b) Remove the items that are temporarily installed.

(c) Identify the fasteners that you must remove in the modification area with a wax pencil.

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(d) Between Frame 53.5A and Frame 53.7A and STGR26 - STGR30, refer to Fig. A-GBBAB Sheet 01, Fig. A-GBBAB Sheet 07 and Fig. A-GBBAB Sheet 09 view A, view G, view J and in accordance with SRM 51-42-00, remove:

219	Fastener	Discard

NOTE: Be careful not to damage the holes.

(43) Subtask 533226-831-246-005 - Do the Inspection of the Fastener Holes between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	1.00
Minimum number of person	1
Subtask elapsed time	1.00
Skills	NON DESTRUCTIVE TESTING

References	
Non Destructive Test Manual (NTM)	Task 51-10-01-250-801
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Do a check of the diameter of the fastener holes, refer to Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11:

1 Make sure that the hole diameter is not equal to or more than the maximum final hole diameter.

2 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.

3 If the hole diameter is not equal to or more than the maximum hole diameter, do the next step.

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(b) Do a rotating probe inspection of the fastener holes, refer to NTM Task 51-10-01-250-801.

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

2 If no cracks are detected, do the next step.

(44) Subtask 533226-831-243-005 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR4 and STGR15A, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 4 to Stringer 15A

Manpower Resources	
Manhours	28.00
Minimum number of person	2
Subtask elapsed time	14.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
12	F5337175320700	1	DOUBLER	
19	F5337175222600	1	SHIM	
23	ASNA2528-3	770	NUT	
25	EN6114K3-4	210	BOLT	
26	EN6114K3-5	38	BOLT	
27	EN6114K3-6	55	BOLT	
29	EN6114K3-8	4	BOLT	
30	EN6114K3-9	4	BOLT	
31	EN6114K3-10	5	BOLT	
33	EN6114K3X6	206	BOLT	
34	EN6114K3X7	112	BOLT	
35	EN6114K3X8	66	BOLT	
36	EN6114K3X9	18	BOLT	
37	EN6114K3X10	14	BOLT	
39	EN6114K3X13	8	BOLT	
41	EN6114K4X7	18	BOLT	
42	EN6114K4X9	18	BOLT	
43	EN6114K4X10	34	BOLT	
44	EN6114K4X11	10	BOLT	
46	EN6114K4X13	16	BOLT	
91	EN6114K3X5	30	BOLT	
93	EN6114K4X8	30	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
94	ASNA2528-4	126	NUT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Structural Repair Manual (SRM)	51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

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(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 05:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11 view A, view B, view D and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

(d) Deburr and clean the fastener holes with:

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

(e) Put the doubler, item 12 and the shim, item 19, in position.

(f) Ream the fastener holes to the final hole diameter given in Fig. A-GBCAE Sheet 04 and Fig. A-GBCAE Sheet 11.

NOTE: Do not ream the fasteners under the rain gutter to the final hole diameter at this step. This will be done during rain gutter installation.

(g) Deburr and clean the holes as necessary, use:

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

(h) Do the countersink in accordance with SRM 51-46-11 of all fastener holes at doubler item 12 except holes for rain gutter (91) installation.

(i) Check if existing countersinks available under shim item 19 and doubler item 12, if necessary fill them in accordance with SRM 51-71-15.

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(j) Between Frame 53.6 and Frame 53.7 and STGR4 - STGR15A, in accordance with SRM 51-76-00 and refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02, Fig. A-GBCAE Sheet 04, Fig. A-GBCAE Sheet 05 and Fig. A-GBCAE Sheet 11 view A, view B, view D, section B-B, section C-C and section D-D, wet install:

1	Doubler	F5337175320700	Item 12
1	Shim	F5337175222600	Item 19
210	Bolt	EN6114K3-4	Item 25
38	Bolt	EN6114K3-5	Item 26
55	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-8	Item 29
4	Bolt	EN6114K3-9	Item 30
5	Bolt	EN6114K3-10	Item 31
206	Bolt	EN6114K3X6	Item 33
112	Bolt	EN6114K3X7	Item 34
66	Bolt	EN6114K3X8	Item 35
18	Bolt	EN6114K3X9	Item 36
14	Bolt	EN6114K3X10	Item 37
8	Bolt	EN6114K3X13	Item 39
30	Bolt	EN6114K3X5	Item 91
770	Nut	ASNA2528-3	Item 23
18	Bolt	EN6114K4X7	Item 41
30	Bolt	EN6114K4X8	Item 93
18	Bolt	EN6114K4X9	Item 42
34	Bolt	EN6114K4X10	Item 43
10	Bolt	EN6114K4X11	Item 44
16	Bolt	EN6114K4X13	Item 46
126	Nut	ASNA2528-4	Item 94
	with		

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(45) Subtask 533226-831-244-005 - Install Rain Gutter at Emergency Exit Door Type 1 Area RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 Stringer 14

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

Material necessary to do the job

Kit 533226D13R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
55	F5337175223000	1	SHIM	
56	F5337175222800	1	SHIM	
60	EN6081D5-09	8	RIVET	
61	EN6069D5-09	1	RIVET	
62	EN6081D5-12	4	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Textile - Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 20-28-00-912-801
Structural Repair Manual (SRM)	51-23-12 51-42-00 51-75-12

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References	
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Temporarily position the rain gutter item (72), shim items 55 and 56, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 06 view F.

1	Gutter-Rain	F5337023620300	Item (72)	Retain
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	

(b) Transfer drill holes from rain gutter item (72) to shim items 55 and 56.

(c) Deburr and clean the holes as necessary, use:

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

(d) Drill one fastener hole at the forward part of shim item 56 as shown on Fig. A-GBCAE Sheet 06 and transfer drill to the aircraft structure.

NOTE: This fastener hole fixes shim item 56 with aircraft structure. It does not fix the rain gutter.

(e) Countersink fastener hole at the shim item 56.

(f) Deburr and clean the holes as necessary, use:

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

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(g) Between all the parts, apply thin layer of interfay sealant

	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(h) Put in position shim item 56, wet install

1	Rivet	EN6069D5-09	Item 61	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(i) Put in position rain gutter item (72) and shim item 55, refer to Fig. A-GBCAE Sheet 06.

(j) Ream the remaining holes at the doubler item 12 and rain gutter item (72) to the final hole diameter, refer to Fig. A-GBCAE Sheet 06.

(k) Between Frame 53.5 and Frame 53.8 and STGR13 - STGR14, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 02 and Fig. A-GBCAE Sheet 06 view A, view B, view F, section F-F, section G-G and in accordance with SRM 51-42-00, wet install:

1	Gutter-Rain	F5337023620300	Item (72)	Retained at removal
1	Shim	F5337175223000	Item 55	
1	Shim	F5337175222800	Item 56	
8	Rivet	EN6081D5-09	Item 60	
4	Rivet	EN6081D5-12	Item 62	
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

except at bonding points.

(l) Install bonding points in accordance with AMM Task 20-28-00-912-801.

(m) In accordance with SUBTASK 533226-831-254 001 Apply Protections to the Upper Door Frame Area, RH .

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(46) Subtask 533226-831-247-005 - Install Doubler at Circumferential Joint between FR53.6 and FR53.7 and between STGR26 and STGR30, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.6 to Frame 53.7 from Stringer 26 to Stringer 30

Manpower Resources	
Manhours	19.00
Minimum number of person	2
Subtask elapsed time	9.50
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
10	F5337175320900	1	DOUBLER	
23	ASNA2528-3	261	NUT	
25	EN6114K3-4	10	BOLT	
27	EN6114K3-6	8	BOLT	
28	EN6114K3-7	4	BOLT	
30	EN6114K3-9	10	BOLT	
31	EN6114K3-10	10	BOLT	
33	EN6114K3X6	6	BOLT	
34	EN6114K3X7	48	BOLT	
36	EN6114K3X9	53	BOLT	
37	EN6114K3X10	46	BOLT	
38	EN6114K3X12	42	BOLT	
92	EN6114K3X11	24	BOLT	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

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References	
Structural Repair Manual (SRM)	51-23-12 51-44-11 51-46-11 51-47-00 51-71-15 51-75-12 51-75-15 51-76-00
Fig. A-GBCAE Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8	Sheet 01 Sheet 02 Sheet 03 Sheet 04 Sheet 05 Sheet 06 Sheet 07 Sheet 08 Sheet 09 Sheet 10 Sheet 11 Sheet 12

(a) Restore the skin outer surface protection as necessary in accordance with SRM 51-75-12, use:

Surface Pretreatment-Light Alloys Chemical Conver	10ABC1	As required
Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required

(b) Temporarily put in position on the outer fuselage skin, refer to Fig. A-GBCAE Sheet 07 and Fig. A-GBCAE Sheet 09:

1	Doubler	F5337175320900	Item 10

(c) Transfer drill the existing fastener holes and drill the new fastener holes in accordance with SRM 51-44-11, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11 view A, view G, view J and fastener table.

NOTE: Do not ream the holes to final diameter at this step.

NOTE: Make sure that the edge distance of the fasteners is in accordance with SRM 51-47-00.

NOTE: Unless otherwise stated, align new holes with existing holes (same pitch).

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(d) Remove the doubler, item 10, deburr and clean, use:

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

(e) Put the doubler, item 10, in position.

(f) Ream the fastener holes to the final hole diameter, refer to Fig. A-GBCAE Sheet 11.

NOTE: Install fasteners as necessary to prevent movement.

(g) Countersink fastener holes at doubler 10.

(h) Clean and deburr the holes as necessary. Use:

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

(i) Check if existing countersinks available under doubler item 10, if necessary fill them in accordance with SRM 51-71-15.

(j) Apply interfay sealant to the mating surfaces:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(k) Between Frame 53.6 and Frame 53.7 and STGR26 - STGR30, refer to Fig. A-GBCAE Sheet 01, Fig. A-GBCAE Sheet 07, Fig. A-GBCAE Sheet 09 and Fig. A-GBCAE Sheet 11 view A, view G, view J and fastener table in accordance with SRM 51-76-00, wet install:

1	Doubler	F5337175320900	Item 10
10	Bolt	EN6114K3-4	Item 25
8	Bolt	EN6114K3-6	Item 27
4	Bolt	EN6114K3-7	Item 28
10	Bolt	EN6114K3-9	Item 30
10	Bolt	EN6114K3-10	Item 31

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24	Bolt	EN6114K3X11	Item 92
6	Bolt	EN6114K3X6	Item 33
48	Bolt	EN6114K3X7	Item 34
53	Bolt	EN6114K3X9	Item 36
46	Bolt	EN6114K3X10	Item 37
42	Bolt	EN6114K3X12	Item 38
261	Nut	ASNA2528-3	Item 23
	with		
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(l) In accordance with SUBTASK 533226-831-255 001 Apply Protections to the Lower Door Frame Area, RH .

(47) Subtask 533226-831-252-001 - Apply Protections to the Upper Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

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(48) Subtask 533226-831-253-001 - Apply Protections to the Lower Door Frame Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

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(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(49) Subtask 533226-831-254-001 - Apply Protections to the Upper Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 4 to Stringer 18A

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	

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ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim, doubler and the rain gutter with

Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

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(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(50) Subtask 533226-831-255-001 - Apply Protections to the Lower Door Frame Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 24 to Stringer 30

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

Material necessary to do the job

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Top Coat Polyurethane - Grey Internal Structure	04JME4	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	

References	
Structural Repair Manual (SRM)	51-23-12 51-75-12

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(a) Restore the internal surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - Grey Internal Structure	04JME4	As required

(b) Apply fillet sealant around the shim and the doubler with

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(c) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(d) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(51) Subtask 533226-831-250-001 - Install Cross Plate of the Emergency Door Upper Area, LH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 14 to Stringer 15

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Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (88) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520000	Item (88)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	

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11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	
6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(52) Subtask 533226-831-251-002 - Install Cross Plate of the Emergency Door Upper Area, RH

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 13 to Stringer 15

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D11R02

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
74	LN9198-4020CF	74	RIVET	
75	LN9198-4820CF	12	RIVET	
76	ASNA0082-204	11	BOLT	
77	ASNA0081A204	4	BOLT	
78	ASNA0082A306	5	BOLT	

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ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
79	ASNA0082-207	1	BOLT	
82	ASNA0082A206	18	BOLT	
83	ASNA0082-203	6	BOLT	
86	ASNA0082-205	2	RIVET	

Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Structural Repair Manual (SRM)	53-31-39
Fig. A-GBEAA Remove/Installation of Cross Plate	Sheet 01 Sheet 02

(a) Wet install the cross plate item (89) as shown in Fig. A-GBEAA Sheet 01, Fig. A-GBEAA Sheet 02 and in accordance with SRM 53-31-39:

1	Cross Plate	F5337015520100	Item (89)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
74	Rivet	LN9198-4020CF	Item 74	
12	Rivet	LN9198-4820CF	Item 75	
11	Bolt	ASNA0082-204	Item 76	
4	Bolt	ASNA0081A204	Item 77	
5	Bolt	ASNA0082A306	Item 78	
1	Bolt	ASNA0082-207	Item 79	
18	Bolt	ASNA0082A206	Item 82	
6	Bolt	ASNA0082-203	Item 83	
2	Rivet	ASNA0082-205	Item 86	

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6	Bolt	NAS6703U4	Item (84)	Retained at removal
6	Washer	AN960XC10LL	Item (85)	Retained at removal
	with			
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	

(53) Subtask 533226-831-213-004 - Install the Scuff Plates to the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D12R00

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	
59	F5337175420200	1	PLATE	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

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(a) At the LH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04 view A, view B, section A-A, section B-B, section C-C, section D-D, section E-E and AMM Task 53-35-15-400-801 wet install:

1	Plate	F5337175420300	Item 58	
1	Plate	F5337175420400	Item 57	
1	Plate	F5337175420200	Item 59	
	with			
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal
2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal

(54) Subtask 533226-831-206-004 - Install the Scuff Plates to the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8 from Stringer 25A to Stringer 27

Manpower Resources	
Manhours	3.00
Minimum number of person	1
Subtask elapsed time	3.00
Skills	AIRFRAME

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Material necessary to do the job

Kit 533226D13R00				
ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
21	NAS1102E3-9	12	SCREW	
22	NAS1169C10L	12	WASHER	
57	F5337175420400	1	PLATE	
58	F5337175420300	1	PLATE	
59	F5337175420200	1	PLATE	

References	
Aircraft Maintenance Manual (AMM)	Task 53-35-15-400-801
Fig. A-GBAAA Removal/Installation of the Scuff Plates	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBAAA Sheet 01, Fig. A-GBAAA Sheet 02, Fig. A-GBAAA Sheet 03 and Fig. A-GBAAA Sheet 04 view A, view B, section A-A, section B-B, section C-C, section D-D, section E-E and AMM Task 53-35-15-400-801 wet install:

1	Plate	F5337175420300	Item 58	
1	Plate	F5337175420400	Item 57	
1	Plate	F5337175420200	Item 59	
	with			
12	Screw	NAS1102E3-9	Item 21	
12	Washer	NAS1169C10L	Item 22	
8	Screw	NAS1102E3-7	Item (105)	Retained at removal
2	Washer	NAS1169C10L	Item (6)	Retained at removal
2	Screw	NAS1102E3-10	Item (8)	Retained at removal
2	Nut	MS21042-3	Item (9)	Retained at removal
2	Washer	AN960KD10L	Item (10)	Retained at removal

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(55) Subtask 533226-831-212-005 - Do the Modification of the LH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D09R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

Consumable CMLD01

ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

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References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view D, view F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Seal Retainer	Item (81)	Retain
1	Door Seal Segment	Item (80)	Retain

(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view E, view G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

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(e) At the LH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view E, view G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	

with

Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the LH Emergency Exit Door 834, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

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(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

(56) Subtask 533226-831-214-005 - Do the Modification of the RH Emergency Exit Door

Work Zones and Access Panels			
	Zone	Access/Work location	
	260	Work location	from Frame 53.5 to Frame 53.8

Manpower Resources	
Manhours	6.00
Minimum number of person	2
Subtask elapsed time	3.00
Skills	AIRFRAME

Material necessary to do the job

Kit 533226D10R01

ITEM	NEW PART N°	QTY (UM)	KEYWORD	SEE NOTES
63	F5227016820000	1	SHIM	
64	NAS1102E3-17	14	SCREW	
65	NAS1726C3	14	NUT	
67	NSA9117-23	1	PLATE	
70	DIN65399-4014CF	72	RIVET	

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Consumable CMLD01				
ITEM	DESCRIPTION	REFERENCE TO CML MAT. No.	QTY PER A/C	SEE NOTES
	Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required	
	Top Coat Polyurethane - External Structure	04JAA3	As required	
	Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required	
	Polysulfide Sealant - General Purpose Brushable	06AAA1	As required	
	Polysulfide Sealant-General Purpose Fillet -	06AAB1	As required	
	Polysulfide Sealant - General Purpose Interfay	06AAC1	As required	
	Non Aqueous Cleaner - General	08BAA9	As required	
	Corrosion Preventive Compound - Water Displacing	12ABC1	As required	
	Corrosion Preventive Compound - Heavy Duty	12ACC1	As required	
	Textile-Lint Free Cotton	14SBA1	As required	

References	
Aircraft Maintenance Manual (AMM)	11-00-00, Page Block 201
Structural Repair Manual (SRM)	51-23-12 51-24-00 51-42-00 51-44-00 51-75-12
Fig. A-GBDAA Modification of the Emergency Exit Door Type 1	Sheet 01 Sheet 02 Sheet 03 Sheet 04

(a) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view D, view F and SRM 51-42-00, remove:

14	Screws		Discard
72	Rivets		Discard
1	Strip	Item (66)	Retain
1	Door Seal Segment	Item (80)	Retain

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(b) Clean the work area with:

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

(c) Apply interfay sealant to the mating surface between the shim item 63 and aircraft skin:

Polysulfide Sealant - General Purpose Interfay	06AAC1	As required

(d) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view E, view G and SRM 51-44-00, position:

1	Shim	F5227016820000	Item 63

Transfer drill 86 fastener holes to Shim, item 63 in accordance with SRM 51-44-00.

NOTE: Make sure that the edges of the gusset are flush with the door structure.

(e) At the RH Emergency Exit Door, refer to Fig. A-GBDAA Sheet 01, Fig. A-GBDAA Sheet 02, Fig. A-GBDAA Sheet 03 and Fig. A-GBDAA Sheet 04 view A, view B, view E, view G and in accordance with SRM 51-42-00 and SRM 51-24-00, wet install:

1	Shim	F5227016820000	Item 63	
1	Strip		Item (66)	Retained at removal
72	Rivet	DIN65399-4014CF	Item 70	
1	Seal Retainer		Item (81)	Retained at removal
1	Door Seal Segment		Item (80)	Retained at removal
14	Screw	NAS1102E3-17	Item 64	
14	Nut	NAS1726C3	Item 65	
	with			

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Polysulfide Sealant - General Purpose Brushable	06AAA1	As required

(f) Apply:

Polysulfide Sealant- General Purpose Fillet -	06AAB1	As required

(g) Re-identify the RH Emergency Exit Door 844, refer to Fig. A-GBDAA Sheet 01, Process and Material Specification (PMS) 01-06-12

1 Carefully remove and discard the identification plate.

2 Install, refer to AMM 11-00-00, Page Block 201:

1	Plate	NSA9117-23	Item 67

3 Re-identify the door in accordance with Appendix 03 - Re-identification of the Emergency Exit Doors .

4 Apply:

Varnish Polyurethane-Low Voc - External Structure	04SBA3	As required

(h) Restore the special coatings as necessary in accordance with SRM 51-23-12:

Corrosion Preventive Compound - Water Displacing	12ABC1	As required
Corrosion Preventive Compound - Heavy Duty	12ACC1	As required

(i) Restore the external surface protection as necessary in accordance with SRM 51-75-12, use:

Primer Epoxy Paint - Corrosion Inhibiting	04DAB2	As required
Top Coat Polyurethane - External Structure	04JAA3	As required

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**CONF ALL

D. TEST

**CONF 001

(1) Subtask 533226-710-201-001 - Operational Test Emergency Exit Door LH/RH

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 33-51-00-710-801 Task 52-71-00-710-801

(a) Do the Operational Test of the Emergency Exit Door 834/844, refer to AMM Task 52-71-00-710-801.

(b) Do the Operational Test of the Escape Slide warning System, refer to AMM Task 52-71-00-710-801.

(c) Do an Operational Check of the Emergency Light via the Multipurpose Control and Display Unit (MCDU) in accordance with AMM Task 33-51-00-710-801.

**CONF 002

(1) Subtask 533226-710-201-001 - Operational Test Emergency Exit Door LH/RH

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 33-51-00-710-801 Task 52-71-00-710-801

(a) Do the Operational Test of the Emergency Exit Door 834/844, refer to AMM Task 52-71-00-710-801.

(b) Do the Operational Test of the Escape Slide warning System, refer to AMM Task 52-71-00-710-801.

(c) Do an Operational Check of the Emergency Light via the Multipurpose Control and Display Unit (MCDU) in accordance with AMM Task 33-51-00-710-801.

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**CONF 003

(1) Subtask 533226-710-201-001 - Operational Test Emergency Exit Door LH/RH

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 33-51-00-710-801 Task 52-71-00-710-801

(a) Do the Operational Test of the Emergency Exit Door 834/844, refer to AMM Task 52-71-00-710-801.

(b) Do the Operational Test of the Escape Slide warning System, refer to AMM Task 52-71-00-710-801.

(c) Do an Operational Check of the Emergency Light via the Multipurpose Control and Display Unit (MCDU) in accordance with AMM Task 33-51-00-710-801.

**CONF 004

(1) Subtask 533226-710-201-001 - Operational Test Emergency Exit Door LH/RH

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 33-51-00-710-801 Task 52-71-00-710-801

(a) Do the Operational Test of the Emergency Exit Door 834/844, refer to AMM Task 52-71-00-710-801.

(b) Do the Operational Test of the Escape Slide warning System, refer to AMM Task 52-71-00-710-801.

(c) Do an Operational Check of the Emergency Light via the Multipurpose Control and Display Unit (MCDU) in accordance with AMM Task 33-51-00-710-801.

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**CONF 005

(1) Subtask 533226-710-201-001 - Operational Test Emergency Exit Door LH/RH

Work Zones and Access Panels		
	Zone	Access/Work location
	260	

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 33-51-00-710-801 Task 52-71-00-710-801

(a) Do the Operational Test of the Emergency Exit Door 834/844, refer to AMM Task 52-71-00-710-801.

(b) Do the Operational Test of the Escape Slide warning System, refer to AMM Task 52-71-00-710-801.

(c) Do an Operational Check of the Emergency Light via the Multipurpose Control and Display Unit (MCDU) in accordance with AMM Task 33-51-00-710-801.

**CONF ALL

E. CLOSE-UP

**CONF 001

(1) Subtask 533226-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-400-801 Task 21-20-00-410-801 Task 25-21-41-400-801 Task 25-23-41-400-801 Task 25-23-43-400-802 Task 25-23-48-400-801 Task 25-24-51-400-801 Task 25-42-41-400-801 Task 25-53-00-400-801 Task 25-80-00-400-001 Task 33-51-38-400-801 Task 36-12-41-400-801 Task 36-22-17-400-801 Task 52-10-00-410-801 Task 52-22-21-400-801
Structural Repair Manual (SRM)	51-72-11

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

(b) Install removed insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the APU duct, refer to AMM Task 36-12-41-400-801

(d) Install sensing elements, refer to AMM Task 36-22-17-400-801.

(e) Install the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-400-801.

(f) Install lavatories as necessary, refer to AMM Task 25-42-41-400-801

(g) Install brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(h) Install sensor actuation assembly and bracket, refer to AMM Task 52-22-21-400-801.

(i) Install of the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-400-801

(j) Install removed air conditioning ducts, refer to AMM Task 21-20-00-400-801.

(k) Install door linings, refer to AMM Task 25-23-48-400-801.

(l) Install removed sidewall panels, refer to AMM Task 25-23-43-400-802.

(m) Install removed ceiling panels, refer to AMM Task 25-23-43-400-802.

(n) Install removed Overhead Storage Compartments, refer to AMM Task 25-24-51-400-801.

(o) Install removed passenger seats, refer to AMM Task 25-21-41-400-801.

(p) Remove the access platform(s).

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

****CONF 002**

(1) Subtask 533226-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

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References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-400-801 Task 21-20-00-410-801 Task 25-21-41-400-801 Task 25-23-41-400-801 Task 25-23-43-400-802 Task 25-23-48-400-801 Task 25-24-51-400-801 Task 25-42-41-400-801 Task 25-53-00-400-801 Task 25-80-00-400-001 Task 33-51-38-400-801 Task 36-12-41-400-801 Task 36-22-17-400-801 Task 52-10-00-410-801 Task 52-22-21-400-801
Structural Repair Manual (SRM)	51-72-11

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

(b) Install removed insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the APU duct, refer to AMM Task 36-12-41-400-801

(d) Install sensing elements, refer to AMM Task 36-22-17-400-801.

(e) Install the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-400-801.

(f) Install lavatories as necessary, refer to AMM Task 25-42-41-400-801

(g) Install brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(h) Install sensor actuation assembly and bracket, refer to AMM Task 52-22-21-400-801.

(i) Install of the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-400-801

(j) Install removed air conditioning ducts, refer to AMM Task 21-20-00-400-801.

(k) Install door linings, refer to AMM Task 25-23-48-400-801.

(l) Install removed sidewall panels, refer to AMM Task 25-23-43-400-802.

(m) Install removed ceiling panels, refer to AMM Task 25-23-43-400-802.

(n) Install removed Overhead Storage Compartments, refer to AMM Task 25-24-51-400-801.

(o) Install removed passenger seats, refer to AMM Task 25-21-41-400-801.

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(p) Remove the access platform(s).

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

**CONF 003

(1) Subtask 533226-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-400-801 Task 21-20-00-410-801 Task 25-21-41-400-801 Task 25-23-41-400-801 Task 25-23-43-400-802 Task 25-23-48-400-801 Task 25-24-51-400-801 Task 25-42-41-400-801 Task 25-53-00-400-801 Task 25-80-00-400-001 Task 33-51-38-400-801 Task 36-12-41-400-801 Task 36-22-17-400-801 Task 52-10-00-410-801 Task 52-22-21-400-801
Structural Repair Manual (SRM)	51-72-11

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

(b) Install removed insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the APU duct, refer to AMM Task 36-12-41-400-801

(d) Install sensing elements, refer to AMM Task 36-22-17-400-801.

(e) Install the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-400-801.

(f) Install lavatories as necessary, refer to AMM Task 25-42-41-400-801

(g) Install brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(h) Install sensor actuation assembly and bracket, refer to AMM Task 52-22-21-400-801.

(i) Install of the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-400-801

(j) Install removed air conditioning ducts, refer to AMM Task 21-20-00-400-801.

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(k) Install door linings, refer to AMM Task 25-23-48-400-801.

(l) Install removed sidewall panels, refer to AMM Task 25-23-43-400-802.

(m) Install removed ceiling panels, refer to AMM Task 25-23-43-400-802.

(n) Install removed Overhead Storage Compartments, refer to AMM Task 25-24-51-400-801.

(o) Install removed passenger seats, refer to AMM Task 25-21-41-400-801.

(p) Remove the access platform(s).

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

**CONF 004

(1) Subtask 533226-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-400-801 Task 21-20-00-410-801 Task 25-21-41-400-801 Task 25-23-41-400-801 Task 25-23-43-400-802 Task 25-23-48-400-801 Task 25-24-51-400-801 Task 25-42-41-400-801 Task 25-53-00-400-801 Task 25-80-00-400-001 Task 33-51-38-400-801 Task 36-12-41-400-801 Task 36-22-17-400-801 Task 52-10-00-410-801 Task 52-22-21-400-801
Structural Repair Manual (SRM)	51-72-11

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

(b) Install removed insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the APU duct, refer to AMM Task 36-12-41-400-801

(d) Install sensing elements, refer to AMM Task 36-22-17-400-801.

(e) Install the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-400-801.

(f) Install lavatories as necessary, refer to AMM Task 25-42-41-400-801

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(g) Install brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(h) Install sensor actuation assembly and bracket, refer to AMM Task 52-22-21-400-801.

(i) Install of the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-400-801

(j) Install removed air conditioning ducts, refer to AMM Task 21-20-00-400-801.

(k) Install door linings, refer to AMM Task 25-23-48-400-801.

(l) Install removed sidewall panels, refer to AMM Task 25-23-43-400-802.

(m) Install removed ceiling panels, refer to AMM Task 25-23-43-400-802.

(n) Install removed Overhead Storage Compartments, refer to AMM Task 25-24-51-400-801.

(o) Install removed passenger seats, refer to AMM Task 25-21-41-400-801.

(p) Remove the access platform(s).

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

**CONF 005

(1) Subtask 533226-942-201-001 - Close-up

Manpower Resources	
Skills	AIRFRAME

References	
Aircraft Maintenance Manual (AMM)	Task 21-20-00-400-801 Task 21-20-00-410-801 Task 25-21-41-400-801 Task 25-23-41-400-801 Task 25-23-43-400-802 Task 25-23-48-400-801 Task 25-24-51-400-801 Task 25-42-41-400-801 Task 25-53-00-400-801 Task 25-80-00-400-001 Task 33-51-38-400-801 Task 36-12-41-400-801 Task 36-22-17-400-801 Task 52-10-00-410-801 Task 52-22-21-400-801
Structural Repair Manual (SRM)	51-72-11

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

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(b) Install removed insulation blankets, refer to AMM Task 25-80-00-400-001.

(c) Install the APU duct, refer to AMM Task 36-12-41-400-801

(d) Install sensing elements, refer to AMM Task 36-22-17-400-801.

(e) Install the sidewall panels 151EW, 151GW, 152EW and 152GW, refer to AMM Task 25-53-00-400-801.

(f) Install lavatories as necessary, refer to AMM Task 25-42-41-400-801

(g) Install brackets and support plate as necessary to perform the work at the upper door frame area in accordance with SRM 51-72-11.

(h) Install sensor actuation assembly and bracket, refer to AMM Task 52-22-21-400-801.

(i) Install of the Emergency Power Supply Unit (EPSU), refer to AMM Task 33-51-38-400-801

(j) Install removed air conditioning ducts, refer to AMM Task 21-20-00-400-801.

(k) Install door linings, refer to AMM Task 25-23-48-400-801.

(l) Install removed sidewall panels, refer to AMM Task 25-23-43-400-802.

(m) Install removed ceiling panels, refer to AMM Task 25-23-43-400-802.

(n) Install removed Overhead Storage Compartments, refer to AMM Task 25-24-51-400-801.

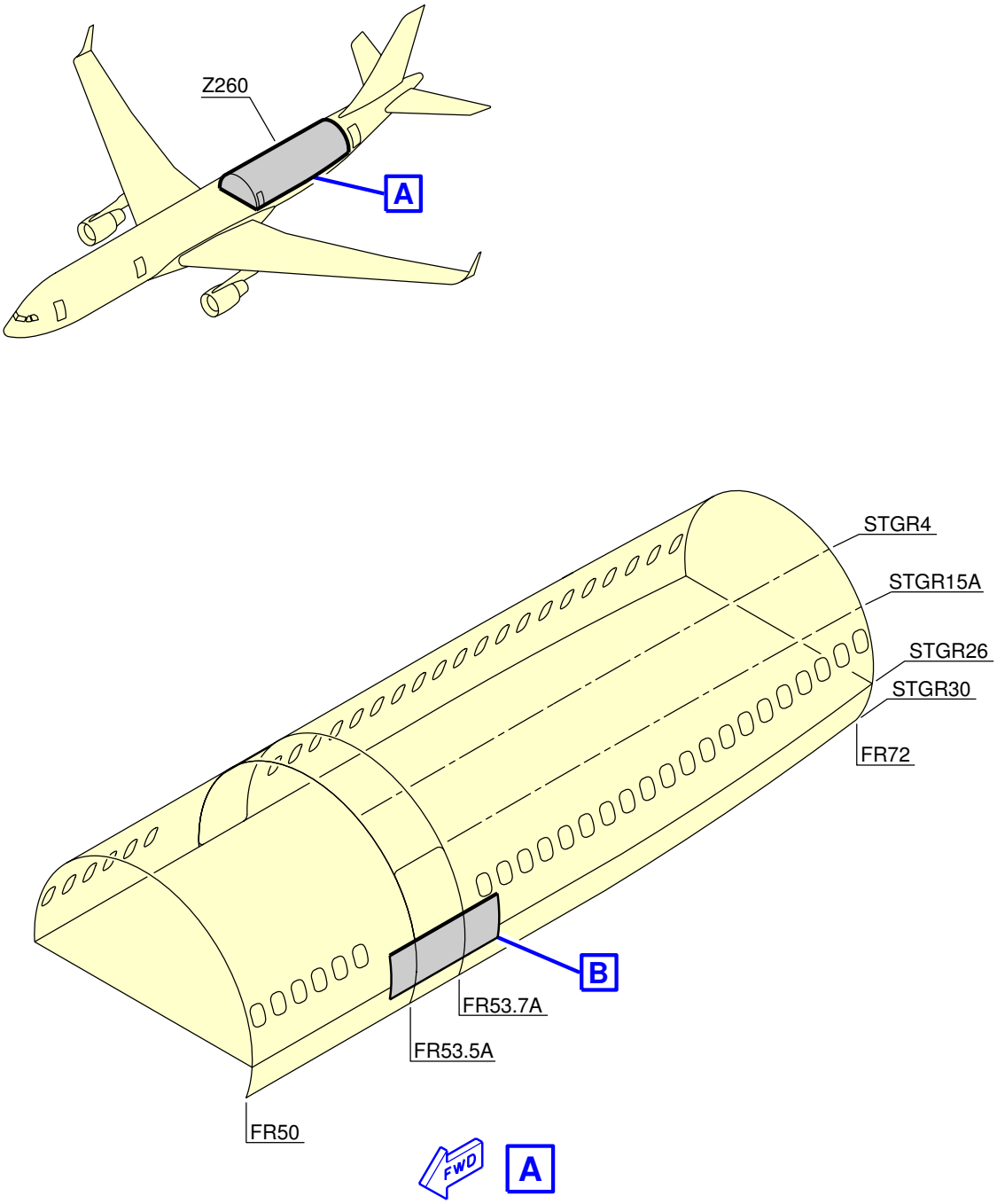
(o) Install removed passenger seats, refer to AMM Task 25-21-41-400-801.

(p) Remove the access platform(s).

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

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**CONF 001 thru 002, 005

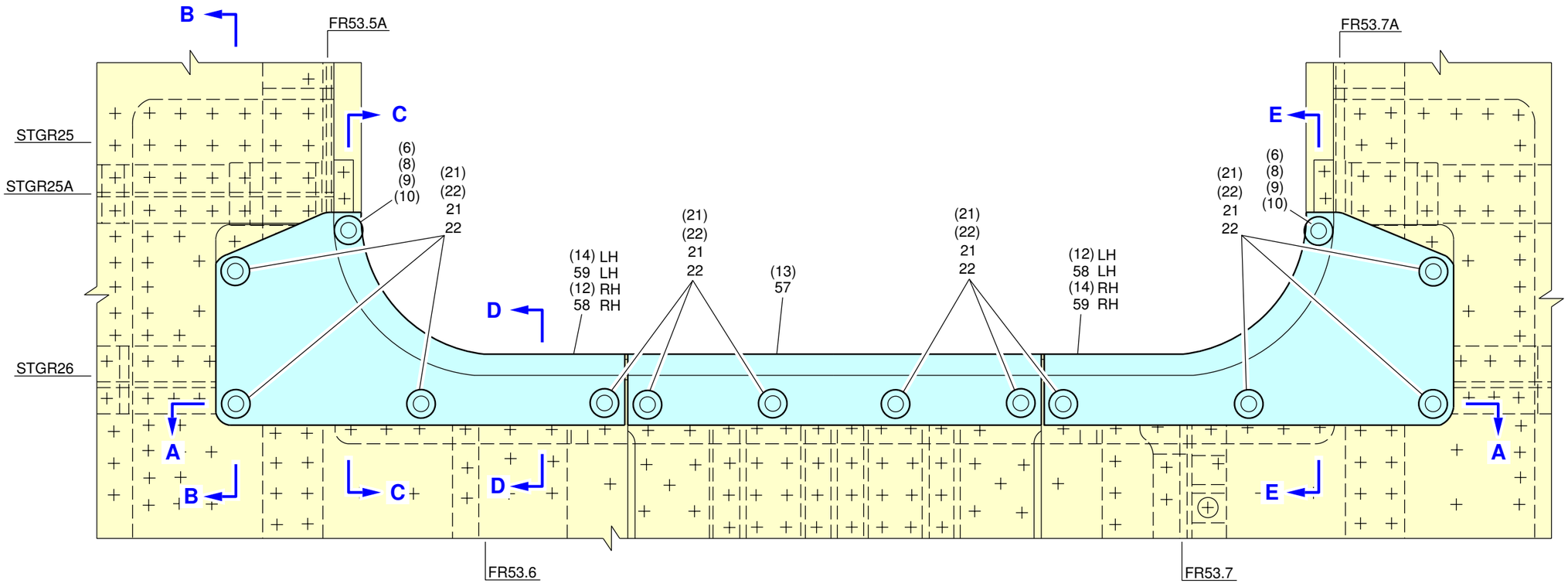


G_SB_533226_6_BAAA_01_03

Figure A-GBAAA - Sheet 01
Removal/Installation of the Scuff Plates

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**CONF 001 thru 002, 005



LH SHOWN
RH SYMMETRICAL

NOTE:
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BAAA_02_08

Figure A-GBAAA - Sheet 02
Removal/Installation of the Scuff Plates

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**CONF 001 thru 002, 005

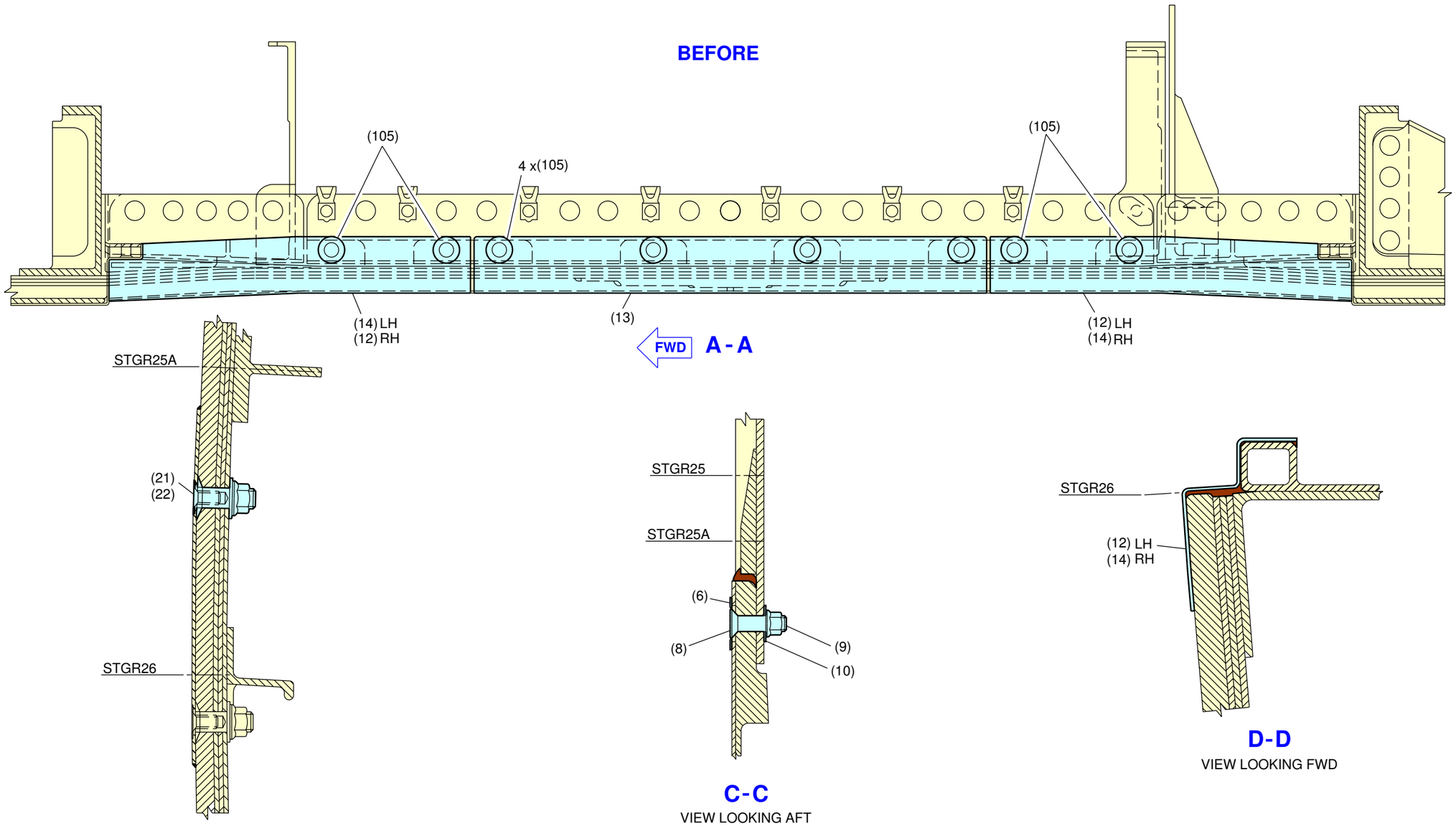
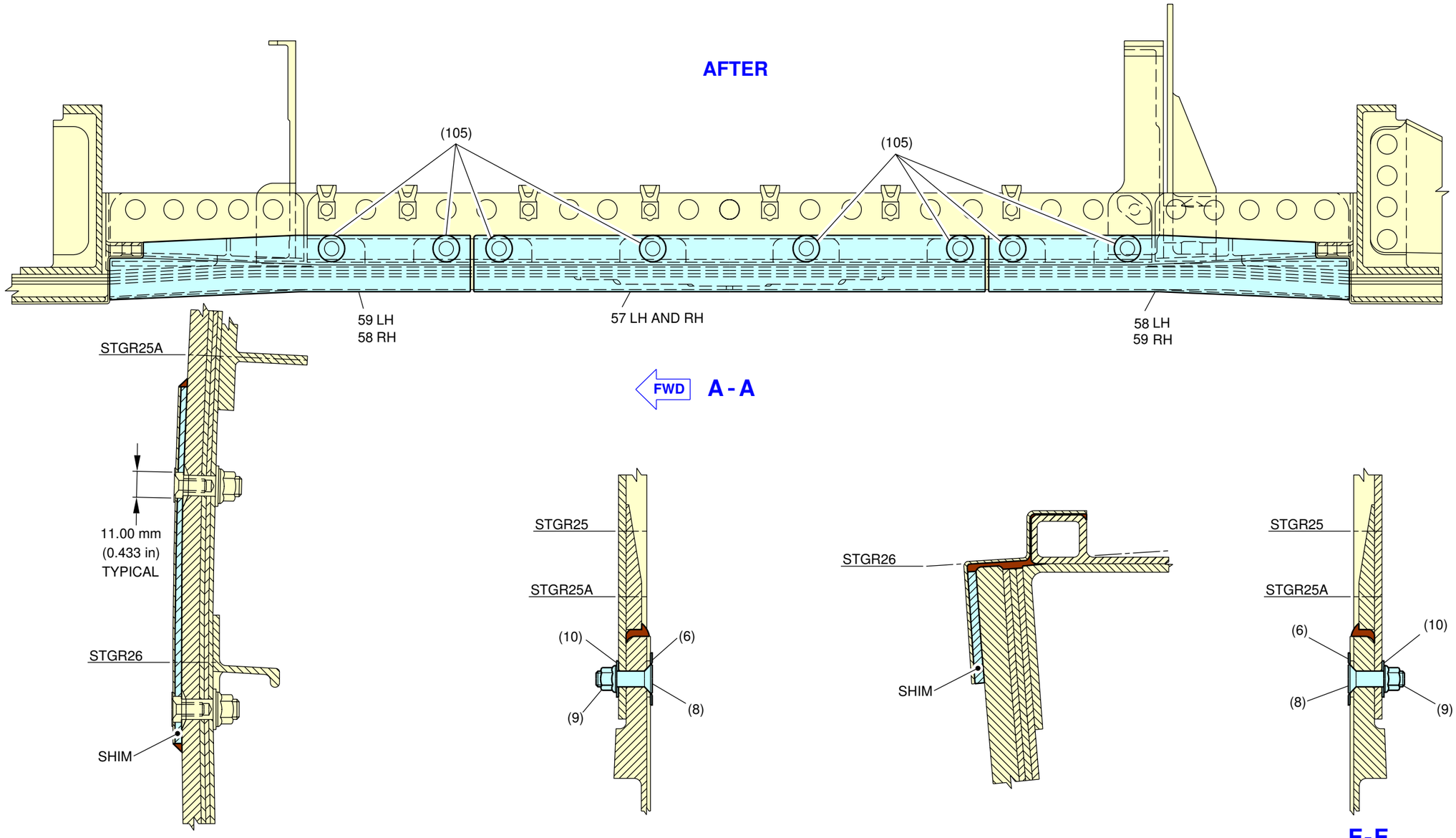


Figure A-GBAAA - Sheet 03
Removal/Installation of the Scuff Plates

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**CONF 001 thru 002, 005



B-B
VIEW LOOKING FWD

C-C
VIEW LOOKING AFT

D-D
VIEW LOOKING FWD

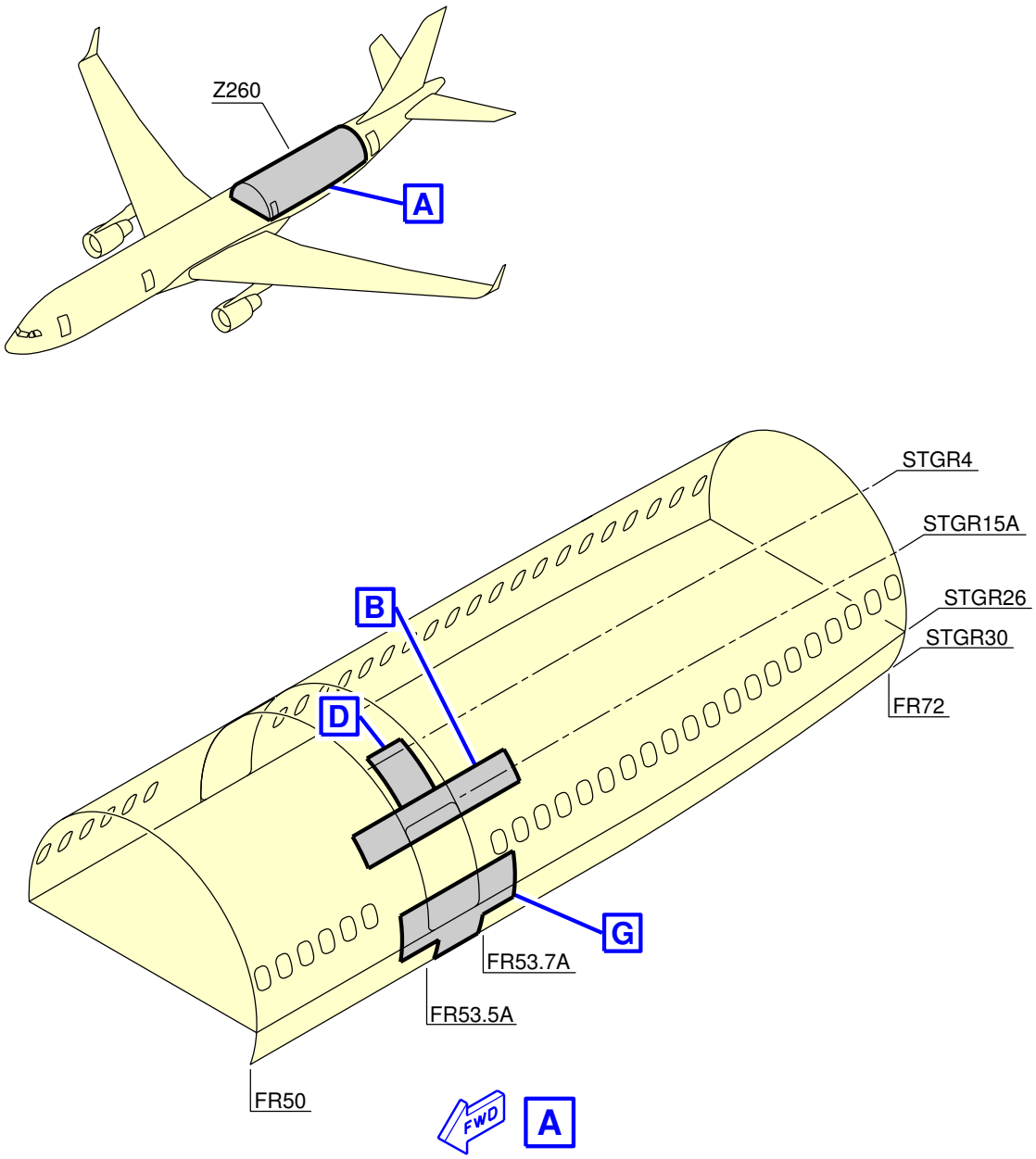
E-E
VIEW LOOKING FWD

G_SB_533226_6_BAAA_04_04

Figure A-GBAAA - Sheet 04
Removal/Installation of the Scuff Plates

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**CONF 001

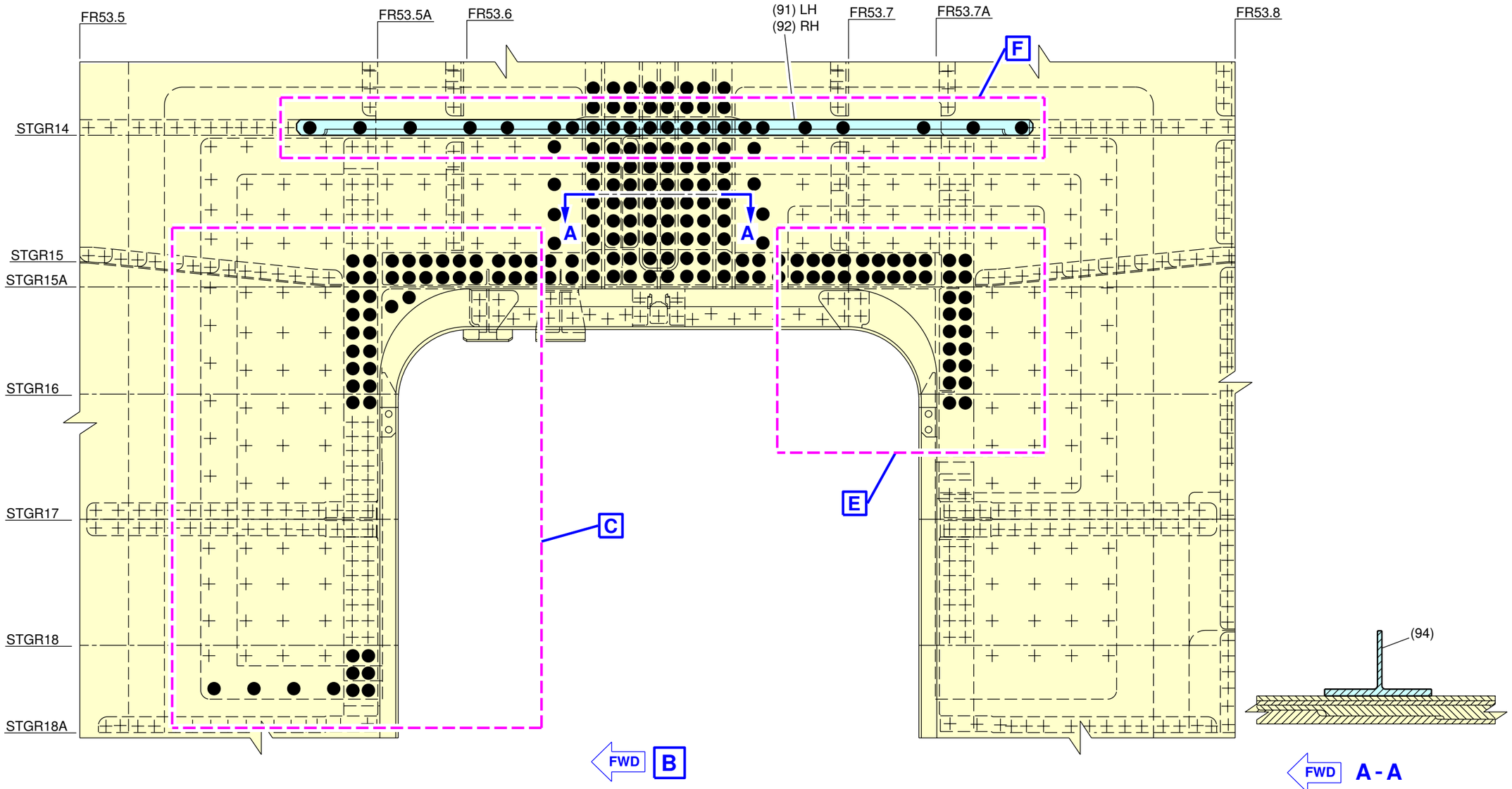


G_SB_533226_6_BBAA_01_03

Figure A-GBBAA - Sheet 01
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001

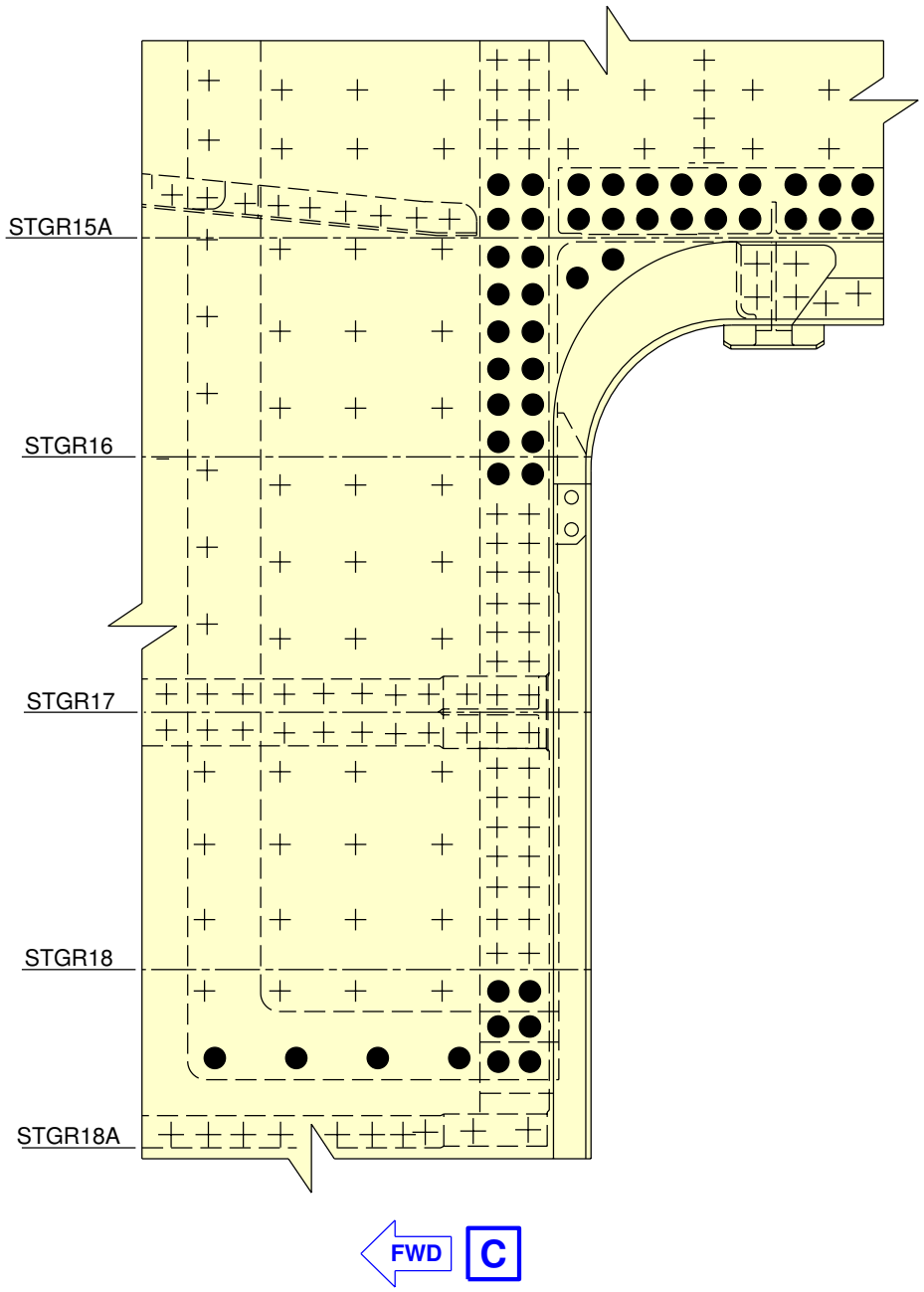


NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

Figure A-GBBAA - Sheet 02
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



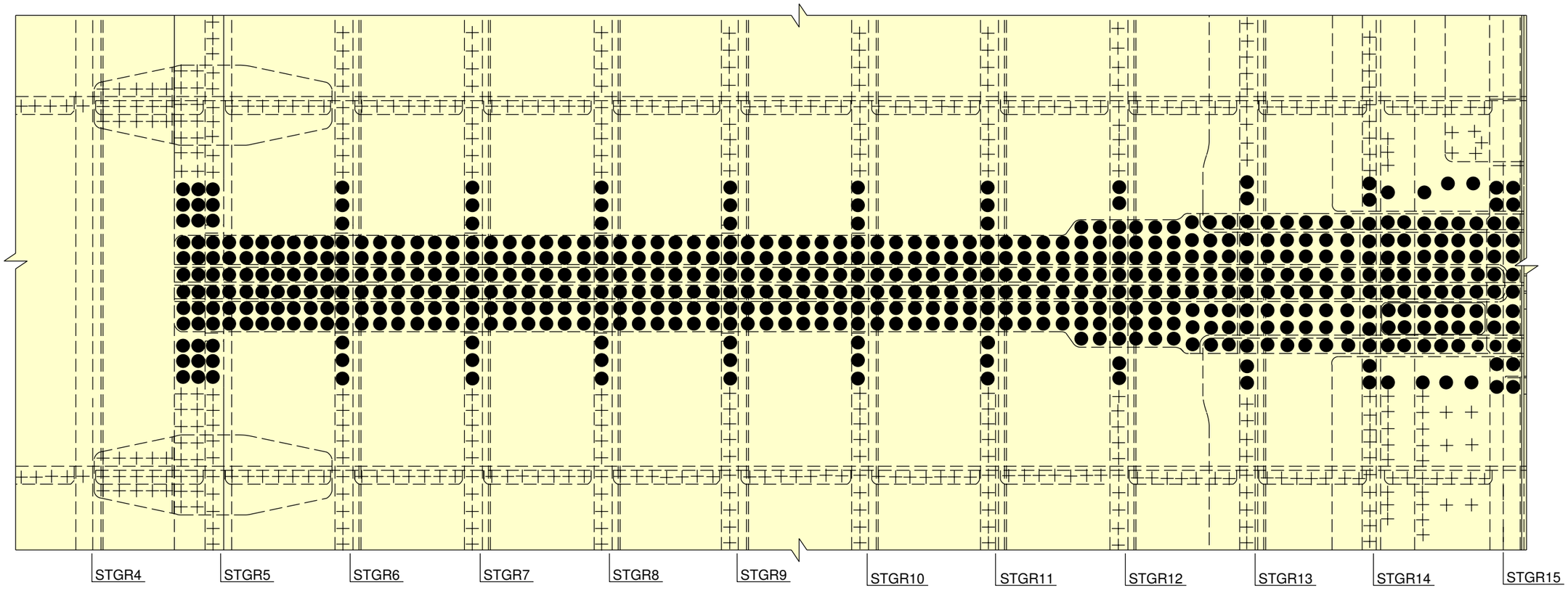
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_03_03

Figure A-GBBAA - Sheet 03
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



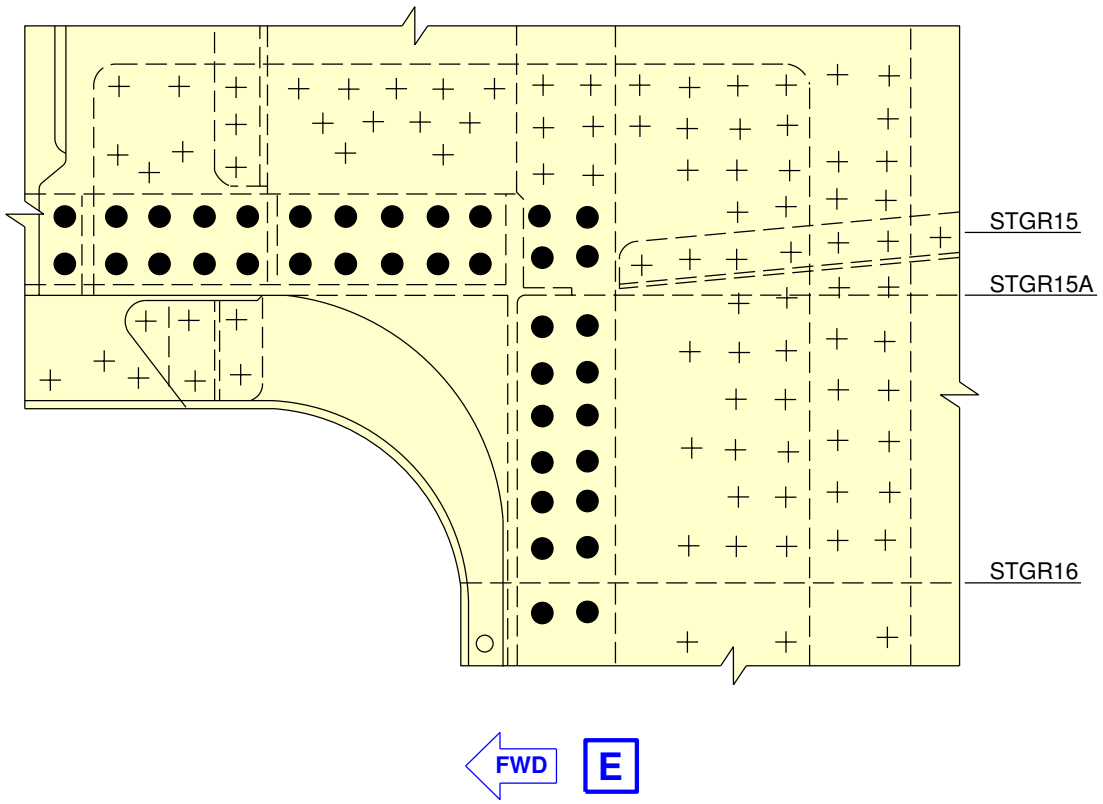
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_04_03

Figure A-GBBAA - Sheet 04
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



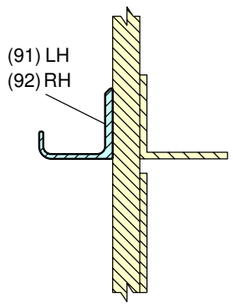
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_05_03

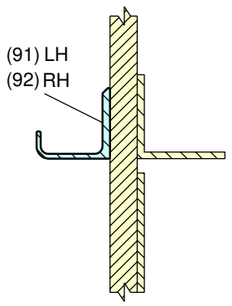
Figure A-GBBAA - Sheet 05
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



B-B
VIEW LOOKING FWD



C-C
VIEW LOOKING FWD

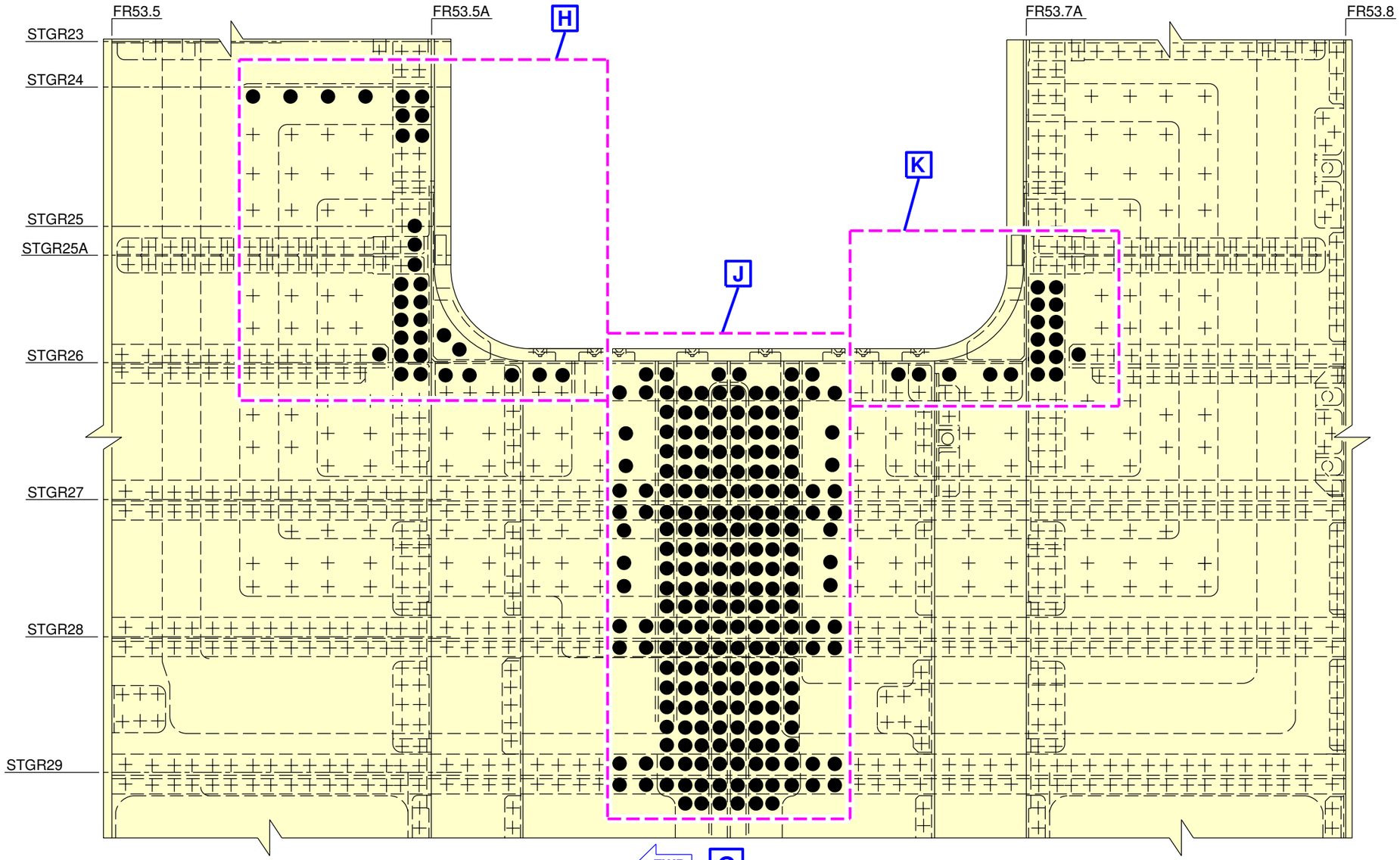
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_06_04

Figure A-GBBAA - Sheet 06
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



LH SHOWN
RH SYMMETRICAL
SCUFF PLATES NOT SHOWN

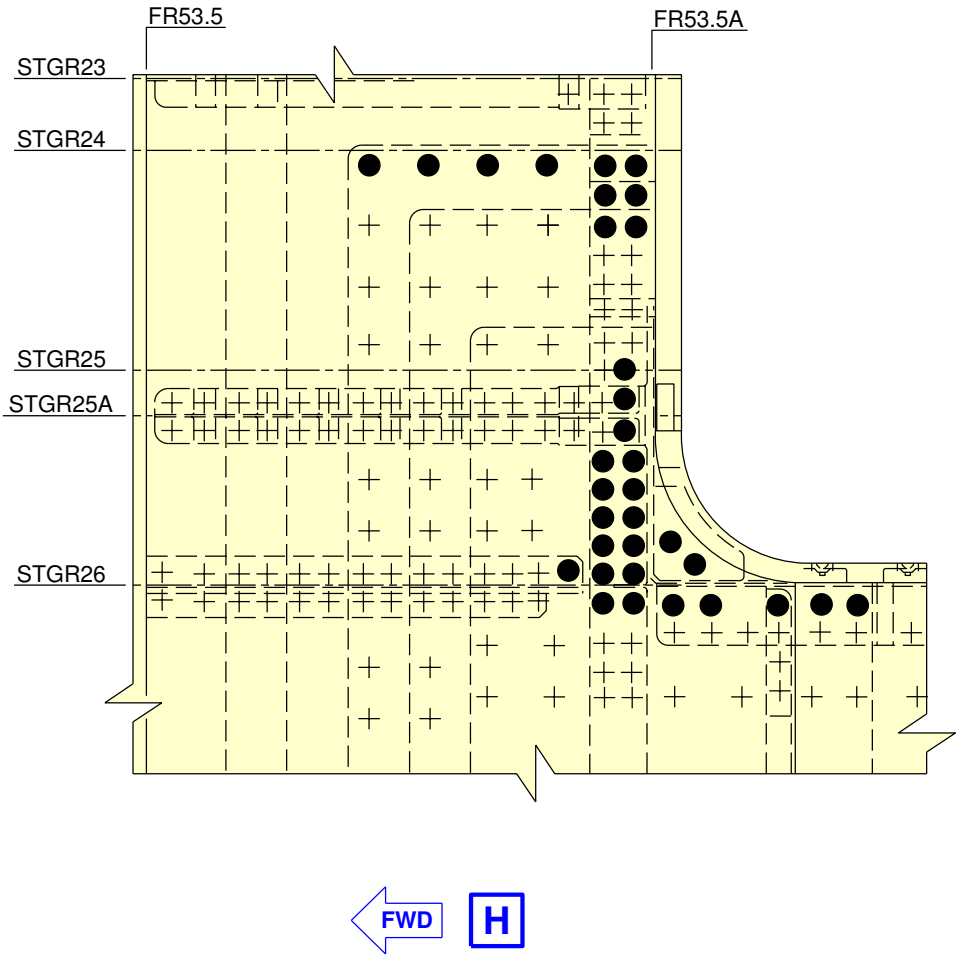
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_07_04

Figure A-GBBAA - Sheet 07
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



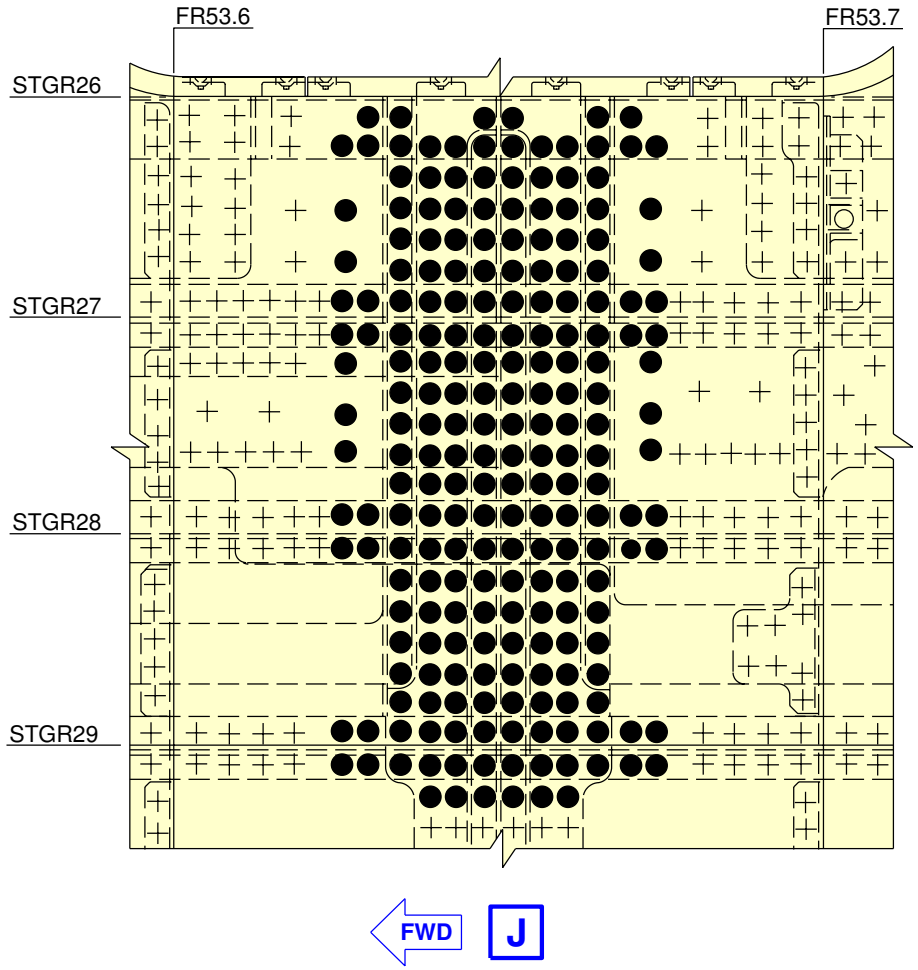
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_08_04

Figure A-GBBAA - Sheet 08
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



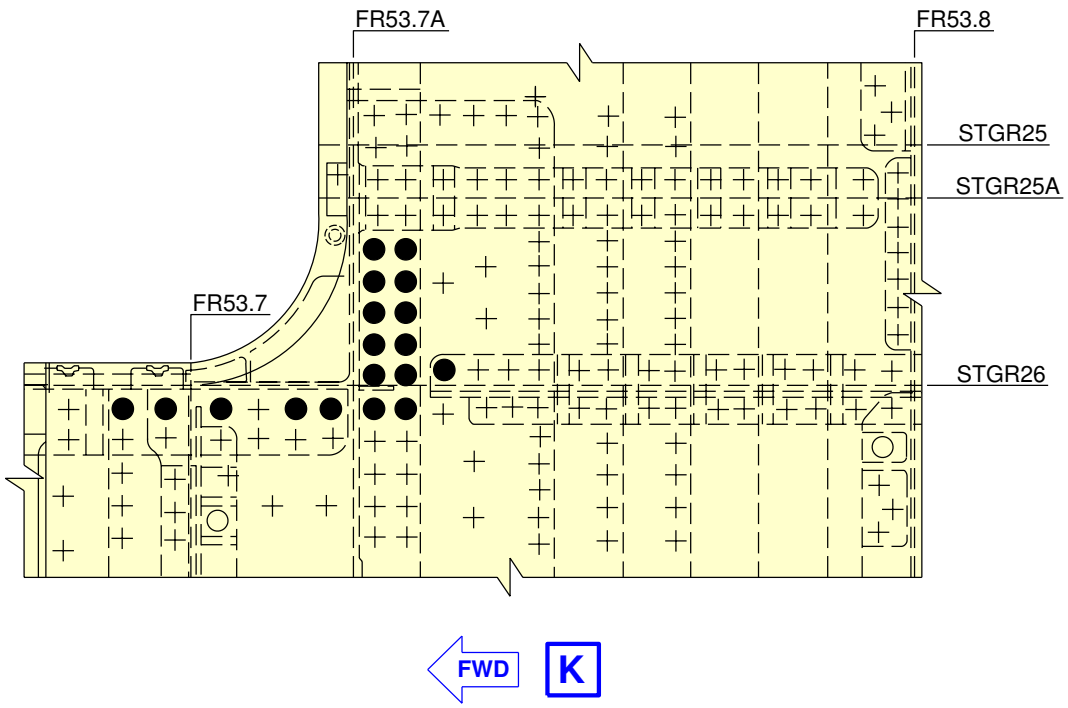
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_09_04

Figure A-GBBAA - Sheet 09
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001



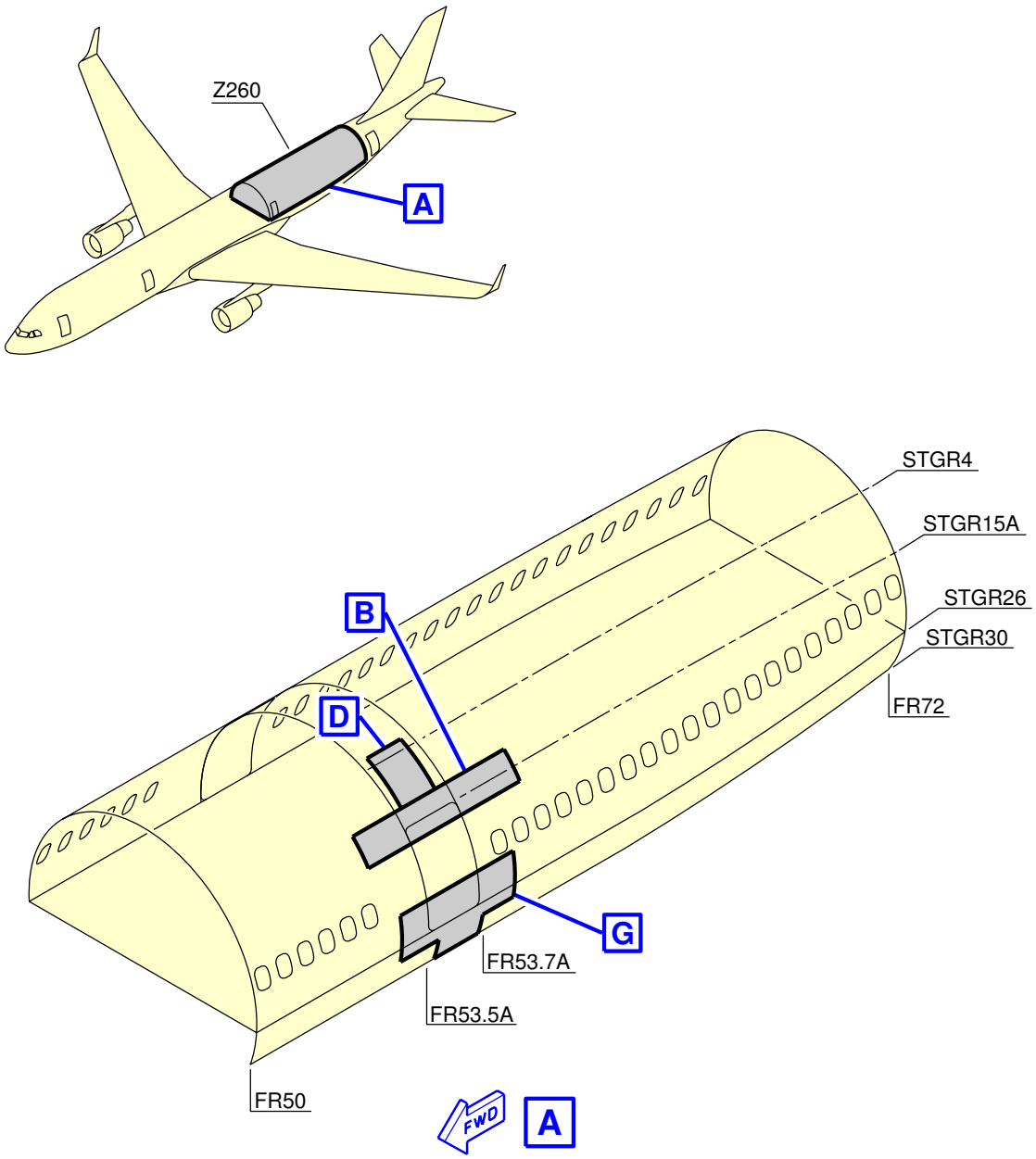
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAA_10_04

Figure A-GBBAA - Sheet 10
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005

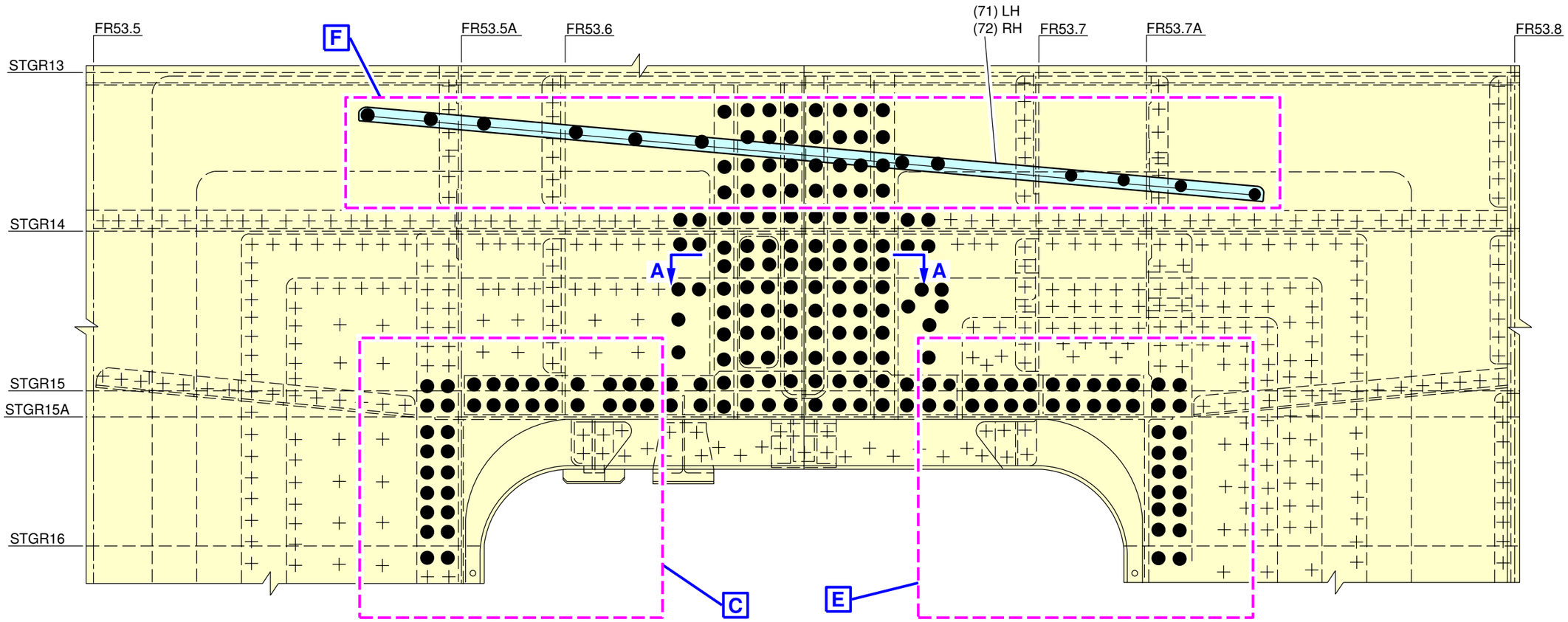


G_SB_533226_6_BBAB_01_03

Figure A-GBBAB - Sheet 01
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



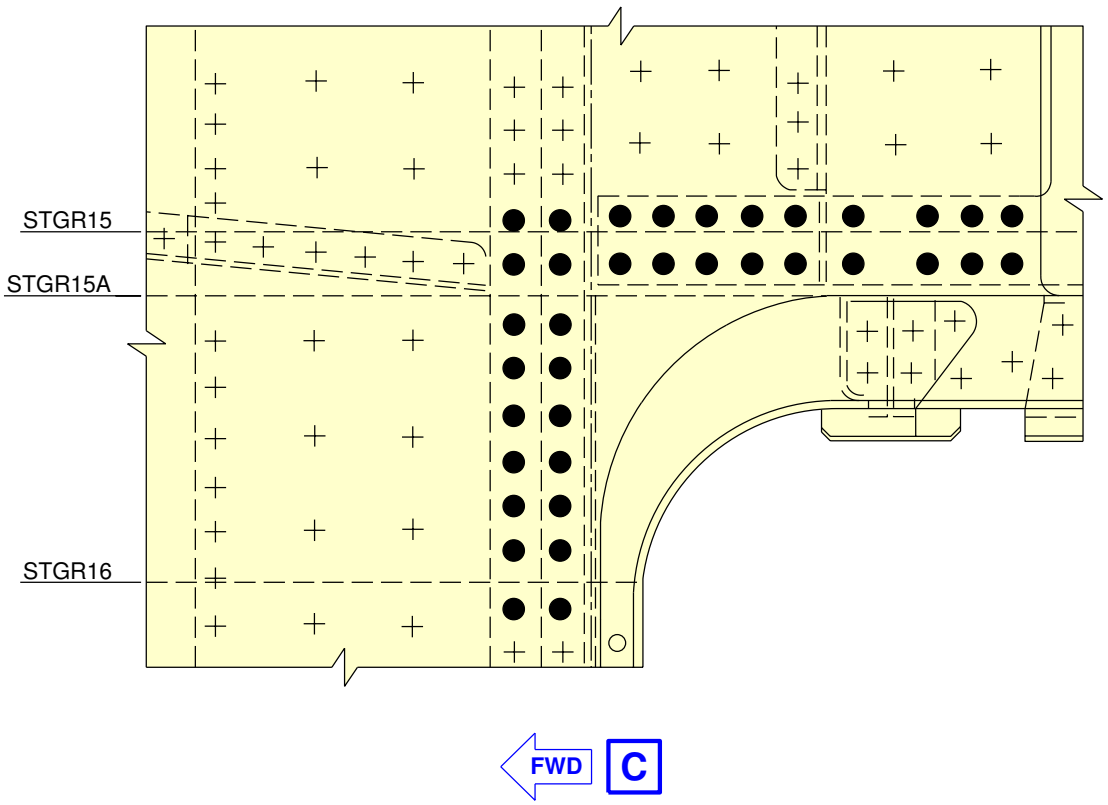
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_02_06

Figure A-GBBAB - Sheet 02
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



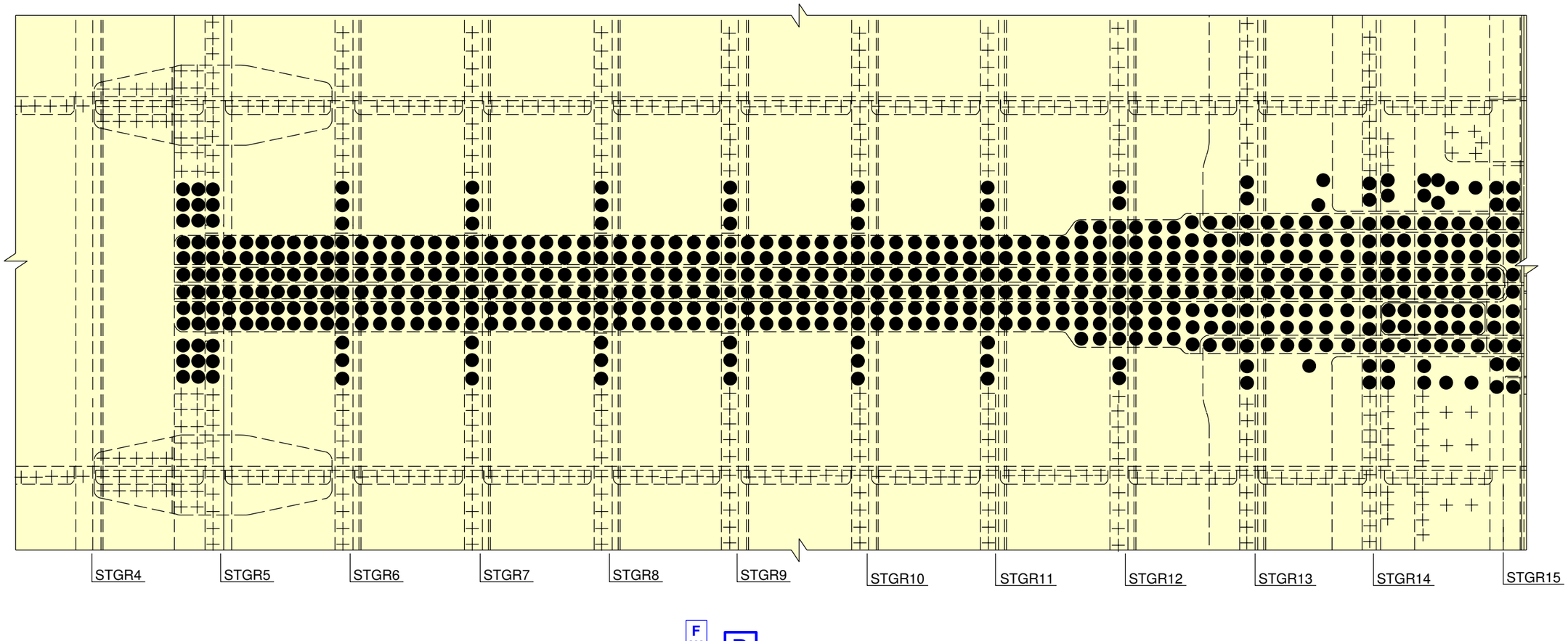
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_03_04

Figure A-GBBAB - Sheet 03
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



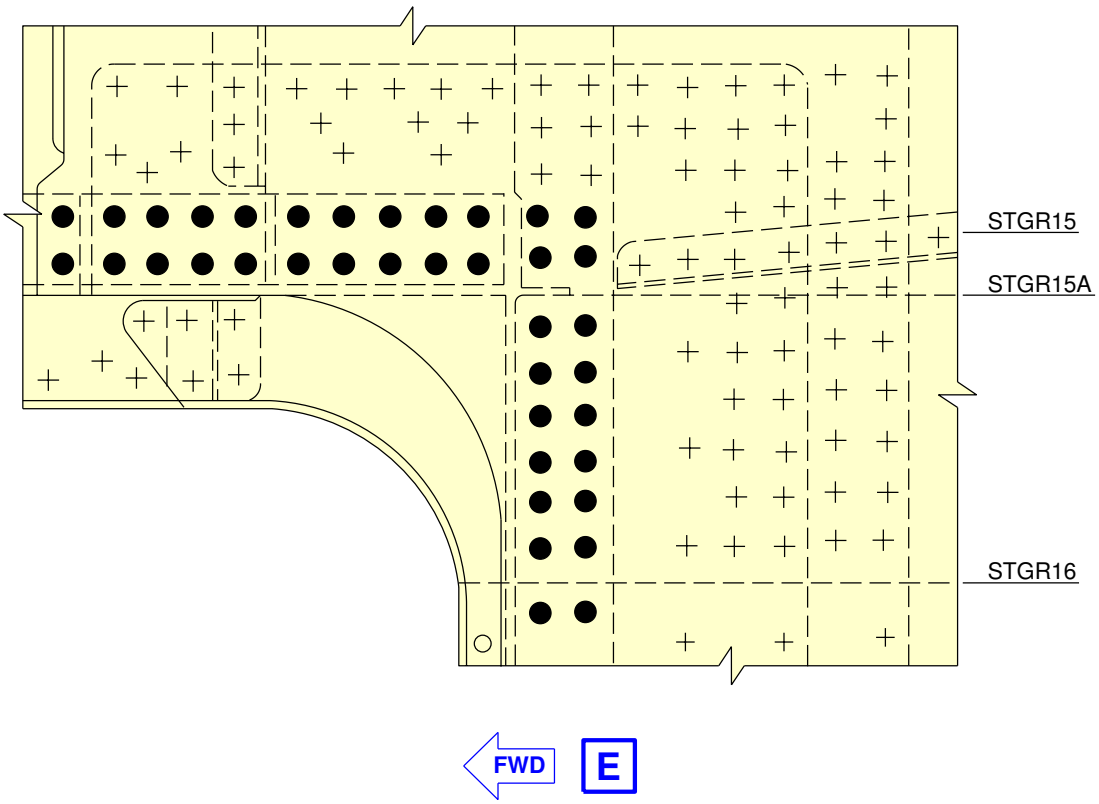
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_04_04

Figure A-GBBAB - Sheet 04
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



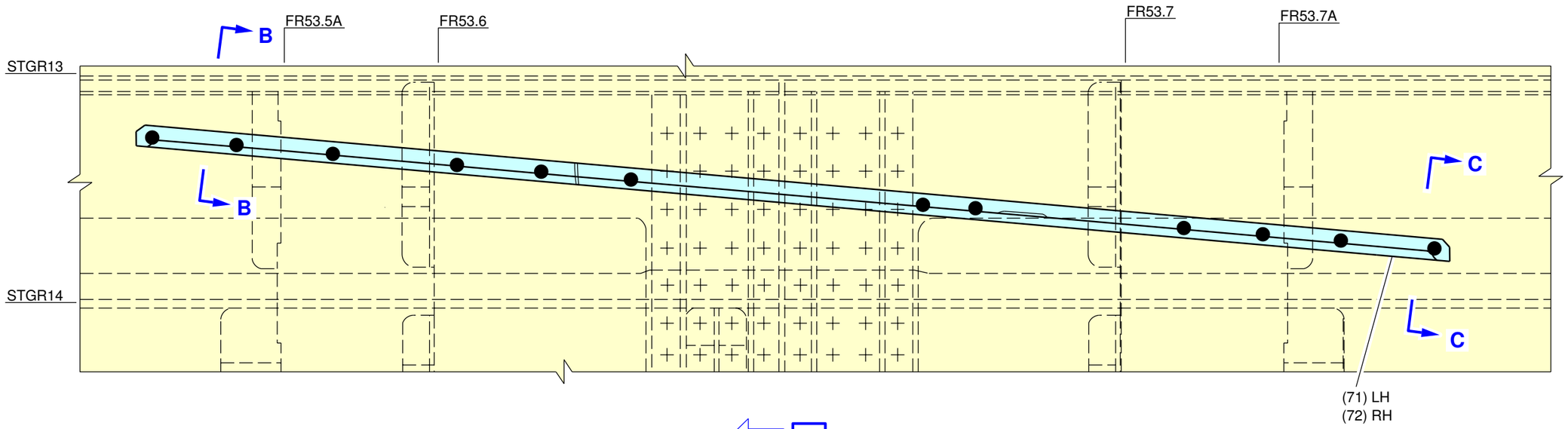
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_05_03

Figure A-GBBAB - Sheet 05
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



B-B
VIEW LOOKING AFT

C-C
VIEW LOOKING AFT

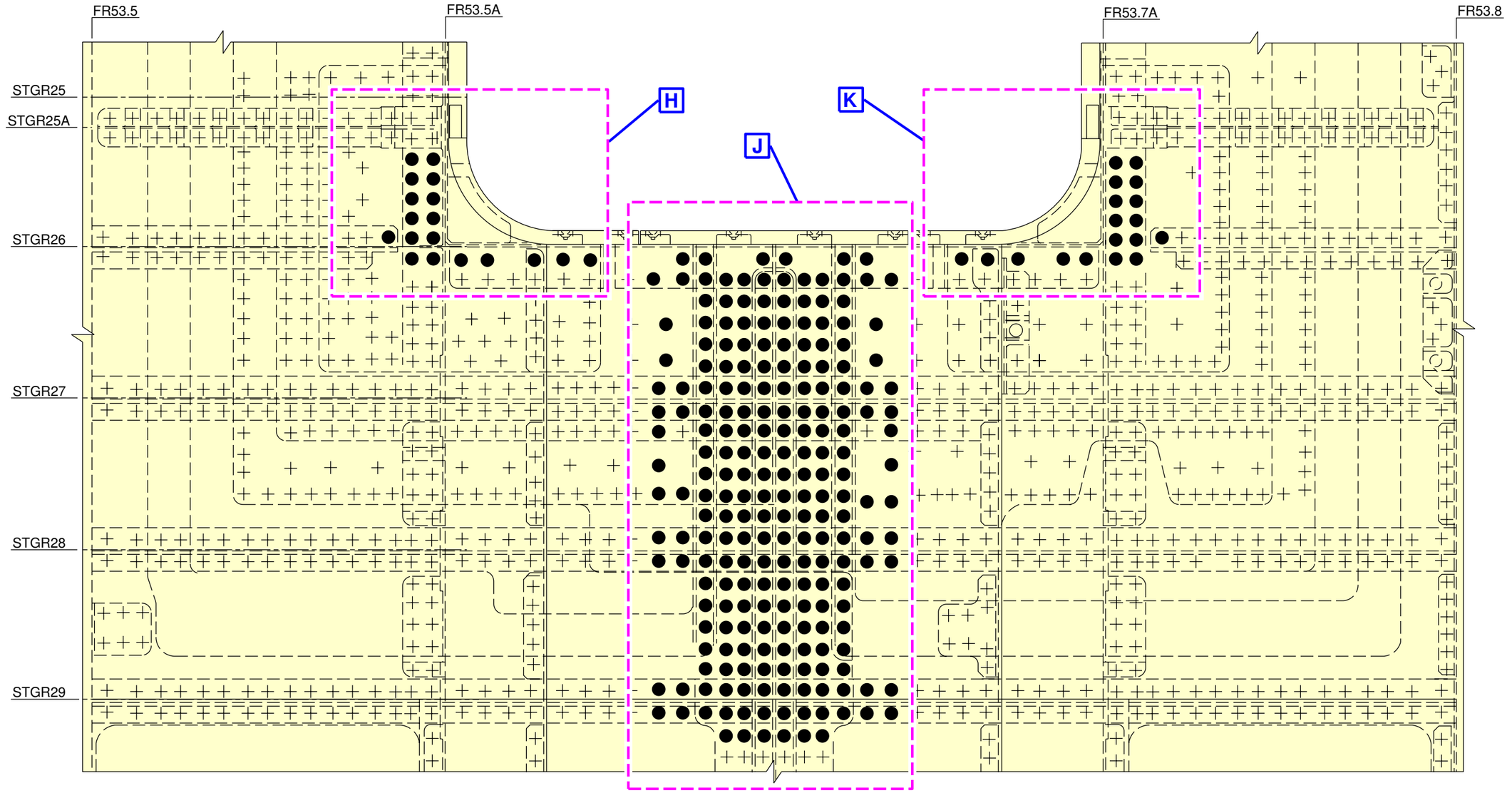
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_06_03

Figure A-GBBAB - Sheet 06
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

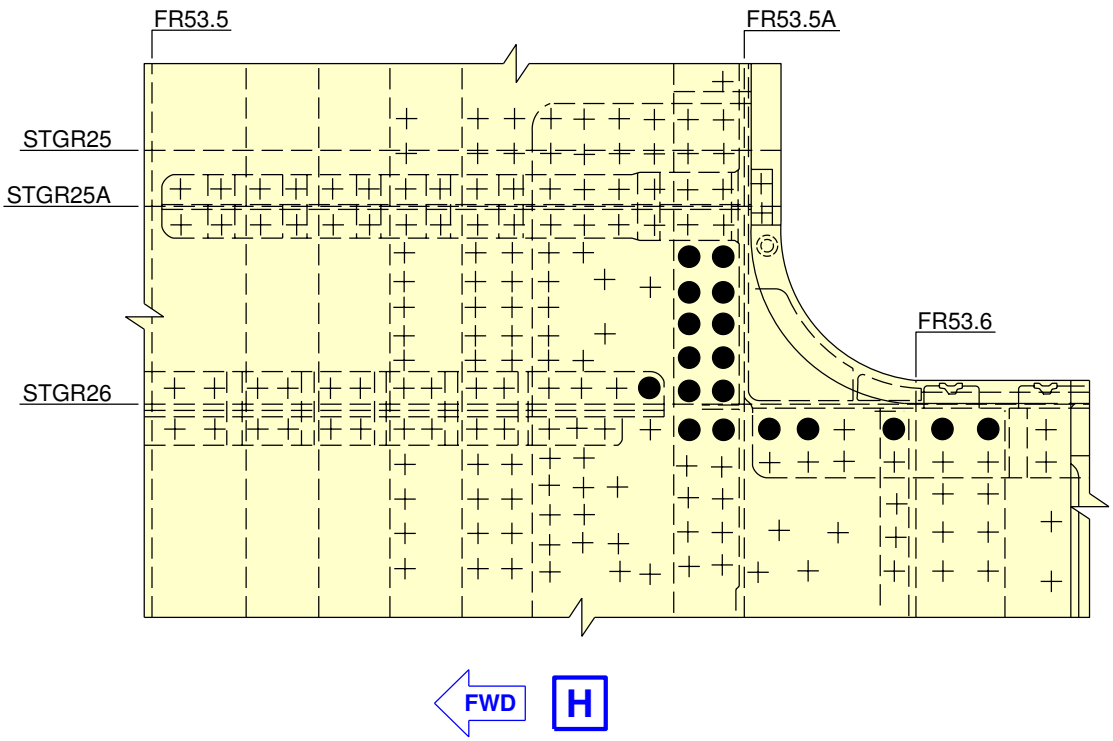
LH SHOWN
RH SYMMETRICAL
SCUFF PLATES NOT SHOWN

G_SB_533226_6_BBAB_07_04

Figure A-GBBAB - Sheet 07
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



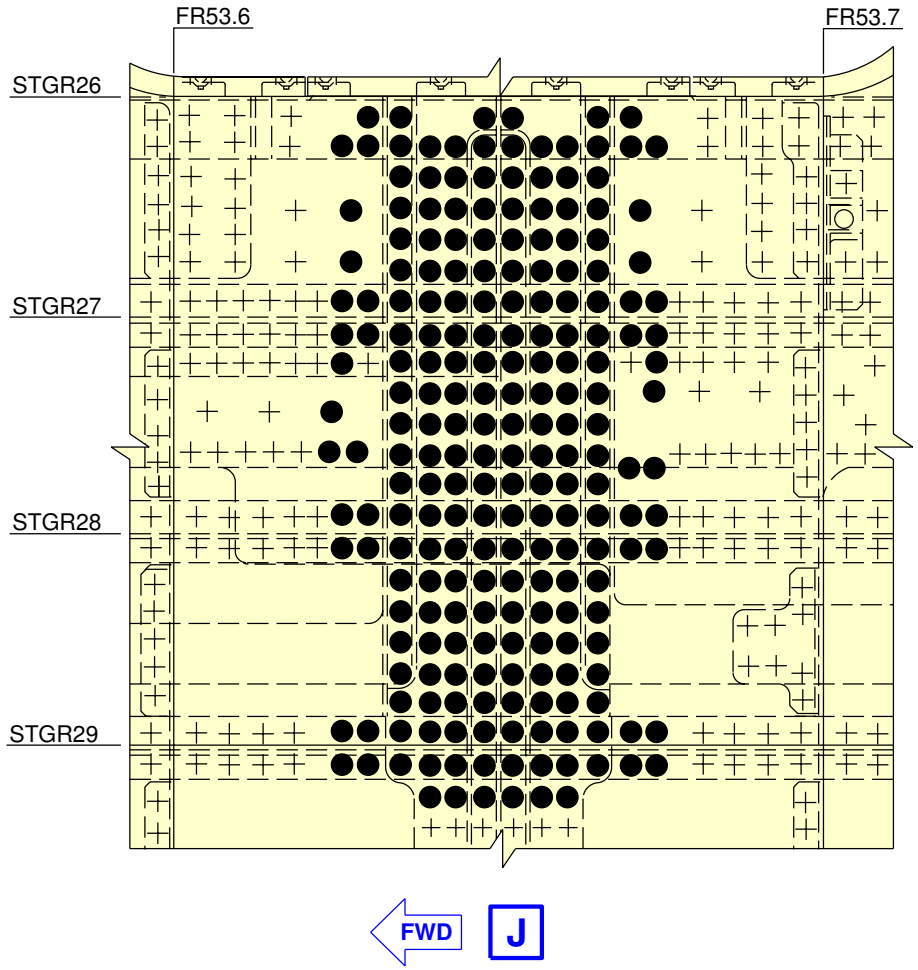
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_08_03

Figure A-GBBAB - Sheet 08
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



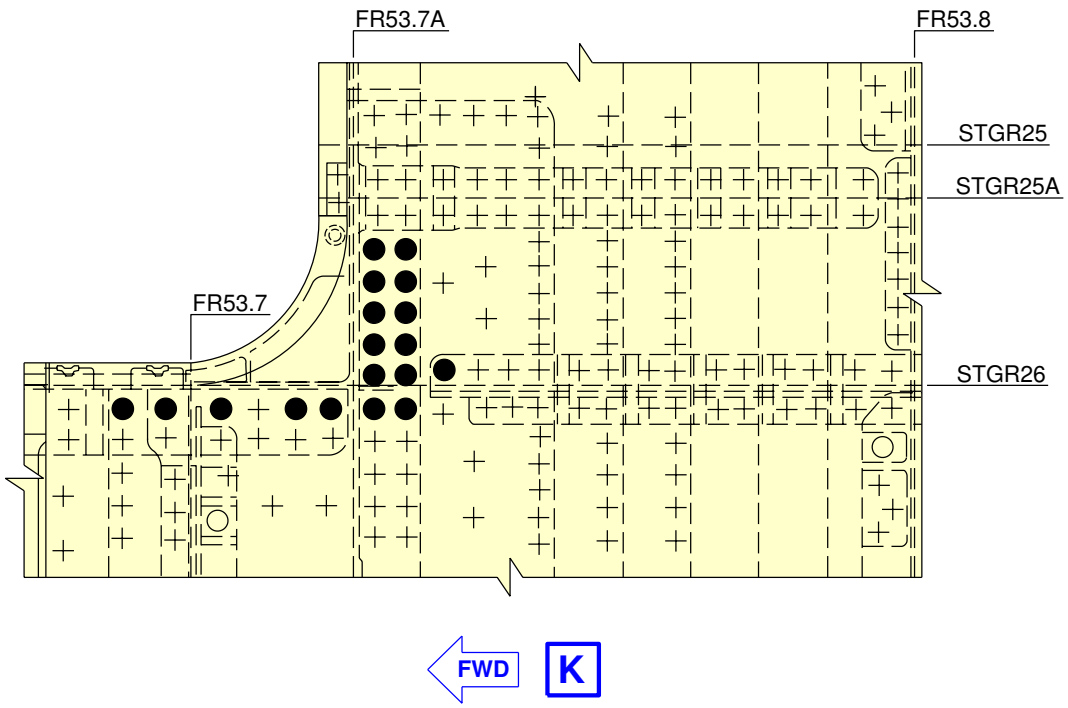
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_09_05

Figure A-GBBAB - Sheet 09
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 002, 005



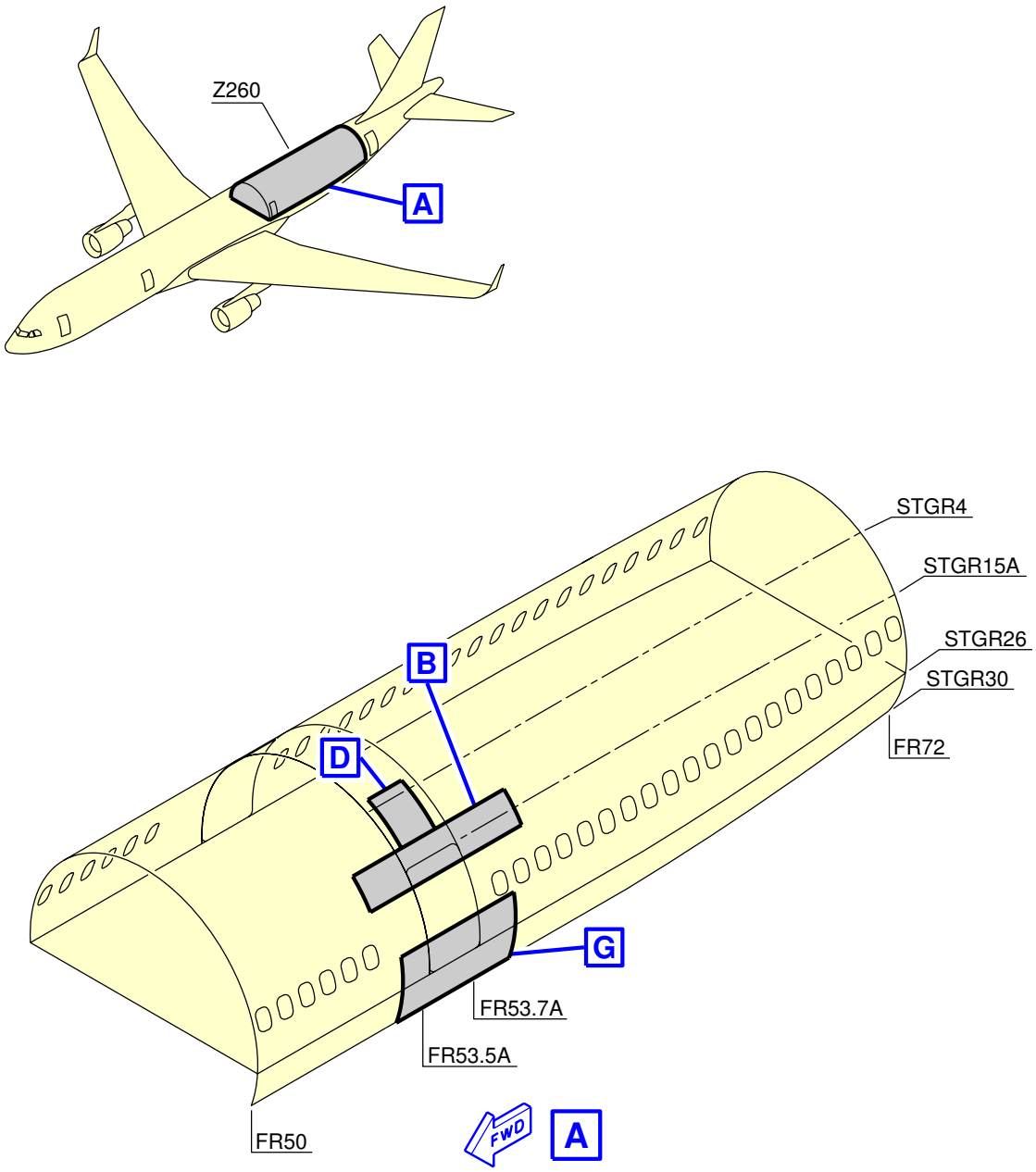
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAB_10_03

Figure A-GBBAB - Sheet 10
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003

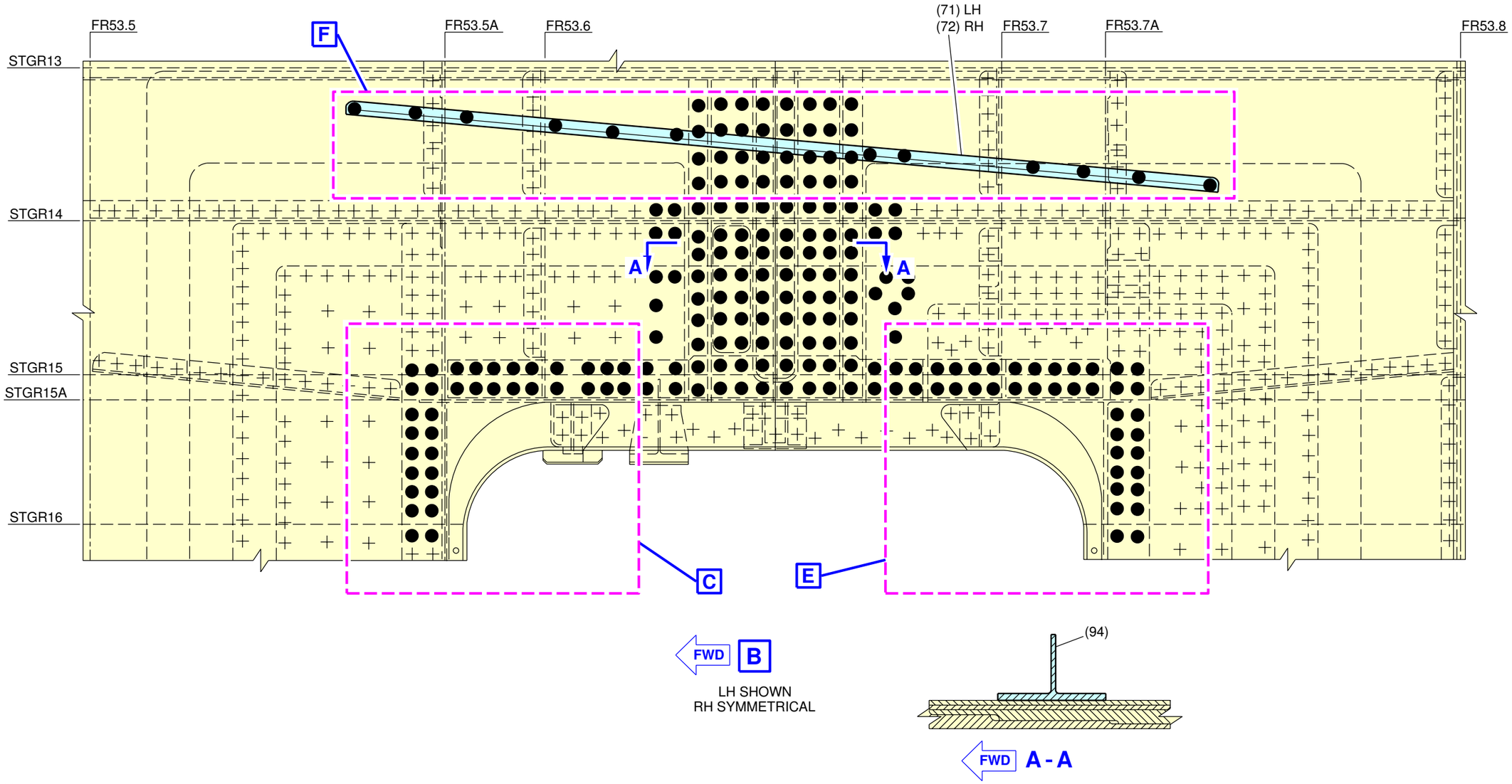


G_SB_533226_6_BBAC_01_03

Figure A-GBBAC - Sheet 01
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



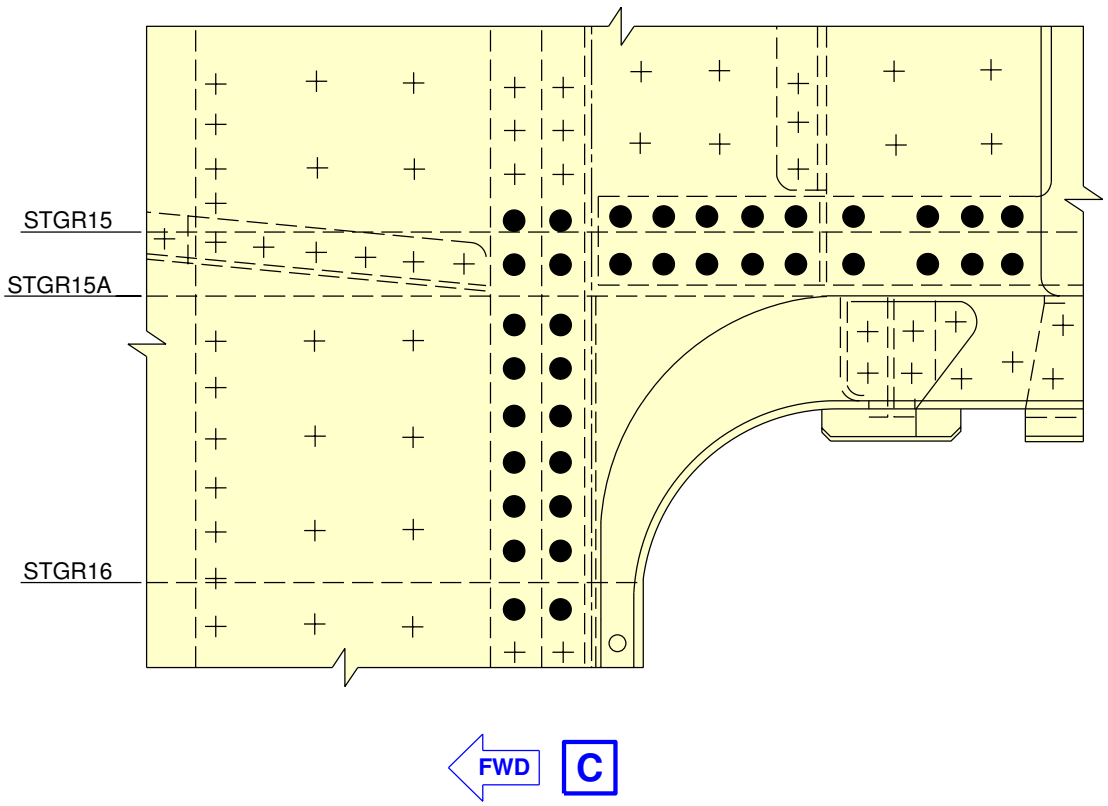
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_02_06

Figure A-GBBAC - Sheet 02
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



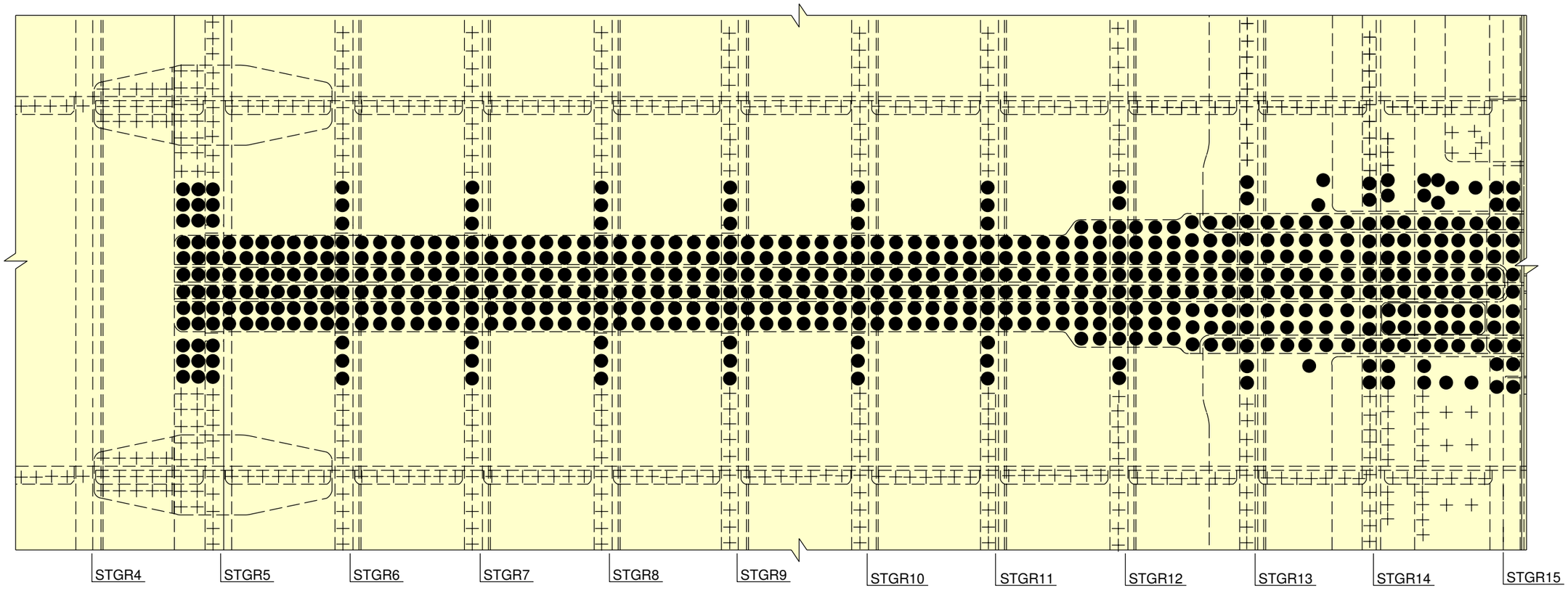
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_03_04

Figure A-GBBAC - Sheet 03
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



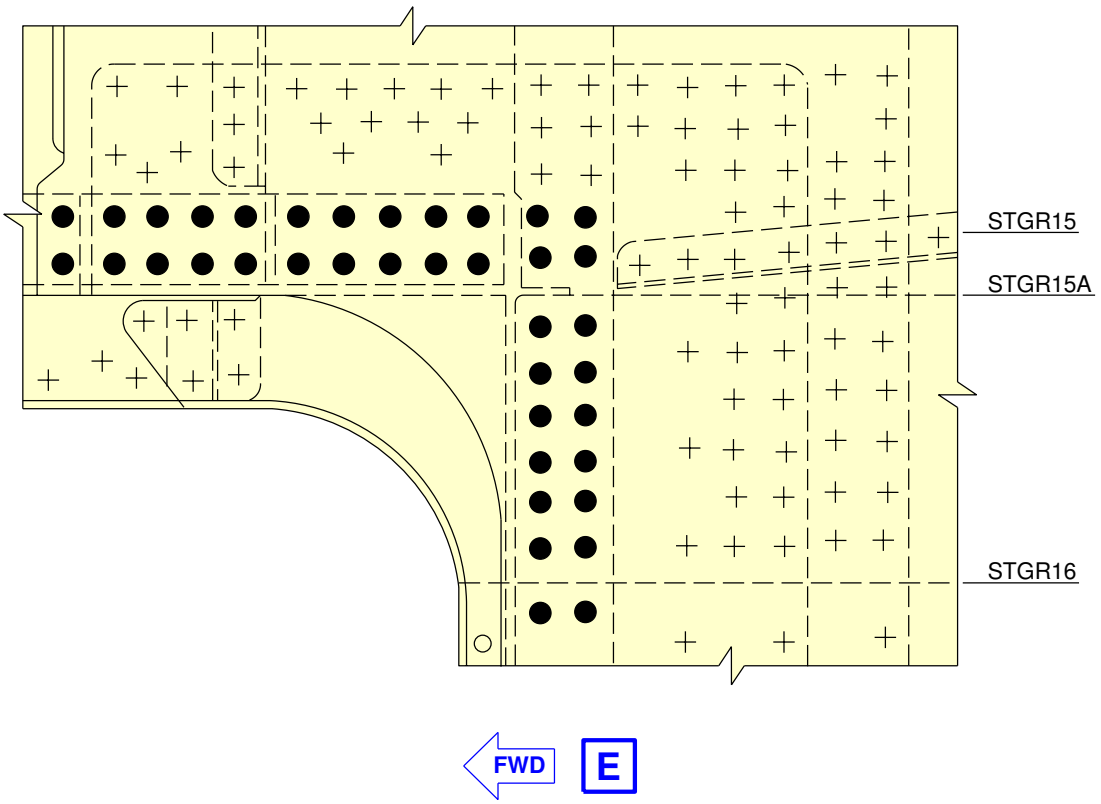
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_04_04

Figure A-GBBAC - Sheet 04
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



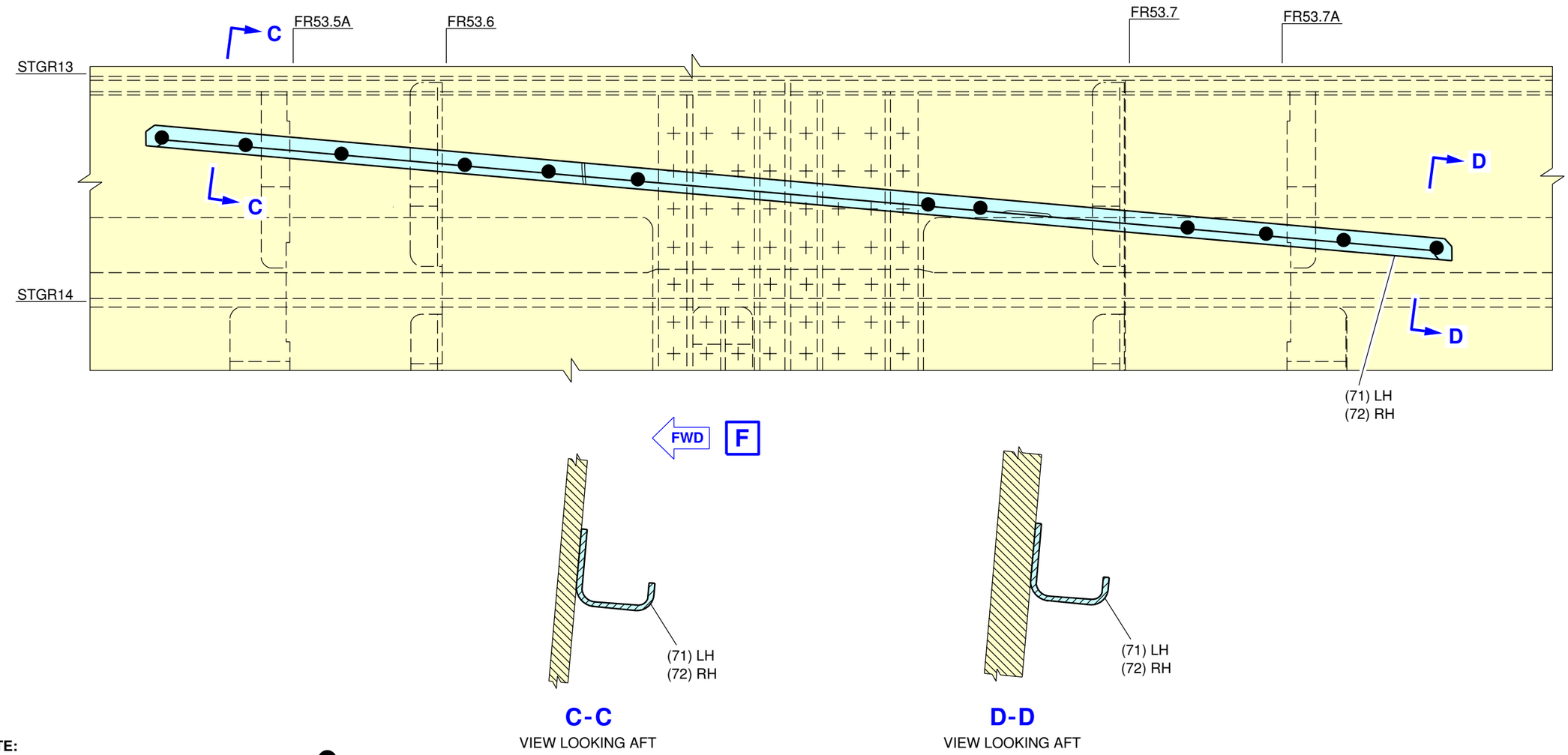
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_05_02

Figure A-GBBAC - Sheet 05
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



C-C
VIEW LOOKING AFT

D-D
VIEW LOOKING AFT

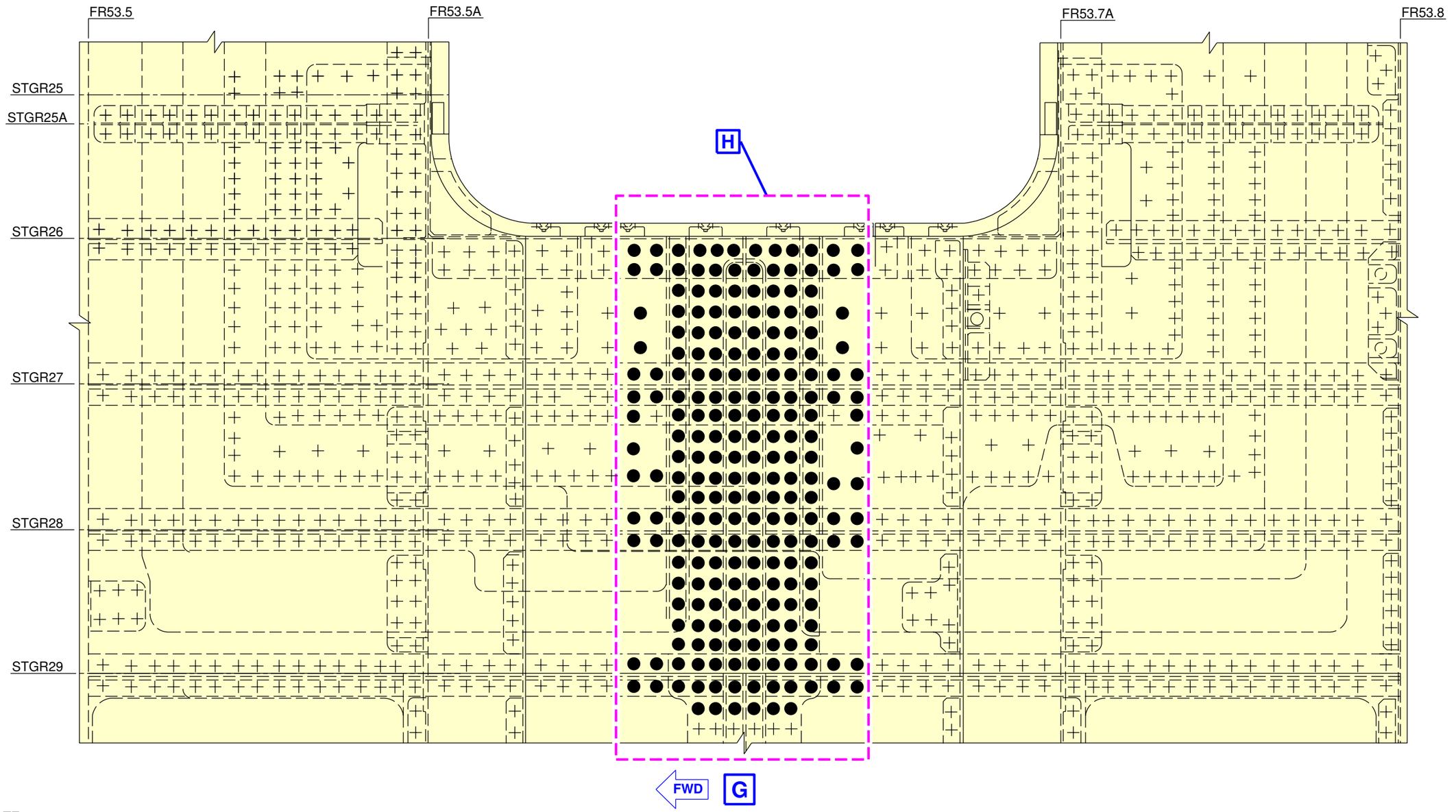
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_06_03

Figure A-GBBAC - Sheet 06
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

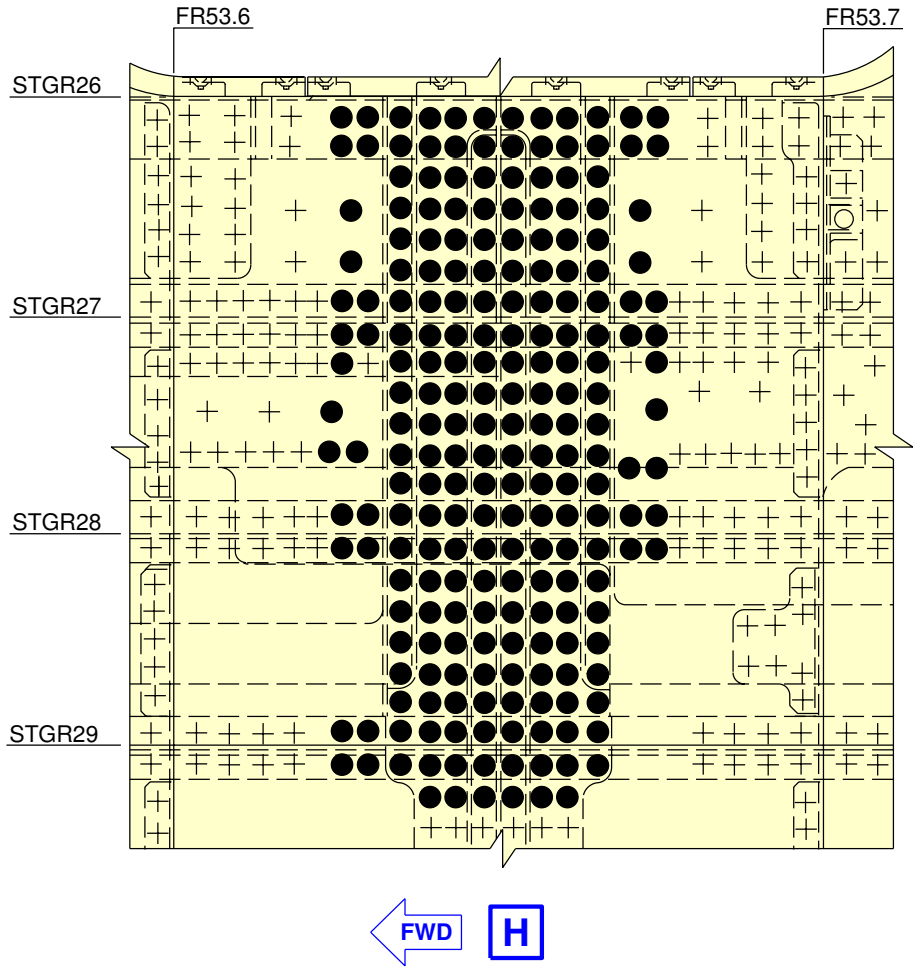
LH SHOWN
RH SYMMETRICAL
SCUFF PLATES NOT SHOWN

G_SB_533226_6_BBAC_07_04

Figure A-GBBAC - Sheet 07
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 003



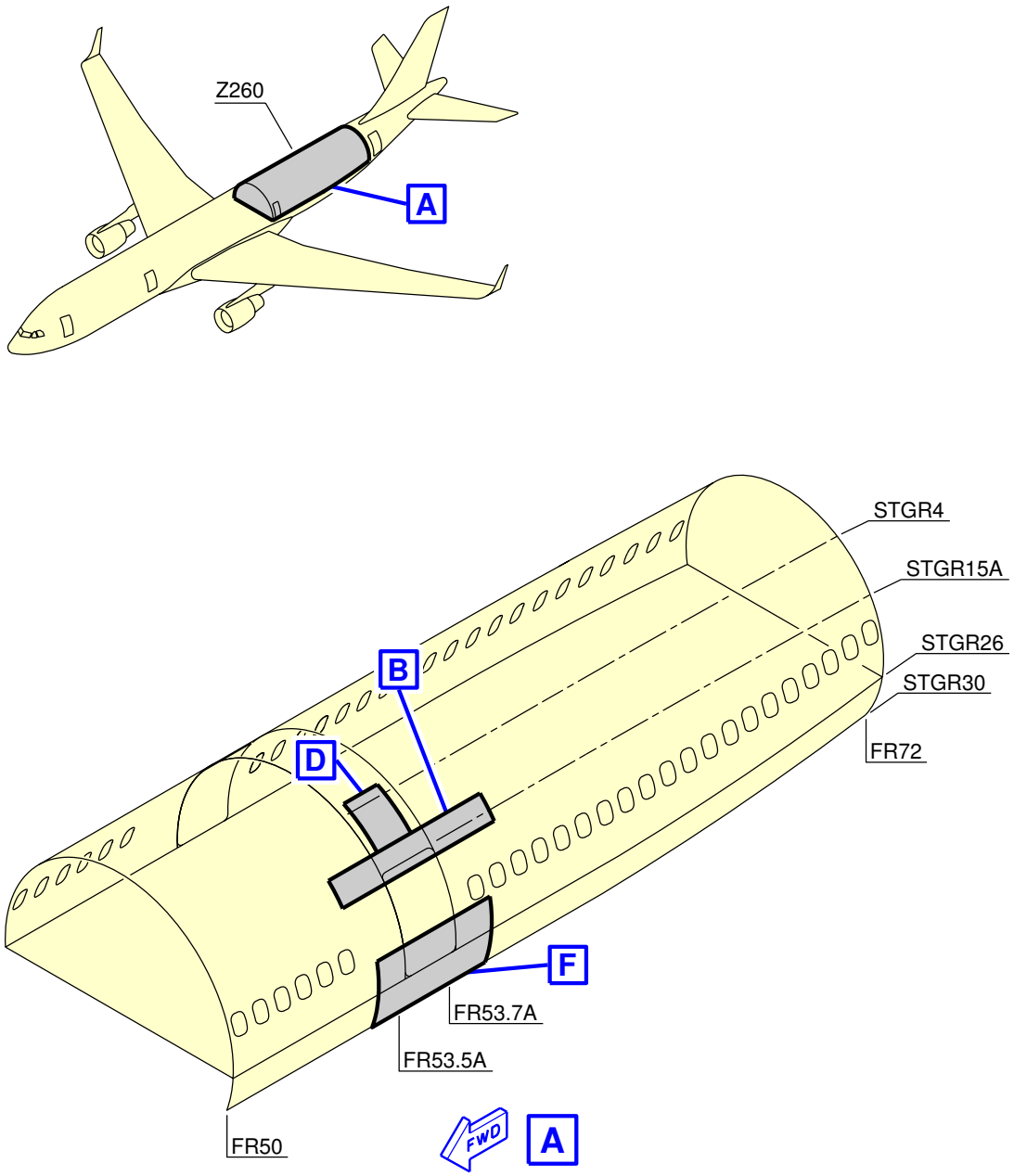
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAC_08_03

Figure A-GBBAC - Sheet 08
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004

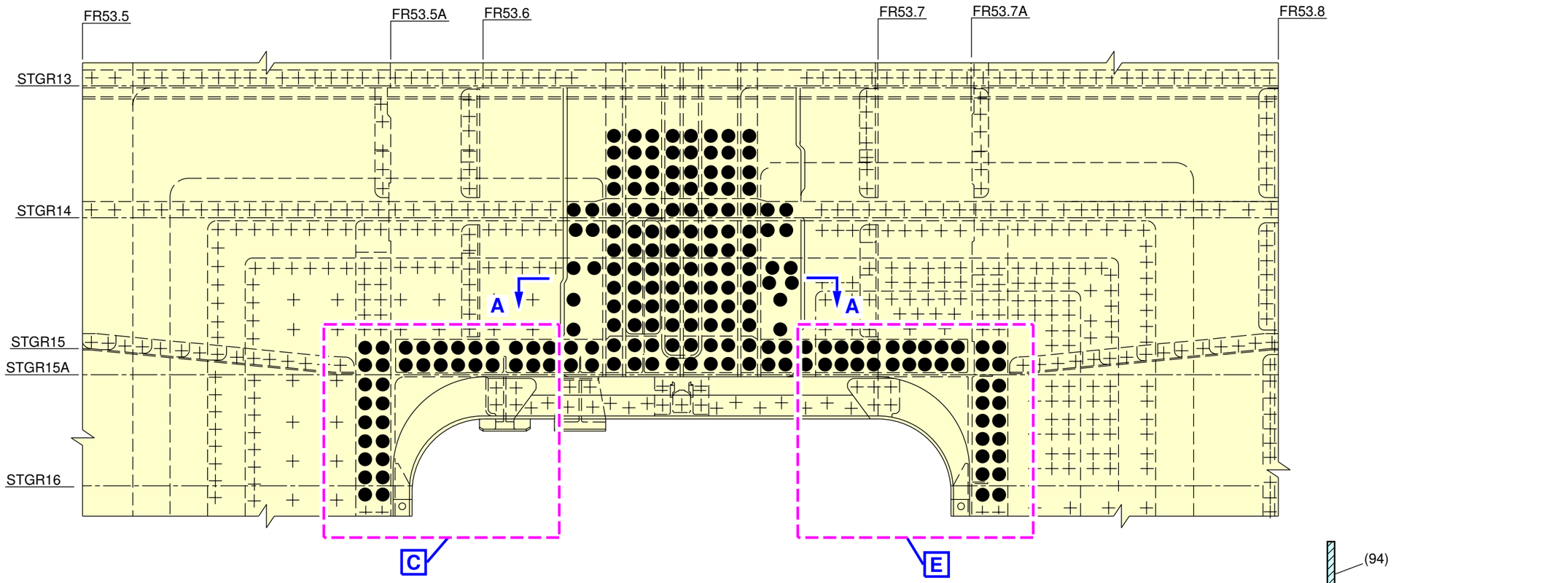


G_SB_533226_6_BBAD_01_03

Figure A-GBBAD - Sheet 01
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



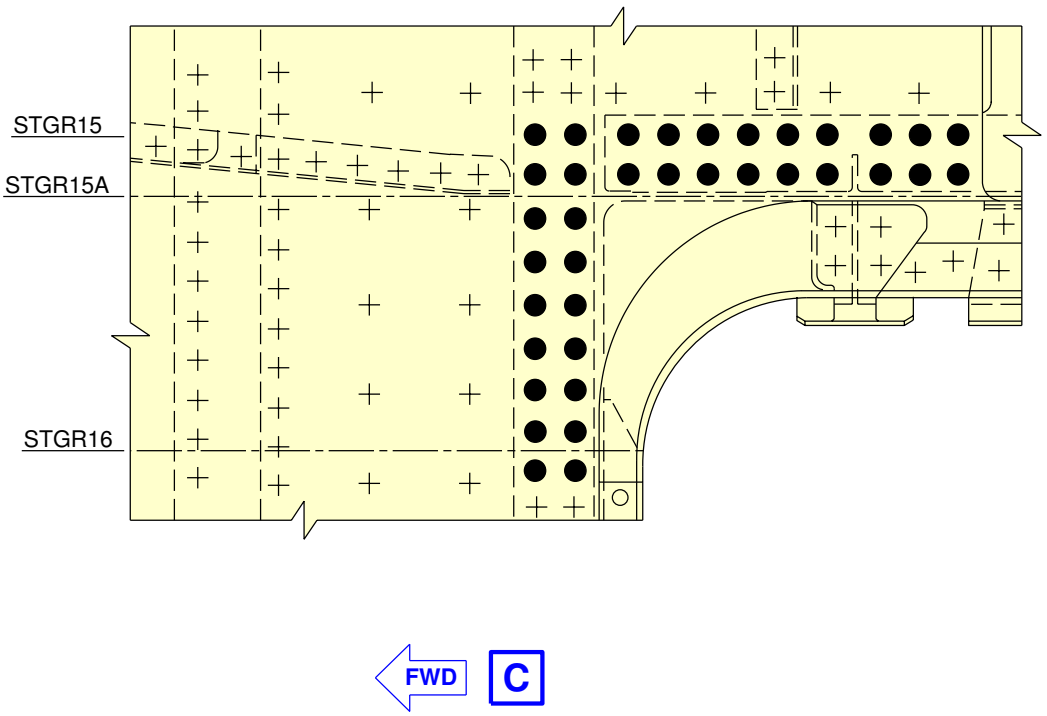
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_02_05

Figure A-GBBAD - Sheet 02
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



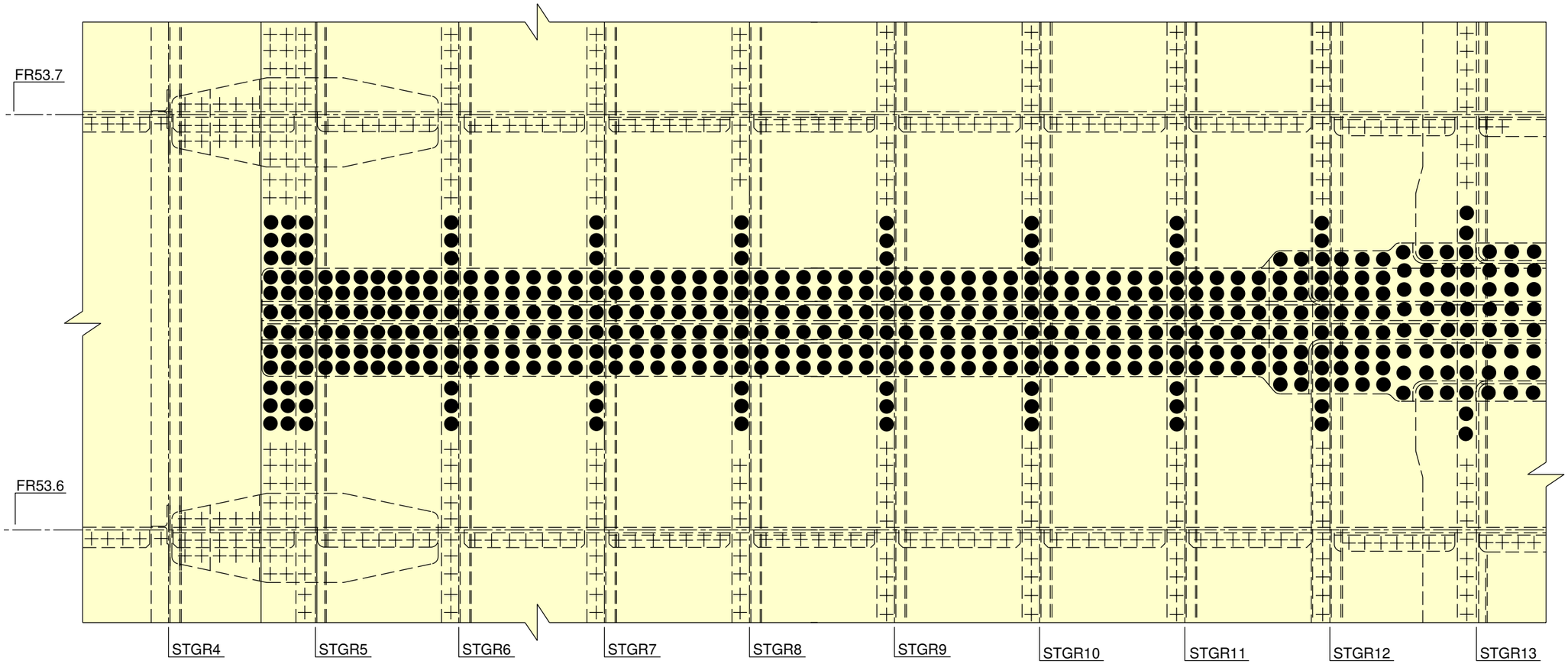
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_03_03

Figure A-GBBAD - Sheet 03
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



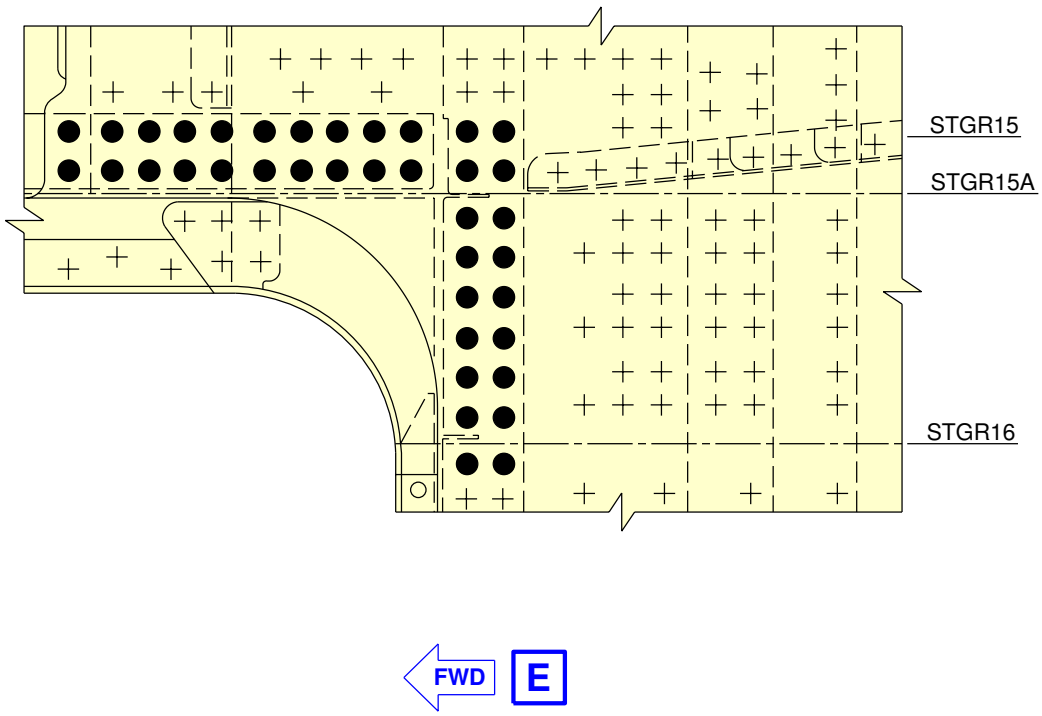
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
+ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_04_04

Figure A-GBBAD - Sheet 04
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



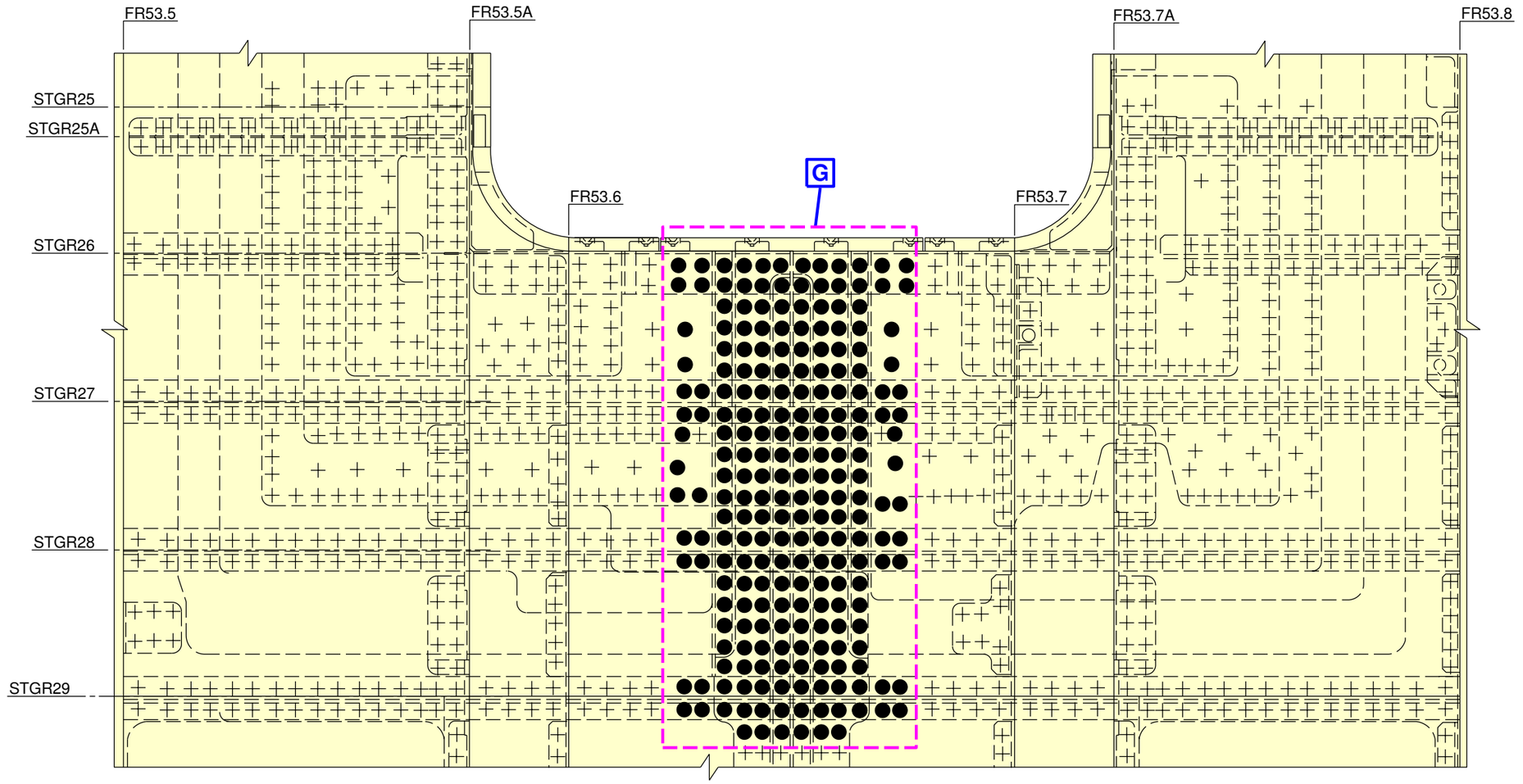
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_05_02

Figure A-GBBAD - Sheet 05
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



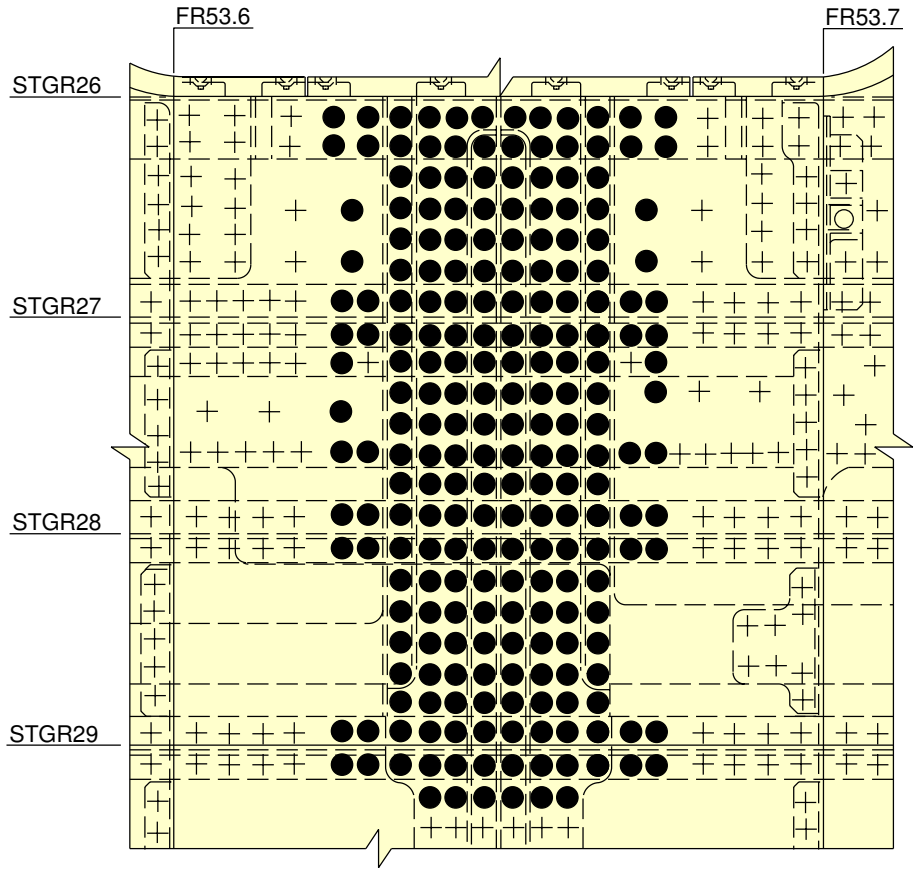
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_06_04

Figure A-GBBAD - Sheet 06
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 004



LH SHOWN
RH SYMMETRICAL
SCUFF PLATES NOT SHOWN

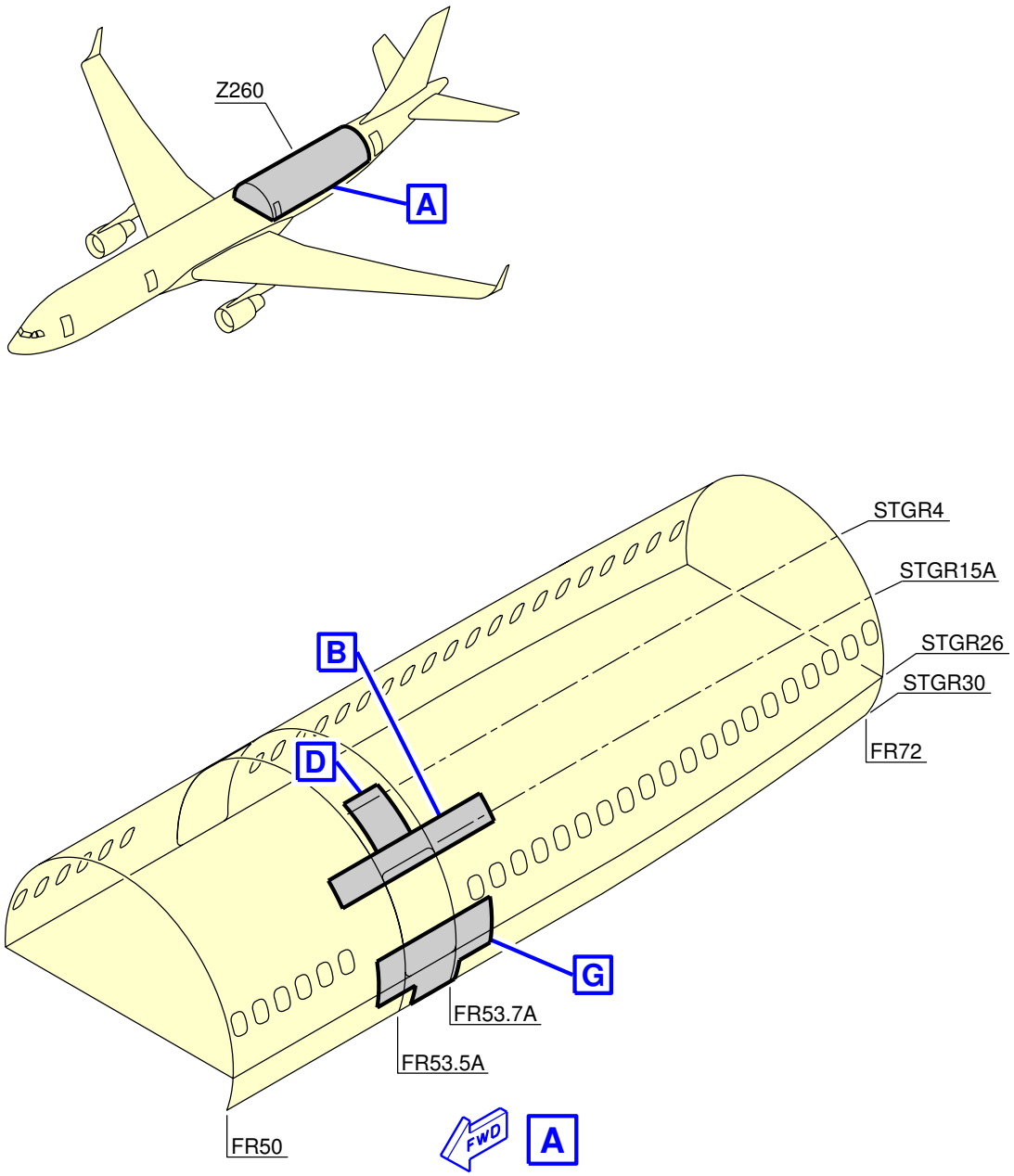
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.
┼ FASTENERS NOT AFFECTED.

G_SB_533226_6_BBAD_07_02

Figure A-GBBAD - Sheet 07
Removal of the Fasteners between FR53.5 and FR53.8

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**CONF 001

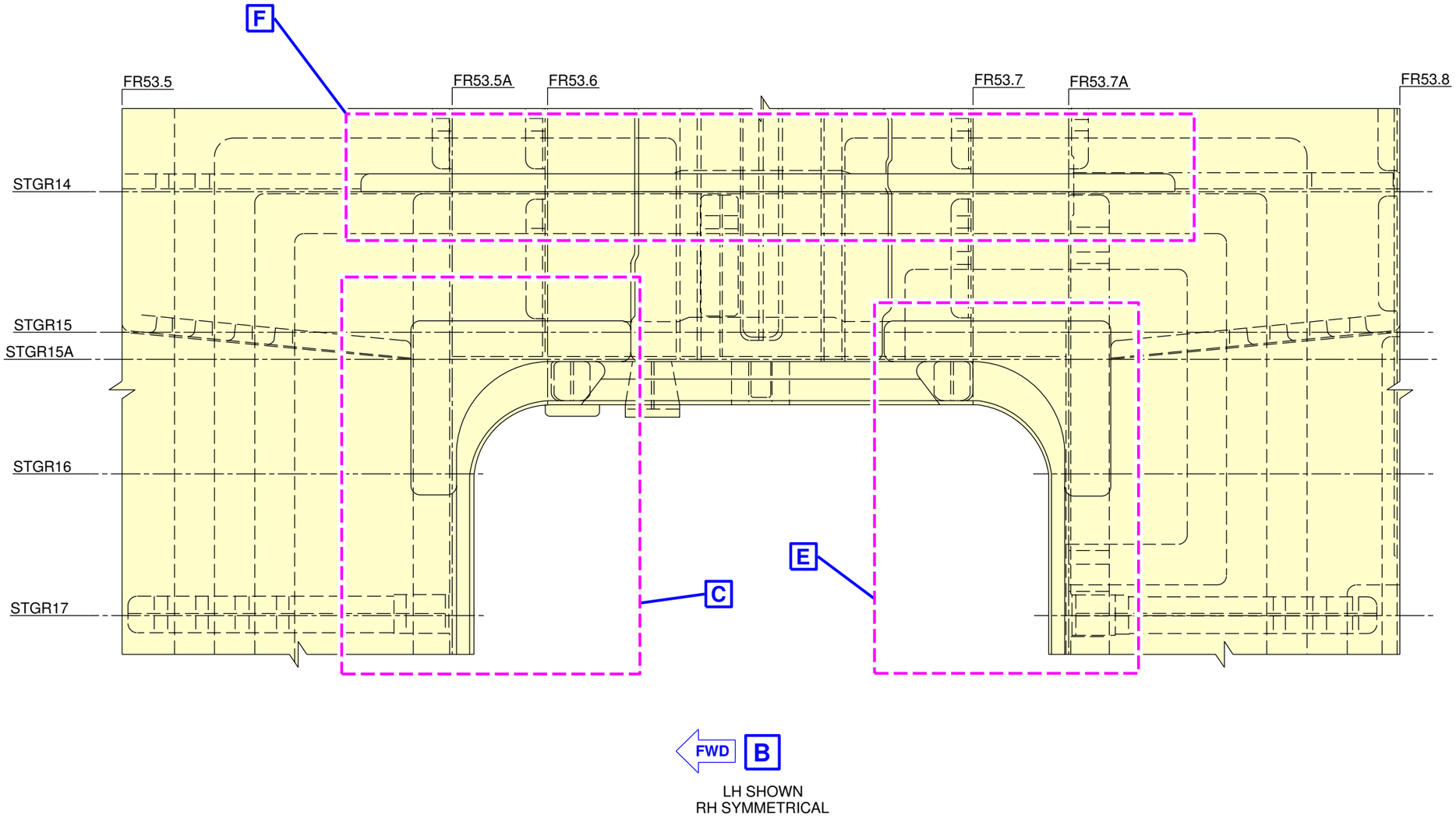


G_SB_533226_6_BCAA_01_03

Figure A-GBCAA - Sheet 01
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 001

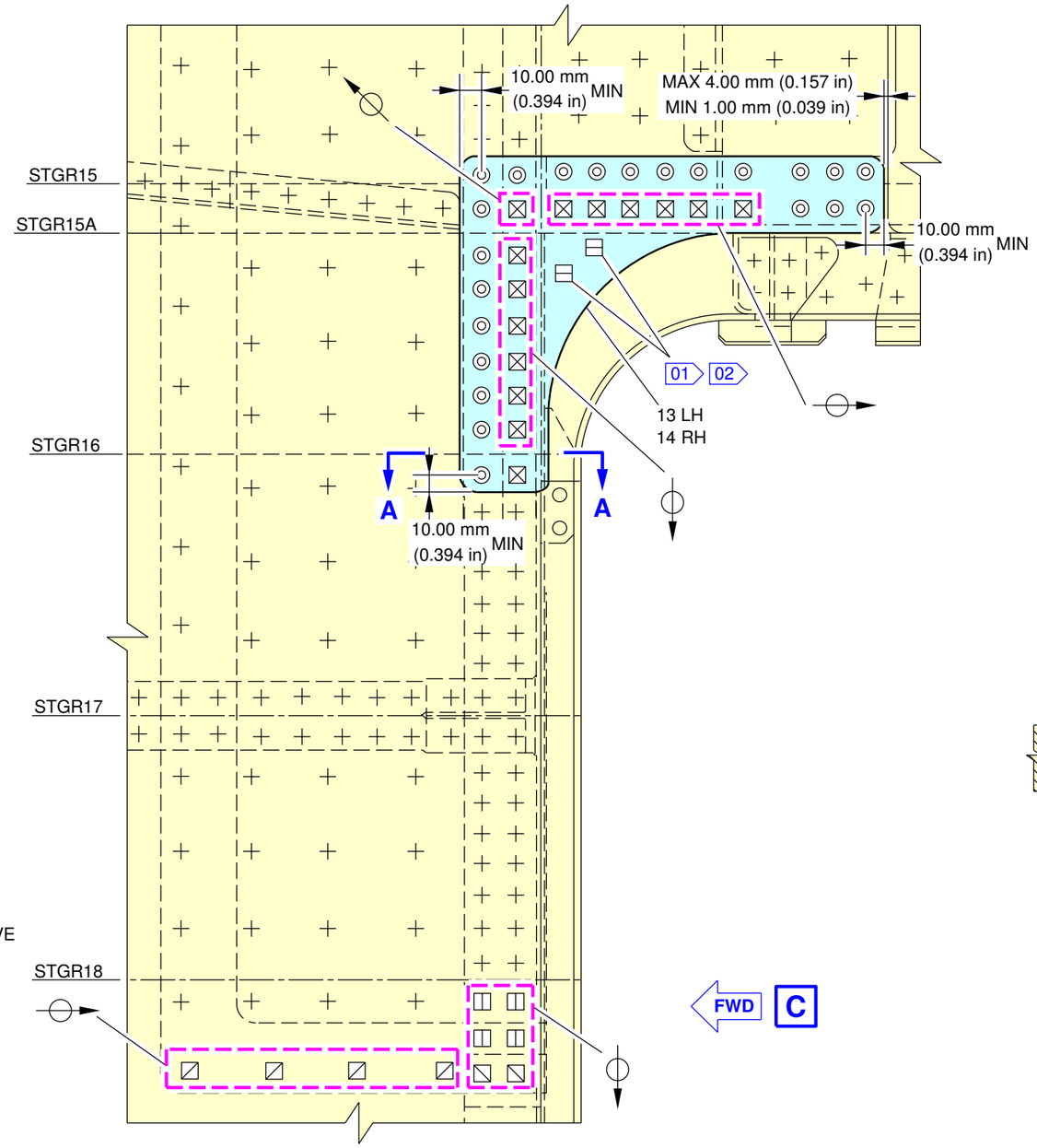


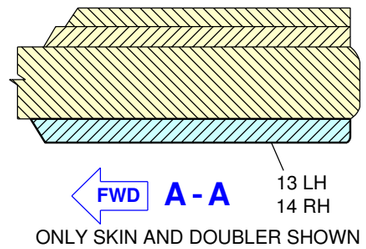
G_SB_533226_6_BCAA_02_01

Figure A-GBCAA - Sheet 02
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 001





ONLY SKIN AND DOUBLER SHOWN

NOTE:

- FASTENERS NOT AFFECTED.
- POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.
- AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

01 THESE FASTENERS ARE COVERED BY EXTERNAL DOUBLER 13 LH (14 RH).

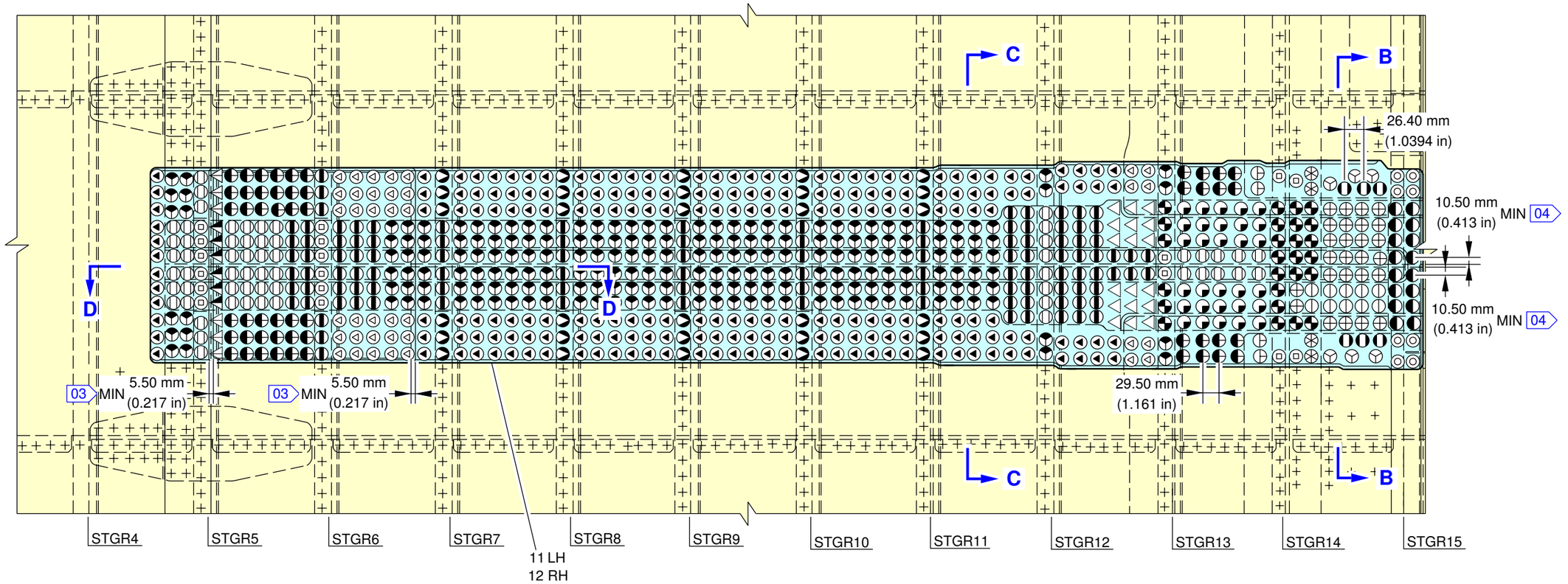
02 THESE RIVETS ARE NOT RIVETED WITH THE EXTERNAL DOUBLER 13 LH (14 RH).

G_SB_533226_6_BCAA_03_06

Figure A-GBCAA - Sheet 03
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

+ FASTENERS NOT AFFECTED.

REFER TO SHEET11 FOR THE APPLICABLE FASTENERS AND NOTES.

03 MINIMUM EDGE DISTANCE FOR THE UPPER AND LOWER ROW OF FASTENERS AT THE SHIM ITEM 19.

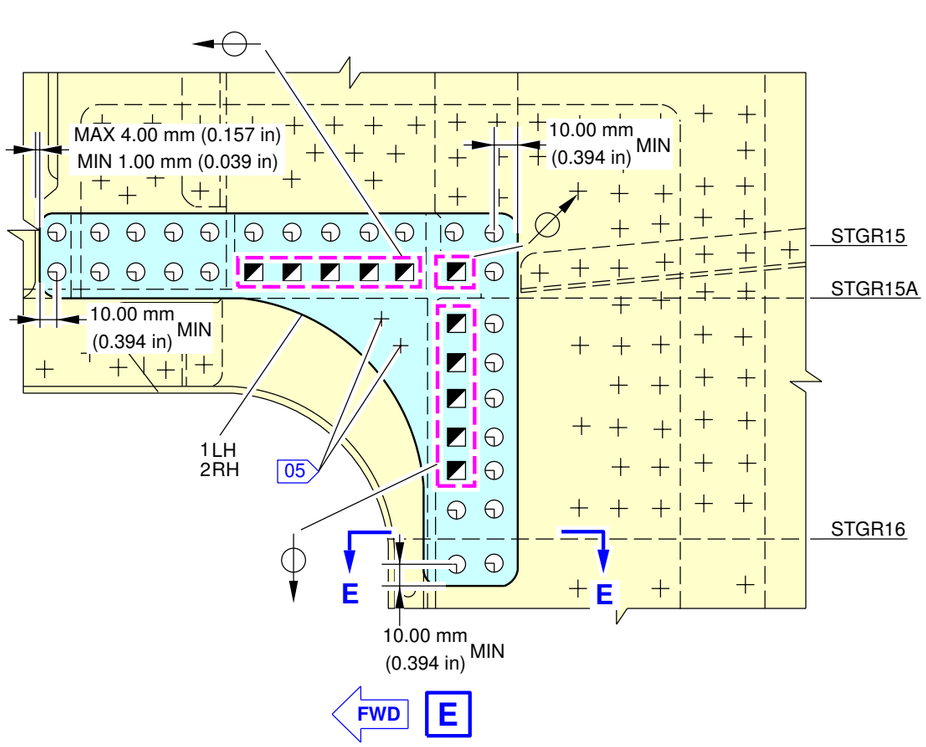
04 MINIMUM EDGE DISTANCE AT SKIN BELOW DOUBLER.

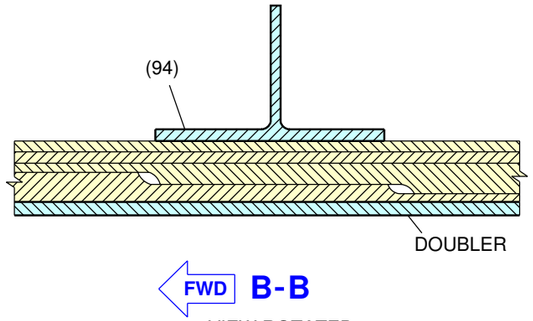
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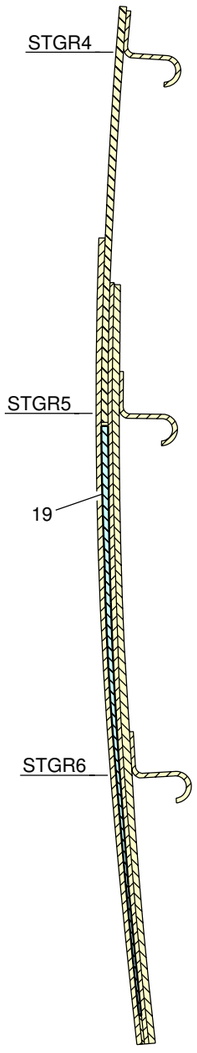
Figure A-GBCAA - Sheet 04
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

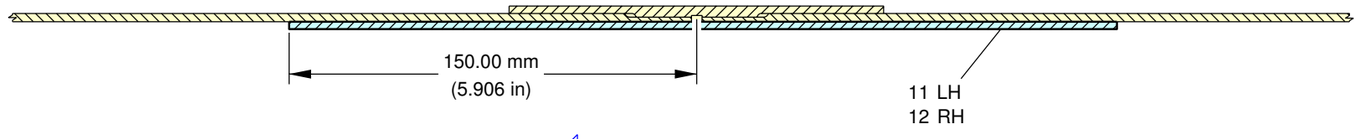
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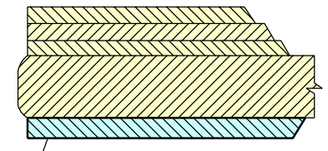
**CONF 001











NOTE:

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

FASTENERS NOT AFFECTED.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

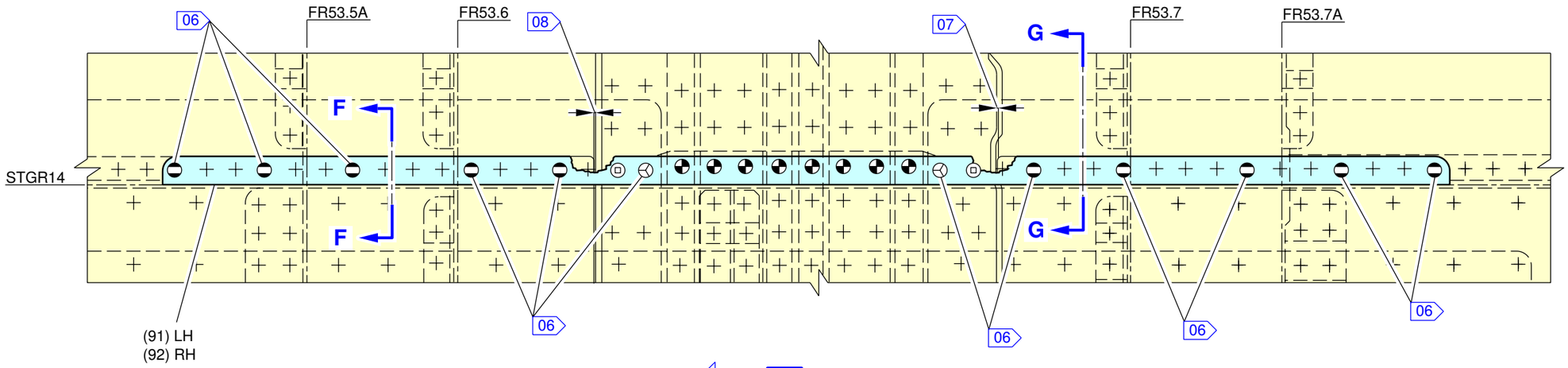
05 RIVETS ARE COVERED BY DOUBLER.

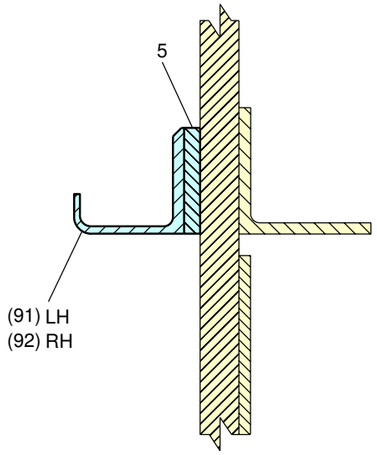
G_SB_533226_6_BCAA_05_06

Figure A-GBCAA - Sheet 05
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

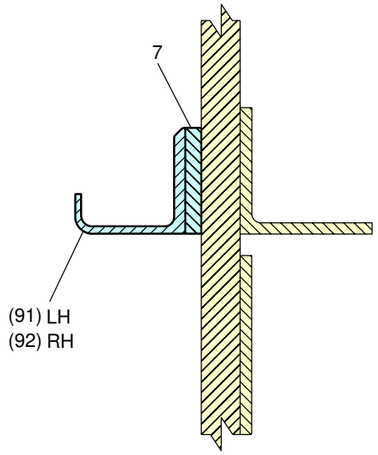
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F-F
VIEW LOOKING FWD



G-G
VIEW LOOKING FWD

NOTE:

┼ FASTENERS NOT AFFECTED.
REFER TO SHEET11 FOR THE APPLICABLE FASTENERS AND NOTES.

06 THESE RIVETS ONLY FOR FIXING OF RAIN DEFLECTOR WITH SHIM OR DOUBLER.

07 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (12 RH) AND THE SHIM ITEM 7 IS 2 mm (0.079 in).

08 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (12 RH) AND THE SHIM ITEM 5 IS 2 mm (0.079 in).

G_SB_533226_6_BCAA_06_07

Figure A-GBCAA - Sheet 06
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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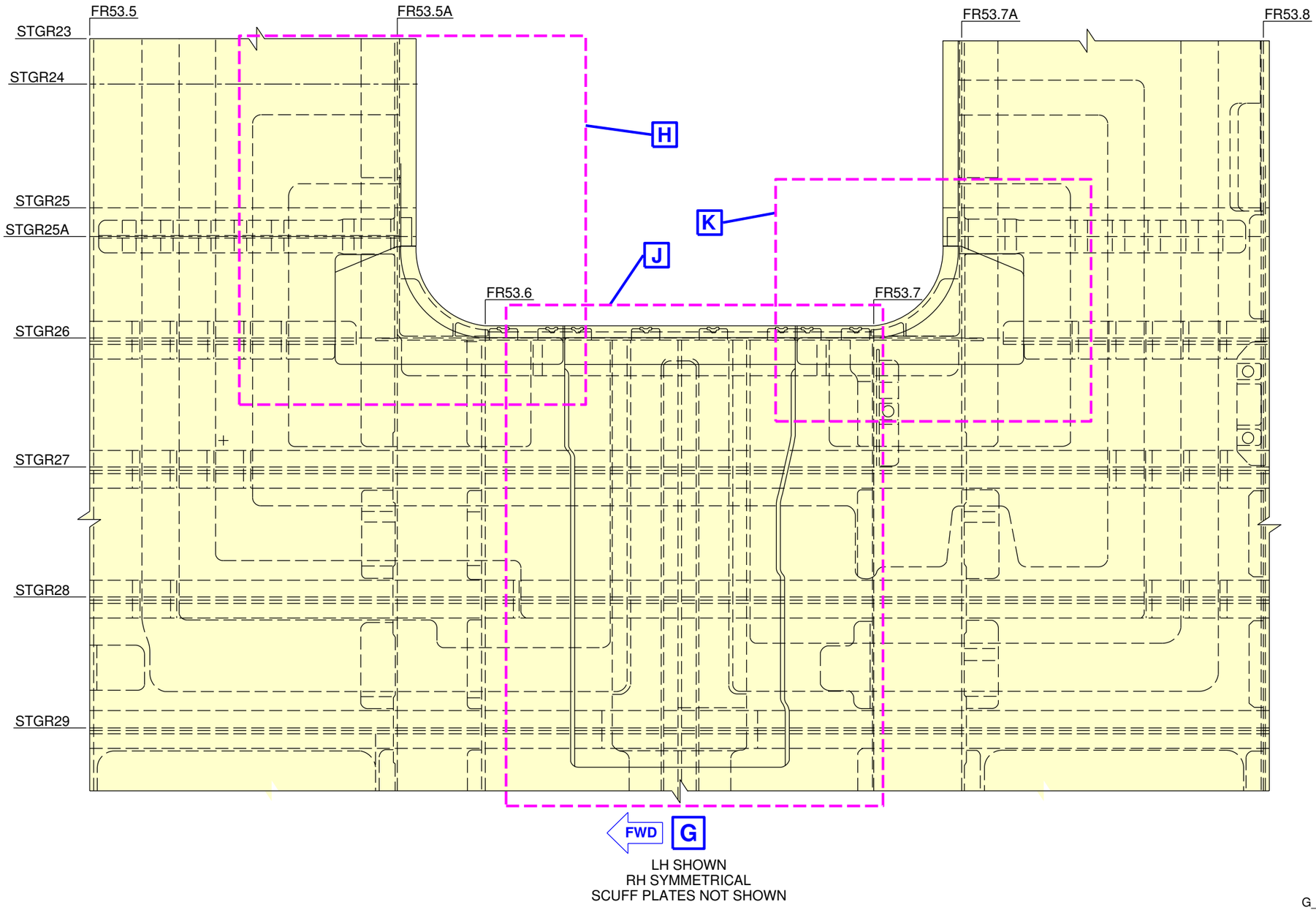
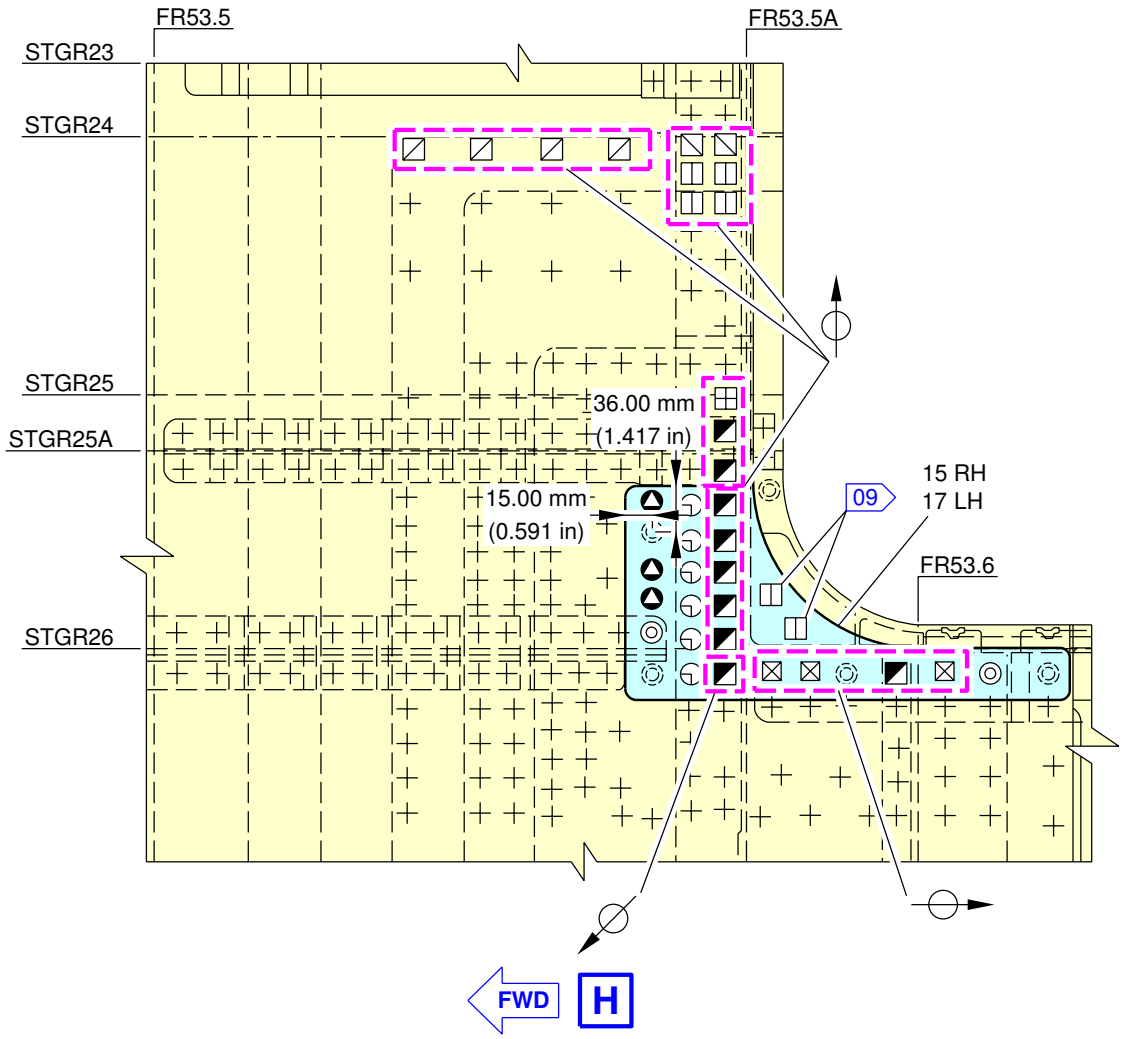


Figure A-GBCAA - Sheet 07
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

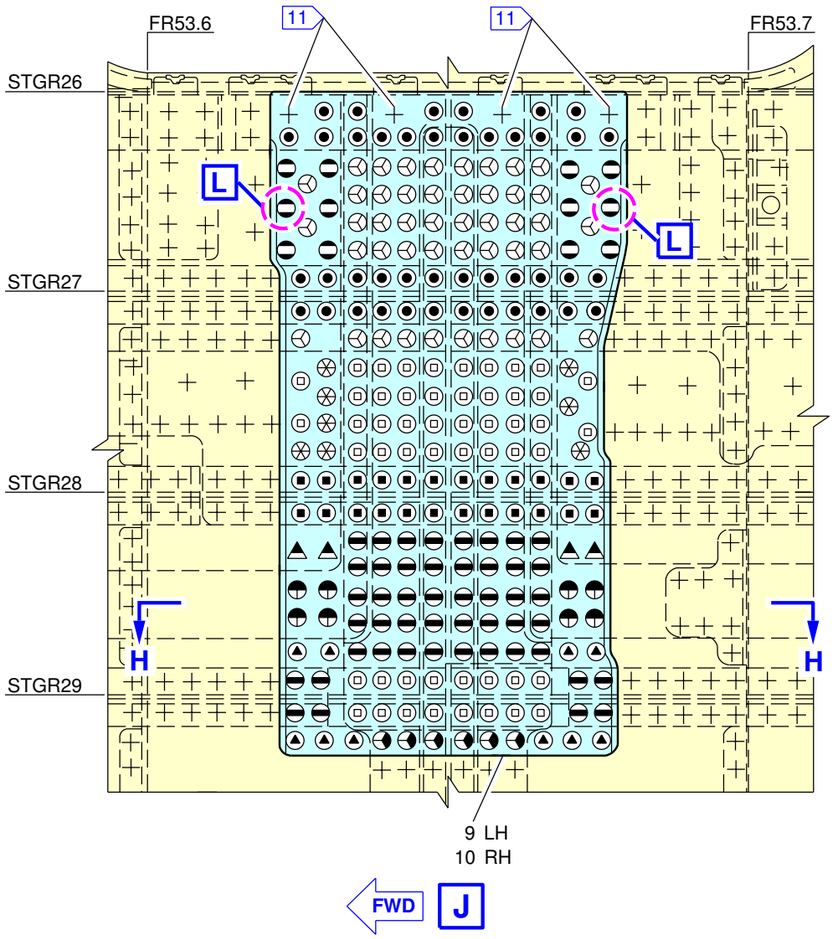
09 THESE FASTENERS ARE COVERED BY EXTERNAL DOUBLER 17 LH (15RH).

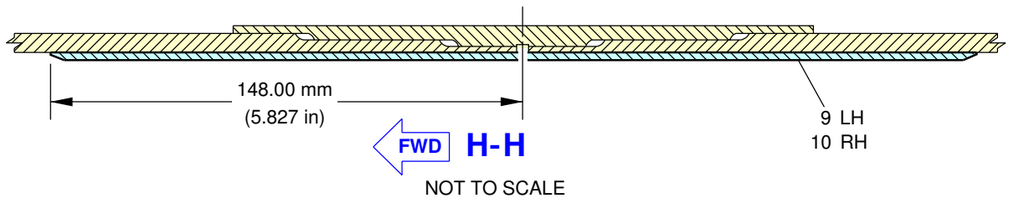
G_SB_533226_6_BCAA_08_07

Figure A-GBCAA - Sheet 08
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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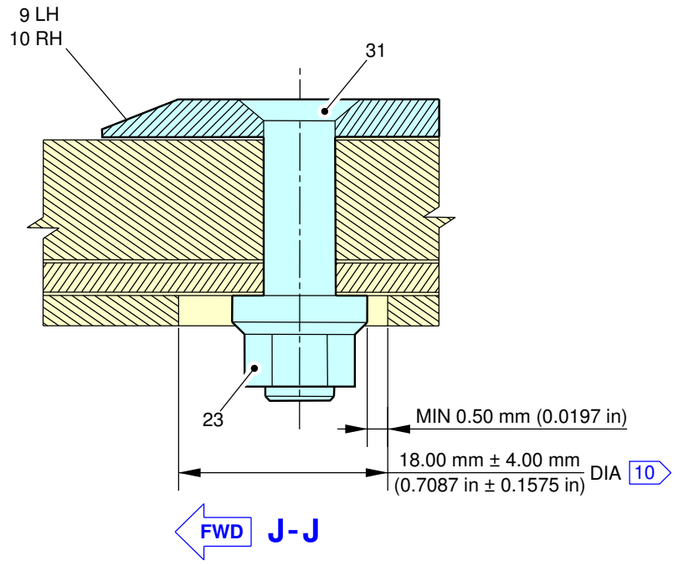
**CONF 001





NOT TO SCALE

TYPICAL



NOTE:

+ FASTENERS NOT AFFECTED.

REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

10 DRILL THROUGH HOLE ONLY IN INNER DOUBLER AND SHIFT MAX TO POSITION OF RIVET BORE.

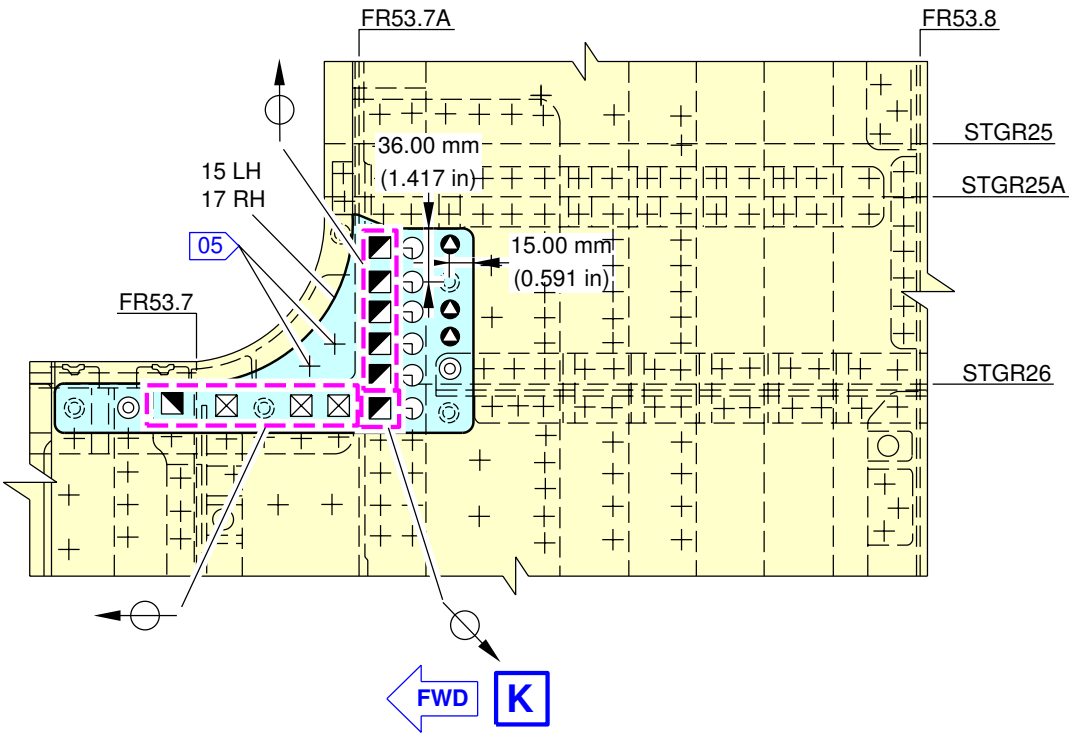
11 A HOLE OF DIAMETER 7 mm HAS TO BE DRILLED FOR SCUFF PLATE INSTALLATION.

G_SB_533226_6_BCAA_09_07

Figure A-GBCAA - Sheet 09
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

05 RIVETS ARE COVERED BY DOUBLER.

G_SB_533226_6_BCAA_10_07

Figure A-GBCAA - Sheet 10
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
▲	–	25	EN6114K3–4	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	26	EN6114K3–5	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◓	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⚠	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	12
		23	ASNA2528–3	NUT				
▲	–	28	EN6114K3–7	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊕	–	29	EN6114K3–8	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊛	–	30	EN6114K3–9	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	31	EN6114K3–10	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▲	–	32	EN6114K3–11	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▼	–	91	EN6114K3X5	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◒	–	33	EN6114K3X6	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	34	EN6114K3X7	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◭	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	13
		23	ASNA2528–3	NUT				
◎	–	36	EN6114K3X9	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊗	–	37	EN6114K3X10	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◉	–	92	EN6114K3X11	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
◉	–	38	EN6114K3X12	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◎	–	39	EN6114K3X13	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◵	–	40	EN6114K3X14	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	50	EN6114K4X7	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				
◒	–	90	EN6114K4X8	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				
◓	–	51	EN6114K4X9	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				
⊕	–	52	EN6114K4X10	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				
⊖	–	53	EN6114K4X11	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				
◓	–	54	EN6114K4X13	BOLT	6.647 mm (0.2610 in)	6.683 mm (0.2630 in)	1ST OVERSIZE INTERFERENCE FIT	–
		49	ASNA2528–4	NUT				

NOTE:

12 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.2 mm.

13 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.4 mm.

G_SB_533226_6_BCAA_11_05

Figure A-GBCAA - Sheet 11
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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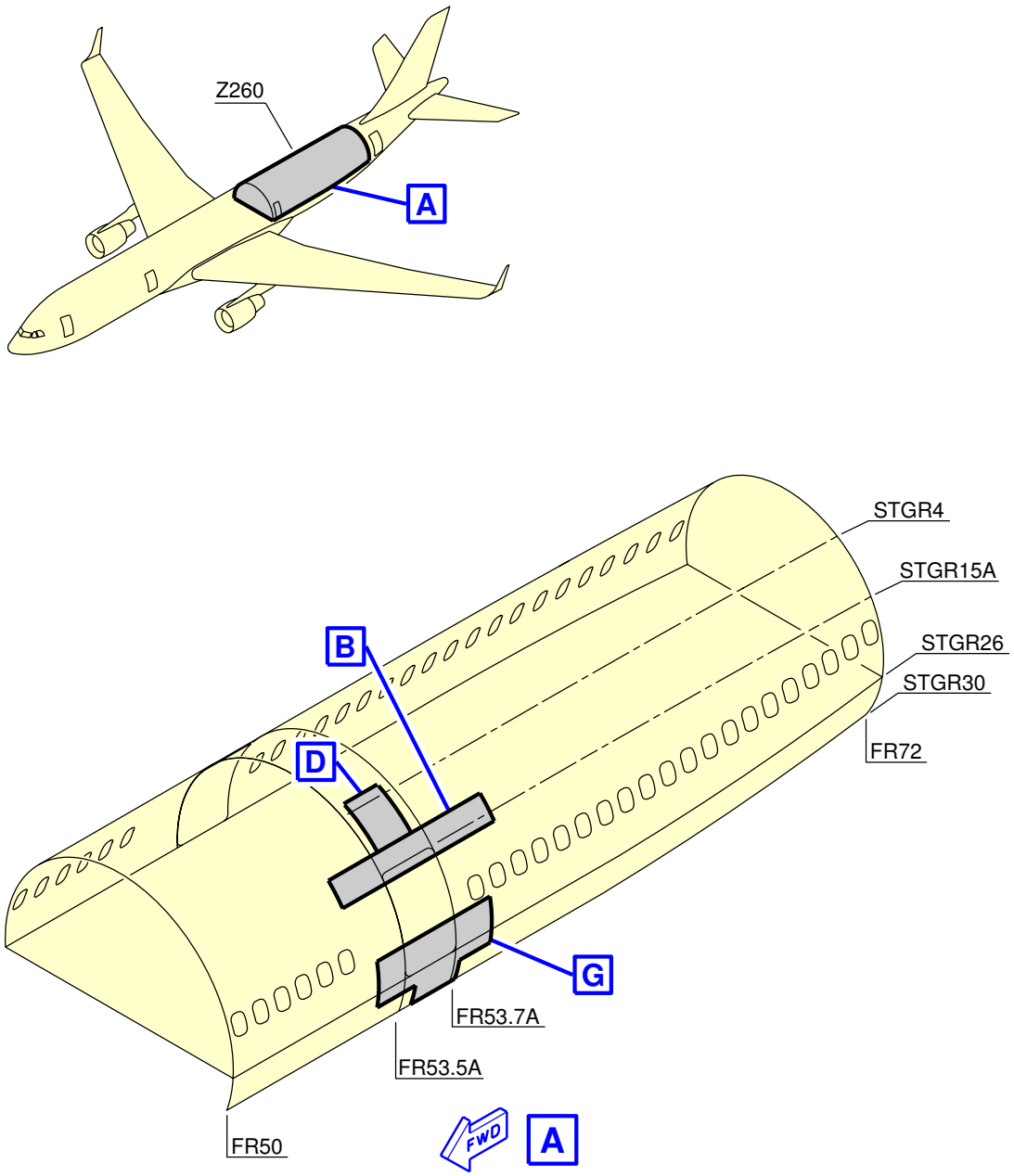
COLD WORKED HOLES											
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STARTING HOLE DIAMETER		STDN	FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
					MIN	MAX		MIN	MAX		
⊘	–	41	EN6114K3A7	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
⊘	–	42	EN6114K3A9	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
⊟	–	43	EN6114K3A10	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
⊟	–	44	EN6114K3A11	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
⊞	–	45	EN6114K3A12	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
⊠	–	46	EN6114K3A13	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◩	–	47	EN6114K3A14	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	48	EN6114K3A15	BOLT	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	6–1–N	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							

G_SB_533226_6_BCAA_12_04

Figure A-GBCAA - Sheet 12
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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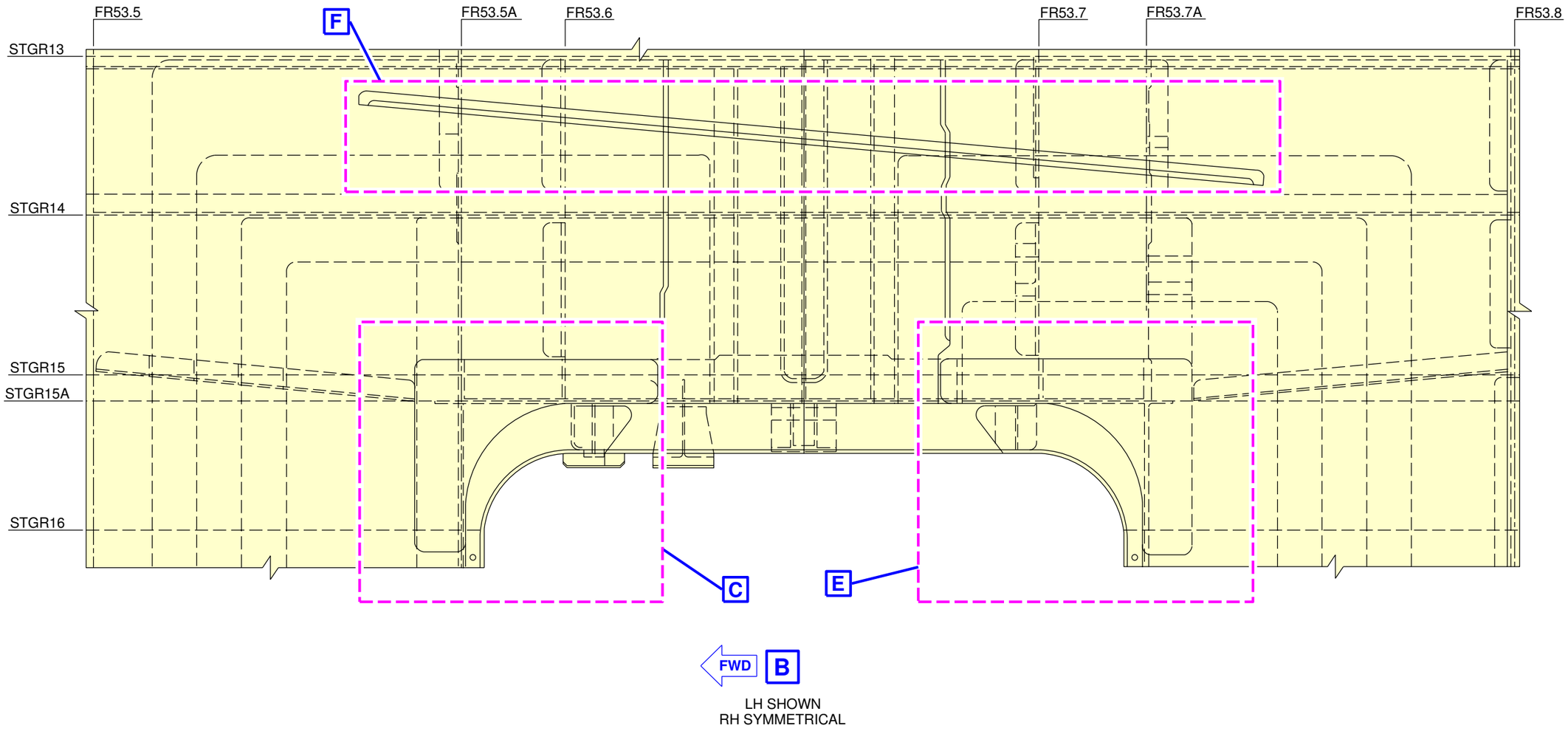


G_SB_533226_6_BCAB_01_03

Figure A-GBCAB - Sheet 01
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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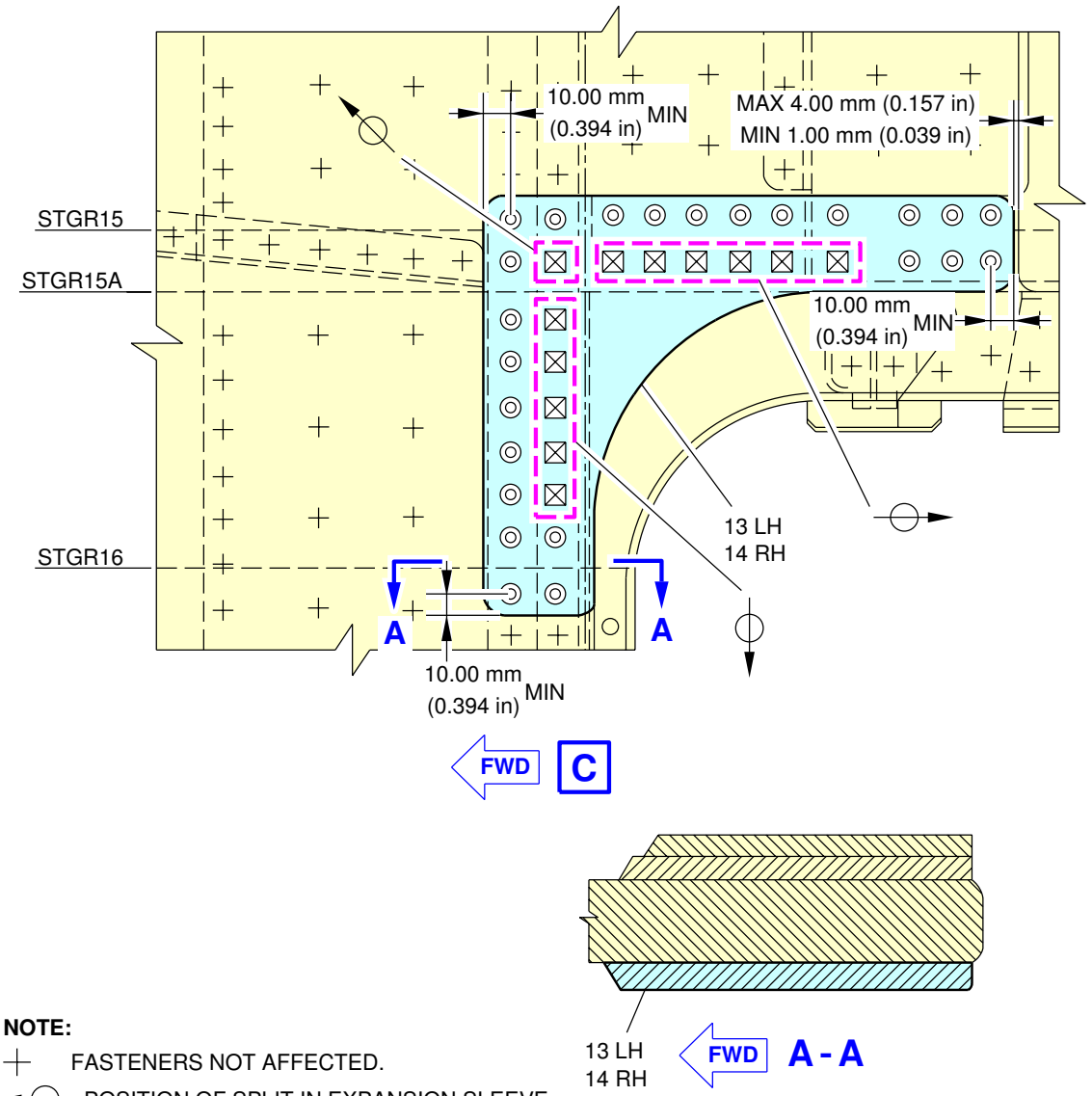
LH SHOWN
RH SYMMETRICAL

G_SB_533226_6_BCAB_02_02

Figure A-GBCAB - Sheet 02
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

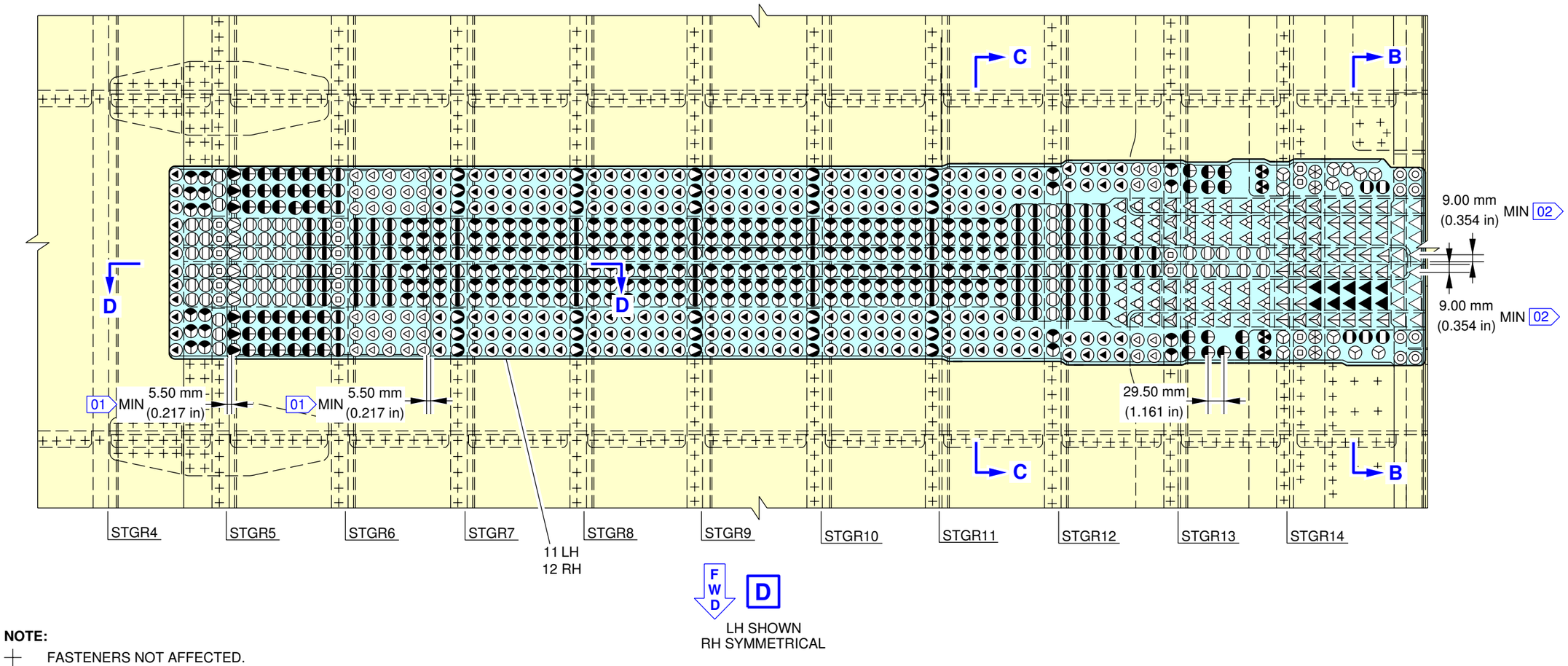
REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

G_SB_533226_6_BCAB_03_05

Figure A-GBCAB - Sheet 03
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

+ FASTENERS NOT AFFECTED.

REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

01 MINIMUM EDGE DISTANCE FOR THE UPPER AND LOWER ROW OF FASTENERS AT THE SHIM ITEM 19.

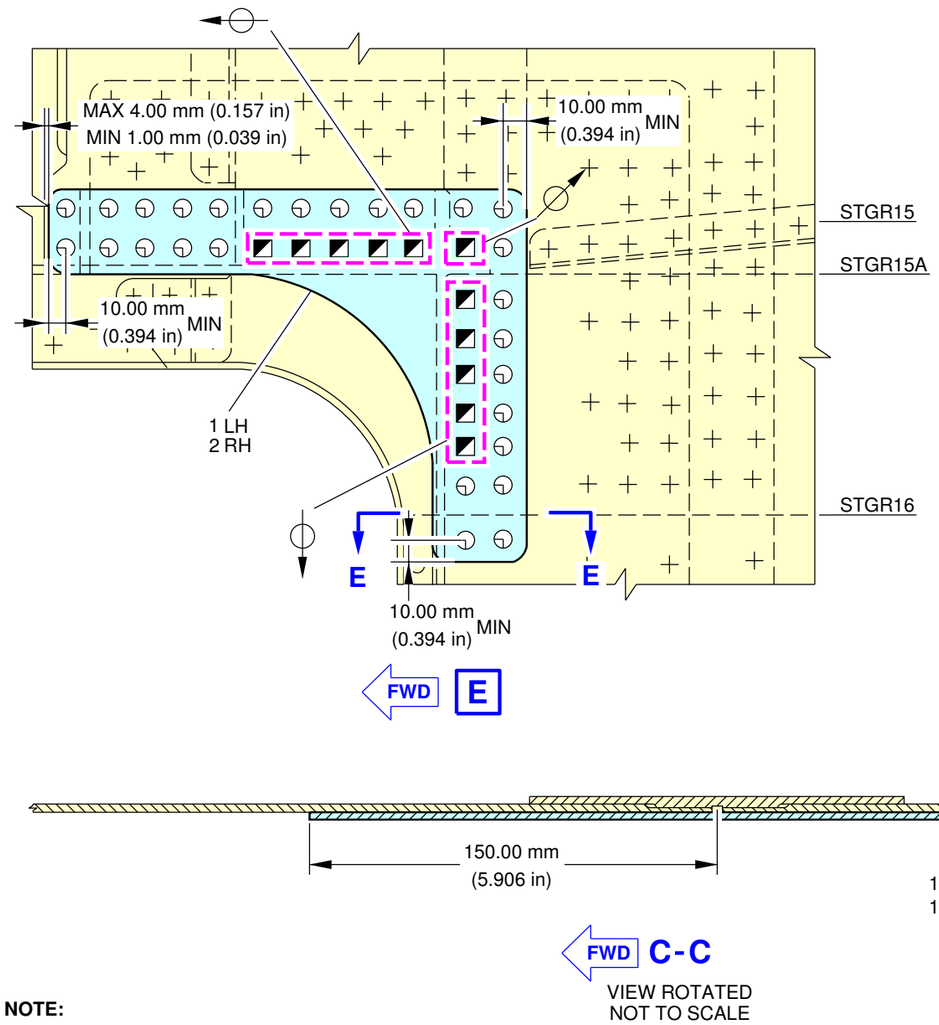
02 MINIMUM EDGE DISTANCE AT SKIN BELOW DOUBLER.

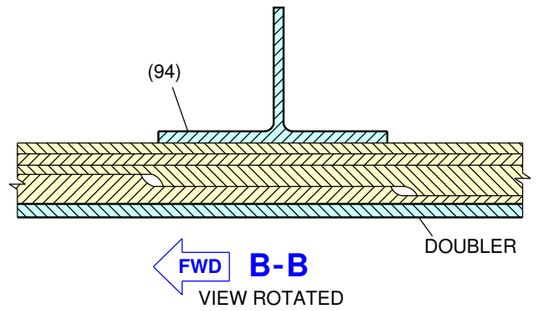
G_SB_533226_6_BCAB_04_07

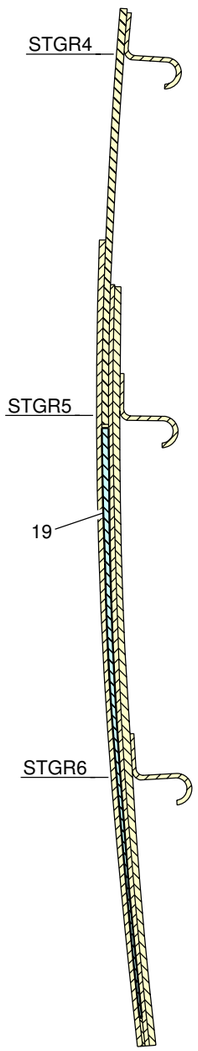
Figure A-GBCAB - Sheet 04
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

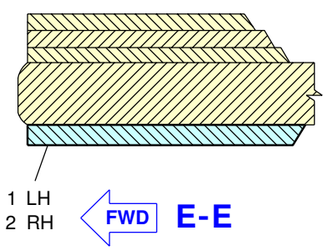
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NOTE:

- FASTENERS NOT AFFECTED.
- POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.
- AREA OF COLD WORKING.

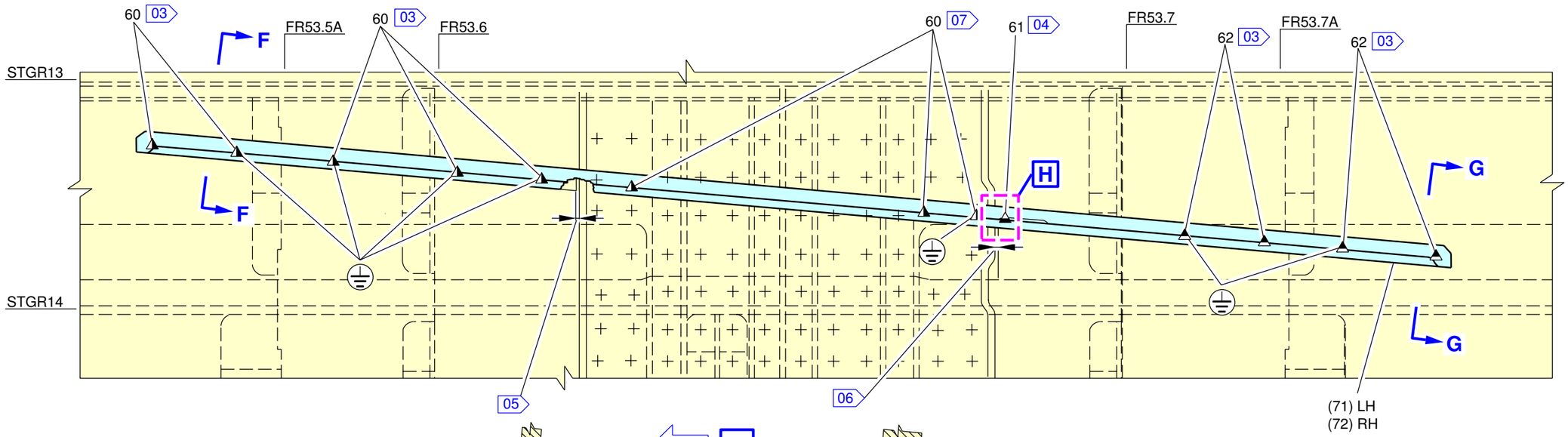
REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

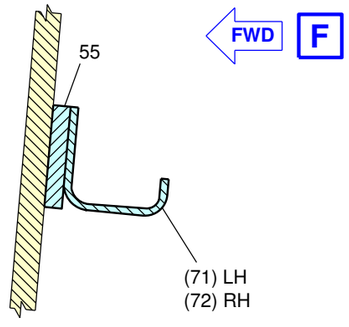
G_SB_533226_6_BCAB_05_05

Figure A-GBCAB - Sheet 05
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

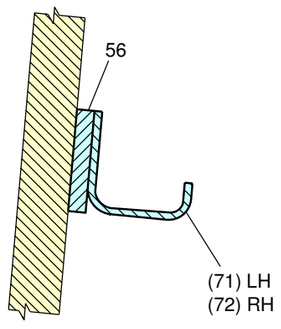
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**CONF 002

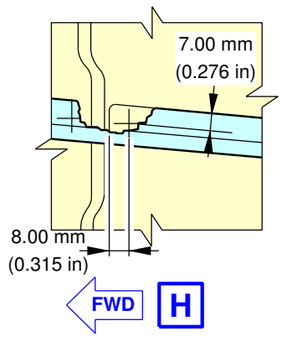




F-F
VIEW LOOKING AFT



G-G
VIEW LOOKING AFT



NOTE:
┼ FASTENERS NOT AFFECTED.
REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

03 THESE RIVETS FIX ONLY THE RAIN GUTTER AND SHIM.
04 THIS RIVET FIXES ONLY THE SHIM.
05 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (ITEM 12 RH) AND THE SHIM ITEM 55 IS 2 mm (0.079 in).
06 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (ITEM 12 RH) AND THE SHIM ITEM 56 IS 2 mm (0.079 in).
07 THIS FASTENER FIXES RAIN GUTTER AND DOUBLER.

G_SB_533226_6_BCAB_06_05

Figure A-GBCAB - Sheet 06
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 002

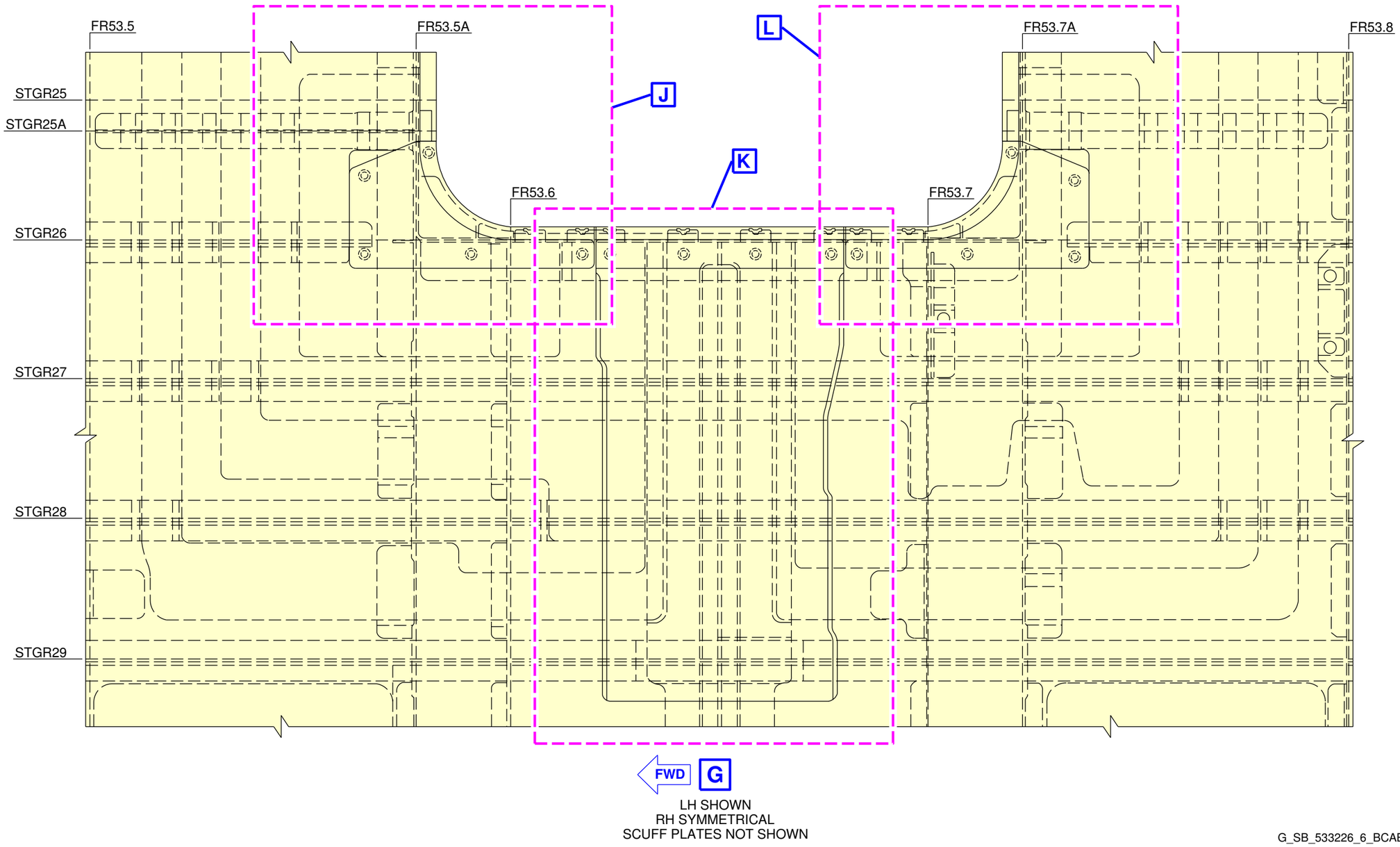
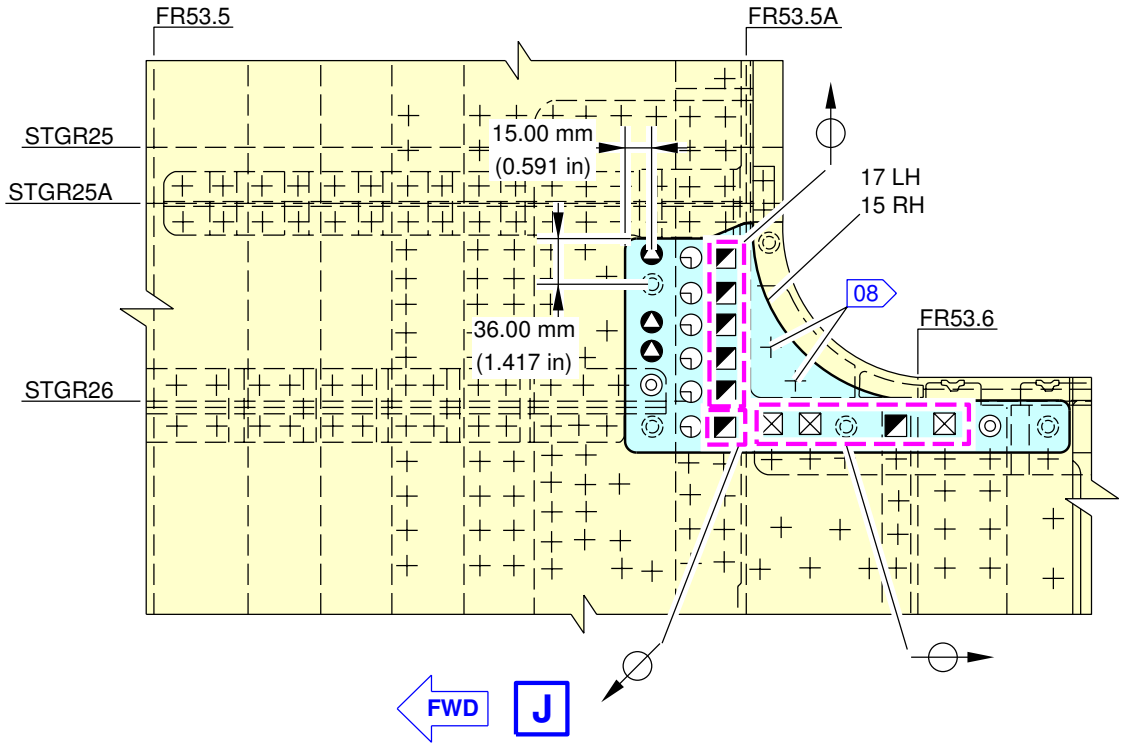


Figure A-GBCAB - Sheet 07
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 002



NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

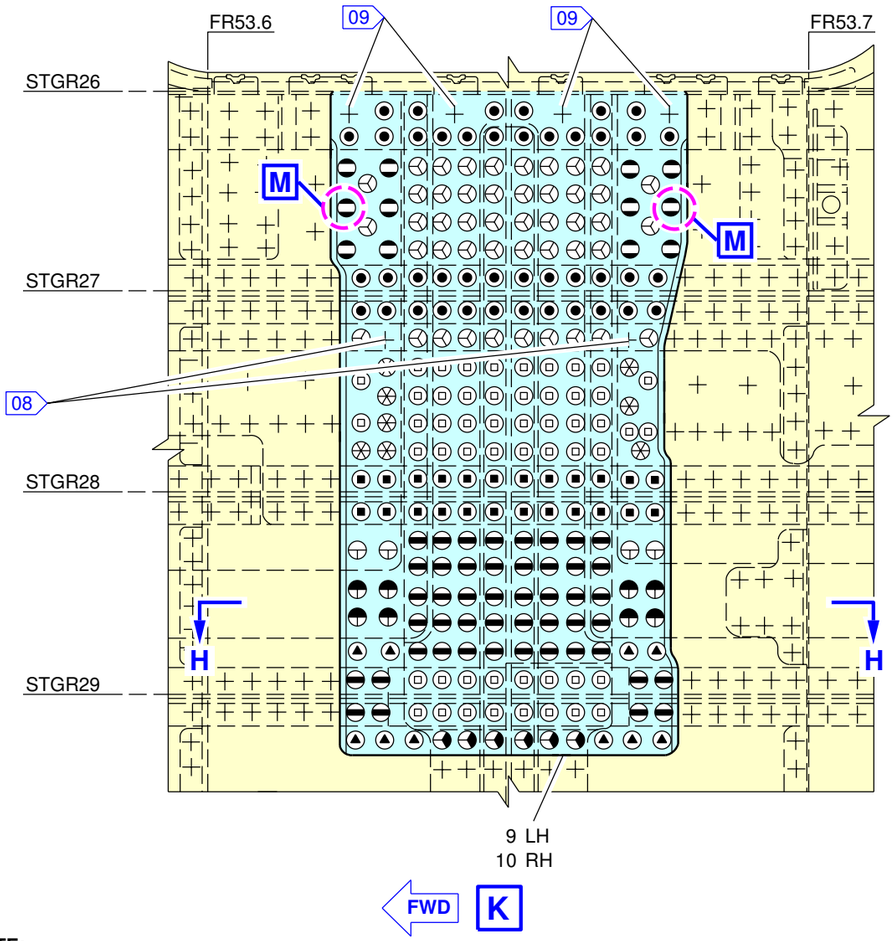
08 RIVETS ARE COVERED BY DOUBLER.

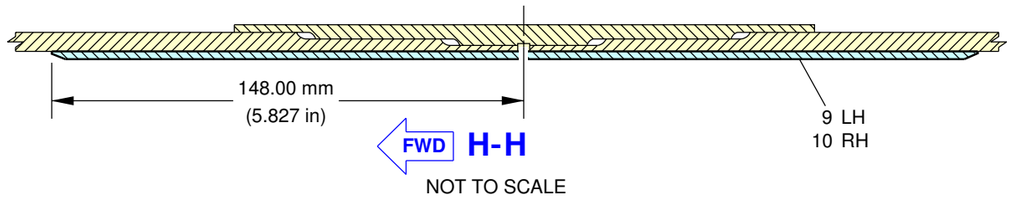
G_SB_533226_6_BCAB_08_06

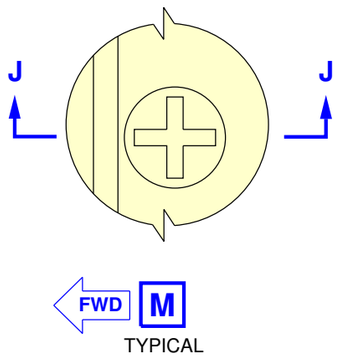
Figure A-GBCAB - Sheet 08
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

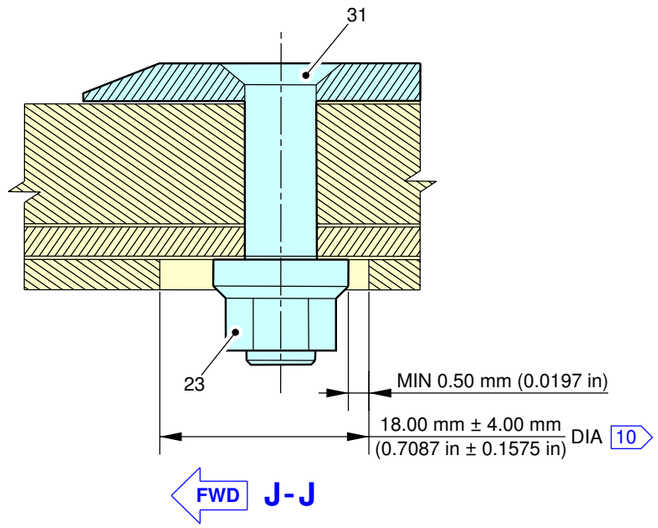
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**CONF 002









NOTE:
REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

08 RIVETS ARE COVERED BY DOUBLER.

09 A HOLE OF DIAMETER 7 mm HAS TO BE DRILLED FOR SCUFF PLATE INSTALLATION.

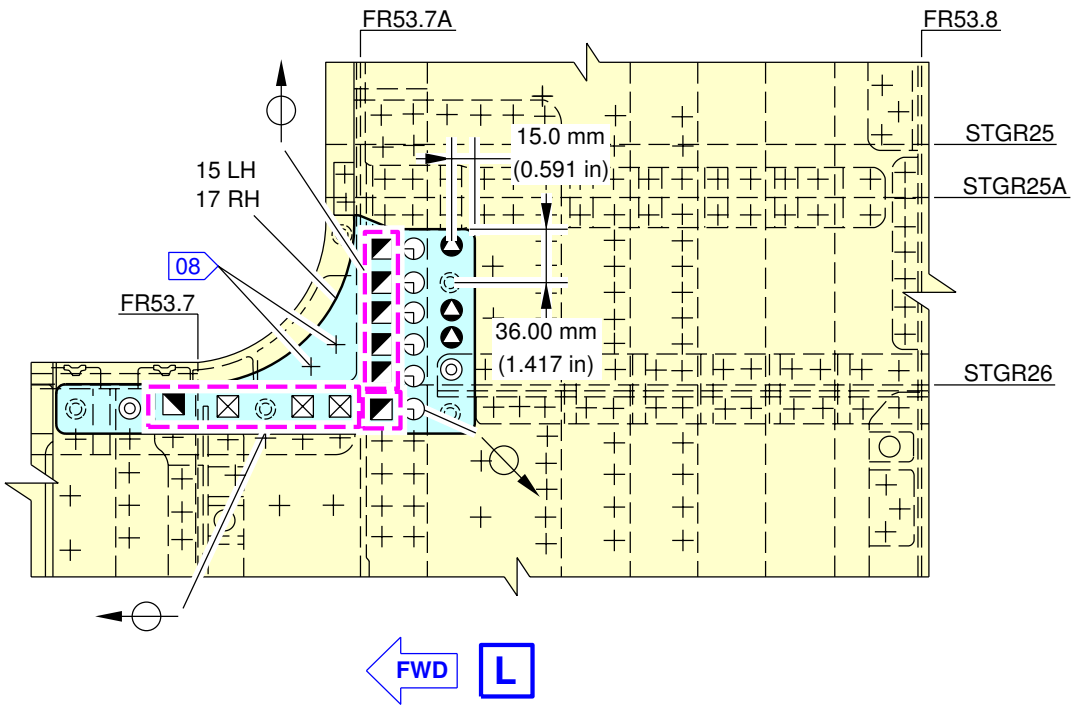
10 DRILL THROUGH HOLE ONLY IN INNER DOUBLER AND SHIFT MAX TO POSITION OF RIVET BORE.

G_SB_533226_6_BCAB_09_07

Figure A-GBCAB - Sheet 09
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 002



NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

08 RIVETS ARE COVERED BY DOUBLER.

G_SB_533226_6_BCAB_10_06

Figure A-GBCAB - Sheet 10
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
	–	25	EN6114K3–4	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	26	EN6114K3–5	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	11
		23	ASNA2528–3	NUT				
	–	28	EN6114K3–7	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	29	EN6114K3–8	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	30	EN6114K3–9	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	31	EN6114K3–10	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	32	EN6114K3–11	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	91	EN6114K3X5	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	33	EN6114K3X6	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	34	EN6114K3X7	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	12
		23	ASNA2528–3	NUT				
	–	36	EN6114K3X9	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	37	EN6114K3X10	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	92	EN6114K3X11	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
	–	38	EN6114K3X12	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	39	EN6114K3X13	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	40	EN6114K3X14	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
	–	41	EN6114K3A7	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	93	EN6114K3A8	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	42	EN6114K3A9	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	43	EN6114K3A10	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	44	EN6114K3A11	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	46	EN6114K3A13	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
	–	60	EN6081D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
	–	61	EN6069D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
	–	62	EN6081D5–12	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–

NOTE:

11 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.2 mm.

12 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.4 mm.

G_SB_533226_6_BCAB_11_04

Figure A-GBCAB - Sheet 11
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 002

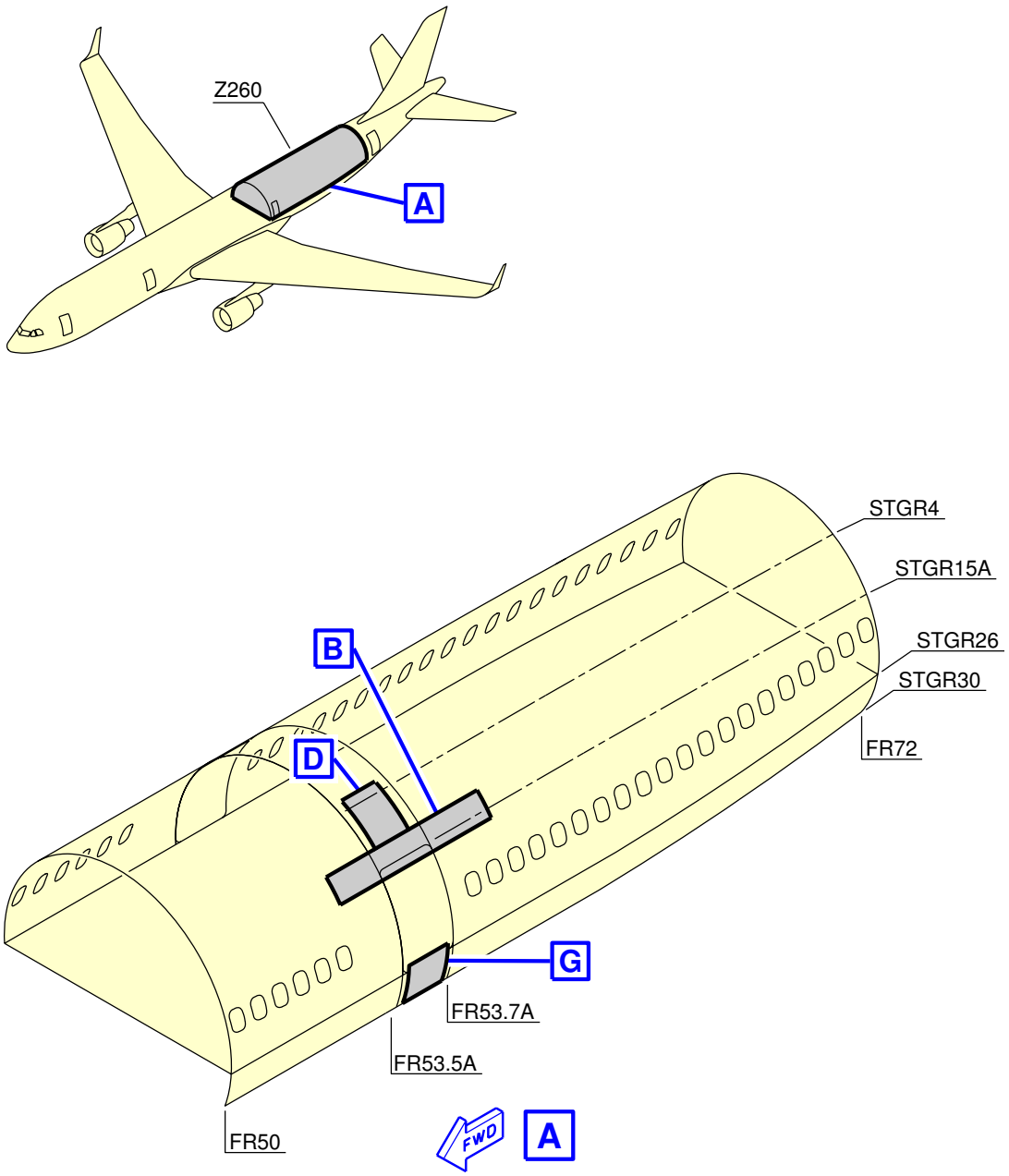
COLD WORKED HOLES											
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
⊠	–	46	EN6114K3A13	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	47	EN6114K3A14	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	48	EN6114K3A15	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							

G_SB_533226_6_BCAB_12_04

Figure A-GBCAB - Sheet 12
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 003

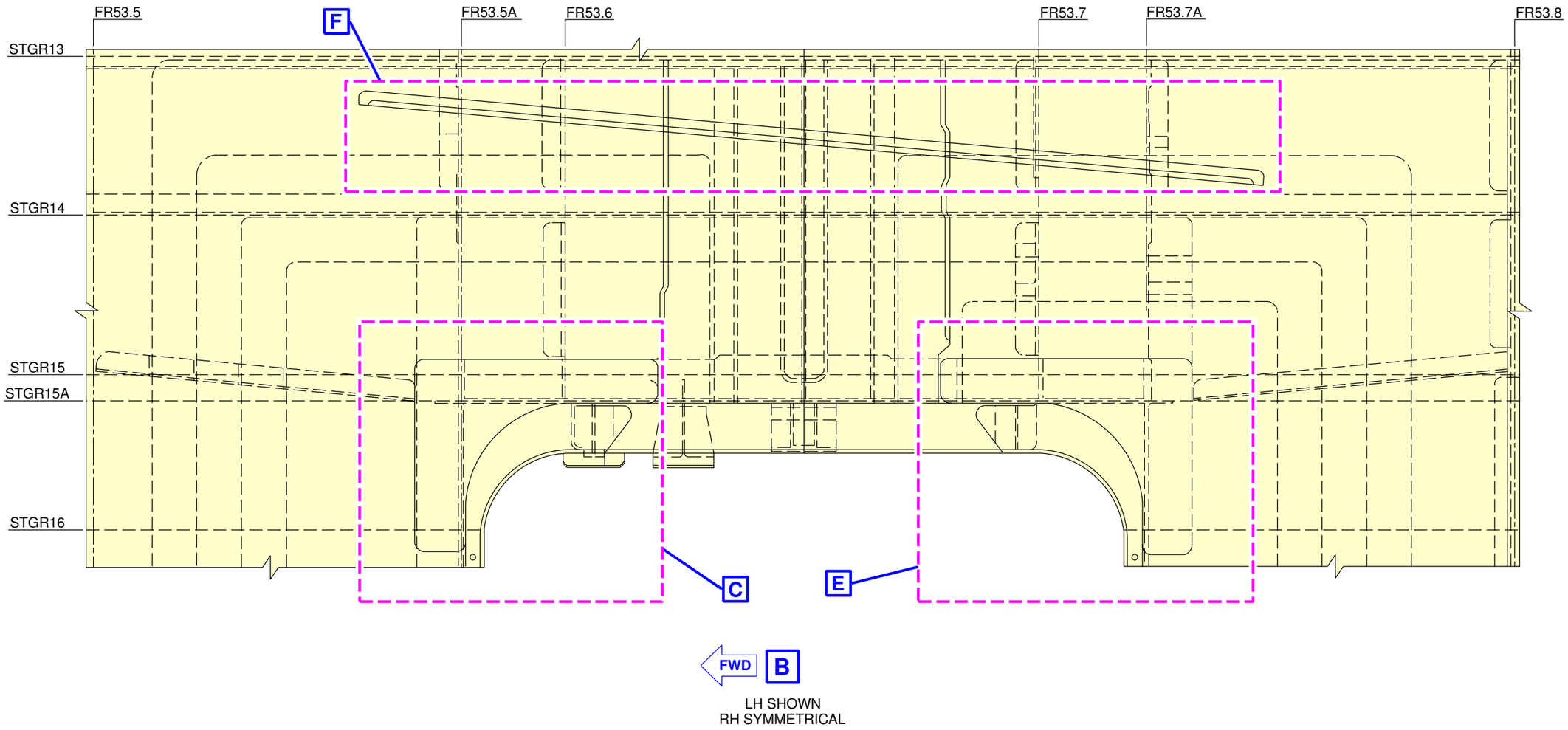


G_SB_533226_6_BCAC_01_03

Figure A-GBCAC - Sheet 01
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 003



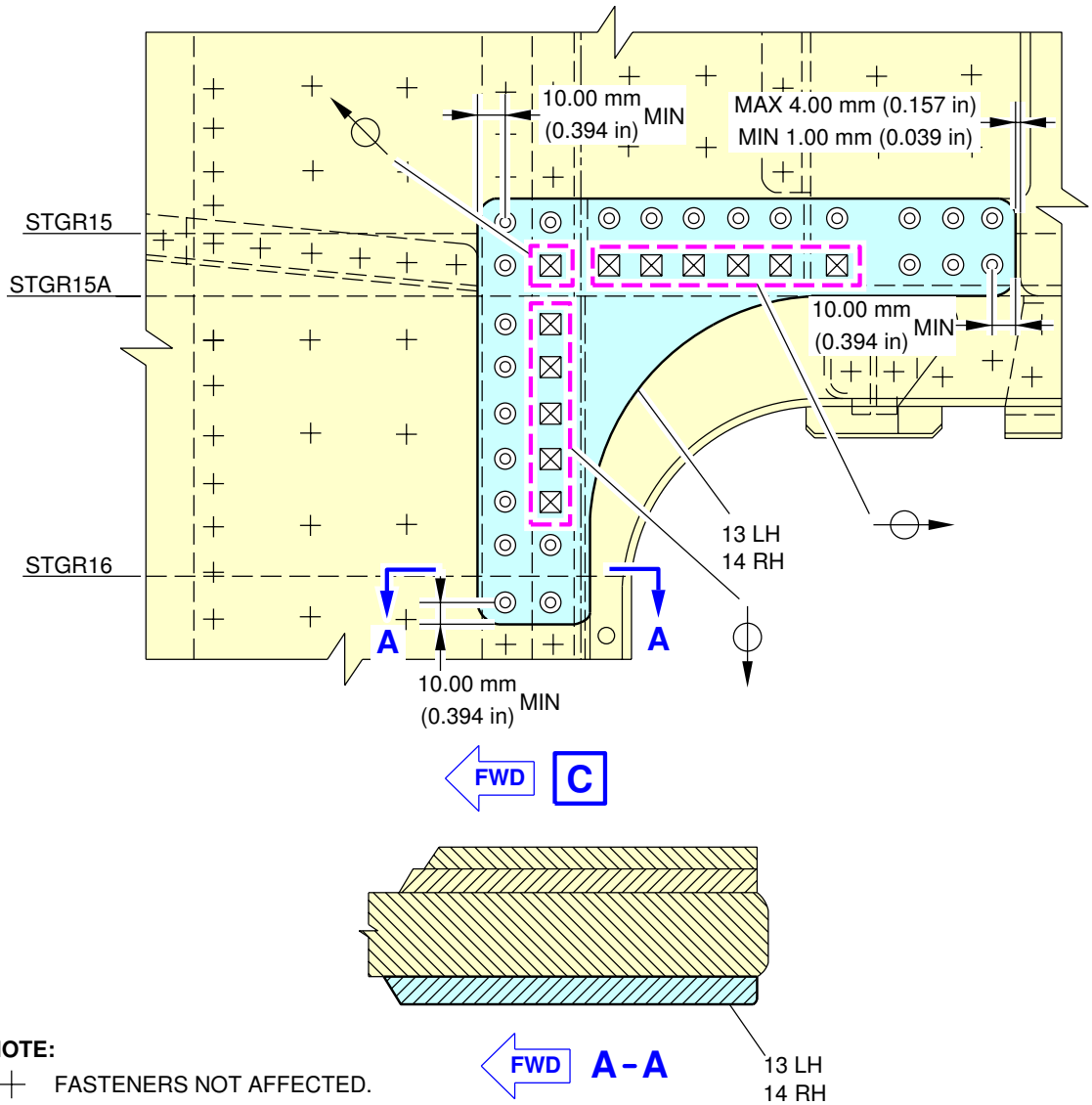
LH SHOWN
RH SYMMETRICAL

G_SB_533226_6_BCAC_02_01

Figure A-GBCAC - Sheet 02
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 003



NOTE:

FASTENERS NOT AFFECTED.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

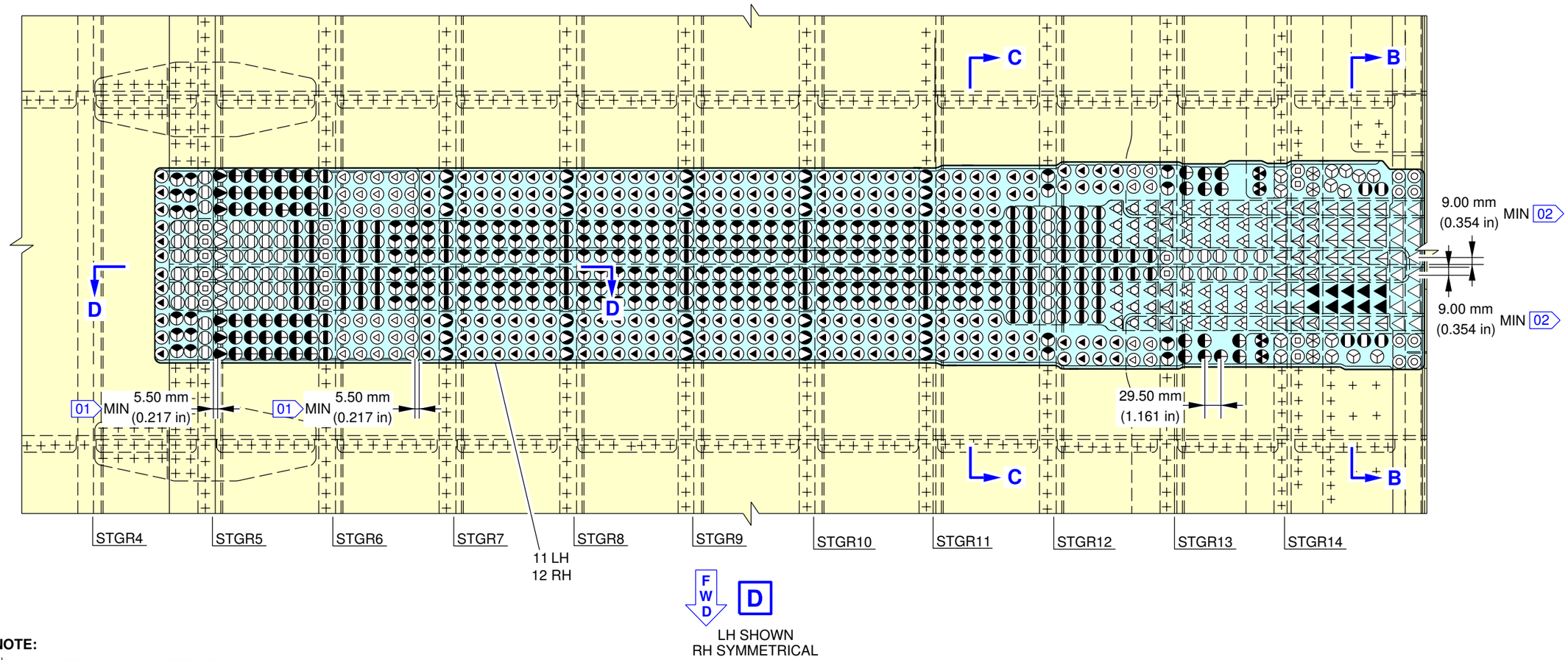
REFER TO SHEETS 9 AND 10 FOR THE APPLICABLE FASTENERS AND NOTES.

G_SB_533226_6_BCAC_03_05

Figure A-GBCAC - Sheet 03
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 003



NOTE:

+ FASTENERS NOT AFFECTED.

REFER TO SHEETS 9 FOR THE APPLICABLE FASTENERS AND NOTES.

01 MINIMUM EDGE DISTANCE FOR THE UPPER AND LOWER ROW OF FASTENERS AT THE SHIM ITEM 19.

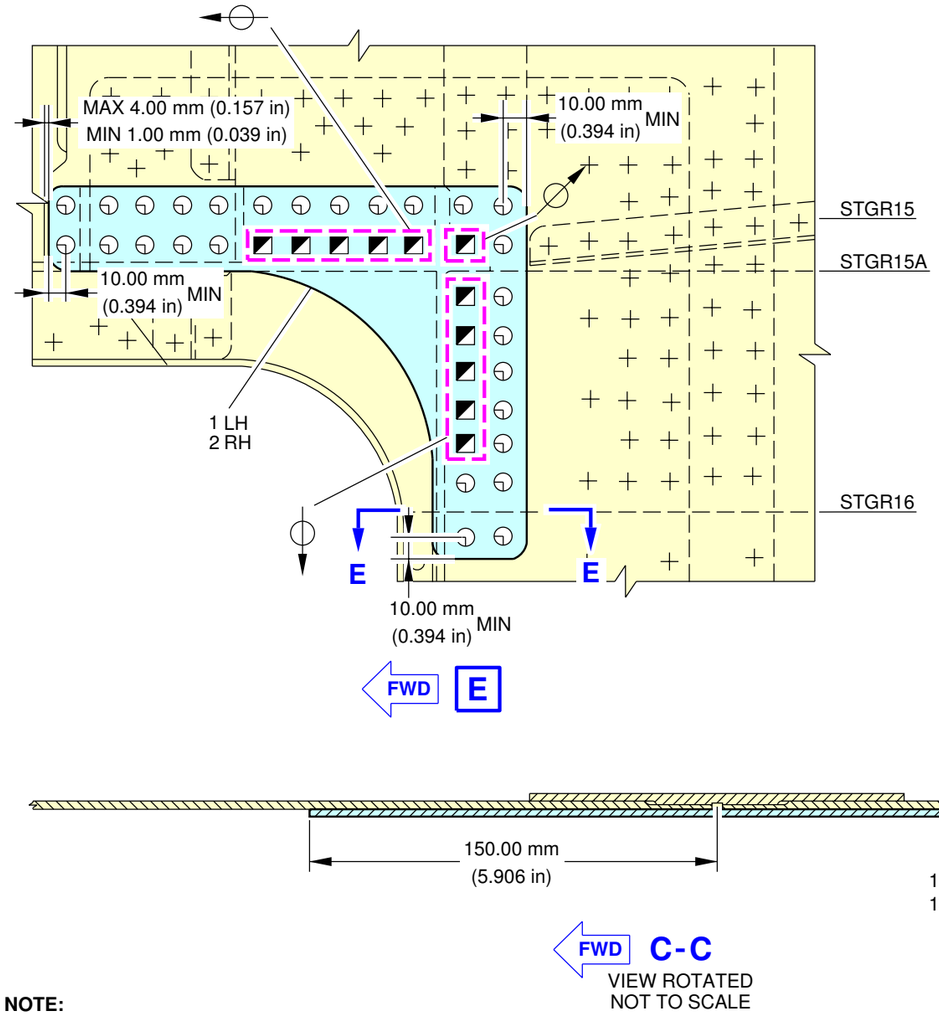
02 MINIMUM EDGE DISTANCE AT SKIN BELOW DOUBLER.

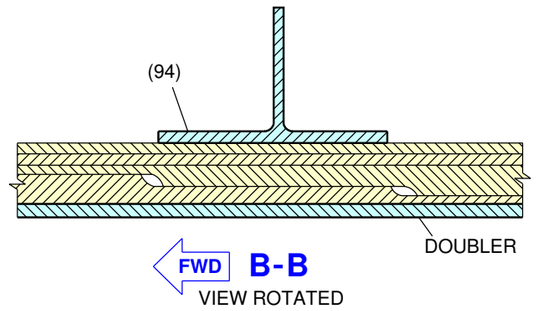
G_SB_533226_6_BCAC_04_07

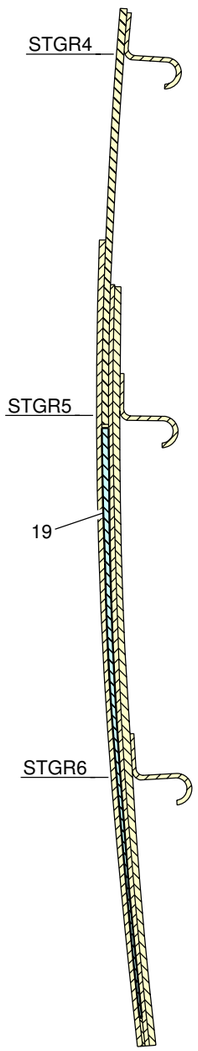
Figure A-GBCAC - Sheet 04
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

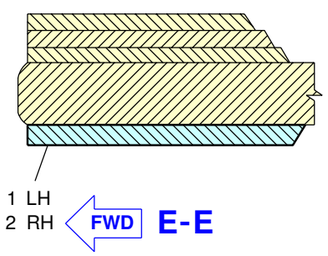
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**CONF 003









NOTE:

- FASTENERS NOT AFFECTED.
- POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.
- AREA OF COLD WORKING.

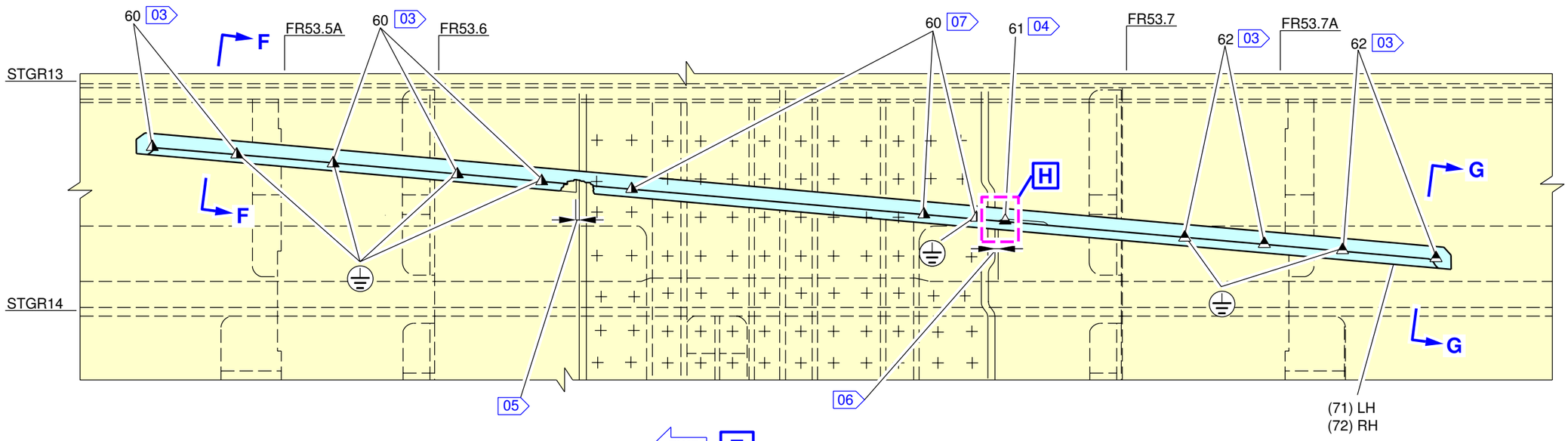
REFER TO SHEETS 9 AND 10 FOR THE APPLICABLE FASTENERS AND NOTES.

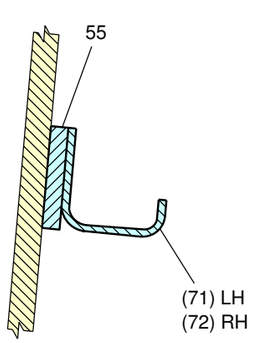
G_SB_533226_6_BCAC_05_05

Figure A-GBCAC - Sheet 05
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

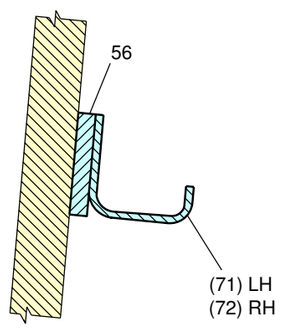
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**CONF 003

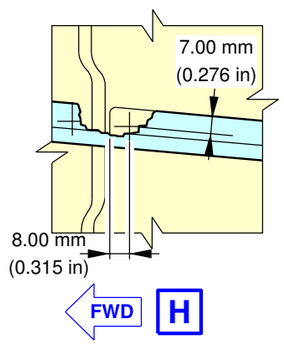




F-F
VIEW LOOKING AFT



G-G
VIEW LOOKING AFT



NOTE:

┼ FASTENERS NOT AFFECTED.

REFER TO SHEETS 9 FOR THE APPLICABLE FASTENERS AND NOTES.

03 THESE RIVETS FIX ONLY THE RAIN GUTTER AND SHIM.

04 THIS RIVET FIXES ONLY THE SHIM.

05 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (12 RH) AND THE SHIM ITEM 55 IS 2 mm (0.079 in).

06 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (12 RH) AND THE SHIM ITEM 56 IS 2 mm (0.079 in).

07 THIS FASTENER FIXES RAIN GUTTER AND DOUBLER.

G_SB_533226_6_BCAC_06_06

Figure A-GBCAC - Sheet 06
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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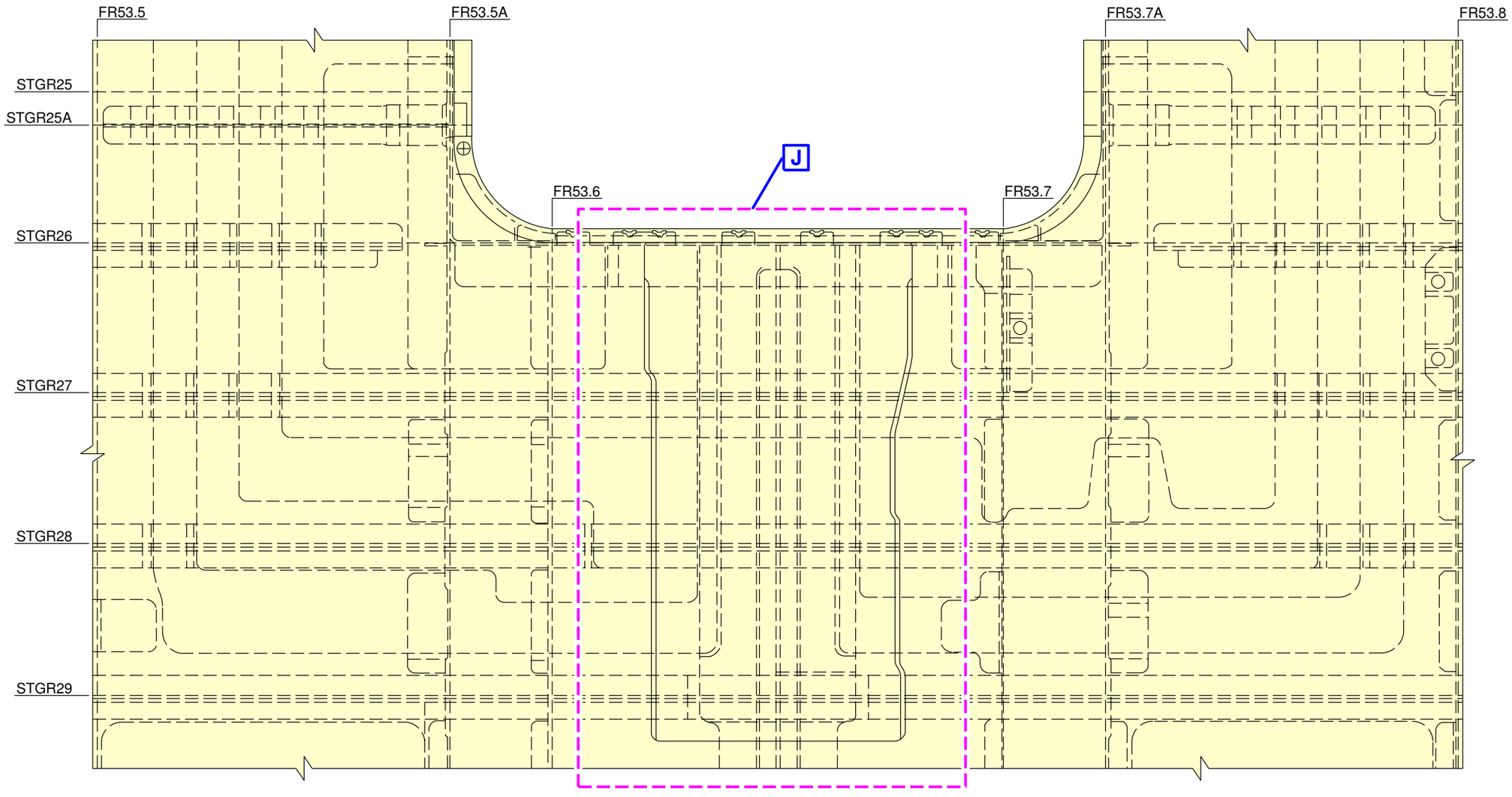
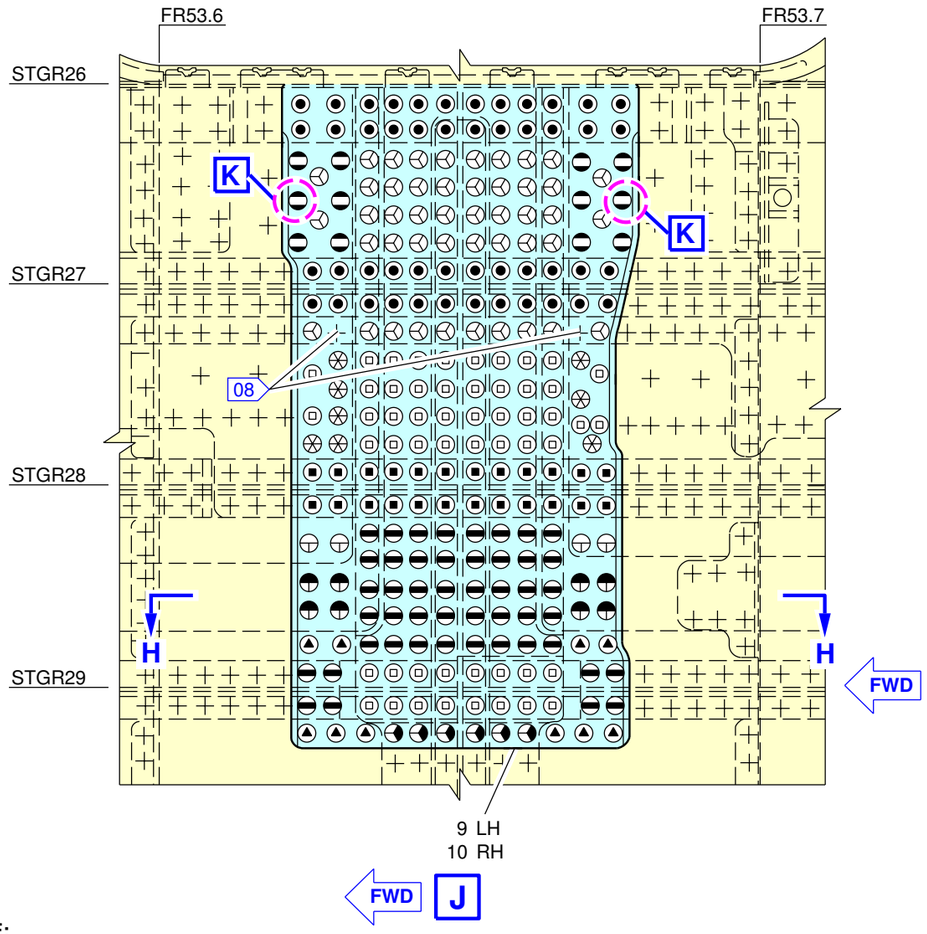
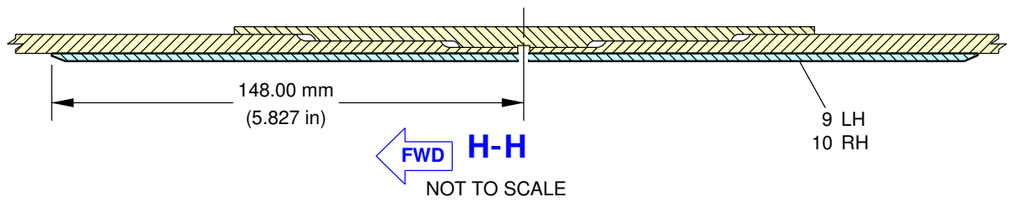


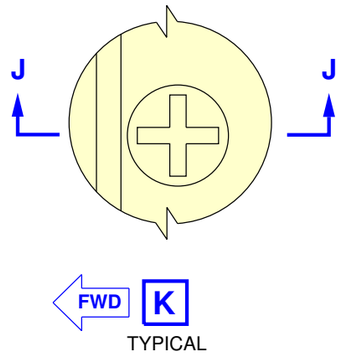
Figure A-GBCAC - Sheet 07
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

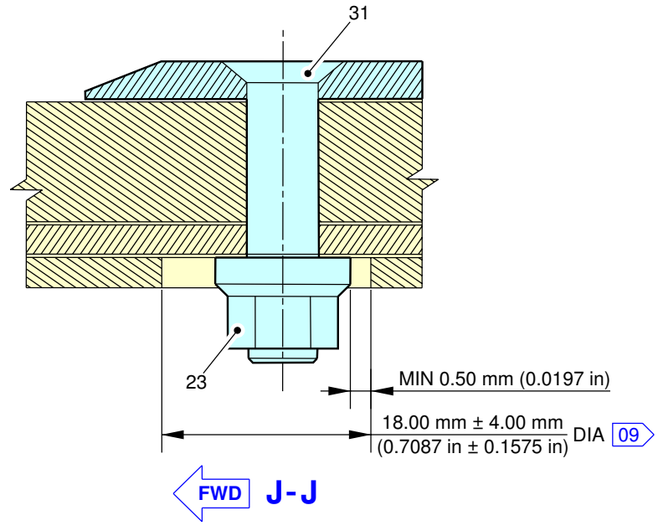
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**CONF 003









NOTE:

+ FASTENERS NOT AFFECTED.

REFER TO SHEETS 9 FOR THE APPLICABLE FASTENERS AND NOTES.

08 FASTENERS ARE COVERED BY DOUBLER.

09 DRILL THROUGH HOLE ONLY IN INNER DOUBLER AND SHIFT MAX TO POSITION OF RIVET BORE.

G_SB_533226_6_BCAC_08_06

Figure A-GBCAC - Sheet 08
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
▲	–	25	EN6114K3–4	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	26	EN6114K3–5	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◓	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◒	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	10
		23	ASNA2528–3	NUT				
⊕	–	28	EN6114K3–7	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
☢	–	29	EN6114K3–8	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊛	–	30	EN6114K3–9	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	31	EN6114K3–10	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◒	–	91	EN6114K3X5	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◑	–	33	EN6114K3X6	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	34	EN6114K3X7	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▽	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	11
		23	ASNA2528–3	NUT				
⊡	–	36	EN6114K3X9	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊗	–	37	EN6114K3X10	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
■	–	92	EN6114K3X11	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
◉	–	38	EN6114K3X12	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◎	–	39	EN6114K3X13	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◵	–	40	EN6114K3X14	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◬	–	41	EN6114K3A7	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	93	EN6114K3A8	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	42	EN6114K3A9	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	43	EN6114K3A10	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
▲	–	44	EN6114K3A11	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
△	–	46	EN6114K3A13	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◭	–	60	EN6081D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
▲	–	61	EN6069D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
▲	–	62	EN6081D5–12	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–

NOTE:

10 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.2 mm.

11 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.4 mm.

G_SB_533226_6_BCAC_09_04

Figure A-GBCAC - Sheet 09
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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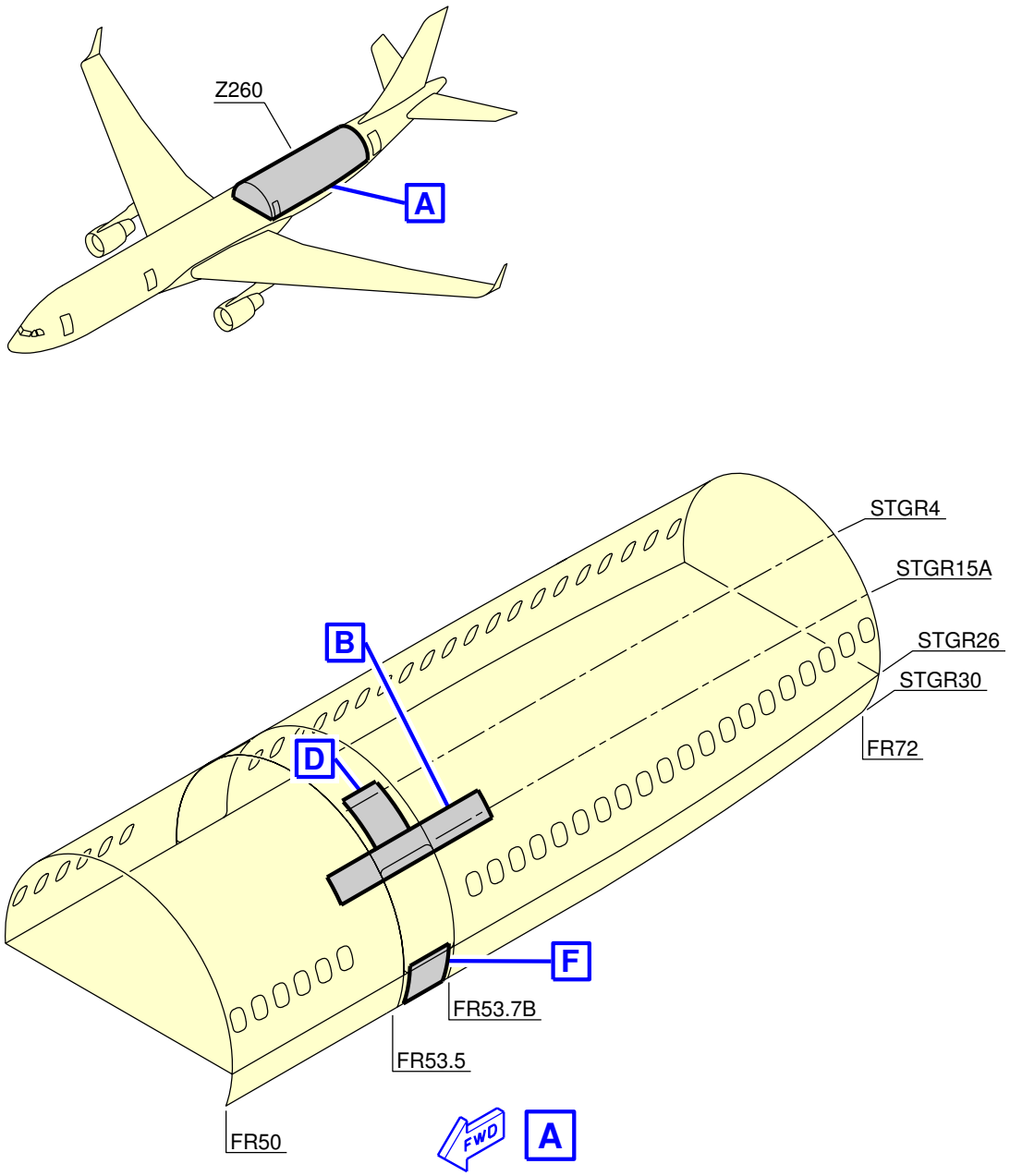
COLD WORKED HOLES											
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
⊠	–	46	EN6114K3A13	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	47	EN6114K3A14	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							

G_SB_533226_6_BCAC_10_04

Figure A-GBCAC - Sheet 10
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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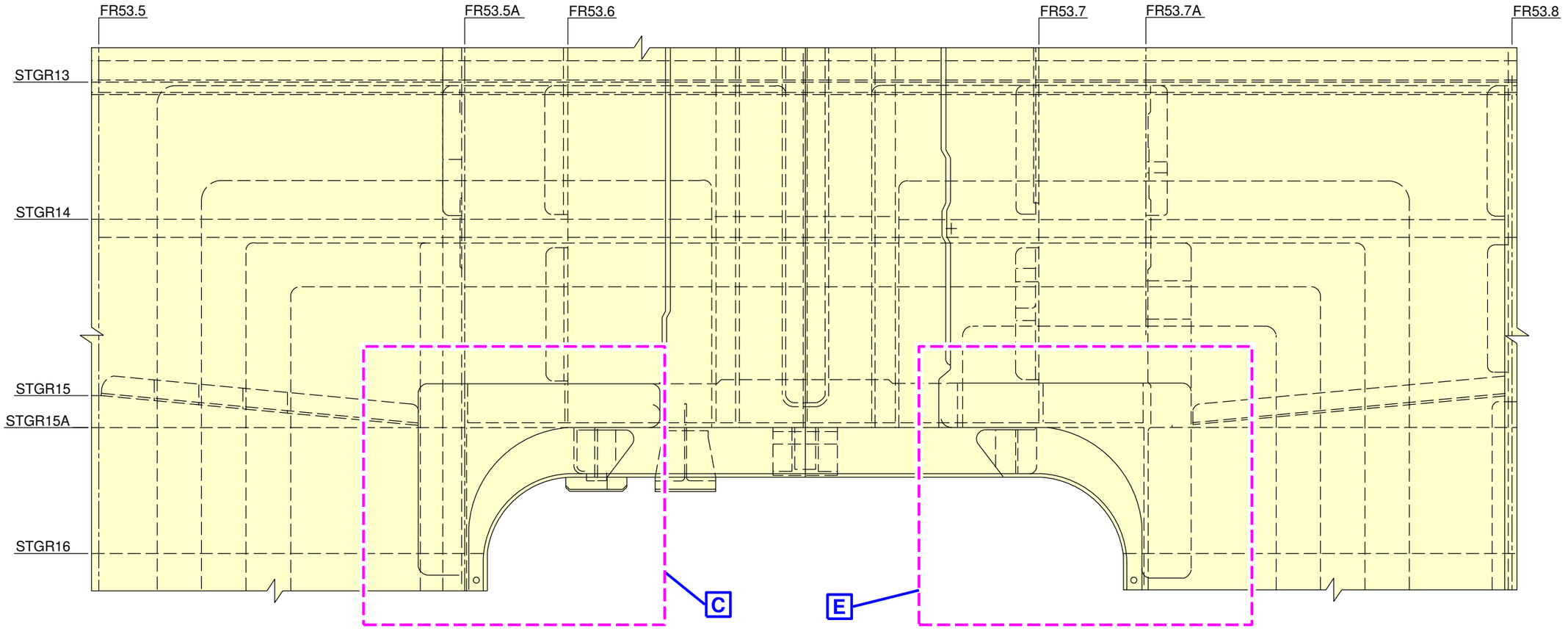


G_SB_533226_6_BCAD_01_03

Figure A-GBCAD - Sheet 01
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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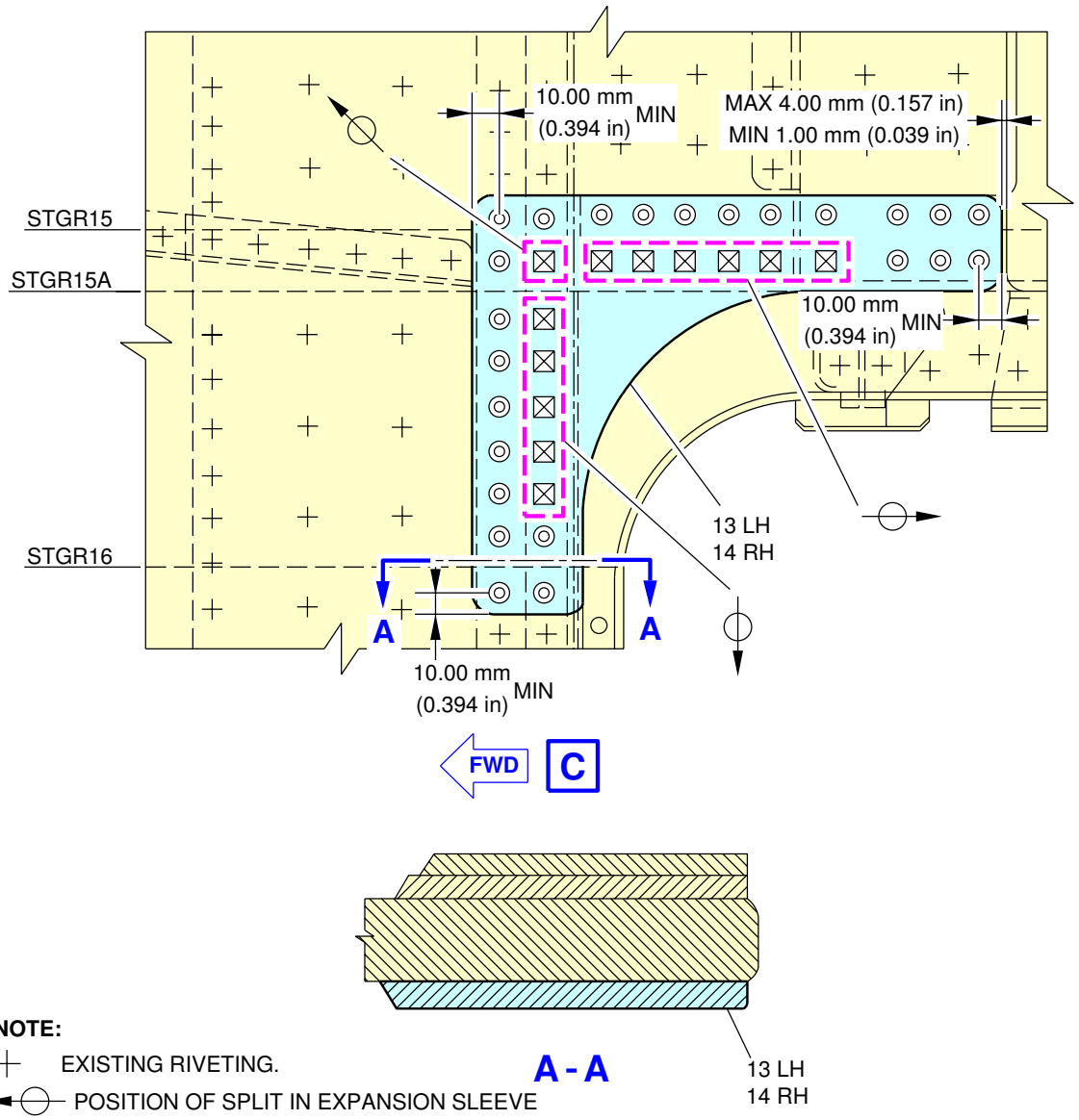
LH SHOWN
RH SYMMETRICAL

G_SB_533226_6_BCAD_02_01

Figure A-GBCAD - Sheet 02
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

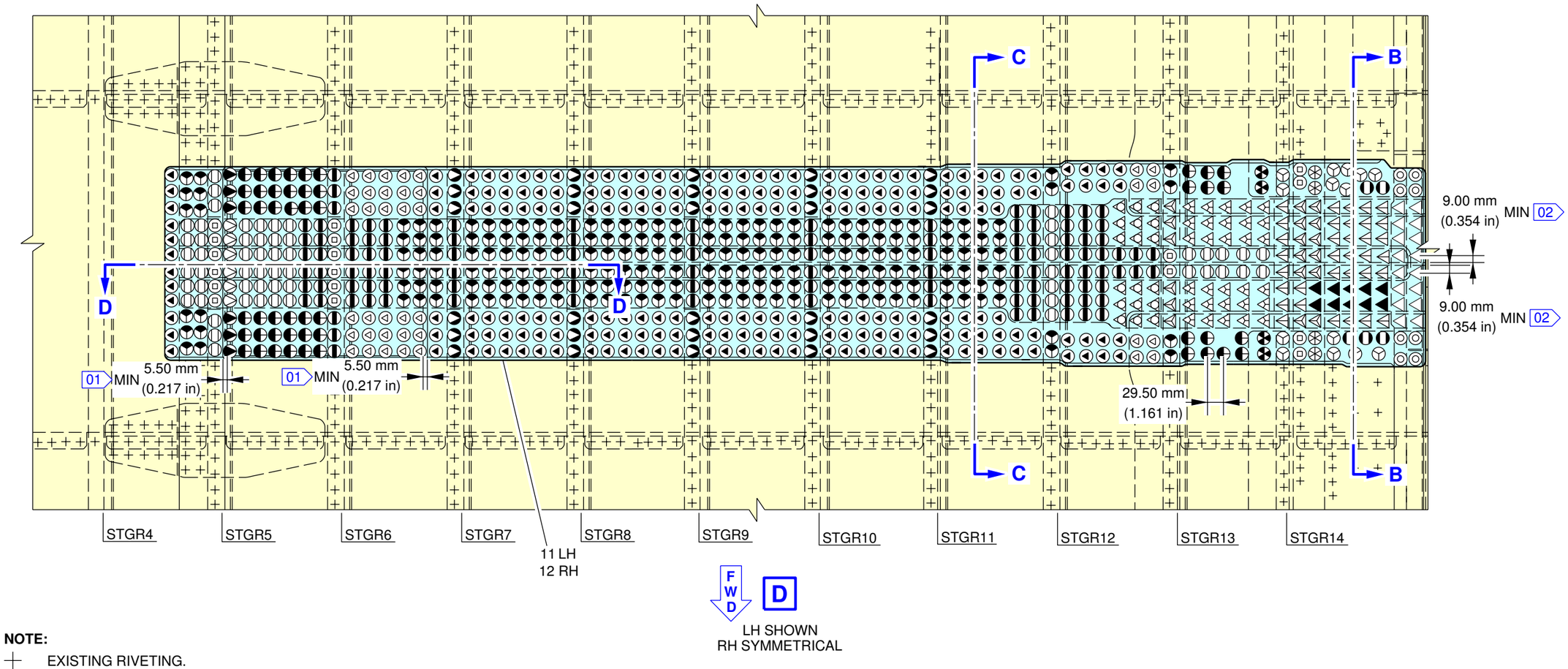
REFER TO SHEETS 8 AND 9 FOR THE APPLICABLE FASTENERS AND NOTES.

G_SB_533226_6_BCAD_03_06

Figure A-GBCAD - Sheet 03
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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NOTE:

┼ EXISTING RIVETING.

REFER TO SHEETS 8 FOR THE APPLICABLE FASTENERS AND NOTES.

01 MINIMUM EDGE DISTANCE FOR THE UPPER AND LOWER ROW OF FASTENERS AT THE SHIM ITEM 19.

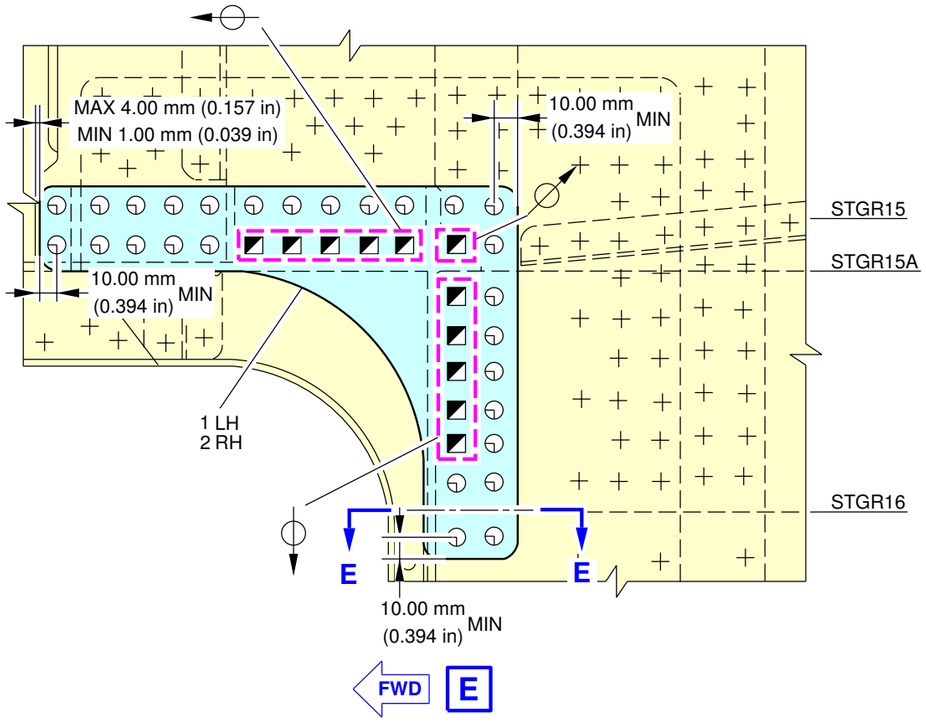
02 MINIMUM EDGE DISTANCE AT SKIN BELOW DOUBLER.

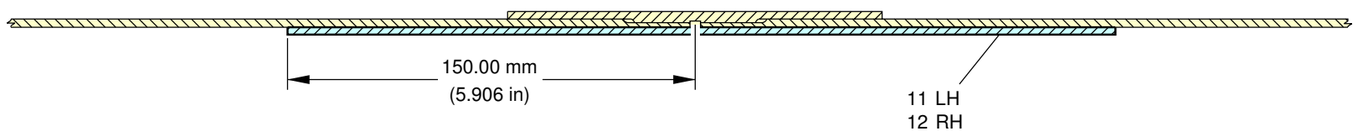
G_SB_533226_6_BCAD_04_09

Figure A-GBCAD - Sheet 04
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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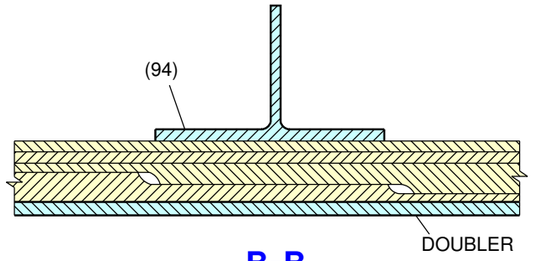
**CONF 004



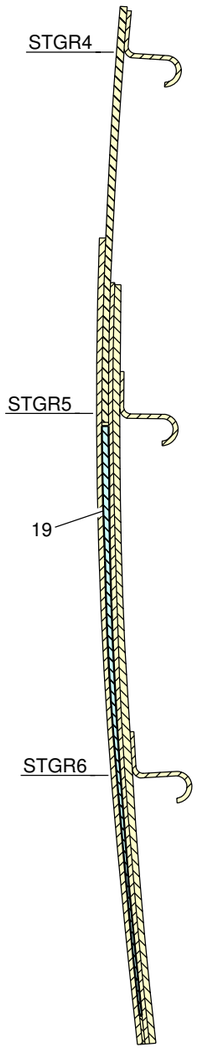


C-C

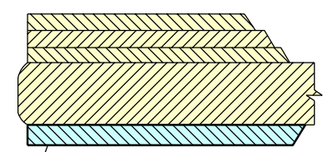
NOT TO SCALE



B-B



D-D



E-E

NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 8 AND 9 FOR THE APPLICABLE FASTENERS AND NOTES.

G_SB_533226_6_BCAD_05_06

Figure A-GBCAD - Sheet 05
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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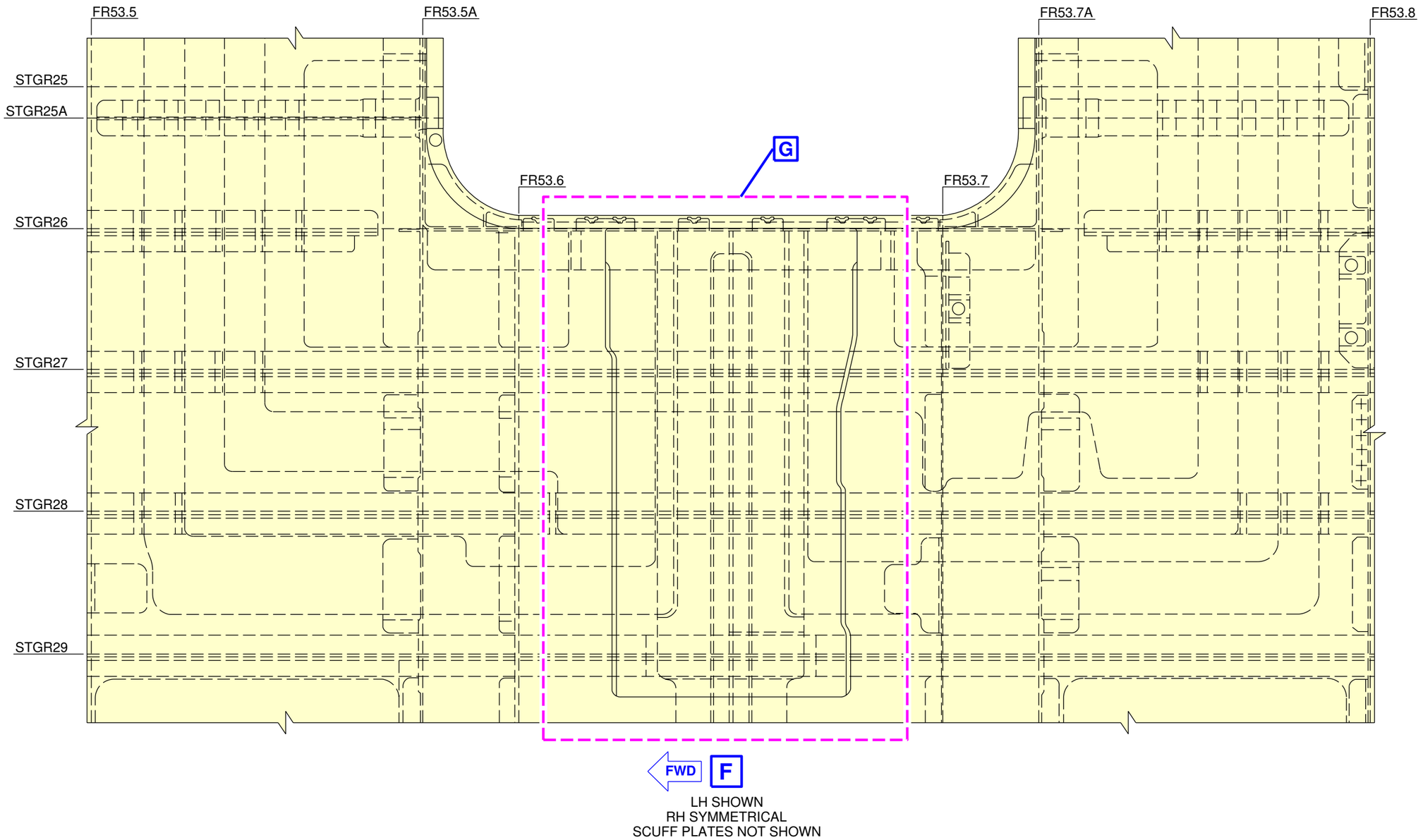
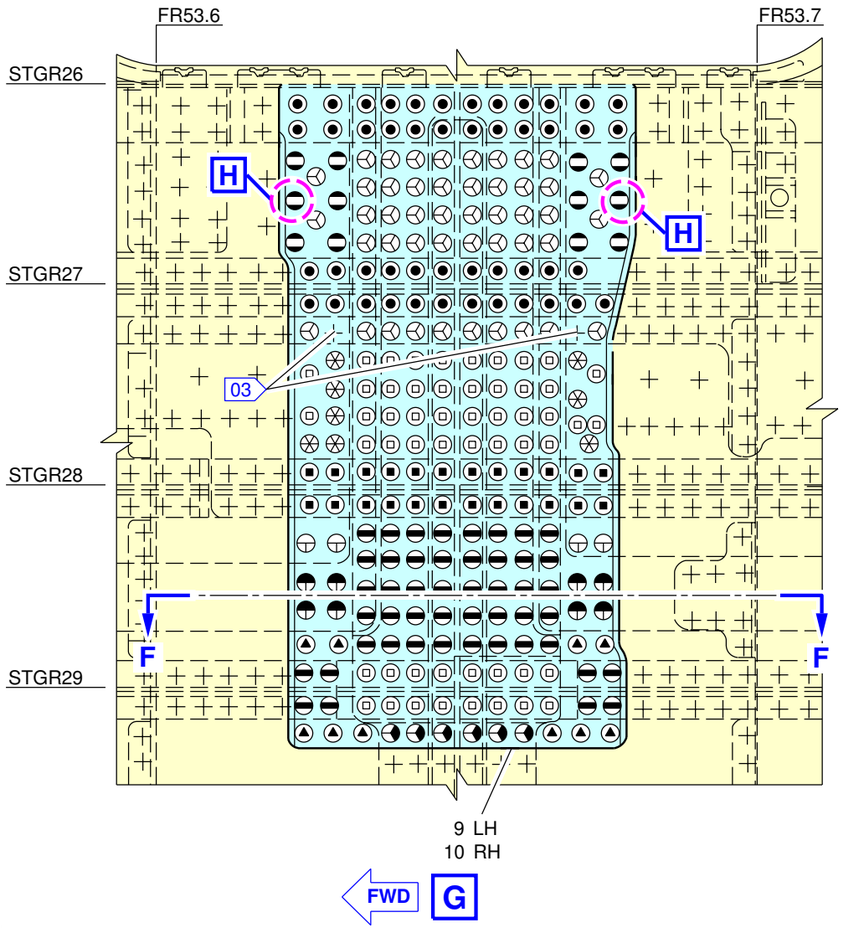
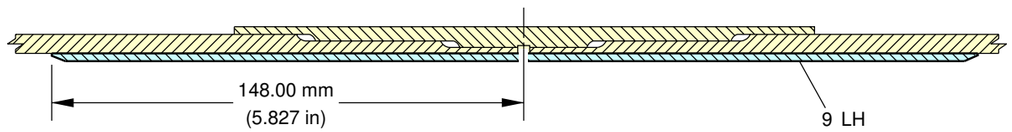


Figure A-GBCAD - Sheet 06
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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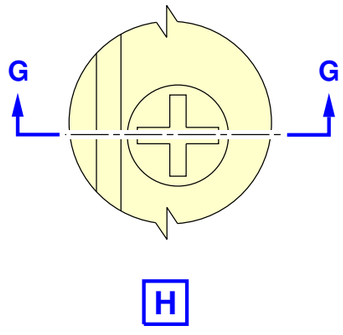
**CONF 004

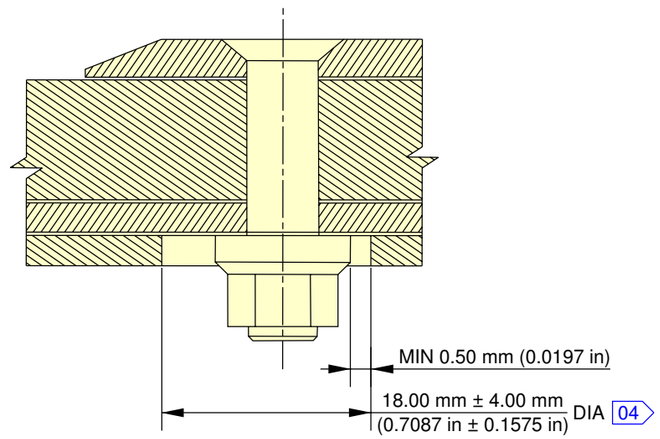




F-F

NOT TO SCALE





G-G

NOTE:

┼ EXISTING RIVETING.

REFER TO SHEETS 8 FOR THE APPLICABLE FASTENERS AND NOTES.

03 FASTENERS ARE COVERED BY DOUBLER.

04 DRILL THROUGH HOLE ONLY IN INNER DOUBLER AND SHIFT MAX TO POSITION OF RIVET BORE.

G_SB_533226_6_BCAD_07_06

Figure A-GBCAD - Sheet 07
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 004

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
▲	–	25	EN6114K3–4	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	26	EN6114K3–5	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◓	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◒	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	05
		23	ASNA2528–3	NUT				
⊕	–	28	EN6114K3–7	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
☢	–	29	EN6114K3–8	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊛	–	30	EN6114K3–9	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	31	EN6114K3–10	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◒	–	91	EN6114K3X5	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◑	–	33	EN6114K3X6	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	34	EN6114K3X7	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▽	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	06
		23	ASNA2528–3	NUT				
⊡	–	36	EN6114K3X9	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊘	–	37	EN6114K3X10	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
■	–	92	EN6114K3X11	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
◉	–	38	EN6114K3X12	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◎	–	39	EN6114K3X13	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◵	–	40	EN6114K3X14	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◬	–	41	EN6114K3A7	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	93	EN6114K3A8	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	42	EN6114K3A9	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
◬	–	43	EN6114K3A10	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
▲	–	44	EN6114K3A11	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				
△	–	46	EN6114K3A13	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT				

NOTE:

05 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.2 mm.

06 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.4 mm.

G_SB_533226_6_BCAD_08_04

Figure A-GBCAD - Sheet 08
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 004

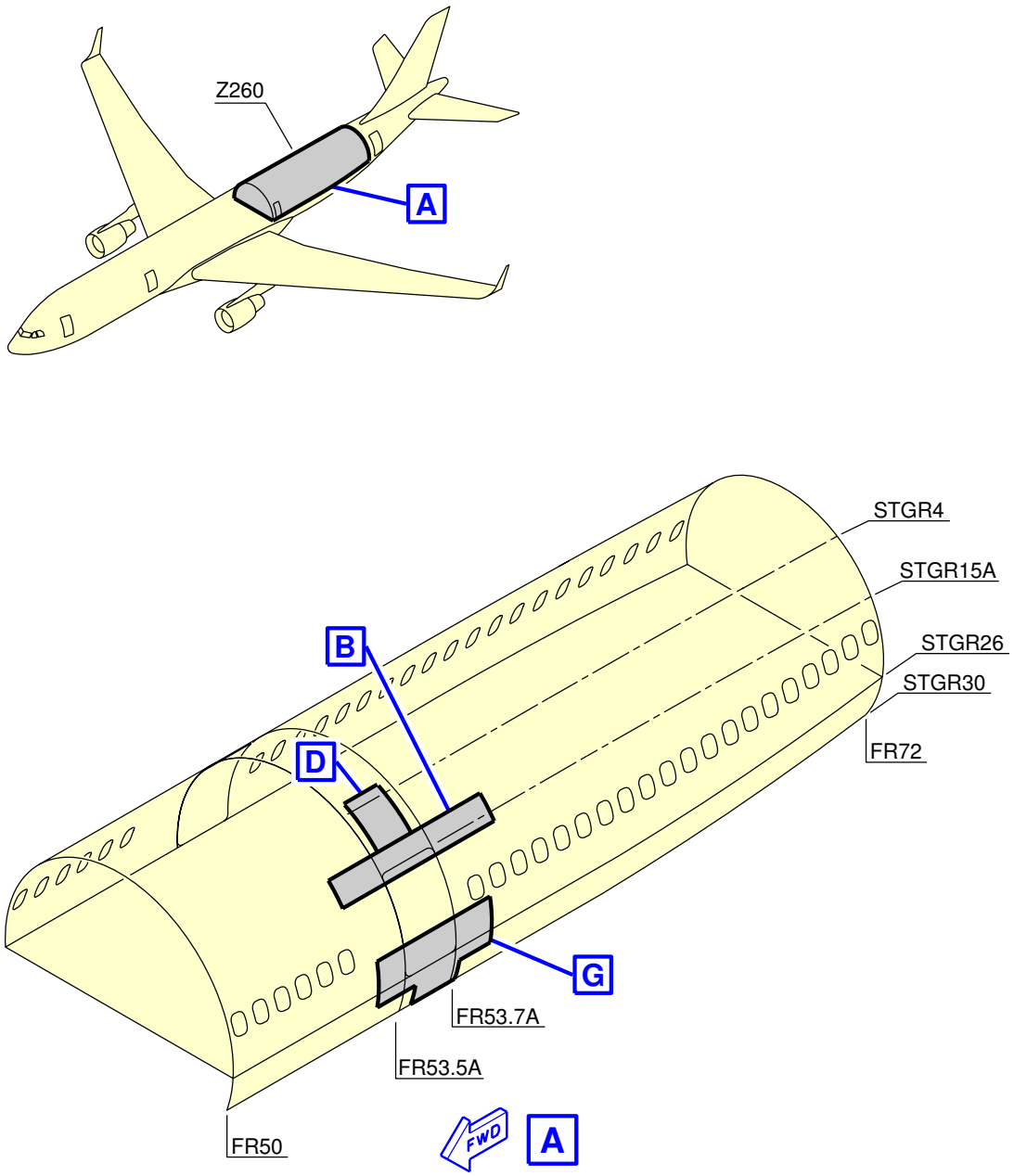
COLD WORKED HOLES											
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
⊠	–	46	EN6114K3A13	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	47	EN6114K3A14	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							

G_SB_533226_6_BCAD_09_04

Figure A-GBCAD - Sheet 09
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005



G_SB_533226_6_BCAE_01_01

Figure A-GBCAE - Sheet 01
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005

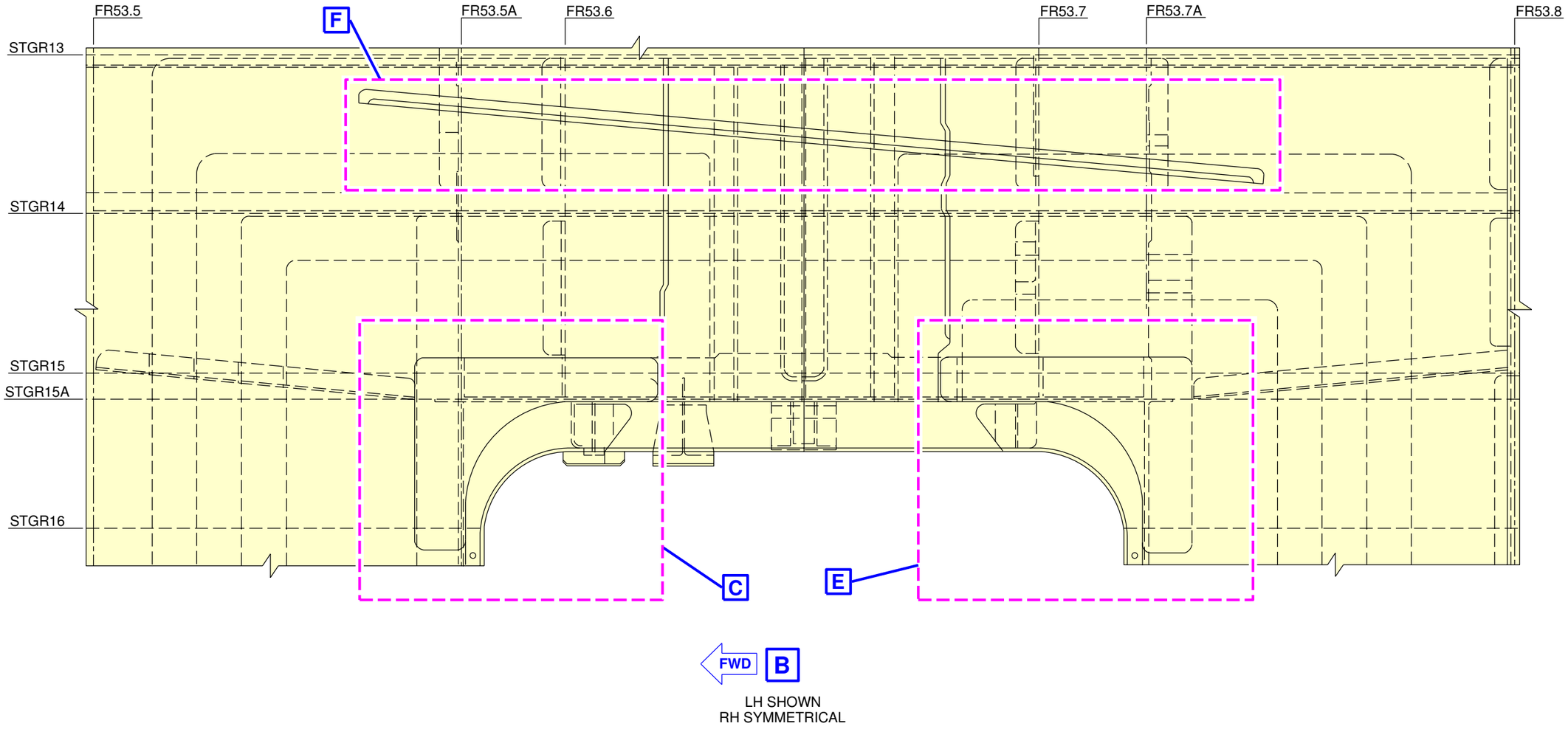
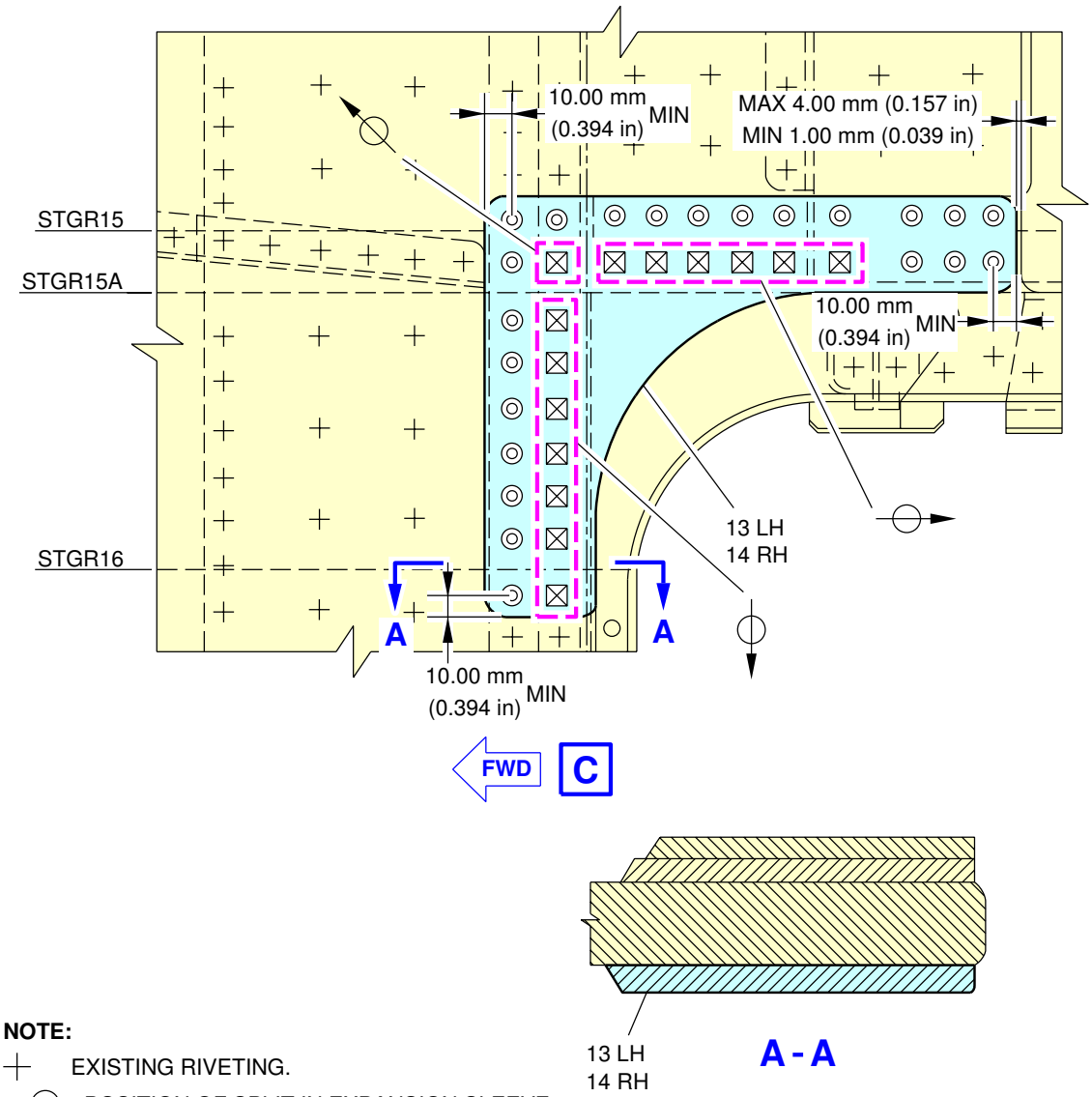


Figure A-GBCAE - Sheet 02
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005



NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

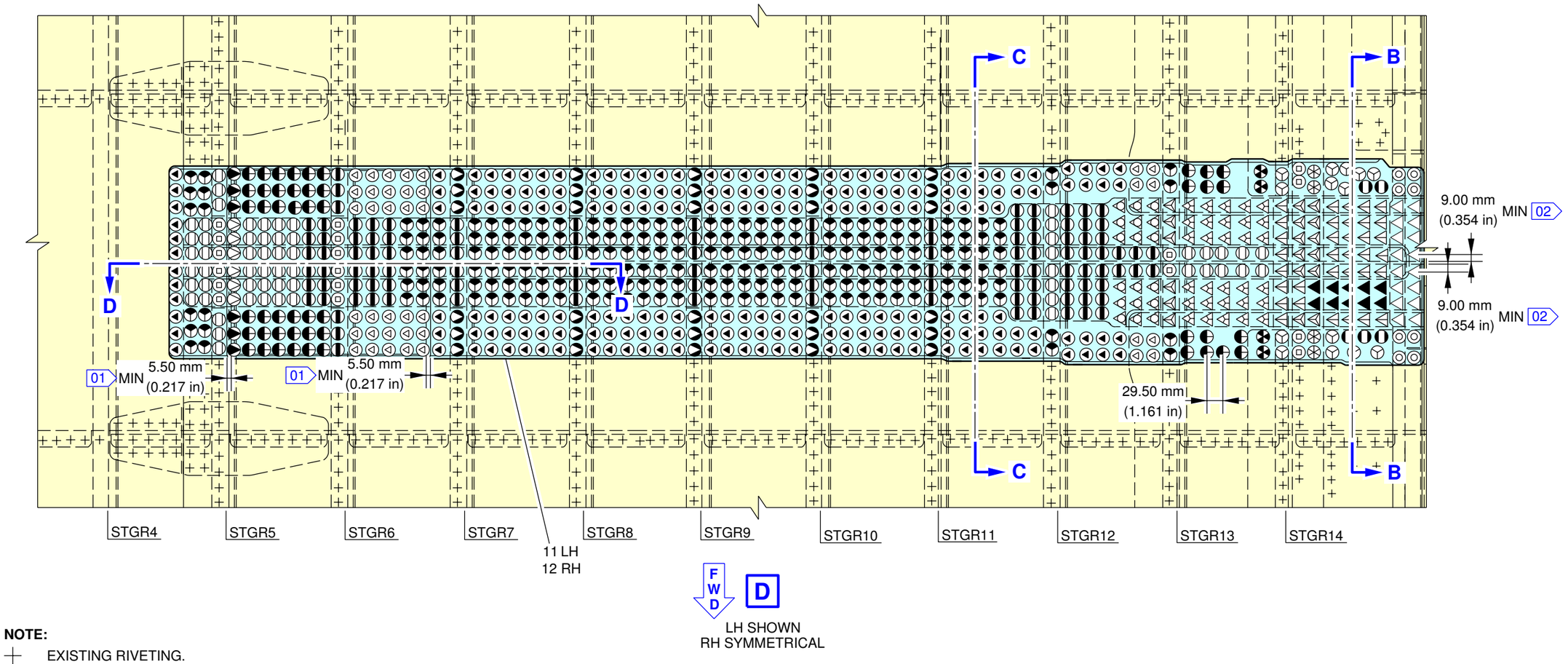
REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

G_SB_533226_6_BCAE_03_00

Figure A-GBCAE - Sheet 03
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005



NOTE:

┼ EXISTING RIVETING.

REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

01 MINIMUM EDGE DISTANCE FOR THE UPPER AND LOWER ROW OF FASTENERS AT THE SHIM ITEM 19.

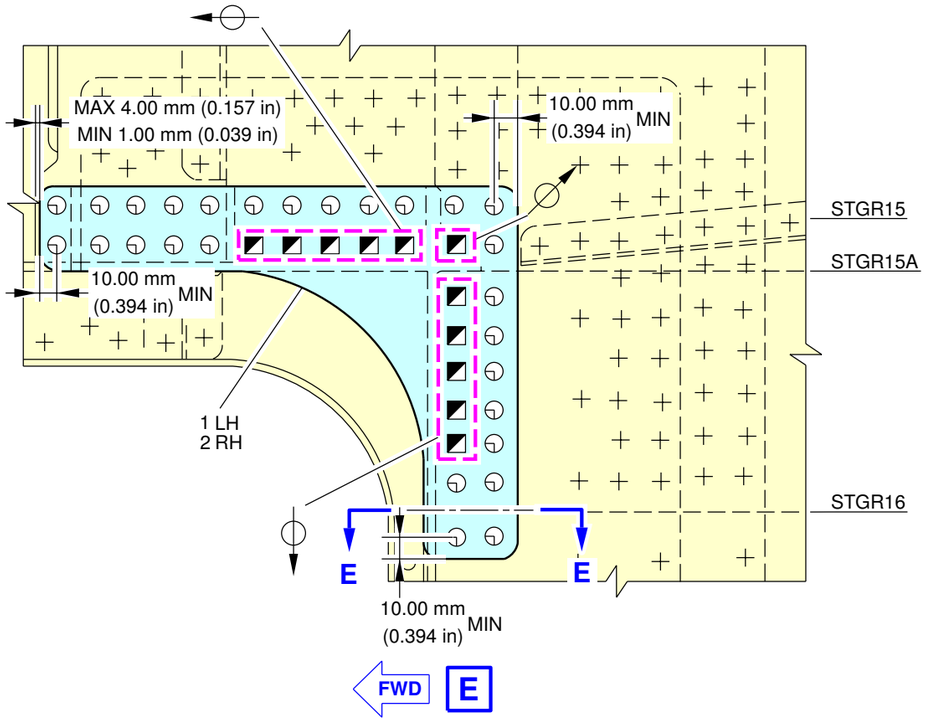
02 MINIMUM EDGE DISTANCE AT SKIN BELOW DOUBLER.

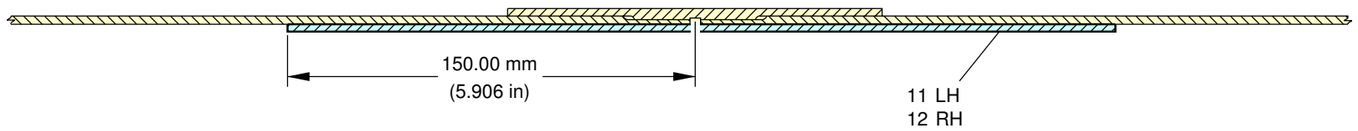
G_SB_533226_6_BCAE_04_00

Figure A-GBCAE - Sheet 04
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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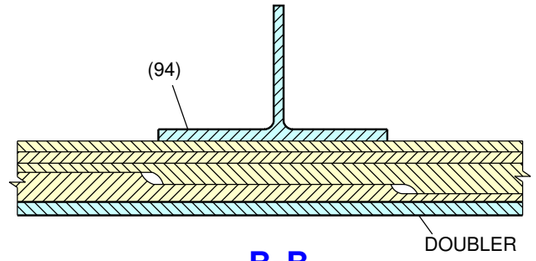
**CONF 005



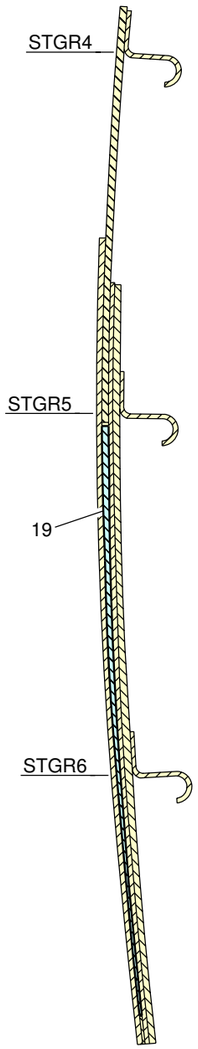


C-C

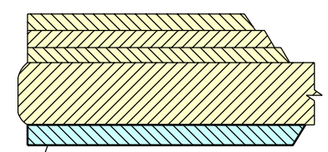
NOT TO SCALE



B-B



D-D



E-E

NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

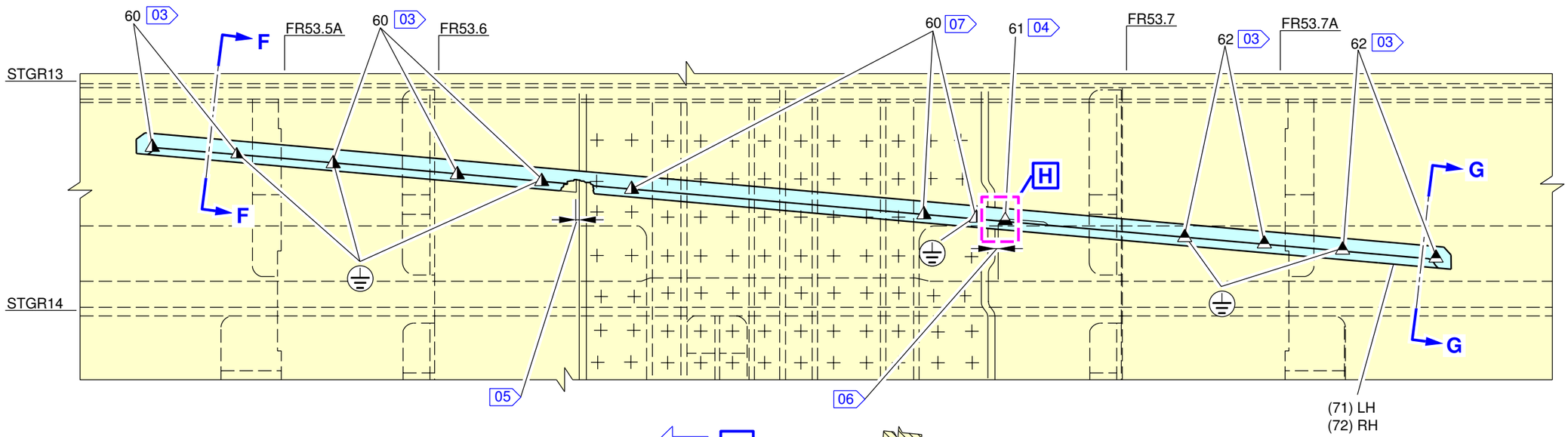
REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

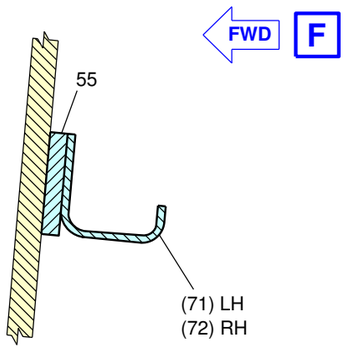
G_SB_533226_6_BCAE_05_00

Figure A-GBCAE - Sheet 05
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

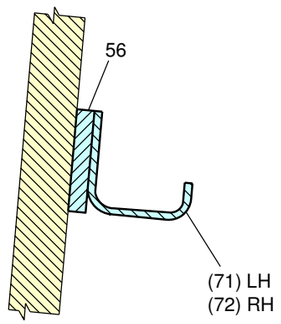
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**CONF 005

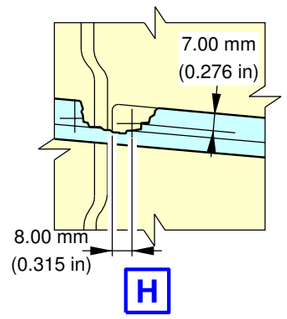




F-F



G-G



NOTE:

┼ EXISTING RIVETING.

REFER TO SHEET 11 FOR THE APPLICABLE FASTENERS AND NOTES.

03 THESE RIVETS FIX ONLY THE RAIN GUTTER AND SHIM.

04 THIS RIVET FIXES ONLY THE SHIM.

05 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (ITEM 12 RH) AND THE SHIM ITEM 55 IS 2 mm (0.079 in).

06 DISTANCE BETWEEN THE DOUBLER ITEM 11 LH (ITEM 12 RH) AND THE SHIM ITEM 56 IS 2 mm (0.079 in).

07 THIS FASTENER FIXES RAIN GUTTER AND DOUBLER.

G_SB_533226_6_BCAE_06_00

Figure A-GBCAE - Sheet 06
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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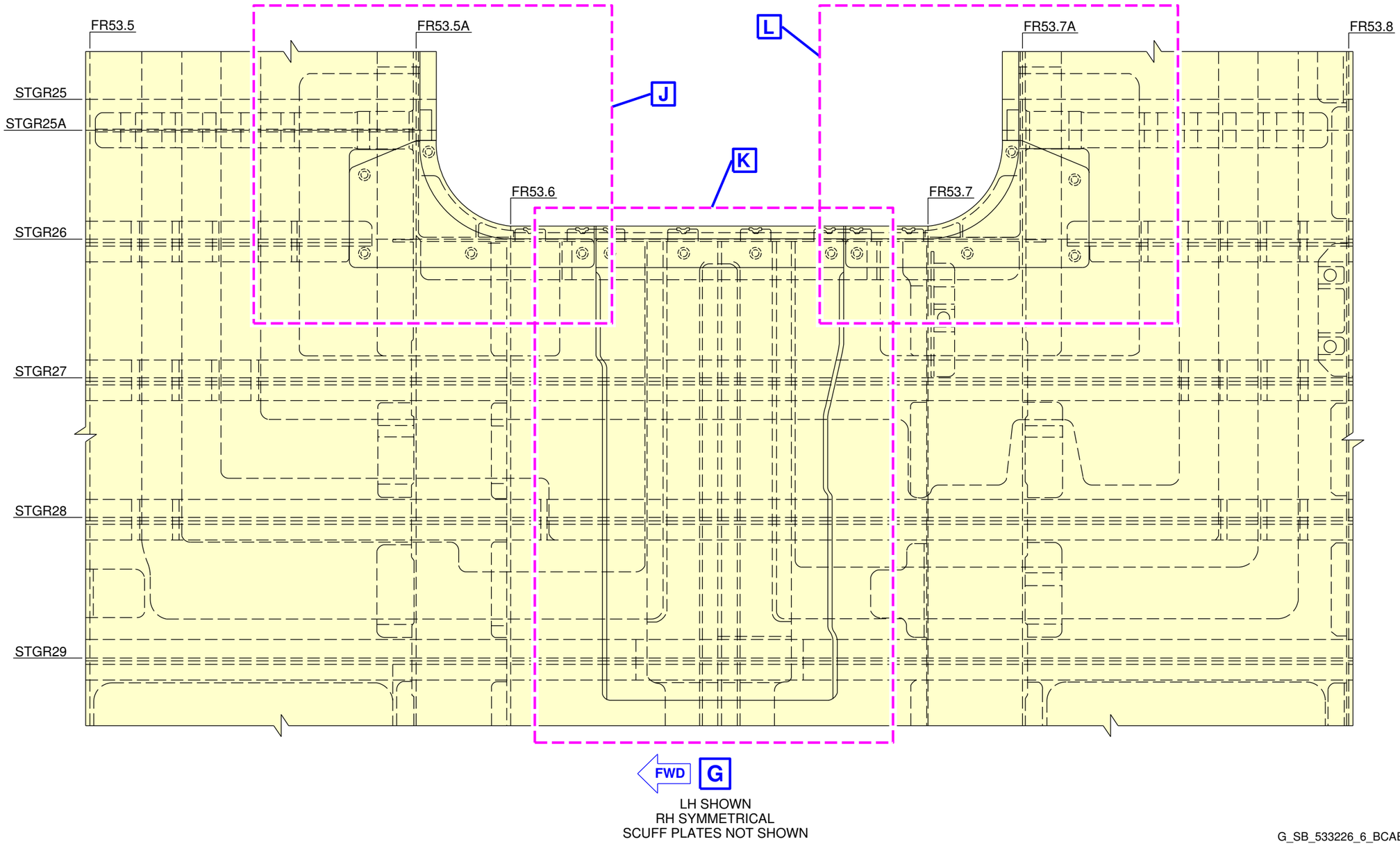
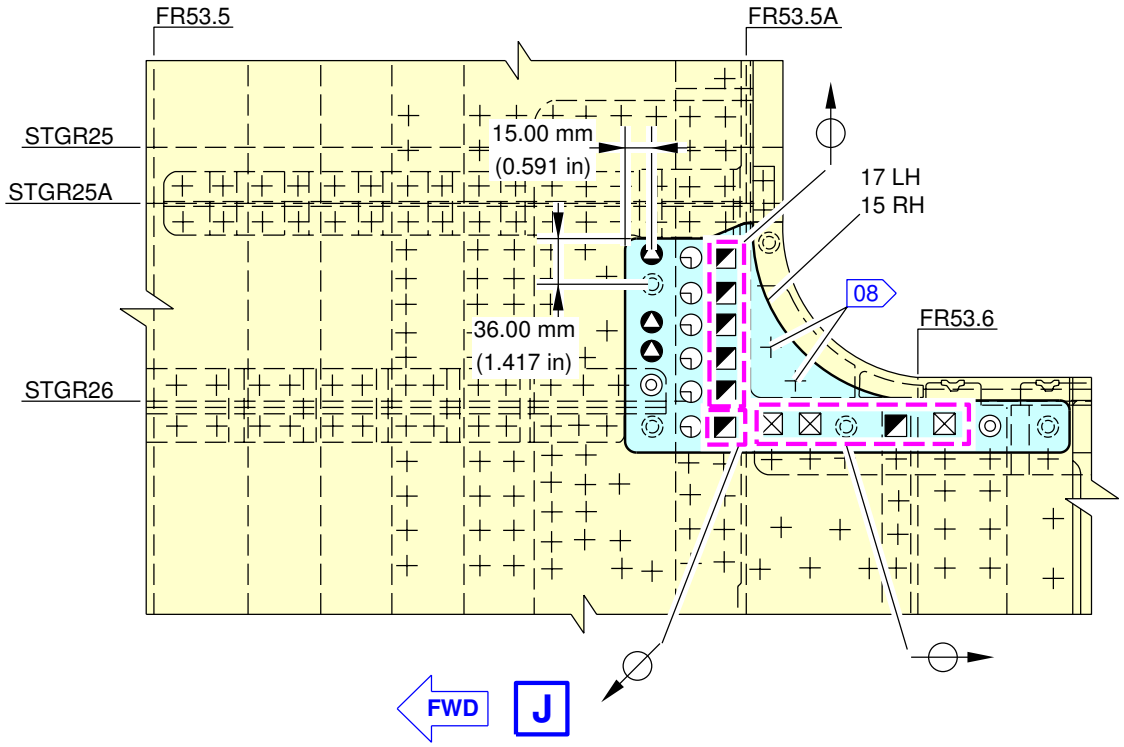


Figure A-GBCAE - Sheet 07
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005



NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

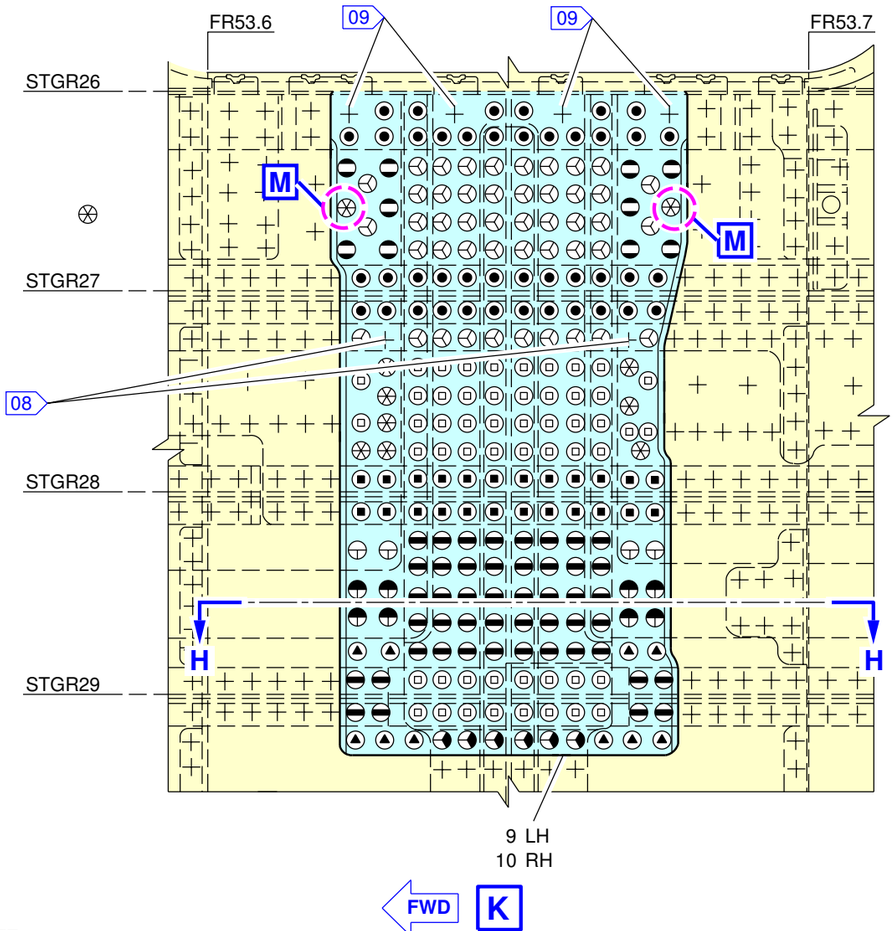
08 RIVETS ARE COVERED BY DOUBLER.

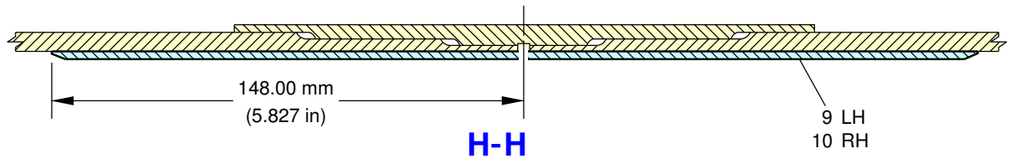
G_SB_533226_6_BCAE_08_00

Figure A-GBCAE - Sheet 08
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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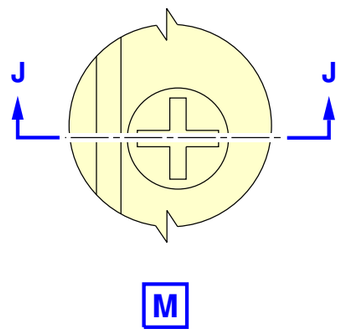
**CONF 005

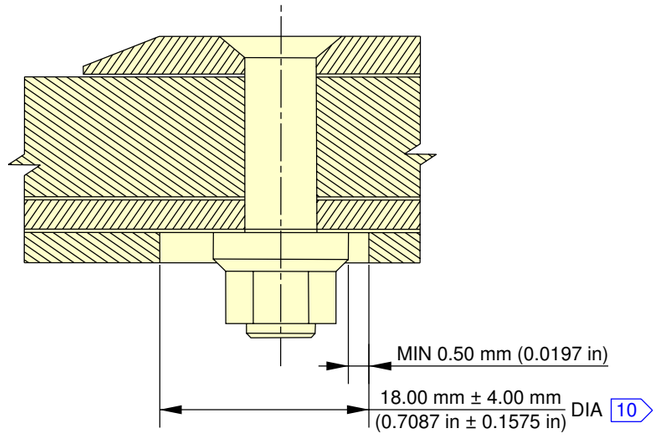




H-H

NOT TO SCALE





J-J

NOTE:
REFER TO SHEET11 FOR THE APPLICABLE FASTENERS AND NOTES.

08 RIVETS ARE COVERED BY DOUBLER.

09 A HOLE OF DIAMETER 7 mm HAS TO BE DRILLED FOR SCUFF PLATE INSTALLATION.

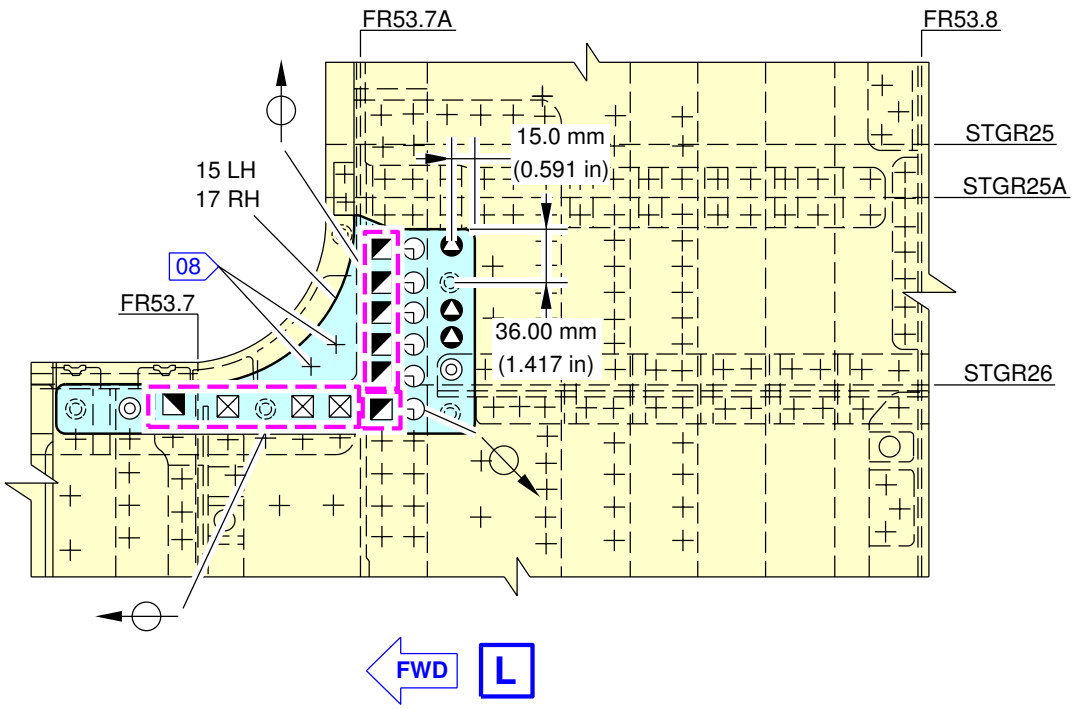
10 DRILL THROUGH HOLE ONLY IN INNER DOUBLER AND SHIFT MAX TO POSITION OF RIVET BORE.

G_SB_533226_6_BCAE_09_00

Figure A-GBCAE - Sheet 09
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005



NOTE:

EXISTING RIVETING.

POSITION OF SPLIT IN EXPANSION SLEEVE DURING COLD EXPANSION.

AREA OF COLD WORKING.

REFER TO SHEETS 11 AND 12 FOR THE APPLICABLE FASTENERS AND NOTES.

08 RIVETS ARE COVERED BY DOUBLER.

G_SB_533226_6_BCAE_10_00

Figure A-GBCAE - Sheet 10
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
▲	–	25	EN6114K3–4	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	26	EN6114K3–5	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◓	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▼	–	27	EN6114K3–6	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	11
		23	ASNA2528–3	NUT				
⊖	–	28	EN6114K3–7	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
☢	–	29	EN6114K3–8	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊛	–	30	EN6114K3–9	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	31	EN6114K3–10	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▲	–	32	EN6114K3–11	BOLT	4.723 mm (0.1860 in)	4.758 mm (0.1870 in)	NOMINAL SIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▼	–	91	EN6114K3X5	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◑	–	33	EN6114K3X6	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	34	EN6114K3X7	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
⊖	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
▽	–	35	EN6114K3X8	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	12
		23	ASNA2528–3	NUT				
⊡	–	36	EN6114K3X9	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◁	–	37	EN6114K3X10	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
■	–	92	EN6114K3X11	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				

NON–COLD WORKED HOLES								
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	FINAL HOLE DIAMETER MIN	FINAL HOLE DIAMETER MAX	SIZE / FIT TYPE	NOTE
●	–	38	EN6114K3X12	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◎	–	39	EN6114K3X13	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
◵	–	40	EN6114K3X14	BOLT	5.056 mm (0.1990 in)	5.090 mm (0.2000 in)	1ST OVERSIZE INTERFERENCE FIT	–
		23	ASNA2528–3	NUT				
△	–	41	EN6114K4X7	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
△	–	93	EN6114K4X8	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
△	–	42	EN6114K4X9	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
△	–	43	EN6114K4X10	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
▲	–	44	EN6114K4X11	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
△	–	46	EN6114K4X13	BOLT	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		94	ASNA2528–4	NUT				
◭	–	60	EN6081D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
▲	–	61	EN6069D5–09	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–
▲	–	62	EN6081D5–12	RIVET	4.060 mm (0.1600 in)	4.170 mm (0.1640 in)	–	–

NOTE:

11 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.2 mm.

12 CLEARED HOLE ONLY IN SHIM ITEM 19 WITH DIAMETER 5.4 mm.

G_SB_533226_6_BCAE_11_00

Figure A-GBCAE - Sheet 11
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF 005

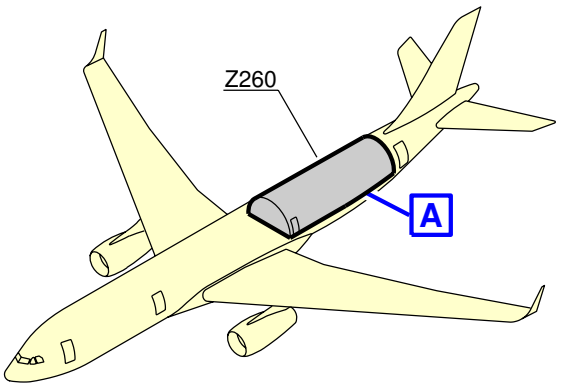
COLD WORKED HOLES											
HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	STDN	STARTING HOLE DIAMETER		FINAL HOLE DIAMETER		SIZE / FIT TYPE	NOTE
						MIN	MAX	MIN	MAX		
⊠	–	95	EN6114K3A13	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◪	–	47	EN6114K3A14	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							
◥	–	48	EN6114K3A15	BOLT	6–1–N	4.880 mm (0.1920 in)	4.950 mm (0.1950 in)	5.452 mm (0.2150 in)	5.487 mm (0.2160 in)	NOMINAL SIZE INTERFERENCE FIT	–
		24	ASNA2528–3A	NUT							

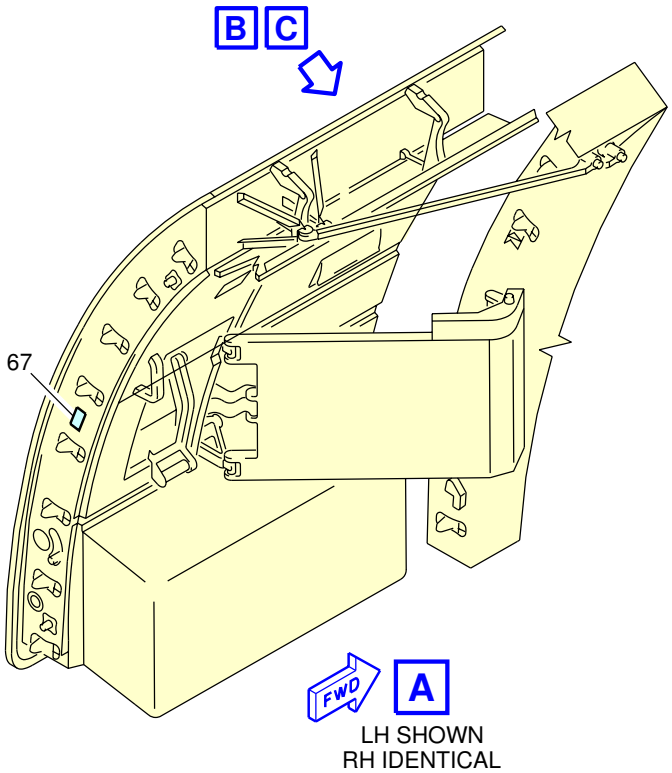
G_SB_533226_6_BCAE_12_00

Figure A-GBCAE - Sheet 12
Reinforcement of the Circumferential Joint and Door Frame between FR53.5 and FR53.8

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**CONF ALL



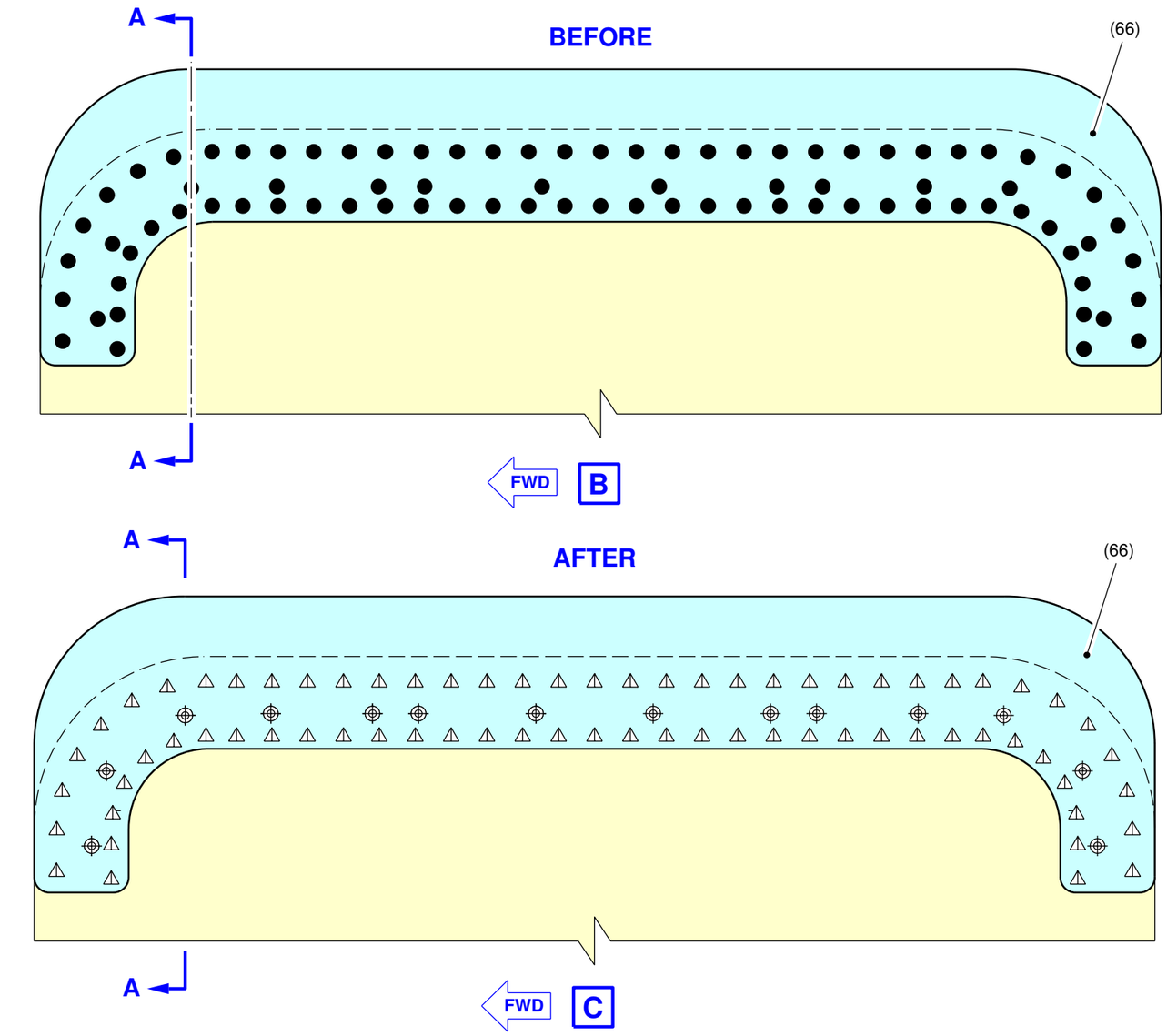


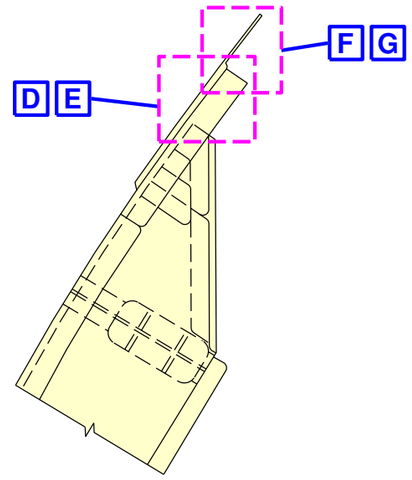
G_SB_533226_6_BDAA_01_02

Figure A-GBDAA - Sheet 01
Modification of the Emergency Exit Door Type 1

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**CONF ALL





A - A
VIEW LOOKING FWD

HOLE SYMBOL	ITEM	PART NUMBER	DESCRIPTION	FINAL HOLE DIAMETER	
				MIN	MAX
⊕	64	NAS1102E3–17	SCREW	—	—
	65	NAS1726C3	NUT		
△	70	DIN65399–4014CF	RIVET	4.06 mm (0.16 in)	4.17 mm (0.164 in)

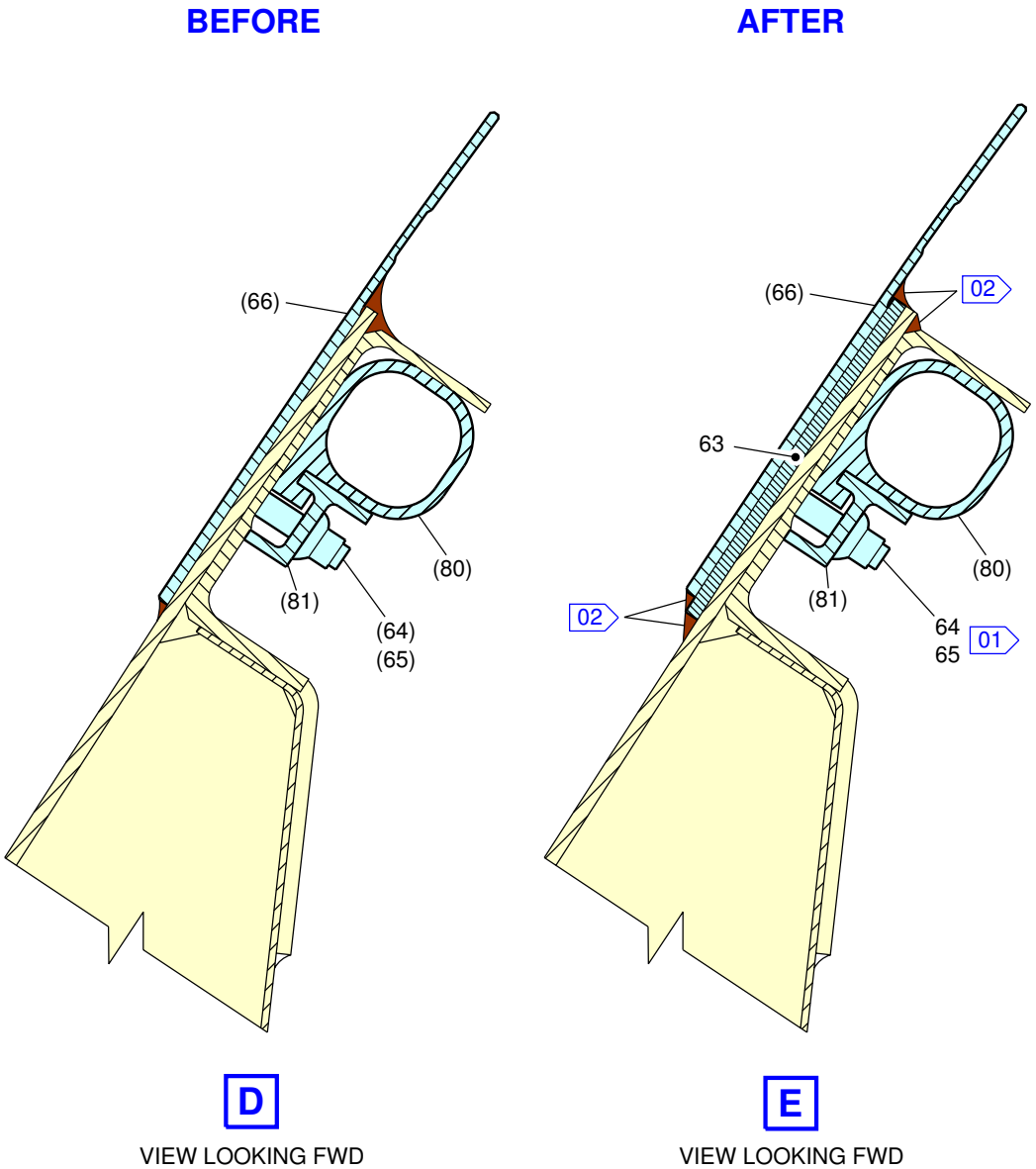
NOTE:
ALL FASTENERS TO BE REMOVED SHOWN THUS ●.

G_SB_533226_6_BDAA_02_05

Figure A-GBDAA - Sheet 02
Modification of the Emergency Exit Door Type 1

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**CONF ALL



NOTE:

01 TORQUE 0.25 – 0.30 daNm.

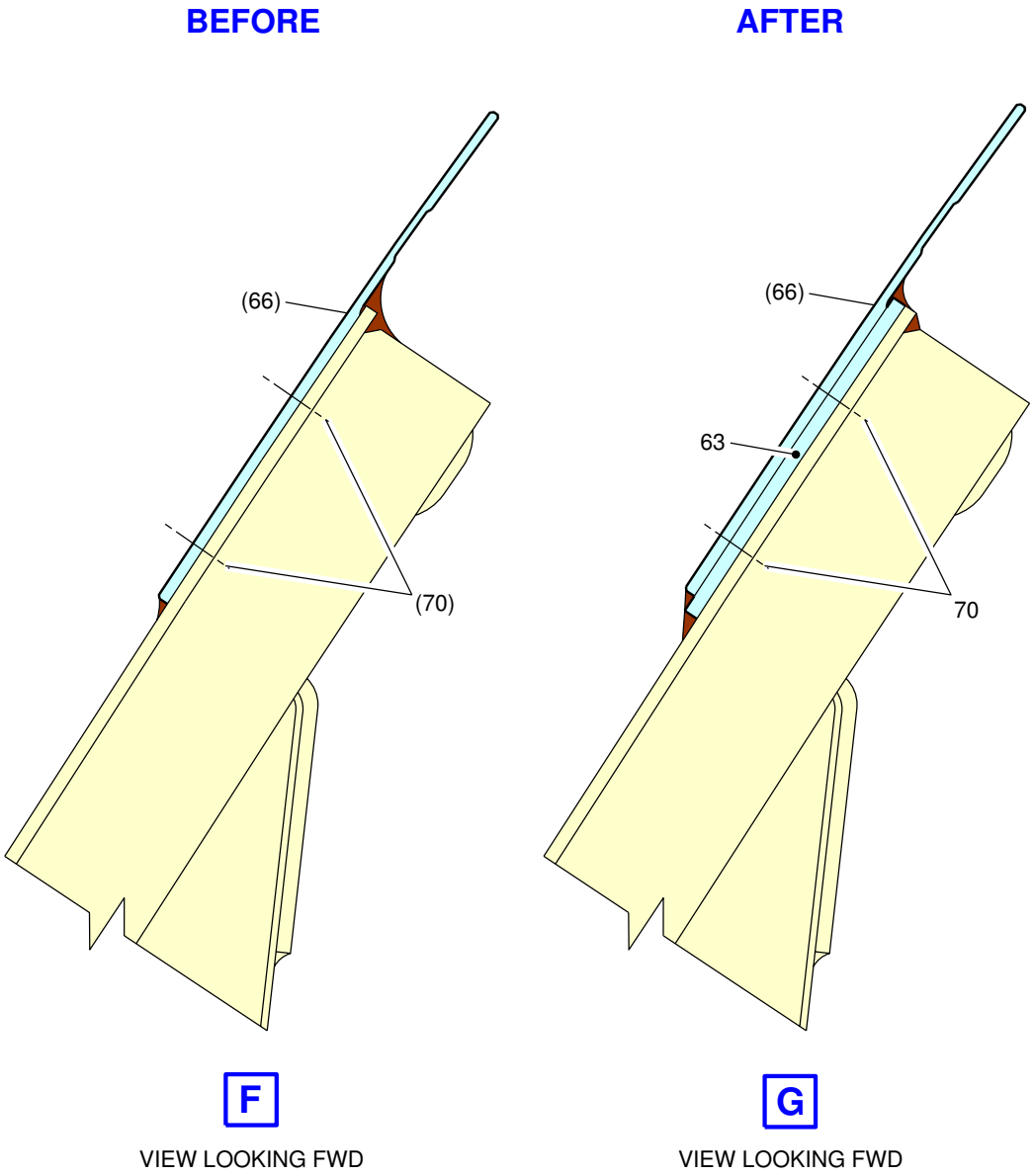
02 EDGE SEALANT MAT. NO. 06AAC1

G_SB_533226_6_BDAA_03_02

Figure A-GBDAA - Sheet 03
Modification of the Emergency Exit Door Type 1

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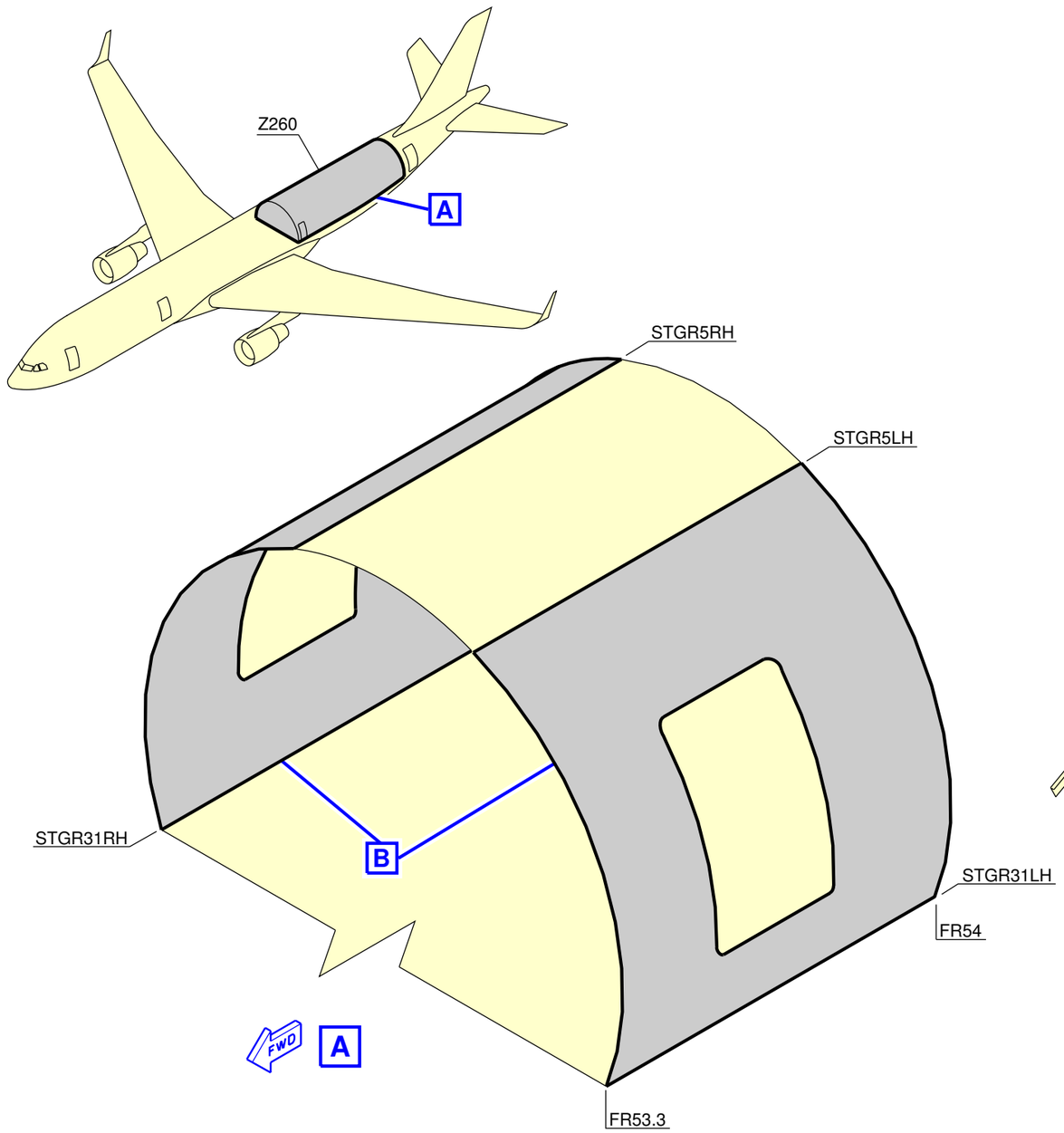


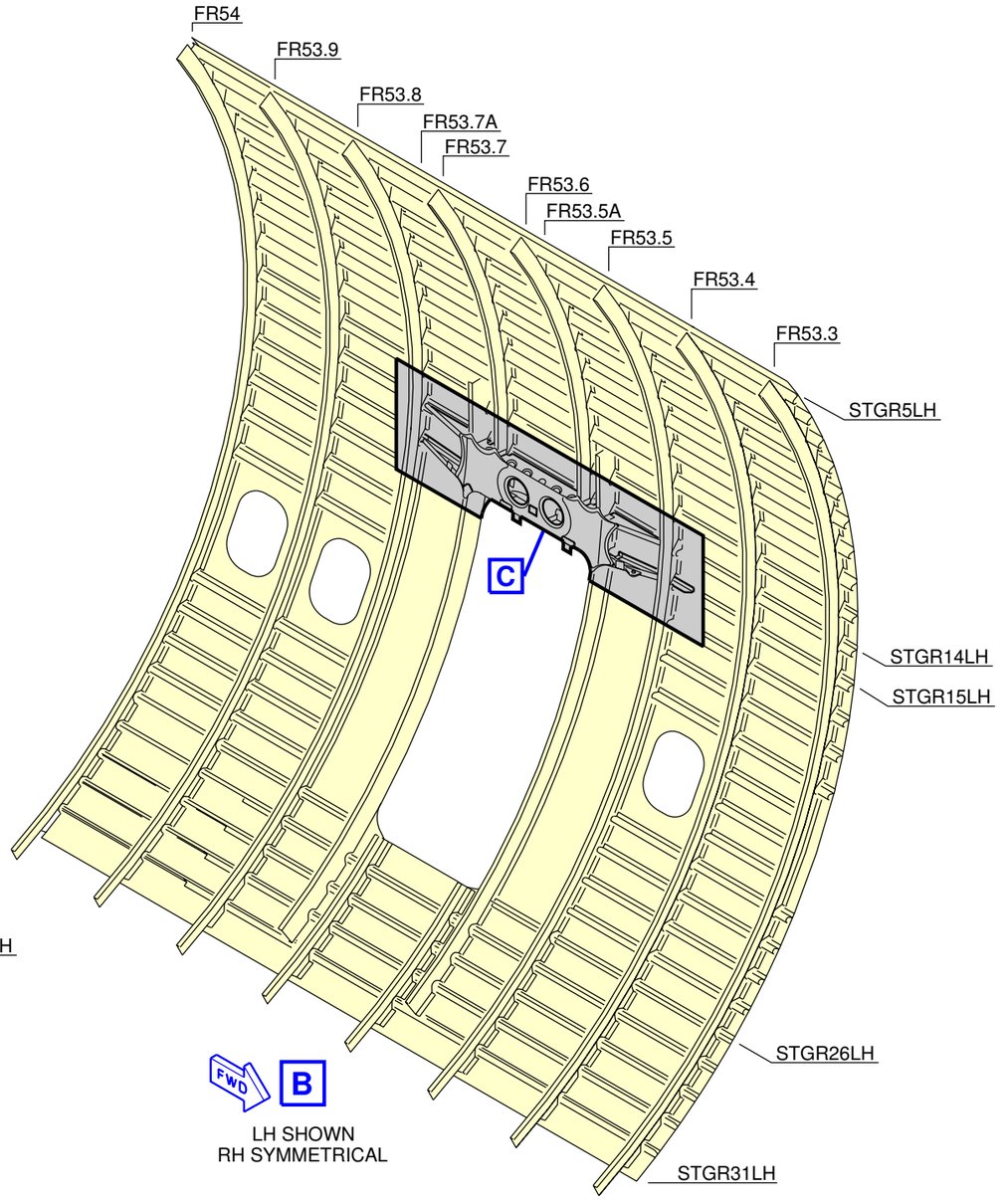
G_SB_533226_6_BDAA_04_04

Figure A-GBDAA - Sheet 04
Modification of the Emergency Exit Door Type 1

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**CONF ALL



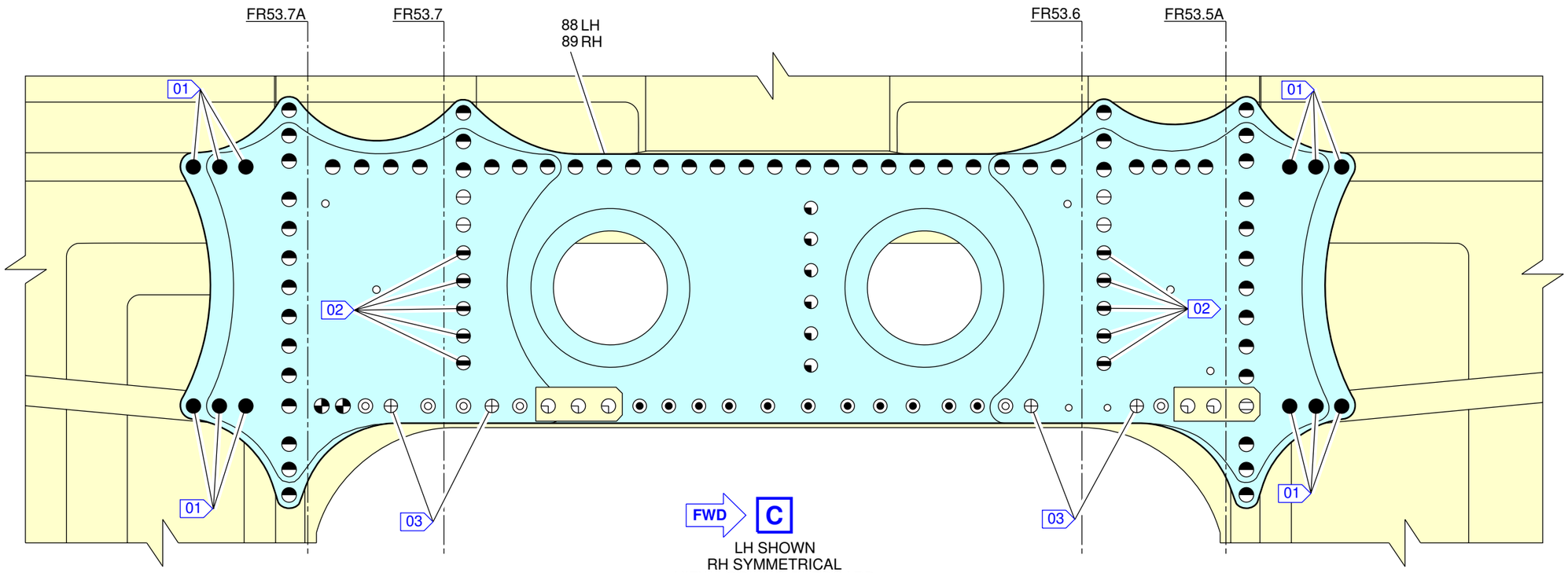


G_SB_533226_6_BEAA_01_02

Figure A-GBEAA - Sheet 01
Remove/Installation of Cross Plate

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**CONF ALL



LH SHOWN
RH SYMMETRICAL
VIEW LOOKING OUTBOARD

HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	NOTE
◓	(74)	74	LN9198–4020CF	RIVET, UNIVERSAL	
●	(75)	75	LN9198–4820CF	RIVET, UNIVERSAL	
◉	(76)	76	ASNA0082–204	BOLT	
⊕	(77)	77	ASNA0081A204	BOLT	
◱	(78)	78	ASNA0082A306	BOLT	
⊖	(79)	79	ASNA0082–207	BOLT	

HOLE SYMBOL	OLD ITEM	NEW ITEM	P/N	DESCRIPTION	NOTE
⊖	(82)	82	ASNA0082A206	BOLT	
◕	(83)	83	ASNA0082–203	BOLT	
◎	(84)	84	NAS6703U4	BOLT	
	(85)	85	AN960XC10LL	WASHER, FLAT	
◕	(86)	86	ASNA0082–205	BOLT	
◓	(87)	87	ASNA0081A206	BOLT	

NOTE:

01 ◓ RIVET SYMBOL ONLY FOR AIRCRAFT UNTIL MSN 122.
02 ⊖ RIVET SYMBOL ONLY FOR AIRCRAFT UNTIL MSN 599.
03 ⊖ RIVET SYMBOL ONLY FOR AIRCRAFT FROM MSN 128 TO MSN 507.

G_SB_533226_6_BEAA_02_06

Figure A-GBEAA - Sheet 02
Remove/Installation of Cross Plate

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**CONF ALL

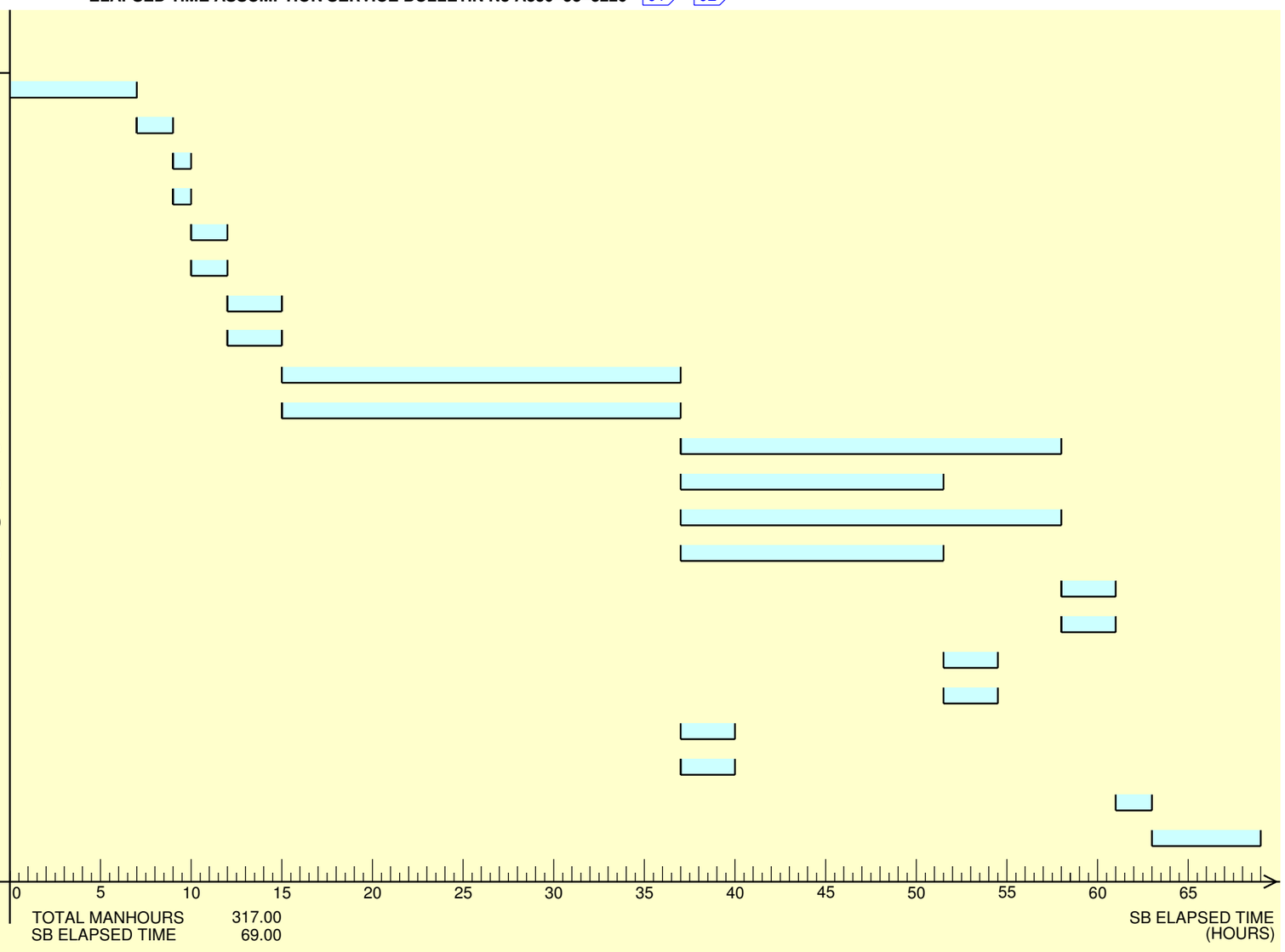
For an explanation of the man-hours and elapsed time, refer to the next page(s).

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**CONF 001 thru 002, 005

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A330–53–3226 01 02

STEPS	MH	PER	ET/S
GET ACCESS	14.00	2	7.00
SPECIAL JACKING	12.00	6	2.00
PERFORM THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA LH	1.00	1	1.00
PERFORM THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA RH	1.00	1	1.00
REMOVE THE SCUFF PLATES OF THE EMERGENCY EXIT DOOR LH	2.00	1	2.00
REMOVE THE SCUFF PLATES OF THE EMERGENCY EXIT DOOR RH	2.00	1	2.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.00	2	3.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.00	2	3.00
MODIFY THE DOOR FRAME OF EMERGENCY EXIT DOOR TYPE 1 LH	38.00	2	22.00
MODIFY THE DOOR FRAME OF EMERGENCY EXIT DOOR TYPE 1 RH	38.00	2	22.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR15 AND STGR4 LH	40.50	2	21.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 LH	28.00	2	14.50
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR15 AND STGR4 RH	40.50	2	21.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 RH	28.00	2	14.50
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.00	2	3.00
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.00	2	3.00
INSTALL THE SCUFF PLATES OF THE EMERGENCY EXIT DOOR LH	6.00	2	3.00
INSTALL THE SCUFF PLATES OF THE EMERGENCY EXIT DOOR RH	3.00	1	3.00
MODIFY THE LH EMERGENCY EXIT DOOR	6.00	2	3.00
MODIFY THE RH EMERGENCY EXIT DOOR	6.00	2	3.00
AIRCRAFT DE–JACKING	12.00	6	2.00
CLOSE–UP	12.00	2	6.00



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

NOTE:

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

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

G_SB_533226_6_AAAA_01_03

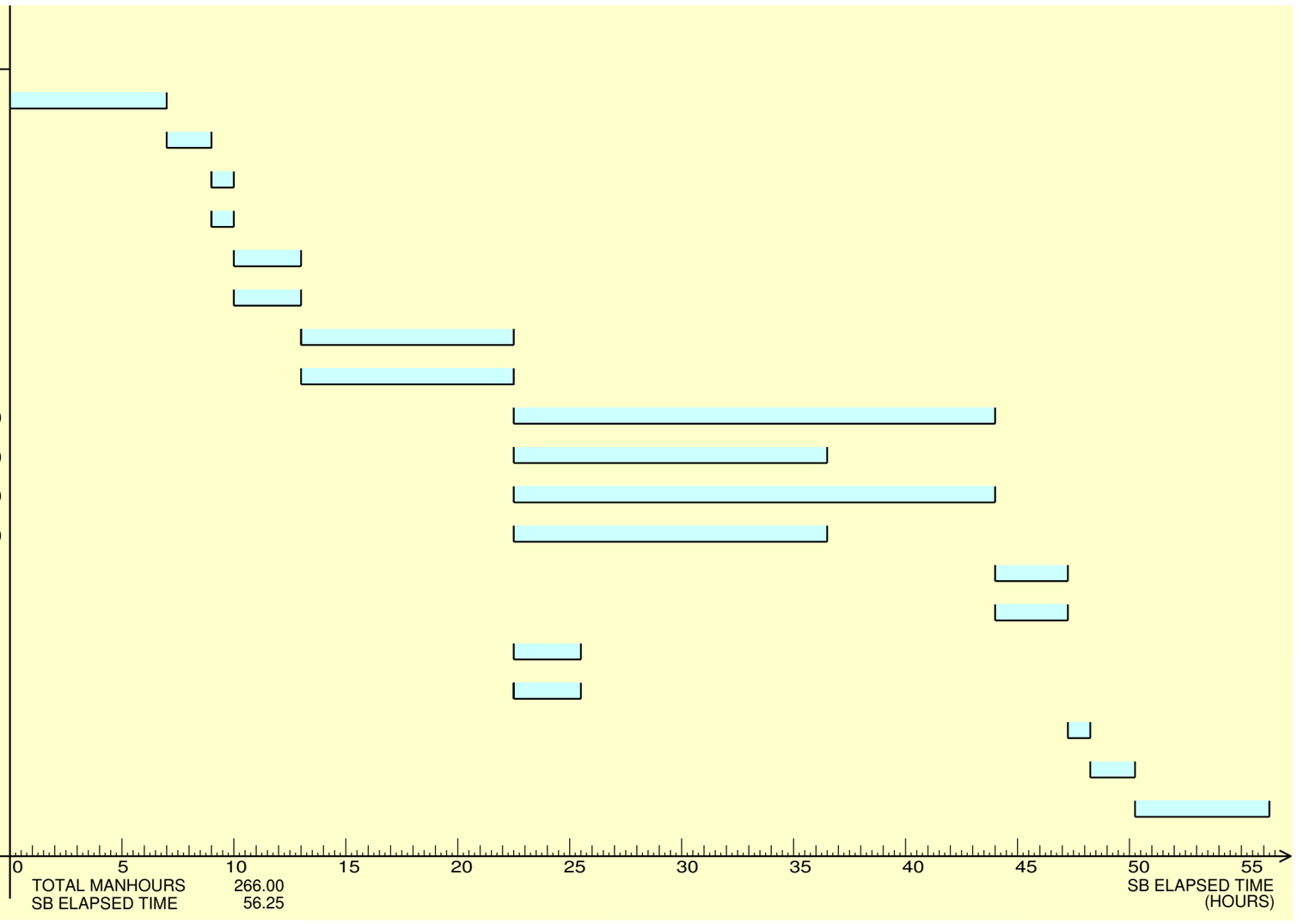
Figure A-GAAAA - Sheet 01
Gantt Chart

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**CONF 003

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A330–53–3226 01 02

STEPS	MH	PER	ET/S
GET ACCESS	14.00	2	7.00
SPECIAL JACKING	12.00	6	2.00
REMOVE THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA LH	1.00	1	1.00
REMOVE THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA RH	1.00	1	1.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.00	2	3.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.00	2	3.00
MODIFY THE DOOR FRAME OF THE EMERGENCY EXIT DOOR TYPE 1 LH	19.00	2	9.50
MODIFY THE DOOR FRAME OF THE EMERGENCY EXIT DOOR TYPE 1 RH	19.00	2	9.50
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR4 AND STGR15 LH	40.50	2	21.50
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 LH	28.00	2	14.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR4 AND STGR15 RH	40.50	2	21.50
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 RH	28.00	2	14.00
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.50	2	3.25
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.50	2	3.25
MODIFY THE LH EMERGENCY EXIT DOOR	6.00	2	3.00
MODIFY THE RH EMERGENCY EXIT DOOR	6.00	2	3.00
TEST	2.00	2	1.00
AIRCRAFT DE–JACKING	12.00	6	2.00
CLOSE–UP	12.00	2	6.00



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

NOTE:

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

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

G_SB_533226_6_AAAB_01_03

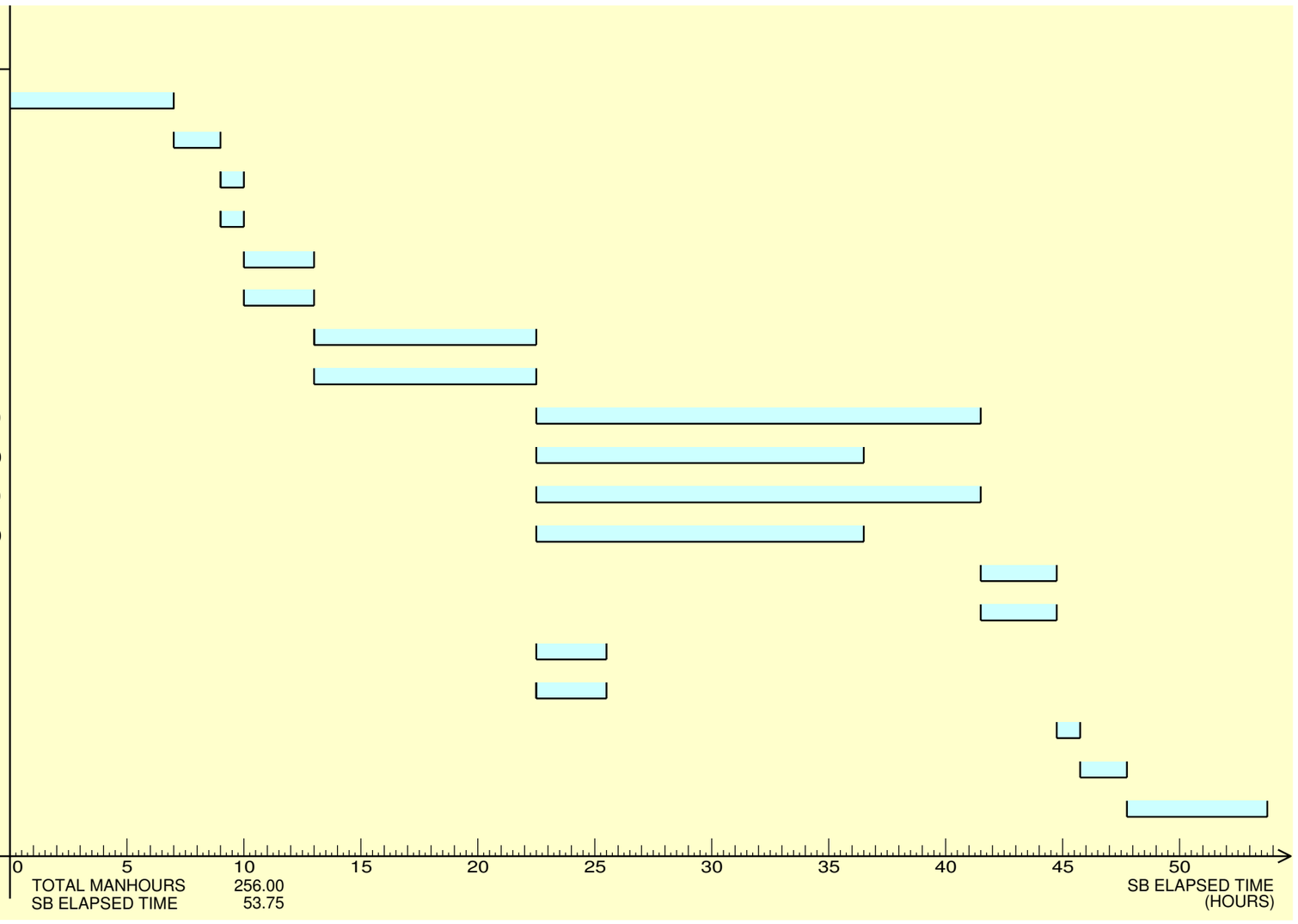
Figure A-GAAAB - Sheet 01
Gantt Chart

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**CONF 004

ELAPSED TIME ASSUMPTION SERVICE BULLETIN No A330–53–3226 01 02

STEPS	MH	PER	ET/S
GET ACCESS	14.00	2	7.00
SPECIAL JACKING	12.00	6	2.00
REMOVE THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA LH	1.00	1	1.00
REMOVE THE PAINT–STRIPPING OF THE AIRCRAFT SKIN AT THE MODIFICATION AREA RH	1.00	1	1.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.00	2	3.00
REMOVE THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.00	2	3.00
MODIFY THE DOOR FRAME OF THE EMERGENCY EXIT DOOR TYPE 1 LH	19.00	2	9.50
MODIFY THE DOOR FRAME OF THE EMERGENCY EXIT DOOR TYPE 1 RH	19.00	2	9.50
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR4 AND STGR15 LH	35.50	2	19.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 LH	28.00	2	14.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR4 AND STGR15 RH	35.50	2	19.00
MODIFY THE CIRCUMFERENTIAL JOINT BETWEEN STGR26 TO STGR30 RH	28.00	2	14.00
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR LH	6.50	2	3.25
INSTALL THE CROSS PLATE OF THE EMERGENCY EXIT DOOR RH	6.50	2	3.25
MODIFY THE LH EMERGENCY EXIT DOOR	6.00	2	3.00
MODIFY THE RH EMERGENCY EXIT DOOR	6.00	2	3.00
TEST	2.00	2	1.00
AIRCRAFT DE–JACKING	12.00	6	2.00
CLOSE–UP	12.00	2	6.00



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

NOTE:

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

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

G_SB_533226_6_AAAC_01_00

Figure A-GAAAC - Sheet 01
Gantt Chart

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CAUTION: MAKE SURE THAT THE LOADS NEVER EXCEED THE MAXIMUM PERMITTED LOADS SPECIFIED IN FIGURE Fig. A-GABAA, Sheet 02.

(1) Jacking procedure for the reinforcement of the circumferential joint at FR53.6 - FR53.7 and between STGR4 - 30 LH and STGR4 to STGR30 RH.

(a) AIRCRAFT CONFIGURATION

- This jacking procedure is valid for the following A/C configurations:

  . Aircraft in full configuration

  . Aircraft in full configuration but with cabin equipment removed (complete or partial). The aircraft has to be de-fueled before the zero stress jacking.

NOTE: If the aircraft configuration is not the same as the configurations above, contact AIRBUS.

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

(b) JACKING PROCEDURE

1 Obey the general jacking instructions in accordance with SRM 51-51-00.

2 In addition to the above mentioned SRM procedure, obey all safety precautions mentioned in AMM Task 07-11-00-581-801 prior to any action on the aircraft.

3 Lift the aircraft on jacks at points A, B1 and B2 in accordance with SRM 51-51-00 and Fig. A-GABAA, Sheet 01 and safety jack at FR85.

4 Install the additional jacking equipment at FR17, FR59 and FR76, refer to Fig. A-GABAA, Sheet 01.

5 Gradually apply the loads shown in step 1, to the jacks at FR17, FR59, FR76 and FR85, refer to Fig. A-GABAA, Sheet 02.

6 Wait until the loads on the jacks become stable and make sure that they are within a tolerance of +/- 10 percent.

7 Do the same procedure to apply the loads shown in step 2, step 3 and step 4.

NOTE: When the loads given in step 4 are stable and within a tolerance of +/- 10 percent, start with the ACCOMPLISHMENT INSTRUCTIONS.

(c) CLOSE-UP

1 Gradually decrease the loads one step after the other from step 4 to zero on the jacks at FR17, FR59, FR76 and FR85 in accordance with SRM 51-51-00 and Fig. A-GABAA, Sheet 02.

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2 Remove the safety jack from FR85.

NOTE: Keep the removed safety jack in a position far away from the aircraft.

3 Remove the additional jacking equipment from FR17, FR59 and FR76.

NOTE: Keep the removed jacking equipment in a position far away from the aircraft.

4 For lowering the aircraft from maintenance jacks at points A, B1 and B2, refer to AMM Task 07-11-00-586-801 in accordance with SRM 51-51-00 and Fig. A-GABAA, Sheet 01.

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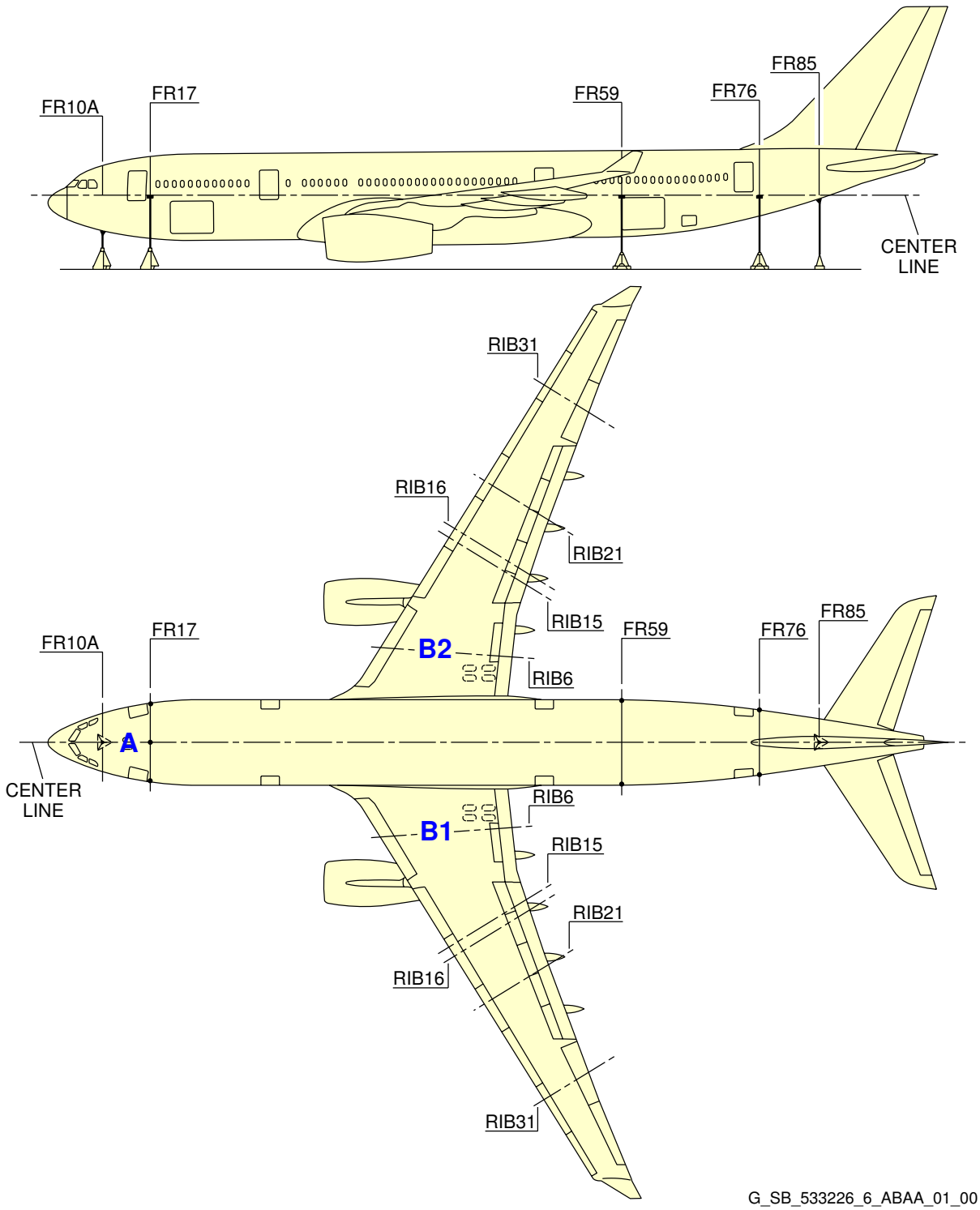


Figure A-GABAA - Sheet 01
Jacking Procedure for the Reinforcement of the Circumferential Joints

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**CONF ALL

FUSELAGE							
JACKING POINTS	MAX LOAD (daN)	APPLIED LOADS (daN) +/– 10%				% OF TOTAL LOADS	ACTUAL LOADS
		STEP 1	STEP 2	STEP 3	STEP 4		
FR17 LH	8250	1625	3250	4875	6500	5	
FR17 RH	8250	1625	3250	4875	6500	5	
FR59 LH	3950	250	500	750	1000	1	
FR59 RH	3950	250	500	750	1000	1	
FR76 LH	7450	1500	3000	4500	6000	5	
FR76 RH	7450	1500	3000	4500	6000	5	
SAFETY JACK	4500	900	1800	2700	3600	3	

NOTE 1: FOR AIRCRAFT APPLICATION, ONLY THE COLUMN 'STEP 4' (+/– 10%) IS VALID.

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

NOTE 3: FOR DE–JACKING REFER TO SRM 51–51–00.

CAUTION: BEFORE ABOVE MENTIONED ZERO STRESS JACKING CAN BE APPLIED, THE AIRCRAFT HAS TO BE IN MAINTENANCE JACKING CONDITION, REFER TO AMM 07–11–00–581–801 (RESTING ON FRONT JACK, LH MAIN JACK AND RH MAIN JACK).

MAIN AND SAFETY JACKS				
FRONT JACK	12300	FOR INFORMATION	9576	8
MAIN JACK LH	73700	FOR INFORMATION	43391	34
MAIN JACK RH	73700	FOR INFORMATION	43391	34

CORRESPONDING WEIGHT OF THE AIRCRAFT (KG): 126958, INCLUDING BALLASTS IF NECESSARY.

G_SB_533226_6_ABAA_02_00

Figure A-GABAA - Sheet 02
Jacking Procedure for the Reinforcement of the Circumferential Joints

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**CONF ALL

PRE MOD PART NUMBER	POST MOD PART NUMBER
F5227000200000	F5227016700000
F5227000200100	F5227016700100
F5227000200200	F5227016700200
F5227000200300	F5227016700300
F5227000200400	F5227016700400
F5227000200500	F5227016700500
F5227000200600	F5227016700600
F5227000200700	F5227016700700
F5227000200800	F5227016700800
F5227000200900	F5227016700900
F5227000201200	F5227016701000
F5227000201300	F5227016701100
F5227000201400	F5227016701200
F5227000201500	F5227016701300
F5227030000000	F5227016701400
F5227030000100	F5227016701500
F5227030000200	F5227016701600
F5227030000300	F5227016701700
F5227030000400	F5227016701800
F5227030000500	F5227016701900
F5227030000600	F5227016702000
F5227030000700	F5227016702100
F5227030000800	F5227016702200
F5227030000900	F5227016702300
F5227030001000	F5227016702400
F5227030001100	F5227016702500
F5227030001200	F5227016702600
F5227030001300	F5227016702700
F5227030001400	F5227016702800
F5227030001500	F5227016702900
F5227030001600	F5227016703000
F5227030001700	F5227016703100
F5227030001800	F5227016703200
F5227030001900	F5227016703300

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For the retrofitted modifications after accomplishment of this Service Bulletin, refer to the table below.

MOD	Config. 001	Config. 002	Config. 003	Config. 004	Config. 005
204309D50888	X				
204309D50892		X			X
204309D50893			X		
204309D50904				X	

Retrofitted Modifications Table

NOTE: "X" is used for the retrofitted modifications after accomplishment of this Service Bulletin.

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TITLE: FUSELAGE - CENTER FUSELAGE - REINFORCE CIRCUMFERENTIAL JOINT BETWEEN FR53.6-FR53.7 FOR EMERGENCY DOOR TYPE 1 AREA

MODIFICATION No.: 204309D50888 204309D50892 204309D50893 204309D50904

SB Reporting status

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

General information

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

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

SB Reporting procedure

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

Refer to ISI 00.00.00179:
- For complete information on reporting means to Airbus. Question 2 "What are the standard practices for SB reporting?"
- If this SB requires previous or simultaneous accomplishment of other SBs, Question 3 "What about the reporting of prerequisite Service Bulletin?"

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

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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:

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1 Rond Point Maurice Bellonte
31707 BLAGNAC CEDEX FRANCE

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Or via your Resident Customer Support Office.

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